

Chapter 4-1

RENEWAL OF PAINTWORK

INTRODUCTION

1. The Truck, Airfield, Crash Rescue Mk.1 is supplied from the manufacturer with a Weidolux daylight red fluorescent finish (RAL 3024). This chapter details the methods to be employed to renew the paintwork in service. Separate instructions, detailed under their respective Service heading, are given for use by the RN and RAF.

RAFGENERAL

2. The materials and application instructions for the application of the red fluorescent finish to the truck are the same as for the application of fluorescent paints on aircraft as described in AP 119A-0601-1D, Chapter 5 (Fluorescent materials). These instructions are to be followed when renewal of paintwork is required.

RNGENERAL

3. The Wiedolux Daylight Fluorescent Finish (Red) (RAL 3024), as used by the truck manufacturer, is to be used when renewal of the paintwork is required.

4. The following paragraphs detail the materials required, their preparation and methods of application.

CAUTION...

It is essential that substitute materials are not used and that the procedure is strictly followed.

MATERIALS REQUIRED

5. The following materials are required and can be obtained from the truck manufacturer:-

HCB - Angus Ltd
Millbrook Trading Estate
Southampton

Wiedolux daylight fluorescent finish system RAL 3024 - RED

Degreasing WIEDO cleaner N 35091 a

Sanding paper

Etch primer WIEDO 2K N 5370

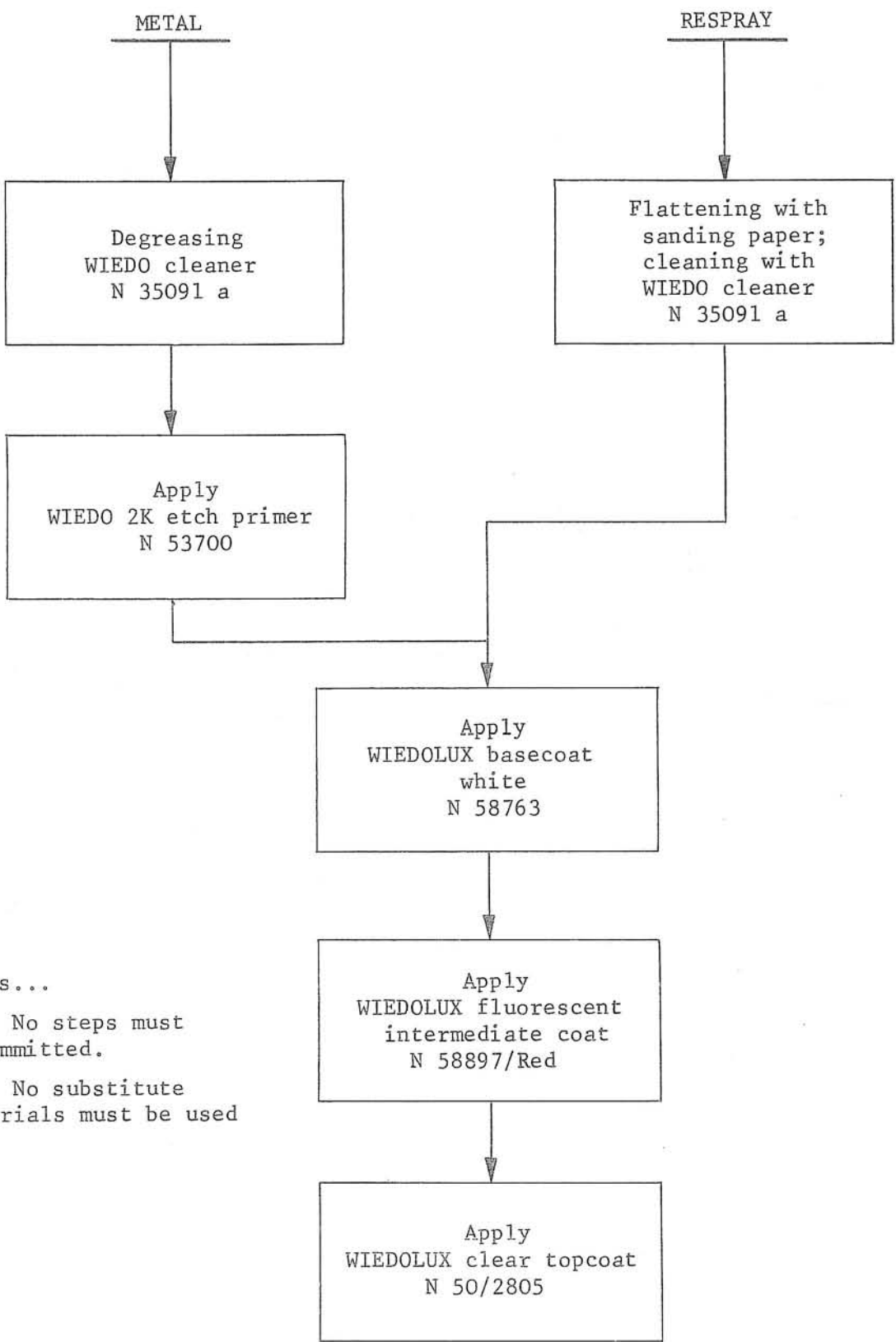
Basecoat WIEDOLUX white N 58763

Fluorescent intermediate coat WIEDOLUX N 58897/Red

Clear topcoat WIEDOLUX N 50/2805

Thinners, spray, for

Etch primer	N 36880
Basecoat white	N 39/3463
Intermediate coat	N 39/3463
Clear topcoat	N 39/3463



Notes...

