



STANDARD OVERHAUL PRACTICES MANUAL

DECODING TABLE FOR BOEING FINISH CODES

**PART NUMBER
NONE**

BOEING PROPRIETARY, CONFIDENTIAL, AND/OR TRADE SECRET

Copyright © 1995 The Boeing Company
Unpublished Work - All Rights Reserved

Boeing claims copyright in each page of this document only to the extent that the page contains copyrightable subject matter. Boeing also claims copyright in this document as a compilation and/or collective work.

This document includes proprietary information owned by The Boeing Company and/or one or more third parties. Treatment of the document and the information it contains is governed by contract with Boeing. For more information, contact The Boeing Company, P.O. Box 3707, Seattle, Washington 98124.

Boeing, the Boeing signature, the Boeing symbol, 707, 717, 727, 737, 747, 757, 767, 777, 787, Dreamliner, BBJ, DC-8, DC-9, DC-10, KC-10, KDC-10, MD-10, MD-11, MD-80, MD-88, MD-90, P-8A, Poseidon and the Boeing livery are all trademarks owned by The Boeing Company; and no trademark license is granted in connection with this document unless provided in writing by Boeing.

PUBLISHED BY BOEING COMMERCIAL AIRPLANES GROUP, SEATTLE, WASHINGTON, USA
A DIVISION OF THE BOEING COMPANY
PAGE DATE: Jul 01/2009

20-41-01

Page 1
Jul 01/2009



STANDARD OVERHAUL PRACTICES MANUAL

Revision No. 94
Jul 01/2009

To: All holders of DECODING TABLE FOR BOEING FINISH CODES 20-41-01.

Attached is the current revision to this STANDARD OVERHAUL PRACTICES MANUAL

The STANDARD OVERHAUL PRACTICES MANUAL is furnished either as a printed manual, on microfilm, or digital products, or any combination of the three. This revision replaces all previous microfilm cartridges or digital products. All microfilm and digital products are reissued with all obsolete data deleted and all updated pages added.

For printed manuals, changes are indicated on the List of Effective Pages (LEP). The pages which are revised will be identified on the LEP by an R (Revised), A (Added), O (Overflow, i.e. changes to the document structure and/or page layout), or D (Deleted). Each page in the LEP is identified by Chapter-Section-Subject number, page number and page date.

Pages replaced or made obsolete by this revision should be removed and destroyed.

ATTENTION

IF YOU RECEIVE PRINTED REVISIONS, PLEASE VERIFY THAT YOU HAVE RECEIVED AND FILED THE PREVIOUS REVISION. BOEING MUST BE NOTIFIED WITHIN 30 DAYS IF YOU HAVE NOT RECEIVED THE PREVIOUS REVISION. REQUESTS FOR REVISIONS OTHER THAN THE PREVIOUS REVISION WILL REQUIRE A COMPLETE MANUAL REPRINT SUBJECT TO REPRINT CHARGES SHOWN IN THE DATA AND SERVICES CATALOG.

20-41-01

TRANSMITTAL LETTER

Page 1

Jul 01/2009

PART NUMBER NONE



STANDARD OVERHAUL PRACTICES MANUAL

Location of Change

Description of Change

NO HIGHLIGHTS

20-41-01

HIGHLIGHTS

Page 1

Jul 01/2009



STANDARD OVERHAUL PRACTICES MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
TITLE PAGE		20-41-01 SUBJECT (CONT)			
O 1	Jul 01/2009	15	Mar 01/2007		
2	BLANK	16	Jul 01/2008		
20-41-01 TRANSMITTAL LETTER		17	Jul 01/2008		
O 1	Jul 01/2009	18	Jul 01/2008		
2	BLANK	19	Jul 01/2008		
20-41-01 HIGHLIGHTS		20	Jul 01/2008		
O 1	Jul 01/2009	21	Mar 01/2009		
2	BLANK	22	Mar 01/2009		
20-41-01 EFFECTIVE PAGES		23	Mar 01/2009		
1	Jul 01/2009	24	Mar 01/2009		
2	BLANK	25	Mar 01/2009		
20-41-01 CONTENTS		26	Mar 01/2009		
1	Nov 01/2006	27	Mar 01/2009		
2	BLANK	28	Mar 01/2009		
20-41-01 REVISION RECORD		29	Mar 01/2009		
1	Jul 01/2005	30	Mar 01/2009		
2	Jul 01/2005	31	Mar 01/2009		
20-41-01 RECORD OF TEMPORARY REVISIONS		32	Mar 01/2009		
1	Jul 01/2005	33	Mar 01/2009		
2	Jul 01/2005	34	Mar 01/2009		
20-41-01 INTRODUCTION		35	Mar 01/2009		
1	Jul 01/2005	36	Mar 01/2009		
2	BLANK	37	Mar 01/2009		
20-41-01 SUBJECT		38	Mar 01/2009		
1	Mar 01/2007	39	Mar 01/2009		
2	Mar 01/2007	40	Mar 01/2009		
3	Mar 01/2007	41	Mar 01/2008		
4	Mar 01/2007	42	Mar 01/2008		
5	Mar 01/2007				
6	Mar 01/2007				
7	Mar 01/2007				
8	Mar 01/2007				
9	Mar 01/2007				
10	Mar 01/2007				
11	Mar 01/2007				
12	Mar 01/2007				
13	Mar 01/2007				
14	Mar 01/2007				

A = Added, R = Revised, D = Deleted, O = Overflow

20-41-01

EFFECTIVE PAGES

Page 1

Jul 01/2009



STANDARD OVERHAUL PRACTICES MANUAL

TABLE OF CONTENTS

<u>Paragraph Title</u>	<u>Page</u>
DECODING TABLE FOR BOEING FINISH CODES	1
INTRODUCTION	1
DECODING TABLE	1

All revisions to this manual will be accompanied by transmittal sheet bearing the revision number. Enter the revision number in numerical order, together with the revision date, the date filed and the initials of the person filing.

[illegible]

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

When the temporary revision is incorporated or cancelled, and the pages are removed, enter the date the pages are removed and the initials of the person who removed the temporary revision.

[illegible]

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

[illegible]

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



STANDARD OVERHAUL PRACTICES MANUAL

INTRODUCTION

1. General

- A. The instructions in this manual tell how to do standard shop procedures during maintenance functions from simple checks and replacement to complete shop-type repair.
- B. This manual is divided into separate sections:
 - (1) Title Page
 - (2) Transmittal Letter
 - (3) Highlights
 - (4) Effective Pages
 - (5) Contents
 - (6) Revision Record
 - (7) Record of Temporary Revisions
 - (8) Introduction
 - (9) Procedures
- C. Refer to SOPM 20-00-00 for a definition of standard industry practices, vendor names and addresses, and an explanation of the True Position Dimensioning symbols used.
- D. The data is general. It is not about all situations or specific installations. Use it as a guide to help you write minimum standards.
- E. If the component overhaul instructions are different from the data in this subject, use the component overhaul instructions.

20-41-01

INTRODUCTION

Page 1

Jul 01/2005



STANDARD OVERHAUL PRACTICES MANUAL

DECODING TABLE FOR BOEING FINISH CODES

1. INTRODUCTION

- A. The data in this subject comes from Boeing Process Documents D2-5000 and D6-5000 which gives the details of procedures and materials for each of the finish codes used on Boeing drawings. This subject does not include all codes found in the source documents, but only those used in the Boeing component overhaul instructions.
- B. A finish code has the prefix F- (finish) or SRF- (special chemical and solvent resistant finish), a basic number for the substrate or general classification, and a decimal for the individual code. Some codes have dash numbers (suffixes) that identify the color. The basic numbers are identified as follows:
 - 1.00 - Ferrous Materials and Corrosion Resistant Steels requiring plating
 - 2.00 - Aluminum Alloys
 - 3.00 - Magnesium Alloys
 - 4.00 - Copper and Nickel Base Alloys
 - 5.00 - Wood
 - 6.00 - Plastics
 - 8.00 - Corrosion Resistant Steels except parts requiring plating
 - 9.00 - Miscellaneous Finishes
 - 10.00 - Titanium
 - 12.00 - Additional Finishes
 - 14.00 thru 25.00 - Special Boeing Commercial Airplane Finish Codes
 - 30.00 - PDM-defined codes
- C. In this manual, Roman numeral callouts (such as for type, class or grade) are considered the same as Arabic numerals. This is to prevent confusion with alphabetic characters, such as Type C (Type 100) as compared to Type C (the letter C).
- D. Refer to SOPM 20-00-00 for a list of all the vendor names and addresses.

