

AERONAUTICAL MATERIAL SPECIFICATION

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AMS 3108

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Revised

PRIMER, OCHER Phenolic

1. ACKNOWLEDGMENT: A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.
2. TYPE: Semi-gloss baking yellow-tan.
3. APPLICATION: As a prime coating on metal surfaces before enameling.
4. COMPOSITION:
 - 4.1 Product (by weight):

Non-Volatile	60% min
Volatile	40% max
 - 4.2 Non-Volatile:

Resin	48 - 50%
Pigment	50 - 52%

 - 4.2.1 Resin: Shall be a thermosetting phenolic type with softening agents added; it shall be free from rosin, rosin derivatives, oils and cellulose derivatives.
 - 4.2.2 Pigment: Shall be a natural ocher.
 - 4.3 Volatile: Shall be an organic solvent composed of one or more of the following types of compounds: alcohols, esters, hydrocarbons and ketones.
5. TECHNICAL REQUIREMENTS:
 - 5.1 General: Primer shall be of uniform consistency, and free from bubbles, grit, rough particles, floating or caked pigments, and from ingredients of respiratory toxicity under normal conditions of use. Component ingredients shall be intimately mixed and processed as required to produce a product which is stable and not subject to abnormal change with age in sealed containers.
 - 5.2 Coarse Particles: Not more than 0.1% by weight of the primer shall be retained on a No. 325 screen.
 - 5.3 Flash Point (Tag Closed Tester): Shall be not lower than 60 F.
 - 5.4 Viscosity: Shall be 9-13 poises absolute at 77 F not less than 24 hours after manufacture.
 - 5.5 Skinning and Livering: Shall be absent in a 1/4-filled closed container after standing one week.
 - 5.6 Color: Shall be yellow-tan, characteristic of ocher.