- (1) No steps must be ommitted.
- (2) No substitute materials must be used

Fig.1 Block diagram of finishing process

6. All paints are available in 1 kg and 5 kg containers and are supplied with the appropriate amount of hardener in separate packs. The Etch primer and spray thinners are supplied in 1 litre or larger containers.

7. The shelf life of the paint materials is 12 months.

PROCEDURE

8. No special spraying equipment or techniques are required to apply this finish but it is essential that the steps shown in block diagram (fig.1) are strictly followed.

9. Special note is to be made of the pot life of the various paints to ensure only sufficient quantities for immediate use are mixed. Unused mixed paint cannot be kept.

10. The intermediate coat has little hiding power because the brilliance of the colour depends on an interaction between the white basecoat and the fluorescent intermediate coat. Sanding operations are not to be carried out between coats.

11. Full details on the mixing and application details of each coat are given under its respective heading.

Etch primer, WIEDO 2K N 53700

12. Mixing and application data is as follows:-

Mixing ratio	2:1 with hardener N 50/2317 supplied
Pre-reaction time	30 min at 20°C
Pot-life	48 hours at 20°C
Spray viscosity	18-20 seconds 4 mm flow cup (DIN)
Spray thinner	N 36880
Spray pressure	4-5 bars (60-70 lbf/in ²)
Nozzle diameter	1.2 - 1.5 mm
Dry film thickness	30 micron (1.2 mil) corresponding to 1½-2 double passes
Coverage	8-10 m ² /litre (50-60 ft ² /pint)
Drying time	30 min at 20°C 10 min at 80°C

Basecoat white WIEDOLUX N 58763

13. Mixing and application data is as follows:-

Mixing ratio	10:1 with hardener N 39/1996 supplied
Pre-reaction time	15-20 min at 20°C
Pot-life	12 hours at 20°C
Spray viscosity	18-20 seconds 4 mm flow cup (DIN)
Spray thinner	N 39/3463
Spray pressure	4-6 bars (60-85 lbf/in ²)
Nozzle diameter	1.2 - 1.5 mm
Dry film thickness	35 micron (1.4 mil) correspond to 2 double passes
Coverage	5-7 m ² /kg (55-75 ft ² /kg)

Drying time	6 hours at 20°C 30 mins at 80-85°C following a flash-off time of 15-20 min.
Wet-on-wet process	Following a flash-off time of 45-60 minutes at room temperature the fluorescent intermediate coat may be applied wet-on-wet.

Fluorescent intermediate coat WIEDOLUX N 58897/Red

14. Mixing and application data is as follows:-

Mixing ratio	10:1 with hardener N 39/1996 supplied
Pre-reaction time	15-20 min at 20°C
Pot-life	12 hours at 20°C
Spray viscosity	18-20 seconds 4 mm flow cup (DIN)
Spray thinner	N 39/3463
Spray pressure	4-6 bars (60-85 lbf/in ²)
Nozzle diameter	1.2 - 1.5 mm
Dry film thickness	Minimum 100 micron (3.9 mil) corresponding to 3 double passes
Coverage	4-5 m ² /kg (45-55 ft ² /kg)
Drying time	10 hours at 20°C 30 minutes at 80-85°C following a flash-off time of 20-30 minutes.

15. To ensure a good result, the specified minimum dry film thickness of 100 micron of the intermediate coat must be applied as uniformly as possible. This corresponds to approximately 200 micron wet film thickness achieved by 3 double passes.

16. The intermediate coat has little hiding power because the brilliance of the colour depends on an interaction between the white basecoat and the fluorescent intermediate coat. Sanding operations are not to be carried out between coats.

17. Should certain areas be required to be left white, these areas should be masked off while the fluorescent intermediate coat is applied and unmasked prior to the application of the clear top coat.

Clear topcoat WIEDOLUX N 50/2805

18. Mixing and application data as follows:

Mixing ratio	2:1 with hardener N 39/1996 supplied
Pre-reaction time	15-20 minutes at 20°C
Pot-life	12 hours at 20°C
Spray viscosity	16-18 seconds 4 mm flow cup (DIN)
Spray thinner	N 39/3463
Spray pressure	5-6 bars (70-85 lbf/in ²)
Nozzle diameter	1.0 - 1.2 mm
Dry film thickness	50 microns (2 mil) corresponding to 2 double passes

Coverage

5-7 m²/kg (55-75 ft²/kg)

Drying time

12 hours at 20°C

30 minutes at 80-85°C following a
flash-off time of 20-30 minutes.