2. DECODING TABLE

- A. BAC = Boeing Process Specification
- B. BMS = Boeing Material Specification

Code	Decoding
F-1.10	Apply no finish, but you can apply temporary protection for handling, transportation, or storage (BAC5034 or SOPM 20-44-02).
F-1.103	Cadmium plate per AMS-QQ-P-416 or BAC5701, Type 2, Class 1 (SOPM 20-42-05).
F-1.115	Brush tin plate 0.0005 inch thick minimum per MIL-STD-865 or BAC5849.
F-1.131	Cadmium plate per BAC5701, Type 3, Class 2 (SOPM 20-42-05) and apply MIL-PRF-85582 primer per BAC5807.
F-1.16	Clean per TT-C-490, Method 2 or 3, or per BAC5749 or BAC5750 and apply one coat of BMS 10-11, Type 1 primer per BAC5736.
F-1.18	Canceled. Use F-1.308.
F-1.181	Canceled. Use F-1.308.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-1.19	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 1, Class 3 (SOPM 20-42-05), but parts heat-treated 220 ksi and above must be plated per BAC5804 (SOPM 20-42-02).
F-1.191	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 1, Class 2 (SOPM 20-42-05), then bake 3 hours minimum at 350-400°F.
F-1.1913	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 1, Class 3 (SOPM 20-42-05). Bake 3 hours minimum at 350-400°F.
F-1.1914	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 1, Class 3 (SOPM 20-42-05).
F-1.1915	Cadmium-titanium plate to a thickness of 0.0002-0.0004 inch per BAC5804, Type 1 without post-plate treatment. Bake 23 hours minimum at 350-400°F unless specified by overhaul instructions.
F-1.1922	Cadmium-titanium plate per BAC5804 and bake 23 hours minimum at 350-400°F.
F-1.1923	Canceled. Use F-1.32.
F-1.1924	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2 (SOPM 20-42-05) and bake 5 to 8 hours at 250-300°F.
F-1.1926	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 2, Class 3 (SOPM 20-42-05) and bake 3 hours minimum at 350-400°F.
F-1.1927	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 2, Class 3 (SOPM 20-42-05) and bake 5 to 8 hours at 250-300°F.
F-1.1928	Canceled. Use F-1.309.
F-1.1929	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2 (SOPM 20-42-05).
F-1.193	Canceled. Use F-12.6599.
F-1.1930	Canceled. Use F-1.103.
F-1.20	Plate as follows: 1. Threaded parts heat-treated below 220 ksi: Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 1, Class 2 (SOPM 20-42-05). 2. Nonthreaded parts heat-treated below 220 ksi: Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2 (SOPM 20-42-05). 3. Parts (that are not springs) heat-treated 220 ksi or above: Cadmium-titanium plate per BAC5804 (SOPM 20-42-02). 4. Springs (of all heat-treats): Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2, then bake 8 hours at 350-400°F. Do not flex springs before baking.
F-1.201	Canceled. Use F-1.308.
F-1.202	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 2, Class 3 (SOPM 20-42-05).
F-1.204	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 3, Class 2 (SOPM 20-42-05), then bake 3 hours minimum at 350-400°F.
F-1.2041	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 3, Class 2 (SOPM 20-42-05).
F-1.205	Zinc plate per ASTM B633, Type 2, Class Fe/Zn 12 or BAC5700.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-1.21	Cadmium plate all but bearing areas per AMS-QQ-P-416, Type 1 or 2, Class 2 (SOPM 20-42-05), but, for parts heat-treated above 220 ksi, cadmium-titanium plate per BAC5804.
F-1.22	Tin plate, 0.0003 inch minimum per ASTM B545, or BAC5717, Type 1 or 2.
F-1.23	Brush tin plate to thickness of 0.00025 inch minimum per MIL-STD-865 or BAC5849.
F-1.25	Canceled. Use F-1.205.
F-1.27	Cadmium plate per AMS-QQ-P-416, Type 3, Class 2 (or BAC5701, Type 3, Class 1) (SOPM 20-42-05). Apply solid film lubricant MIL-L-46010, Type 2 per BAC5811, Type 6, Class 4 (SOPM 20-50-08).
SRF-1.28	Cadmium plate per AMS-QQ-P-416 (or BAC5761), Type 2, Class 2 (SOPM 20-42-05), and apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
F-1.281	Brush cadmium plate to 0.0003 inch minimum thickness per MIL-STD-865 or BAC5849.
F-1.282	Brush cadmium plate to 0.0003 inch minimum thickness per MIL-STD-865 or BAC5849 and bake 3 hours minimum at 350-400°F.
SRF-1.283	Canceled. Use SRF-1.28.
F-1.285	Canceled. Use SRF-1.28.
SRF-1.285	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2 (SOPM 20-42-05), and bake 3 hours minimum at 350-400°F. Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
SRF-1.286	Cadmium-titanium plate and bake 23 hours minimum at 350-400°F with post-plate chromate treatment per BAC5804 (SOPM 20-42-02). Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
F-1.29	Cadmium-titanium plate to a thickness of 0.0005-0.0007 inch, bake, and apply chromate postplate treatment per BAC5804 (SOPM 20-42-02). Apply primer TT-P-1757, color Y to a dry film thickness of 0.0003-0.0005 inch per BAC5774.
SRF-1.30	Cadmium plate per AMS-QQ-P-416, Type 2, Class 2 (SOPM 20-42-05), but on steels heat-treated 220 ksi and above, low hydrogen embrittlement cadmium-titanium plate per BAC5804 (SOPM 20-42-02), or cadmium plate per BAC5718 (SOPM 20-42-01) with post-plate chromate treatment. Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
F-1.301	Phosphate coat per TT-C-490, Type 1 or BAC5810, Type 3 and apply two layers of BMS 10-11, Type 1 primer per BAC5774.
F-1.302	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2 (SOPM 20-42-05), but on steels heat-treated 220 ksi and above, low hydrogen embrittlement cadmium-titanium plate per BAC5804 (SOPM 20-42-02) or cadmium plate per BAC5718 (SOPM 20-42-01).
F-1.303	Apply phosphate coating per TT-C-490, Type 1 or BAC5810, Type 3.
SRF-1.305	Zinc plate per BAC5700, Type 2, Class 2 or ASTM B633, Type 2, Class Fe/Zn 13. Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-1.308	Cadmium-titanium plate per MIL-STD-1500, Type 2, Class 1 (or BAC5804) and bake 12 hours minimum at 350-400°F (SOPM 20-42-02).
F-1.309	Cadmium-titanium plate per MIL-STD-1500, Type 2, Class 2 (or BAC5804) and bake 12 hours minimum at 350-400°F (SOPM 20-42-02).
F-1.32	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2, then bake 3 hours minimum at 350-400°F. Do not extend, compress or bend springs before the bake.
F-1.37	Electroless nickel plate per AMS 2404 or BAC5728, 0.0015 inch thick. Then bake 3 hours minimum at 350-400°F.
F-1.50	Cadmium plate parts below 220 ksi per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2 (SOPM 20-42-05). Cadmium-titanium plate parts heat-treated 220-240 ksi per BAC5804 (SOPM 20-42-02) with post-plate chromate treatment. After plating, apply one layer of BMS 10-11, Type 1 primer per BAC5774. Then apply two layers of A-A-3164 lacquer, Fed. Std. 595 Color 37038 per BAC5706.
F-1.51	Chromium plate to specified thickness per AMS-QQ-C-320, Class 2, or BAC5709. Bake 23 hours minimum at 350-400°F.
F-1.56	Abrasive clean per TT-C-490, Method 1 or BAC5748, or acid clean per TT-C-490, Method 6 or BAC5751, Type X. Apply MIL-PRF-23377 primer to a dry film thickness of 0.0006-0.0009 inch per BAC5807.
F-1.60	Cadmium plate per AMS-QQ-P-416, Type 1 or 3, Class 2 followed by a 3 to 5% (by weight) chromic acid dip on exterior surface of hollow open-end member. Apply one layer of BMS 10-11, Type 1 primer on interior surface per BAC5736. (Obsolete).
F-1.61	(Now equivalent to SRF-1.61.)
SRF-1.61	Cadmium plate exterior surface of hollow open-end member (ends unplugged) per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2, but plate parts heat-treated 220 ksi and above per BAC5804 with interior post-chromate treatment. Apply two layers of BMS 10-11, Type 1 primer to interior surface per BAC5720.
F-1.611	Finish open tubular and hollow parts as follows: Exterior surfaces: Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2 (SOPM 20-42-05). Bake after plating as required. Interior surfaces: Clean per TT-C-490, Method 6 or BAC5751, Type X. Apply one layer of BMS 10-11, Type 1 primer per BAC5720 (SOPM 20-41-03).
SRF-1.611	Finish open tubular and hollow parts as follows: Cadmium plate exterior surfaces per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2 (SOPM 20-42-05) and bake 3 hours minimum at 350-400°F. Apply one layer of BMS 10-11, Type 1 primer on interior surfaces per BAC5736 (SOPM 20-41-02).
SRF-1.612	Finish open tubular and hollow parts as follows: Cadmium-titanium plate exterior surfaces to 0.0005 inch minimum thickness with post-plate chromate treatment per BAC5804. Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
F-1.62	Cadmium-titanium plate per MIL-STD-1500, Type 2, Class 3 (0.0002-0.0004 inch thick) or BAC5804 and bake 12 hours minimum at 350-400°F.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-1.66	Nickel plate to 0.0005 inch minimum thickness per AMS-QQ-N-290, Class 2 (or BAC5746) followed by chromium plate to 0.001 inch minimum thickness per AMS-QQ-C-320, Class 2 (or BAC5709).
F-1.70	Cadmium plate the exterior of hollow closed members per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2, but cadmium-titanium plate parts heat-treated 220 ksi and above per BAC5804 with post-plate chromate treatment. On the interior surface, apply MIL-C-11796, Class 1 corrosion preventive compound per BAC5720, Type 1 (SOPM 20-41-03).
F-1.701	Cadmium plate the exterior surface per AMS-QQ-P-416 (or BAC5701), Type 2, Class 1 (SOPM 20-42-05). Clean the interior surfaces and apply MIL-C-11796, Class 1 corrosion preventive compound per BAC5720, Type 1 (SOPM 20-41-03).
F-1.702	Cadmium-titanium plate the exterior surfaces of closed or partially closed, tubular and hollow members per MIL-STD-1500 (or BAC5804), Type 2, Class 1 (SOPM 20-42-02). Clean the interior surfaces and apply MIL-C-11796, Class 1 corrosion preventive compound per BAC5720, Type 1 (SOPM 20-41-03).
F-1.71	Cancelled. Use F-1.70.
F-1.712	Cancelled. Use F-1.702.
F-1.72	Zinc plate the exterior surface per ASTM B633, Type 2, Class Fe/Zn 12 or per BAC5700. Apply MIL-C-11796, Class 1 corrosion preventive compound to the interior surface per BAC5720, Type 1 (SOPM 20-41-03).
F-1.73	Clean and coat the interior surfaces of hollow parts (open or closed) with MIL-C-11796, Class 1 corrosion preventive compound per BAC5720, Type 1 (SOPM 20-41-03).
F-1.76	Cancelled. Use F-1.308.
F-1.801	Electroless nickel plate to 0.0015 minimum thickness per AMS 2404, MIL-C-26074 Class 1, Grade C, or BAC5728, Class 1. Bake 3-4 hours at 350-400°F.
F-1.802	(Same as F-1.801, but use only AMS 2404 or BAC5728, Class 1).
F-1.803	Electroless nickel plate per MIL-C-26074, Class 1, Grade C (0.0015 inch) or BAC5728, Class 1, and bake 1 to 3 hours at 350-400°F.
F-1.804	Electroless nickel plate per MIL-C-26074, Class 2, Grade C (0.0015 inch) or per BAC5728, Class 2, and bake 50-70 minutes at 725-775°F.
F-1.81	Nickel plate to 0.001 inch minimum thickness per AMS-QQ-N-290, Class 2 (or BAC5746), then gold plate per MIL-G-45204, Type 3, Grade A, Class 2 (or BAC5761).
F-1.821	Nickel plate to a thickness of 0.003 inch minimum per BAC5746, Type 1 (SOPM 20-42-09).
F-1.822	Electrolytic nickel plate per BAC5746, Type 1, and bake 3 hours minimum at 350-400°F.
F-1.823	Nickel plate 0.002 inch minimum per AMS-QQ-N-290 (or BAC5746), Class 2.
F-1.83	Silver plate to a thickness of 0.0005 inch minimum per ASTM B700, Type 1 or 2, Grade A, or per BAC5715.
F-1.841	Canceled. Use F-1.90.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-1.842	Canceled. Use F-1.90.
F-1.843	Chromium plate per AMS-QQ-C-320 (or BAC5709), Class 2, and bake 23 hours minimum at 350-400°F. Parts stripped and replated must be baked for 23 hours minimum at 350-400°F before you plate them again.
F-1.846	Use F-15.04.
F-1.90	Chrome plate to specified thickness per AMS-QQ-C-320, Class 2 or per BAC5709.
F-1.901	Silver plate per ASTM B700 or BAC5715.
F-1.91	Nickel plate to 0.003 inch per AMS-QQ-N-290, Class 2 or per BAC5746, and bake 3 hours minimum at 350-400°F.
F-1.912	Electroless nickel plate per AMS 2404 (0.0015 inch) or per BAC5728.
F-1.9121	Electroless nickel plate and bake per BAC5728, Class 1.
F-1.9125	Electroless nickel plate and bake per BAC5728, Class 2.
F-1.913	Nickel plate per AMS 2404 (or BAC5728), Class 1 surfaces as indicated below. Then bake the part 3 hours at 350-400°F. 1. Plate close-tolerance machined surfaces to the thickness specified by overhaul instructions. 2. Plate other machined surfaces to 0.0015 inch minimum thickness. 3. Plate surfaces as cast or forged, to 0.003 inch minimum. These surfaces can also be plated along with the machined surfaces above followed by nickel plating to reach a combined thickness of 0.003 inch to meet the requirements of QQ-N-290 or BAC5746, Class 2.
F-1.9132	Electroless nickel plate and bake per AMS 2404 or BAC5728, Class 1.
F-1.92	Cadmium plate per BAC5701, Type 2, Class 2 and apply two layers of BMS 10-11, Type 1 primer per BAC5720 or BAC5774.
SRF-1.92	Cadmium plate per BAC5701, Type 2, Class 2 and apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-1.94	Apply BMS 3-8 dry film lubricant per BAC5811, Type 8 (SOPM 20-50-08).
F-1.941	Apply phosphate coat to meet requirements of MIL-DTL-16232, Type M, Class 1 or per BAC5810, Class 1. Apply lubricant per BAC5008 as specified by overhaul instructions.
F-2.10	Apply no finish, but you can apply temporary protection for transportation, handling, or storage (BAC5034 or SOPM 20-44-02).
F-2.104	Chemical treat all surfaces of tubular member per MIL-C-5541, Class 1A, or BAC5719, or BAC5626 or anodize per MIL-A-8625, Type 1, Class 1 or BAC5019 or BAC5632. Apply one layer of BMS 10-11, Type 1 primer per BAC5774.
