

DATE <u>11/30/54</u>	<b>TMC SPECIFICATION NO. S- 241</b>	
SH. <u>1</u> OF <u>1</u>		
COMPILED BY M.H.S.	TITLE: <u>LOW TEMPERATURE BAKE ENAMEL</u>	JOB
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**PURPOSE:**

The purpose of this specification is to outline the materials and method of applying low temperature bake enamel finish.

**COLOR:**

TO BE SUPPLIED LATER

**MATERIALS REQUIRED:**

- #X1419 Semi Gloss Bake Enamel
- #902 Reducer

**SOURCE:**

- Eastern Lacquer Co.
- Eastern Lacquer Co.

**SURFACE PREPARATION:**

- 1- Clean surface of all foreign materials.
- 2- Apply zinc chromate primer, per Specification, S-114.

**PROPORTIONS OF MATERIAL:**

- Three parts enamel.
- One part reducer.

**METHOD OF APPLICATION:**

- 1- Apply by spraying one uniform coat of enamel.
- 2- Bake 45 minutes at 150° F.

**APPLICABLE SPECIFICATIONS:**

- S-114 Zinc Chromate Primer.
- Military Specification MIL-P-15090 Type 111 Class 2.

**SHIPPING AND MARKING:**

All finished material shall be shipped in suitable containers to give maximum protection during transit.  
All containers shall be plainly marked with the purchase order number, manufacturer's name and the TMC part number.