F-2.114	Chemical treat per BAC5719, Type 2, Class A. (BAC5719, Type 1, Class A or B is optional for spotwelded assemblies.) Apply one layer of BMS 10-11, Type 1 primer per BAC5774.
SRF-2.114	Chemical treat per BAC5719, Type 2, Class A. (BAC5719, Type 1, Class A is optional for spot welded assemblies.) Apply one layer of BMS 10-11, Type 1 primer per BAC5736.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-2.115	(Now equivalent to SRF-2.115.)
SRF-2.115	Chemical treat per MIL-C-5541, Class 1A or BAC5719, Class A, or anodize per MIL-A-8625, Type 1, Class 1 or BAC5019 or BAC5632. Apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-2.130	(Now equivalent to SRF-2.130.)
SRF-2.130	Chemical treat exterior skins with clear film per MIL-C-5541, Class 3 or BAC5719, Class B. To interior surface of skin, apply one layer of BMS 10-11, Type 1 primer per BAC5736.
SRF-2.132	Anodize per BAC5019 or BAC5632 and apply one layer of BMS 10-11, Type 1 primer to interior surfaces only per BAC5736.
F-2.14	Anodize (do not seal) per MIL-A-8625, Type 2, Class 1 or BAC5022 or BAC5884. Apply dry film lubricant MIL-L-46010 per BAC5811, Type 6, Class 4 (SOPM 20-50-08).
F-2.150	Chemical treat per MIL-C-5541, Class 1A or BAC5719 or BAC5626, or anodize per MIL-A-8625, Type 1, Class 1 or BAC5019 or BAC5884 or BAC5632. Apply one layer of BMS 10-11, Type 1 enamel per BAC5774.
SRF-2.150	Chemical treat per MIL-C-5541, Class 1A or per BAC5719, Class A (BAC5719, Type 2, Class B is optional if film and primer are applied before parts are removed from conveyor), or anodize per MIL-A-8625, Type 1, Class 1 or BAC5019 or BAC5632. Apply two layers of BMS 10-11, Type 1 primer per BAC5736.
F-2.154	Chromic acid anodize per MIL-A-8625, Type 1 or 1C (preferred), or anodize per BAC5019 or BAC5632. On faying surface only, apply one layer of BMS 10-11, Type 1 primer per BAC5774.
F-2.157	Chromic acid anodize the interior and exterior surfaces of tubular parts per MIL-A-8625, Type 1 or 1C, Class 1 or per BAC5019 or BAC5884 or BAC5632.
F-2.159	Apply directional coarse grain buff satin finish with L-Lea compound or 120-grit aluminum oxide or equivalent to the area and in the direction indicated. Then sulfuric acid anodize per MIL-A-8625, Type 2 or BAC5022 to match color chip BAC901 per D-14080. (Obsolete).
SRF-2.19	Anodize per BAC5019 or BAC5632 and apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-2.20	Anodize per MIL-A-8625, Type 1, Class 1 or 1C (preferred), or per BAC5019 or BAC5884 or BAC5632.
F-2.201	Anodize per MIL-A-8625, Type 2, Class 1 or per BAC5022 or BAC5884.
F-2.202	Anodize to meet the requirements of MIL-A-8625, Type 1 (chromic acid) or Type 2 (sulfuric acid) or per BAC5884 or BAC5022 or BAC5632.
F-2.204	Hard anodize per MIL-A-8625, Type 3 or BAC5821, Class 1.
F-2.21	Chemical treat per MIL-C-5541, Class 1A or per BAC5626, Type 1 or 2, Class A or per BAC5719.
F-2.22	Chemical treat per MIL-C-5541, Class 1A, or BAC5626, or anodize per MIL-A-8625 (or BAC5719), Type 1C or BAC5719, Class A or BAC5632.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-2.221	Chemical treat per MIL-C-5541 (colored film) or BAC5719. Let the parts stay in the treatment solution only until they get an iridescent film or 2 minutes, whichever is less. A deep yellow or gold color is not acceptable.
F-2.23	Hot tin dip per BAC5717, Type 2.
F-2.24	Anodize and dye black per MIL-A-8625, Type 2, Class 2; or BAC5716 or BAC5884.
F-2.25	Canceled. Use F-2.22.
F-2.26	Chromic acid anodize per BAC5019 or BAC5884 or BAC5632.
F-2.30	Chemical treat per MIL-C-5541, Class 1A or BAC5719, Class A, or chromic acid anodize per MIL-A-8625, Type 1, Class 1 or BAC5632. Apply one layer of BMS 10-11, Type 1 primer per BAC5774.
SRF-2.30	Chemical treat per MIL-C-5541, Class 1A or BAC5719, Class A (BAC5719, Type 2, Class B is optional if film and primer are applied without part removal from conveyor), or chromic acid anodize per MIL-A-8625, Type 1 or 1C (preferred), Class 1 or BAC5019 or BAC5632. Apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-2.304	Canceled. Use SRF-2.30.
SRF-2.31	Chemical treat per MIL-C-5541, Class 1A or per BAC5719, Class A (BAC5719, Type 2, Class B is optional if film and primer are applied without part removal from conveyor). Apply one layer of BMS 10-11, Type 1, Grade E primer per BAC5736.
SRF-2.311	Anodize per BAC5019 or BAC5632 and apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-2.312	Anodize per MIL-A-8625, Type 1 or 1C, Class 1 or BAC5019. Apply one layer of BMS 10-11, Type 1 primer per BAC5774.
F-2.33	Chromium plate per BAC5709.
F-2.34	Electroless nickel plate per BAC5728. Bake 55-65 minutes at 245-275°F.
F-2.44	Tin plate to 0.0005-inch minimum thickness per ASTM B545 or BAC5717. Brush plating per BAC5849 is optional.
F-2.48	Chemical treat per BAC5626, Type 1 or 2, Class B, or BAC5719, Class B clear.
F-2.56	Tin plate to a thickness of 0.0002-inch minimum per ASTM B545, or BAC5717, Type 1 or 2.
F-2.60	Chemical treat surface per MIL-C-5541, Class 1A, or BAC5719 or BAC5626 or chromic acid anodize per MIL-A-8625, Type 1, Class 1, BAC5019 or BAC5884. Apply one layer of BMS 10-11, Type 1 primer per BAC5774. Then apply two layers of A-A-3164 lacquer, FED-STD-595 color 37038 gray per BAC5706.
F-2.61	Canceled. Use F-2.60.
F-2.70	Anodize exterior surface of hollow open ended member per MIL-A-8625, Type 1 or 1C, Class 1, or per BAC5884 or BAC5019. Plugs are not necessary to keep the acid from interior surfaces that can drain.
F-2.742	Chemical treat interior and exterior surfaces of tubing per MIL-C-5541, Class 1A, or per BAC5626 or BAC5719.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-2.743	Chemical treat exterior surfaces of oxygen tubing (ends plugged) per MIL-C-5541, Class 1A or BAC5719, or BAC5626. Tubing must be plugged to keep out the acid solution.
F-2.80	Chromic acid anodize the exterior surface of hollow, open ended members per MIL-A-8625, Type 1 or 1C, Class 1 or BAC5019 or BAC5884. Let the solution touch interior surfaces that can drain. Apply one layer of BMS 10-11, Type 1 primer per BAC5774 on interior surfaces.
F-2.86	Anodize to thickness of 0.0015-0.0025 inch (0.038-0.063 mm) per MIL-A-8625, Type 3 or per BAC5821, Class 1.
SRF-2.90	Chemical treat per MIL-C-5541, Type 1, Class 1 or BAC5719, Class A, or anodize per MIL-A-8625, Type 1, Class 1 or 1C (preferred) or per BAC5019. Plugs are not necessary to keep the acid from interior surfaces that can drain. Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
SRF-2.901	Colored-film chemical treat interior and exterior surfaces per MIL-C-5541, Class 1A or per BAC5719, Class A. Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
SRF-2.902	Chemical treat interior and exterior surfaces per MIL-C-5541, Class 1A (colored film). Apply one layer of BMS 10-11, Type 1 primer per BAC5736 on interior surface only.
F-2.930	Chemical treat per MIL-C-5541, Class 3, or BAC5626, or BAC5719, Class B, by manual procedures only (immersion not permitted).
F-2.94	Hard anodize to 0.0015-0.0025 inch thickness per MIL-A-8625, Type 3 or BAC5821, Type 1.
F-2.940	Chemical treat per MIL-C-5541, Class 1A, or BAC5626, or BAC5719 by manual procedures only (immersion not permitted).
F-2.964	Anodize per MIL-A-8625, Type 2, Class 1 or BAC5884.
F-3.10	Apply no finish, but temporary protection can be applied for transportation, handling, or storage per BAC5034 (SOPM 20-44-02).
SRF-3.17	Chemical treat (Dow 7) per AMS-M-3171, Type 3 or BAC5609, Class 1. Apply two layers of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
F-3.20	Dow 17 anodize per ASTM D1732, Class 2 (any Type), or chemical treat per BAC5734 (SOPM 20-43-02), or per AMS-M-3171, Type 3 or per BAC5609.
F-3.21	Dow 17 anodize per ASTM D1732, Class 2 (any Type) or BAC5734 (SOPM 20-43-02).
SRF-3.30	Dow 17 anodize per BAC5734 (SOPM 20-43-02), or Dow 7 treat per AMS-M-3171, Type 3 or per BAC5609. Apply two layers of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
SRF-3.305	Dow 17 anodize per BAC5734 (SOPM 20-43-02), and apply two layers of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
SRF-3.31	Dow 17 anodize per BAC5734 (SOPM 20-43-02), or Dow 7 treat per AMS-M-3171, Type 3 or per BAC5609. Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-3.71	Anodize per ASTM D1732, Class 2 (any Type) or chemical treat per BAC5734 (SOPM 20-43-02), or chemical treat per AMS-M-3171, Type 3 or per BAC5609. Apply three layers of BMS 10-11, Type 1 primer per BAC5774.
SRF-3.71	Dow 17 anodize per BAC5734 (SOPM 20-43-02), or Dow 7 treat per AMS-M-3171, Type 3 or per BAC5609. Apply three layers of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
SRF-3.72	Apply one layer of BMS 10-11, Type 1 and then overcoat with BMS 10-11, Type 2 enamel to a dry film thickness of 0.002-0.006 inch per BAC5738.
F-4.10	Apply no finish.
F-4.11	Cadmium plate per AMS-QQ-P-416, Type 2, Class 3 or per BAC5701.
F-4.13	Nickel plate to 0.0005 inch minimum thickness per AMS-QQ-N-290, Class 2 or BAC5746.
F-4.20	Cadmium plate nonthreaded parts per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2. Cadmium plate threaded parts per AMS-QQ-P-416 (or BAC5701), Type 1, Class 2.
F-4.201	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 2, Class 2.
F-4.202	Canceled. Use F-4.203.
F-4.203	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 1, Class 2.
F-4.21	Tin plate to 0.0003 inch minimum thickness per ASTM B545 or BAC5717.
F-4.22	Brush tin plate to 0.0005 inch minimum thickness per MIL-STD-865 or BAC5849.
SRF-4.30	Cadmium plate per AMS-QQ-P-416 (or BAC5701), Type 2 or 3, Class 2. Apply one layer of BMS 10-11, Type 1 primer per BAC5736.
SRF-4.35	Zinc plate per BAC5700, Type 2, Class 2 or ASTM B633, Type 2, Class Fe/Zn 13. Apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-4.60	Hot tin dip per BAC5717.
F-4.91	Nickel plate to 0.003 inch minimum thickness per AMS-QQ-N-290, Class 2 or BAC5746.
SRF-5.51	Apply two layers of BMS 10-11, Type 1 primer per BAC5736.
F-6.10	Apply no finish.
SRF-6.21	Apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-6.55	Apply AMS-C-83231, Class A, Type 1 coating per MIL-F-18264 or per BAC5880, Type 1, Class 1.
F-8.05	Apply no finish.
F-8.06	Abrasive clean per TT-C-490, Method 1 or BAC5748 if possible. If not possible, solvent/acid clean per TT-C-490, Method 6, or BAC5751, Type 10.
F-8.07	Prepare surface and passivate per AMS-QQ-P-35 or BAC5751, Type 2, or BAC5625, Type 2.
F-8.22	Clean per TT-C-490, Method 1 or 6, or BAC5748, or BAC5751, Type 10. Apply TT-P-1757 primer, color Y to dry film thickness of 0.0003-0-0005 thick per MIL-P-6808 or BAC5774. Overcoat with two layers of A-A-3164 lacquer, Federal Standard 595, color number 37038 per MIL-F-18264 or BAC5706.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
SRF-8.51	Apply one brush layer of BMS 10-11, Type 1 per BAC5736 on indicated surfaces only. Let this dry. This primer can go 0.500 inch out from the edge of the mating part on the interior surface, but wipe the unwanted primer from the exterior surface.
F-9.05	Apply no finish, but temporary protection can be applied for transportation, handling and storage (BAC5034 or SOPM 20-44-02).
F-9.10	No finish is necessary.
SRF-10.15	Apply one brush layer of BMS 10-11, Type 1 primer per BAC5736 on indicated surfaces only. Let this dry. This primer can go 0.500 inch out from the edge of the mating part on the interior surface, but wipe the unwanted primer from the exterior surface.
F-12.12	Apply pretreatment primer MIL-C-8514 to a dry film thickness of 0.0002-0.0005 inch per MIL-C-8507 or BAC5777.
F-12.14	Assemble with a thin layer of MIL-C-16173, Class 2, Grade 2 corrosion preventive compound on both internal and external surfaces of mating threads per BAC5034.
SRF-12.20	Apply one layer (two layers on assemblies containing magnesium alloy) of BMS 10-11, Type 1 primer per BAC5736.
F-12.205	(Now equivalent to SRF-12.205.)
F-12.206	(Now equivalent to SRF-12.206.)
SRF-12.205	Apply one layer of BMS 10-11, Type 1 primer per BAC5736. (Same as F-20.02).
SRF-12.206	Apply two layers of BMS 10-11, Type 1 primer per BAC5736. (Same as F-20.03).
SRF-12.207	Apply one layer of BMS 10-11, Type 1 primer per BAC5736 to each faying surface or the surface indicated. Overspray onto adjacent surfaces is permitted.
F-12.22	On chemically treated or anodized surfaces, apply one layer of BMS 10-11, Type 1 primer per BAC5774. Then apply two layers of BMS 10-100 coating per BAC5797.
F-12.23	Apply BMS 10-20 coating per BAC5793.
F-12.25	Apply one layer of aluminized lacquer A-A-3165 per MIL-F-18264 or BAC5706.
F-12.28	Lubricate installed control cable with BMS 3-24 (Aeroshell Grease 16) per BAC5008 (SOPM 20-50-07).
SRF-12.29	Apply two layers of BMS 10-11, Type 2 enamel, Boeing D-14080 color 702 white gloss per BAC5736.
F-12.346	Apply MIL-S-4383 (3M Company compound EC776SR) corrosion protective coating per BAC5741. (Obsolete).
F-12.35	Apply two layers of BMS 10-100 coating per BAC5797.
F-12.354	Apply MIL-C-8514 pretreatment primer to 0.0002-0.0005 inch thickness per BAC5777 or chemical treat per BAC5626. As an alternative for parts without overlapping surfaces, anodize per BAC5632. Apply one layer of BMS 10-11, Type 1 primer per BAC5736. Then apply BMS 10-100 coating to dry film thickness of 0.002-0.003 inch, per BAC5797.
F-12.355	Canceled. Use F-12.354.
F-12.40	(Now equivalent to SRF-12.40.)

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code

Decoding

SRF-12.40 ^[1]	Brush or swab BMS 10-11, Type 1 primer on all areas of the hole, and also any countersink, counterbore or other recess, and immediately install the fastener or insert, but use corrosion preventive compound MIL-C-11796, Class 3, not primer, if the fastener must be kept easy to remove.
F-12.41 ^[1]	Install with wet BMS 10-11, Type 1 primer per BAC5774.
F-12.415 ^[1]	Install with BMS 10-11, Type 1 primer, or BAC5710, Type 59 primer, wet or dry, per BAC5736.
F-12.42	Install antifriction (rolling element) and friction (sliding element) bearings with a thin layer of MIL-G-23827 grease applied to mating surfaces of bearing and housing per BAC5008.
F-12.423	Apply a thin layer of MIL-G-23827 grease per BAC5008 (SOPM 20-50-07) to all surfaces before installation.
F-12.43	Apply a thin layer of MIL-L-7870 oil per BAC5008 (SOPM 20-50-07) to all surfaces at installation.
F-12.44	Apply MIL-C-11796, Class 3 corrosion preventive compound per BAC5034 to the mating surfaces of press fits, and also scarf joints and other surfaces that must have protection.
SRF-12.46 ^[1]	Assemble with wet BMS 10-11, Type 1 primer.
F-12.51	Apply two layers of A-A-3164 lacquer, FED-STD-595 color 37038 gray per BAC5706.
F-12.52	Apply solid dry film lubricant MIL-L-46010 per BAC5811, Type 6, Class 4 (SOPM 20-50-08).
F-12.62	Apply two layers of A-A-3164 lacquer, FED-STD-595 color 36251 per BAC5706.
SRF-12.63	Apply one layer of BMS 10-11, Type 2 enamel, color 707 gray gloss per BAC5736. (Same as F-21.02)
F-12.64	Apply one layer of A-A-3165 lacquer, tinted to be white gloss color 702, per BAC5706.
SRF-12.64	Apply one layer of BMS 10-11, Type 2 enamel color 702 white to 0.001-0.002 inch dry film thickness per BAC5736 (SOPM 20-41-02).
F-12.6599	Apply primer MIL-PRF-23377, Type 1, Class C, or MIL-PRF-85582, Type 1 Class C1 or C2, to a dry film thickness of 0.0006-0.0009 inch per BAC5807.
F-12.75	Apply one layer of color 515 black wrinkle finish enamel MIL-E-5558, Type 1 or 2 per BAC5706. (Obsolete).
F-12.78	Canceled. Use F-12.52.
F-12.91	Apply BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02) to aluminum adhesive bonded assemblies, but not on the exterior surfaces of clad skins.
SRF-12.915	Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02) to completed adhesive-bonded assemblies with or without magnesium, but not on exterior surfaces of clad skins. This primer layer is not necessary on the interior surfaces of stiffeners coated with BMS 5-15 or BMS 5-42 liquid adhesive.
F-12.964	Apply two layers of A-A-3164 lacquer, FED-STD-595 color 34424, per BAC5706.
SRF-14.01	Clear chemical treat and apply BMS 10-11, Type 1 primer as follows:

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code

Decoding

1. If the overhaul instructions specify skin quality, apply clear chemical conversion coating to exterior surfaces per BAC5719, Class B (SOPM 20-43-03). Obey the appearance requirements of D6-9002.

2. Apply chemical conversion coating to interior surfaces per MIL-C-5541, Class 1A or BAC5719, Class A or C (SOPM 20-43-03).

Optional: Parts with exterior skin quality surfaces can be clear chemical conversion coated per BAC5719, Class B on all surfaces (SOPM 20-43-03).

3. Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02) to interior surfaces only.

SRF-14.011

Exterior Surfaces: Clear chemical treat per BAC5719 (SOPM 20-43-03).

Interior Surfaces: Chemical treat per BAC5719 (SOPM 20-43-03) or MIL-C-5541 and apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).

OPTIONAL FOR MODEL 747 ONLY

Exterior Surfaces: Do not apply the finish on detail parts or assemblies. Refer to the overhaul instructions for the final finish.

Interior Surfaces: Chemical treat per BAC5719 (SOPM 20-43-03) or MIL-C-5541 and apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).

Optional: Apply one layer of BMS 5-89 corrosion inhibiting adhesive primer per BAC5514-589 (SOPM 20-50-14).

SRF-14.012

Exterior Surfaces: Apply colorless chemical coating per BAC5719 (SOPM 20-43-03). You can use a prebonding deoxidizer on the exterior surfaces.

Interior Surfaces: Chemical treat per BAC5719 (SOPM 20-43-03) or MIL-C-5541 and apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).

SRF-14.02

On exterior skins, treat faying surfaces to be bonded with BMS 5-89 primer per BAC5514-589 (SOPM 20-50-14).

SRF-14.03

Use SRF-14.01.

F-14.05

Use F-17.40.

SRF-14.06

Use F-20.201.

F-14.061

Solvent clean the countersink and counterbore surfaces and apply BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02). Let this dry before fastener installation.

SRF-14.08

Before adhesive bonding, apply mixed-primer-system finish as follows:

1. Clean aluminum surfaces per BAC5514. Mask skin quality surfaces.

NOTE: A skin quality surface is a clad aluminum surface that can be used as an exterior skin.

2. (Optional) Chromic acid anodize per BAC5514, or anodize per BAC5555.

3. Apply a smooth wet continuous coat of EC2320 adhesive (3M Company, V76381) for a dry film thickness of 0.0002 inch. Do not apply this adhesive on skin quality surfaces, unless the surfaces are in the bond area.

4. Let the adhesive dry 15 minutes minimum.

20-41-01

**STANDARD OVERHAUL PRACTICES MANUAL****Code****Decoding**

5. Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02). Do not apply the primer on skin quality surfaces, unless the surfaces are in the bond area.

6. Let the primer dry 15 minutes maximum.

7. Bake at 225-250°F for 80-100 minutes. This bake can be omitted if the parts will be bonded within 96 hours at 225-350°F.

8. Manually apply Alodine 1000 per BAC5719, Method 2, Class B (SOPM 20-43-03) to the skin quality surfaces.

SRF-14.081

Canceled. Use SRF-14.08.

F-14.082

Seal the chromic acid anodize with Alodine 1000 as follows:

1. General

A. You must keep the unsealed anodize from contamination. Wear clean white gloves when you touch the parts. Otherwise, keep the bonded parts covered at all times with polyethylene sheets.

B. The seal must be done within 24 hours after the parts are bonded.

2. Alkaline clean and rinse per BAC5749 (SOPM 20-30-03).

3. Put the parts in Alodine 1000 solution for 3-4 minutes.

4. Rinse and dry.

SRF-14.09

Bond and finish per BAC5514.

F-14.091

(Now equivalent to SRF-14.09).

F-14.111

Chrome plate, matte finish (nonreflective)

1. Apply nondirectional matte chromium plate finish on indicated surface(s). (Underplate of nickel is permitted.)

2. The indicated surface(s) must match color chip BAC9250 for color and appearance.

F-14.13

Apply MIL-C-16173, Grade 1 corrosion preventive compound to all ID bore surfaces.

F-14.135

Apply MIL-C-16173, Grade 2 corrosion preventive compound to all ID bore surfaces.

F-14.14

Use F-16.12.

F-14.15

Use F-15.33.

F-14.16

Cadmium plate (0.0002-0.0003 inch) per AMS-QQ-P-416, Type 2, Class 3.

F-14.17

Cadmium plate (0.0002-0.0003 inch) per AMS-QQ-P-416, Type 1, Class 3.

F-14.18

Use F-15.44.

F-14.19

Nickel plate per AMS-QQ-N-290, Class 2.

F-14.20

Chrome plate, satin finish

1. Apply a directional, coarse grain buff satin finish with Lea Compound Grade L of 120-grit aluminum oxide, or equivalent, on the surface and in the direction shown by overhaul instructions.

2. Nickel plate 0.0005-inch minimum thickness.

3. Do Lea Grade L satin finish as in step 1.

20-41-01

**STANDARD OVERHAUL PRACTICES MANUAL****Code****Decoding**

4. Chromium plate 0.0003-inch minimum thickness.
5. Bake at 250°F for 30 minutes.
6. The indicated surface must agree with metal finish standard BAC9890 for color and appearance.

F-14.21

Chrome plate, mirror finish

1. Buff to mirror finish.
2. Copper plate 0.0005 inch minimum thickness.
3. Buff to mirror finish.
4. Nickel plate 0.0005 inch minimum thickness.
5. Chromium plate 0.00002 inch minimum thickness.
6. The surface must agree with metal finish standard BAC9020 for color and appearance.

F-14.221

Decorative satin finish (medium), anodized

1. Apply a directional, medium grain buff, satin finish with 180-grit aluminum oxide or equivalent (surface and direction to be indicated by overhaul instructions).
2. Sulfuric acid anodize
3. The surface must agree with metal finish standard BAC9121 for color and appearance.

F-14.222

Decorative satin finish (medium)

1. Apply a directional, medium grain buff, satin finish with 180-grit aluminum oxide, or equivalent.
2. The buffed surface must agree with metal finish standard BAC9137 for color and appearance.

F-14.223

Decorative satin finish (coarse)

1. Apply directional, coarse grain buff, satin finish with a medium S/C grit Norton Bear-Tex wheel or equivalent (surface and direction to be indicated by the overhaul instructions). Blend coarse grain finish with Scotch Brite Pad No. 7446 or equivalent.
2. Chemical treat in accordance with BAC5719, Class B (SOPM 20-43-03).
3. The surface must agree with metal finish standard BAC 93736 for color and appearance.

F-14.23

Mirror finish with clear coating.

1. Buff to mirror finish.
2. Apply clear coating per BAC5755, Type 11.
3. The surface must agree with metal finish standard BAC9026 for color and appearance.

F-14.231

Mirror and satin finish with clear coating.

1. Buff the area to mirror finish. Or apply directional coarse-grain buff satin finish with 120-grit aluminum oxide, or equivalent. The overhaul instructions will indicate the surface and the direction.

20-41-01

**STANDARD OVERHAUL PRACTICES MANUAL****Code****Decoding**

2. Apply clear coating per BAC5755, Type 11.
3. The surface must agree with metal finish standard BAC9024 for color and appearance.
- SRF-14.232 Apply Alodine 1200 and two layers BMS 10-11, Type 1 primer, per BAC5745 (obsolete). Or chemical treat per MIL-C-5541 (colored film) and apply two layers of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
- F-14.25 Anodize, decorative
1. Apply directional coarse grain buff satin finish with 120-grit aluminum oxide, or equivalent (surface and direction to be indicated by overhaul instructions).
2. Sulfuric acid anodize.
3. The surface must agree with metal finish standard BAC901 for color and appearance.
- F-14.251 Anodize, decorative special
1. Apply directional coarse grain buff satin finish with 120 grit aluminum oxide, or equivalent (surface and direction to be indicated by overhaul instructions).
2. Sulfuric acid anodize.
3. The surfaces must agree with metal finish standard BAC901A for color and appearance.
- F-14.26 Clear baking enamel for 356 aluminum
1. Apply directional coarse grain buff satin finish with 120 grit aluminum oxide or equivalent (surface and direction to be indicated by overhaul instructions).
2. Apply clear coating per BAC5755, Type 11.
3. The surface must agree with metal finish standard BAC9025 for color and appearance.
- F-14.261 Clear baking enamel for A380 aluminum
1. Apply a directional, coarse grain buff satin finish with Lea Compound Grade L of 120-grit aluminum oxide, or equivalent, on the surface and in the direction shown by overhaul instructions.
2. Apply clear coating per BAC5755, Type 11.
3. The surface must agree with metal finish standard BAC92032 for color and appearance.
- F-14.29 Satin finish, directional grain aluminum alloy anodize (sulfuric acid) decorative
1. Apply directional coarse grain buff satin finish with 120-grit aluminum oxide or equivalent (surface and direction to be indicated by overhaul instructions).
2. Sulfuric acid anodize all over.
3. The surface must agree with metal finish standard BAC990 for color and appearance.
- F-14.2974 Canceled. Use F-14.2977.
- F-14.2976 Anodize, decorative special, walnut brown brushed finish for 5052 aluminum

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
	1. Apply directional coarse grain buff satin finish with 120 grit aluminum oxide or equivalent (surface and direction to be indicated by overhaul instructions). 2. Apply Duranodic integral anodize process all over (dyed coating not acceptable). 3. The surface must agree with metal finish standard BAC80399 for color and appearance.
F-14.2977	Aluminum alloys 2024, 6061 and 7075 Non-Clad material 1. Apply a directional satin finish with 180 grit aluminum oxide or equivalent. 2. Sulfuric acid anodize all over and dye to be color BAC80893 dark bronze.
F-14.2992	Anodize decorative, nondirectional 1. Etch to get a nondirectional surface finish. 2. Sulfuric acid anodize. 3. The surface must agree with metal finish standard BAC9512 for color and appearance.
F-14.2998	With medium Scotch-Brite or equivalent, make a smooth nondirectional surface finish. Then sulfuric acid anodize per BAC5022, Grade C, Class 1. The surface must agree with metal finish standard BAC93803 for finish and appearance.
SRF-14.52	Skydrol resistant finish 1. Apply BMS 5-126, Type 2, Class 1 epoxy polyamide adhesive as a sealer per BAC5710, Type 40. 2. Apply BMS 10-11, Type 1 epoxy primer and BMS 10-11, Type 2 epoxy enamel, color BAC707 gray gloss, per BAC5736 (SOPM 20-41-02).
F-14.61	Prepare surface and apply 2 coats of Sherwin-Williams Hi-Speed lacquer, semi-gloss color BAC711, per BAC5755.
F-14.64	Prepare surface and apply two layers of Sherwin-Williams Hi-Speed lacquer, Boeing color 712 white, semi-gloss per BAC5755.
SRF-14.65	Prepare surface and apply one layer of BMS 10-11, Type 1 yellow epoxy primer and one layer of BMS 10-11, Type 2 epoxy enamel, Boeing color 705 gray, semi-gloss per BAC5736 (SOPM 20-41-02).
F-14.66	Apply two layers of vinyl coating per BAC5755, Type 9.
F-14.661	Apply flexible urethane coating per BAC5755, Type 15.
F-14.67	Canceled. Use SRF-14.672.
F-14.671	Canceled. Use SRF-14.672.
SRF-14.672	Prepare the surface per BAC5837 (SOPM 20-10-06). But prepare interior plastic parts per BAC5322.
SRF-14.673	Canceled. Use SRF-14.672.
F-14.674	Apply one layer of BMS 10-21, Type 2 coating per BAC5639 (SOPM 20-10-06).

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-14.675	1. Prepare the surface per BAC5837 (SOPM 20-10-06). 2. Apply one layer of BMS 10-21, Type 2 coating per BAC5639 (SOPM 20-10-06). 3. Apply 1 layer of BMS 10-103, Type 1 primer per BAC5325, or one layer of BMS 10-79 Type 2 or 3 primer per BAC5882.
F-14.676	Prepare the surface per BAC5322, Type 2, Class 1.
F-14.677	Apply one layer of BMS 10-60, Type 2 gloss enamel, color 707 gray, per BAC5845. Do not apply primer before you apply this enamel.
F-14.6771	Apply BMS 10-60, Type 2 gloss enamel, color 707 gray, per BAC5845. Do not apply primer before you apply this enamel.
F-14.678	Prepare the surface per BAC5322, Type 2, Class 2.
F-14.6781	Prepare the surface per BAC5322, Type 1, Class 2.
F-14.6782	Prepare the surface per BAC5322, Type 4, Class 2.
F-14.679	Prepare the surface per BAC5837 (SOPM 20-10-06), but do not use surfacer. Pinhole filler can be used to fill small surface defects, and putty can be used to fill local areas only, as necessary.
SRF-14.68	Canceled. Use F-14.685.
F-14.682	Apply Astrocoat 8200/8201B primer and Astrocoat 8000/8100 rain erosion coating (V60003) per BAC5880 (SOPM 20-44-03).
F-14.683	Apply polyurethane rain erosion resistant coating per BAC5880, Type 1, Class 2 (SOPM 20-44-03).
F-14.684	Apply 10-14 mils AMS-C-83445, Class 1 (Replaces MIL-C-83445, Class 1) rain erosion-resistant coating per BAC5880, Type 1, Class 2 (SOPM 20-44-03).
F-14.685	Apply one layer of BMS 10-21, Type 3 coating per BAC5639 (SOPM 20-10-06).
F-14.686	Apply polyurethane rain-erosion-resistant coating, color 707 gray, per BAC5880, Type 1, Class 5 (SOPM 20-44-03).
F-14.687	Apply polyurethane rain-erosion-resistant coating per BAC5880, Type 4 (SOPM 20-44-03).
SRF-14.69	Apply one layer of BMS 10-11, Type 2 enamel, color BAC769 gray, flat as a special primer per BAC5755. (obsolete)
F-14.692	Apply one layer BMS 10-103, Type 1 primer per BAC5325.
F-14.693	Apply two layers BMS 10-103, Type 1 primer per BAC5325.
F-14.695	Apply one layer BMS 10-103 Type 1 primer per BAC5325 to the fasteners or fastener rows.
F-14.696	Prepare the surface per BAC5837 (SOPM 20-10-06).
F-14.80	Stainless steel - satin finish (for nonstructural decorative applications only). 1. Apply directional coarse grain satin finish with 120-grit adhesive on the surface and in the direction shown by the overhaul instructions. 2. The indicated surface must agree with color chip BAC906 for color and appearance.
F-14.802	Stainless steel satin finish (for nonstructural decorative applications only).

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
	1. Clean per BAC5625 (SOPM 20-30-03).
	2. Apply directional coarse grain satin finish with 120-grit adhesive on the surface and in the direction shown by the overhaul instructions.
SRF-14.87	Apply phosphate-fluoride treatment to titanium per BAC5861 and then apply high temperature coating per BAC5710, Type 24.
F-14.871	Apply high temperature coating per BAC5710, Type 24.
F-14.88	Apply phosphate-fluoride coating to titanium parts per BAC5861. Optional for titanium parts to be painted: Abrasive clean parts per BAC5748, Type 2, Class 1 or 2 (SOPM 20-30-03), or clean per BAC5753, Method 2 (SOPM 20-30-03). Paint the parts within 4 hours.
F-14.881	Apply phosphate-fluoride coating to titanium parts per BAC5861.
F-14.882	Abrasive clean titanium parts per BAC5748, Type 2, Class 1 or 2 (SOPM 20-30-03), phosphate fluoride treat them per BAC5861, or clean per BAC5753, Method 2 (SOPM 20-30-03). Paint the parts within 4 hours.
F-14.886	Apply BMS 14-4, Type 3 coating per BAC5840 (SOPM 20-50-13).
F-14.887	Apply phosphate-fluoride coating (BAC5861) or prepare the surface (BAC5753, Method 2). No substitutions permitted.
F-14.888	Etch (BAC5753, Method 2).
F-14.89	Canceled. Use F-15.43.
F-14.891	Canceled. Use F-15.43.
F-14.892	Canceled. Use F-15.43.
F-14.90	Prepare the surface and apply two layers of Sherwin Williams Hi-Speed Lacquer, Boeing color 704, flat per BAC5755 (SOPM 20-41-04).
F-14.902	Prepare the surface and apply one layer of metallic Hi-Speed lacquer, Boeing color 904 per BAC5755 (SOPM 20-41-04).
F-14.903-XXX ^{*[2]}	Superseded. Use F-22.32-XXX.
SRF-14.903-XXX	Use F-21.26-XXX
F-14.9031-XXX ^{*[2]*[3]}	Lacquer, special flat, textured Prepare the surface and apply textured Hi-Speed flat lacquer (1-1-1-XXX, Texture A) per BAC5755.
SRF-14.9031-XXX ^{*[2]}	Canceled. Use F-22.26-XXX
SRF-14.9032-XXX ^{*[2]}	Canceled. Use F-22.26-XXX
F-14.904-XXX ^{*[2]*[3]}	Lacquer, special semigloss Prepare the surface and apply two layers of Hi-Speed semigloss lacquer (1-1-2-XXX, 1-7-2-XXX, 1-72-2-XXX) per BAC5755.
SRF-14.904-XXX ^{*[2]}	Use F-21.27-XXX
SRF-14.905-XXX ^{*[2]}	Use F-21.28-XXX
F-14.905-XXX ^{*[2]*[3]*[4]}	Lacquer, special gloss

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code

Decoding

Prepare the surface and apply two layers of Hi-Speed gloss lacquer (1-1-3-XXX, 1-7-3-XXX, 1-71-3-XXX) per BAC5755.

F-14.907 ^{*[3]}

Lacquer, dull dark gray

Clean the epoxy primed surfaces with toluene. Lightly sand the primer with 320-grit or finer abrasive paper and then wipe with methyl isobutyl ketone. Apply two layers of Sherwin Williams Hi-Speed Dark Gray Flat Lacquer (1-1-1-703) per BAC5755.

F-14.908-XXX

Canceled; use F-21.13-XXX (for interior only)

F-14.909

Canceled; use F-21.13-701 (for interior only)

F-14.91 ^{*[3]}

Lacquer, special dark gray

Prepare the surface and apply two layers of Sherwin-Williams Hi-Speed Dark Gray Flat Lacquer (1-1-1-703) per BAC5755.

F-14.92 ^{*[3]}

Lacquer, special white

Prepare surface and apply two coats of Sherwin-Williams Hi-Speed White Flat Lacquer (1-1-1-700) per BAC5755.

F-14.93 ^{*[3]}

Lacquer, special light gray

Prepare surface and apply two coats of Sherwin-Williams Hi-Speed Light Gray Flat Lacquer (1-1-1-705) per BAC5755.

F-14.941-XXX ^{*[2]}

Apply BMS 10-55 semigloss water emulsion paint per BAC5755.

F-14.942-XXX ^{*[2]}

Apply BMS 10-55 flat water emulsion paint per BAC5755, Type 1.

Repair of BAC5019 anodic surface.

SRF-14.957

Manually apply colorless chemical coating per BAC5719. Apply one coat of BMS 10-11, Type 1 primer and one coat of BMS 10-11, Type 2 enamel, per BAC5736 (SOPM 20-41-02). Use Boeing color to match alloy as follows:

2024 Aluminum - use BAC7025 gray, semigloss. All other aluminum - use BAC7051 gray, semigloss.

SRF-14.96

Canceled. Use F-21.27-751.

SRF-14.9621

Canceled. Use SRF-14.9623.

F-14.9622

Apply abrasion resistant molybdenum disulfide coating per BAC5710, Type 39, Class A (SOPM 20-44-01).

SRF-14.9622

Use F-14.9622

F-14.9623

Apply abrasion resistant molybdenum disulfide coating per BAC5710, Type 39, Class B (SOPM 20-44-01).

SRF-14.9623

Use F-14.9623

F-14.9624

Apply BMS 10-86, Type 1 or 2 teflon filled coating, color BAC700 white per BAC5710, Type 27 (SOPM 20-44-01).

SRF-14.9624

Use F-14.9624

F-14.9625

Apply BMS 10-86, Type 1, or Type 2 teflon filled coating, color BAC707 gray per BAC5710, Type 27 (SOPM 20-44-01).

SRF-14.9625

Use F-14.9625

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-14.9627	Use F-19.81
F-14.963	Apply aluminized epoxy primer per BAC5755, Type 10.
SRF-14.963	Use F-14.963
SRF-14.964	Magnesium drums, pulleys, and quadrants 1. Anodize per BAC5734 or chemical treat per AMS-M-3171, Type 3 or BAC5609, on all surfaces of the part. 2. Apply one layer of BMS 10-11, Type 1 primer to all surfaces of the part, one layer of BMS 10-11, Type 2 enamel, color BAC707 gray to areas other than grooves, and multiple layers of BMS 10-11, Type 2 enamel, color BAC707 gray to the grooves per BAC5738.
SRF-14.967	Use F-21.27-7025
F-14.97	Lacquer, black Prepare the surface and apply two layers of Sherwin-Williams Hi-Speed Flat Black Lacquer (1-1-1-706) ^{*[3]} per BAC5755.
F-14.971	Use F-14.972
F-14.972	Apply clear coating per BAC5755, Type 11.
SRF-14.975	Apply Prestec 2381 (White) per BAC5710, Type 37.
SRF-14.976	Apply Prestec 2301 (Black) per BAC5710, Type 37.
SRF-14.981-XXX ^{*[2]}	Canceled.
F-14.9812	Apply BMS 10-60, Type 1 Boeing color 702 white gloss enamel per BAC5845.
SRF-14.9812	Use F-14.9812.
F-14.9813	Apply BMS 10-60, Type 1 Boeing color 707 gray gloss enamel per BAC5845.
SRF-14.9813	Use F-14.9813
F-14.9814	Apply BMS 10-60, Type 1 Boeing color 7025 gray gloss enamel per BAC5845.
SRF-14.9814	Use F-14.9814
F-14.9815-XXX ^{*[2]}	Apply BMS 10-60, Type 1 gloss enamel per BAC5845.
SRF-14.9815-XXX ^{*[2]}	Use F-14.9815-XXX
F-14.9816-XXX ^{*[2]}	Apply BMS 10-60, Type 1 semigloss enamel per BAC5845.
SRF-14.9816-XXX ^{*[2]}	Use F-14.9816-XXX
F-14.9817-XXX ^{*[2]}	Apply BMS 10-60, Type 1 flat enamel per BAC5845.
SRF-14.9817-XXX ^{*[2]}	Use F-14.9817-XXX
F-14.9818	Apply BMS 10-60, Type 1 Boeing color 707 gray gloss enamel per BAC5845, but with a dry film thickness of 0.002-0.003 inch.
F-14.9843-XXX ^{*[2]}	Canceled.
F-14.9844-XXX ^{*[2]}	Canceled.
F-14.9845-XXX ^{*[2]}	Canceled.
F-14.9855-XXX ^{*[2]}	Canceled.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code

Decoding

F-14.9856-XXX ^[2]

Canceled.

F-14.9861-XXX ^[2]

Apply Alodine 1000 pretreatment, BMS 10-79 primer and BMS 10-60, Type 2 gloss enamel.

F-14.9862-XXX ^[2]

Apply Alodine 1000 pretreatment, BMS 10-79 primer and BMS 10-60, Type 2 flat enamel.

F-14.9863-XXXX ^[2]

Prepare the surface and apply one layer of BMS 10-79, Type 2 primer per BAC5882 (SOPM 20-44-04) and one layer of BMS 10-60, Type 2 enamel per BAC5845.

F-14.9864-XXX

Prepare the surface and apply one layer of BMS 10-79, Type 2 primer per BAC5882 (SOPM 20-44-04) and BMS 10-60, Type 2 semigloss enamel per BAC5845.

F-14.9865-XXX ^[2]

Prepare the surface and apply one layer of BMS 10-79 primer per BAC5882 (SOPM 20-44-04) and two layers of BMS 10-60, Type 2 gloss enamel per BAC5845 but with the dry film thickness to be 2.0-3.0 mils.

F-14.9874-XXX ^[2]

Apply BMS 10-72, Type 6 enamel.

F-14.9875-XXX ^[2]

Chemical treat. Apply BMS 10-72, Type 8 primer and BMS 10-72, Type 8 gloss enamel.

F-14.9876-XXX ^[2]

Chemical treat. Apply BMS 10-72, Type 8 primer and BMS 10-72, Type 8 flat enamel.

F-14.9877-XXX ^[2]

Apply BMS 10-72, Type 8 primer and BMS 10-72, Type 8 gloss enamel.

F-14.9878-XXX ^[2]

Apply BMS 10-72, Type 8 primer and BMS 10-72, Type 8 flat enamel.

F-14.9879-XXX ^[2]

Superseded. Use F-20.63-XX.

F-14.9880-XXX ^[2]

Apply BMS 10-72, Type 6 primer and BMS 10-72, Type 6 enamel.

SRF-14.991

Use F-20.09.

SRF-14.993-XXX

Canceled.

SRF-14.9931-XXX

Canceled.

SRF-14.9932-XXX

Canceled.

F-14.995

Yellow epoxy primer

NOTE: If the surfaces are not aluminum, go to step 2.

1. If there are scratches or other bare surfaces remaining after the application of the first coat of primer, chemical treat them per BAC5719.

2. Clean and reactivate the primed surfaces per BAC5736 (SOPM 20-41-02).

3. Apply one layer of BMS 10-11, Type 1 yellow primer per BAC5736 (SOPM 20-41-02). When you apply this primer to an assembly, paint only the surfaces that can be seen directly or with a mirror.

SRF-14.995

Use F-14.995.

F-14.996

Touch-up of scratched or damaged primer

NOTE: If the surfaces are not aluminum, go to step 2.

1. If there are scratches or other bare surfaces remaining after the application of the first coat of primer, chemical treat them per BAC 5719.

2. Clean and reactivate the primer around the bare area per BAC5736 (SOPM 20-41-02).

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code

Decoding

	3. Apply one layer of BMS 10-11, Type 1 yellow primer to bared area and over the reactivated primer per BAC5736 (SOPM 20-41-02).
SRF-14.996	Use F-14.996.
F-14.9961	Touch-up of unprimed fastener heads and scratched or damaged primer. NOTE: If the surfaces are not aluminum, go to step 2. 1. If there are scratches, bare fastener heads, or other bare surfaces remaining after application of the first coat of primer, chemical treat them per BAC5719. 2. Clean and reactivate the primer per BAC5736 (SOPM 20-41-02) in the areas that will be painted as specified by step 3. 3. Apply one layer of BMS 10-11, Type 1 yellow primer to the fastener heads, scratches, and bared surfaces, per BAC5736 (SOPM 20-41-02). Overspray must be only on the reactivated surfaces.
SRF-14.9961	Use F-14.9961.
F-14.9962	(Same as F-14.9961 but also applies to collars.)
SRF-14.9962	Use F-14.9962.
F-14.9963	Touch-up before final enamel application 1. Lightly sand and solvent clean coatings immediately adjacent to the areas to be touched-up. 2. On aluminum surfaces, if there are scratches or other bare surfaces, chemical treat them per BAC5719. 3. Apply two layers of BMS 10-79, Type 3 primer to all scratches, bare areas and bare fastener ends per BAC5882. 4. Apply one layer of MIL-C-83286 enamel to all surfaces without enamel, per BAC5893. Use a color to agree with the adjacent areas.
F-14.9964	1. Clean and reactivate the primer per BAC5736 (SOPM 20-41-02) in the areas that will be painted. 2. Apply one layer of BMS 10-103, Type 1 primer to the scratches and bare surfaces per BAC5325. Overspray must be only on the reactivated surfaces.
F-14.9965	1. Clean and reactivate the primer per BAC5736 (SOPM 20-41-02) in the areas that will be painted. 2. Apply one layer of BMS 10-123, Type 1 primer to the scratches and bare surfaces per BAC5357. Overspray must be only on the reactivated surfaces.
F-14.9966	Touch-up before final enamel application 1. On aluminum surfaces, if there are scratches or other bare surfaces, chemical treat them per BAC5719, Type 2, Class A. 2. Clean and reactivate the primer per BAC5736 (SOPM 20-41-02) in the areas that will be painted. 3. Apply one layer of BMS 10-20, Type 2 primer to the scratches and bare surfaces per BAC5793. Overspray must be only on the reactivated surfaces.
F-14.9967	1. Not necessary when the fastener end is cap, brush, or fillet sealed.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code

Decoding

	2. Clean and reactivate the primer per BAC5736 (SOPM 20-41-02) in the areas that will be painted.
	3. Apply one layer of BMS 10-20, Type 2 primer to the fastener ends per BAC5793. Overspray must be only on the reactivated surfaces.
SRF-14.998	Apply Dow Corning Silicone Coating 3145 per BAC5710, Type 42.
F-15.01	Cadmium-titanium plate and apply chromate post-plate treatment per BAC5804 (SOPM 20-42-02).
F-15.02	Cadmium plate (0.0002-0.0004 inch thick) per AMS-QQ-P-416 (or BAC5701), Type 2, Class 3 (SOPM 20-42-05).
F-15.03	Chromium plate per AMS-QQ-C-320, Class 2A or BAC5709, Class 2 (SOPM 20-42-03).
F-15.031	Chromium plate per AMS-QQ-C-320, Class 2 or BAC5709, Class 2.
F-15.04	Chromium plate per BAC5709 (SOPM 20-42-03).
F-15.05	Cadmium plate (0.0002-0.0004 inch) per AMS-QQ-P-416, Type 1, Class 3 (SOPM 20-42-05).
F-15.06	Cadmium plate per AMS-QQ-P-416, Type 2, Class 2 or BAC5701, Type 2, Class 2 (SOPM 20-42-05).
F-15.07	Silver plate (0.0005 inch minimum plating thickness) per BAC5715 or AMS-QQ-S-365, each Type 1 or 2, Grade A (SOPM 20-42-06).
F-15.08	Electroless nickel plate (0.0015-inch minimum plating thickness) and bake per BAC5728 (SOPM 20-42-08).
F-15.09	Hot tin dip per BAC5717, Type 2.
F-15.10	Electrolytic nickel plate and bake 3 hours minimum at 350-400°F per AMS-QQ-N-290 or BAC5746, Type 1 (SOPM 20-42-09).
F-15.11	Use F-15.370.
F-15.20	Apply BMS 10-67, Type 2 (Aluminum Bronze) per BAC5851 (SOPM 20-10-05) to the thickness specified by overhaul instructions.
F-15.21	Apply detonation gun coating of tungsten-carbide-cobalt LW-1N40 (Union Carbide, V4G314) to thickness specified by overhaul instructions.
F-15.23	Cadmium plate (0.0002-0.0004 inch thick) per AMS-QQ-P-416, Type 2, Class 3, or BAC5701, Type 2, Class 3 (SOPM 20-42-05), and bake 5-8 hours at 250-300°F.
F-15.24	Canceled. Use F-15.06.
F-15.25	Use F-15.02.
F-15.28	Apply diffused nickel-cadmium plate per AMS 2416.
F-15.29	Stylus cadmium plate per BAC5854 (SOPM 20-42-10).
F-15.30	Canceled. Use F-16.05.
F-15.32	Cadmium-titanium plate (0.0005-0.0007 inch thick), and apply chromate post plate treatment per BAC5804 (SOPM 20-42-02).
F-15.33	Nickel plate per BAC5746, Type 3 (SOPM 20-42-09).
F-15.34	Chrome plate and bake per BAC5709, Class 3 (SOPM 20-42-03).

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-15.35	Cadmium-titanium plate per BAC5804 (SOPM 20-42-02), 0.0005-inch minimum thickness on all surfaces.
F-15.350	Apply BMS 10-67, Type 15 (cobalt alloy T-400) coating per BAC5851, Class 5, Grade A or Grade B to the thickness specified.
F-15.3501	Apply BMS 10-67, Type 15 (cobalt alloy T-400) coating per BAC5851, Class 5, Grade B to the thickness specified.
F-15.351	Apply BMS 10-67, Type 19 (self fluxing 50% tungsten carbide-cobalt 50% nickel-chrome-silica) coating per BAC5851, Class 5, Grade A or Grade B to the thickness specified.
F-15.3511	Apply BMS 10-67, Type 19 (self fluxing 50% tungsten carbide-cobalt 50% nickel-chrome-silica) coating per BAC5851, Class 5, Grade B to the thickness specified.
F-15.36	Cadmium plate (0.0003-0.0005 inch thick) per AMS-QQ-P-416 or BAC5701, each Type 2, Class 2 (SOPM 20-42-05).
F-15.360	1. Apply BMS 10-67, Type 1 (tungsten carbide) per BAC5851, Class 4 (SOPM 20-10-05) to the thickness specified. 2. Finish per BAC5855 (SOPM 20-10-05) to the surface finish specified.
F-15.3601	Apply BMS 10-67, Type 1 (tungsten carbide-cobalt) coating per BAC5851, Class 4, Grade B to the thickness specified.
F-15.361	1. Apply BMS 10-67, Type 15 (cobalt alloy T-400) per BAC5851, Class 4 to the thickness specified. 2. Finish per BAC5855 to the surface finish specified.
F-15.370	1. Apply BMS 10-67, Type 1 (tungsten carbide-cobalt) per BAC5851, Class 1 (SOPM 20-10-05) to the thickness specified. 2. Finish per BAC5855 (SOPM 20-10-05) to the surface finish specified.
F-15.371	1. Apply BMS 10-67, Type 15 (cobalt alloy T-400) per BAC5851, Class 1 to the thickness specified. 2. Finish per BAC5855 (SOPM 20-10-05) to the surface finish specified.
F-15.372	1. Apply BMS 10-67, Type 14 (copper-nickel-indium alloy) per BAC5851, Class 1 to the thickness specified. 2. Finish per BAC5855 (SOPM 20-10-05) to the surface finish specified.
F-15.373	Apply BMS 10-67, Type 6 (chromium oxide) per BAC5851 Class 1 (SOPM 20-10-05) to the thickness specified.
F-15.380	1. Apply BMS 10-67, Type 1 (tungsten carbide) coating per BAC5851, Class 2, 3, or 4 to the thickness specified. 2. Finish per BAC5855 (SOPM 20-10-05) to the surface finish specified.
F-15.3801	Apply BMS 10-67, Type 1 (tungsten carbide-cobalt) coating per BAC5851, Class 2, Grade B or Class 3, Grade B, or Class 4, Grade B to the thickness specified.
F-15.381	1. Apply BMS 10-67, Type 15 (cobalt alloy T-400) per BAC5851, Class 2, 3, or 4 to the thickness specified. 2. Finish per BAC5855 (SOPM 20-10-05) to the surface finish specified.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-15.384	1. Apply BMS 10-67, Type 17 (tungsten carbide-cobalt-chrome) coating per BAC5851, Class 2 to the thickness specified.
	2. Finish per BAC5855 (SOPM 20-10-05) to the surface finish specified.
F15.3841	Apply BMS 10-67, Type 17 (tungsten carbide-cobalt-chrome) coating per BAC5851, Class 2, Grade B to the thickness specified.
F-15.385	Apply BMS 10-67, Type 1 (tungsten carbide-cobalt) per BAC5851, Class 2, 3, or 4 or BMS 10-67, Type 17 (tungsten carbide-cobalt-chrome) per BAC5851, Class 2 or Class 4 to the thickness specified.
F-15.386	Apply BMS 10-67, Type 17 (tungsten carbide-cobalt-chrome) per BAC5851, Class 2 or Class 4 to the thickness specified.
F-15.3861	Apply BMS 10-67, Type 17 (tungsten carbide-cobalt-chrome) coating per BAC5851, Class 2, Grade B or Class 4, Grade B to the thickness specified.
F-15.387	Apply BMS 10-67, Type 1 (tungsten carbide-cobalt) per BAC5851, Class 2 to the thickness specified.
F-15.3871	Apply BMS 10-67, Type 1 (tungsten carbide-cobalt) coating per BAC5851, Class 2, Grade B to the thickness specified.
F-15.390	1. Apply BMS 10-67, Type 1 (tungsten carbide-cobalt) coating per BAC5851, Class 3 to the thickness specified.
	2. Finish per BAC5855 (SOPM 20-10-05) to the surface finish specified.
F-15.3901	Apply BMS 10-67, Type 1 (tungsten carbide-cobalt) coating per BAC5851, Class 3, Grade B to the thickness specified.
F-15.391	1. Apply BMS 10-67, Type 15 (Cobalt Alloy T-400) per BAC5851, Class 3 to the thickness specified.
	2. Finish per BAC5855 (SOPM 20-10-05) to the surface finish specified.
F-15.393	1. Apply BMS 10-67, Type 16 (chromium carbide) per BAC5851, Class 3 to the thickness specified.
	2. Finish per BAC5855 (SOPM 20-10-05) to the surface finish specified.
F-15.40	Zinc-nickel plate per BAC5637, Type 2, Class 2.
F-15.401	Zinc-nickel plate, 0.0003 to 0.0005 inch thick, per BAC5637, Type 2, Class 2.
F-15.402	Zinc-nickel plate (BAC5637, Type 2, Class 2 or AMS 2417, Type 2), or cadmium plate (QQ-P-416, Type 2, Class 2 or BAC5701, Type 2, Class 2).
F-15.403	(Same as F-15.402, but 0.0003-0.0005 inch thick, and notched tensile tests for hydrogen embrittlement are not necessary.)
F-15.404	(Same as F-15.402, but notched tensile tests for hydrogen embrittlement are not necessary.)
F-15.405	Zinc-nickel plate (BAC5637, Type 2, Class 2 or AMS 2417, Type 2). Notched tensile tests for hydrogen embrittlement are not necessary.
F-15.406	Zinc-nickel plate (BAC5637, Type 3, Class 2).
F-15.407	Zinc-nickel plate 0.0003-0.0005 inch thick (BAC5637, Type 2, Class 2 or AMS 2417, Type 2). Notched tensile tests for hydrogen embrittlement are not necessary.

20-41-01

**STANDARD OVERHAUL PRACTICES MANUAL**

Code	Decoding
F-15.408	Zinc-nickel plate 0.0003-0.0005 inch thick (BAC5637, Type 2, Class 2 or AMS 2417, Type 2) and bake 5-8 hours at 250-300°F. Notched tensile tests for hydrogen embrittlement are not necessary.
F-15.41	Cadmium plate 0.0003-0.0005 inch thick per AMS-QQ-P-416, Type 2, Class 2 (SOPM 20-42-05). Bake 5-8 hours at 250-300°F.
F-15.42	Cadmium plate per AMS-QQ-P-416, Type 2, Class 2, or BAC5701 Type 2, Class 2, (SOPM 20-42-05). Bake 5-8 hours at 250-300°F. Notched tensile tests for hydrogen embrittlement relief are not necessary.
F-15.43	Apply thin dense chromium plating per BAC5709, Class 4 (SOPM 20-42-03).
F-15.44	Nickel plate per BAC5746, Type 1.
F-15.45	Tin plate per BAC5717, Type 1.
F-15.46	Brush cadmium plate per BAC5849.
F-15.47	Cadmium plate per AMS-QQ-P-416, Type 3, Class 3. Hydrogen embrittlement relief bake at 350-400°F for 23 hours minimum. Notched tensile tests for hydrogen embrittlement relief are not necessary.
F-15.48	Zinc-nickel plate (BAC5637, Type 2, Class 2) or cadmium plate (BAC5701, Type 2, Class 2).
F-15.49	Zinc-nickel plate (BAC5637, Type 2, Class 2) or cadmium plate (BAC5701, Type 2, Class 2), each 0.0003-0.0005 inch thick.
F-15.50	Zinc-nickel plate (BAC5680, Type 2).
F-15.51	Zinc-nickel plate 0.0005-0.0007 inch thick (BAC5680, Type 2)
F-15.52	Zinc-nickel plate (BAC5680, Type 3).
F-15.53	Zinc-nickel plate 0.0005-0.0007 inch thick (BAC5680, Type 3)
F-15.54	Stylus zinc-nickel plate (BAC5664).
F-16.01	Cadmium plate per AMS-QQ-P-416, Type 2, Class 2 (SOPM 20-42-05) and apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
F-16.02	Canceled. Use F-16.01.
F-16.03	Cadmium plate per BAC5701, Type 2, Class 2. Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
F-16.04	Cadmium plate per AMS-QQ-P-416, Type 3, Class 2 or BAC5701, Type 3, Class 2 (SOPM 20-42-05). Notched tensile tests for hydrogen embrittlement relief are not necessary.
F-16.05	Cadmium-titanium alloy plate per BAC5804, and apply phosphate treatment per BAC5810, Type 3.
F-16.06	Cadmium plate per BAC5701, Type 2, Class 2.
F-16.07	Cadmium plate per BAC5701, Type 2, Class 3.
F-16.08	Cadmium plate per BAC5701, Type 2, Class 3, but the plating thickness can be 0.0004-inch maximum.
F-16.09	Cadmium plate per BAC5701, Type 2, Class 3, but bake 5-8 hours at 250-300°F.

20-41-01

**STANDARD OVERHAUL PRACTICES MANUAL**

Code	Decoding
F-16.10	Phosphate treat per BAC5810, Type 1.
F-16.11	Cadmium plate, 0.0003-0.0005 inch thick, per BAC5701, Type 2, Class 2 (SOPM 20-42-05).
F-16.12	Phosphate treat per BAC5810, Type 3.
F-16.13	Cadmium plate per BAC5701, Type 3, Class 2.
F-17.01	Chemical treat per MIL-C-5541 (colored film) or chromic acid anodize per MIL-A-8625, Type 1, Class 1, but seal in dilute chromate solution per BAC5019.
F-17.02	Chromic acid anodize per BAC5019, Class 3.
F-17.03	Sulfuric acid anodize per MIL-A-8625, Type 2, Class 1 or BAC5022, Grade A.
F-17.031	Sulfuric acid anodize and deionized water seal per MIL-A-8625, Type 2, Class 1 or per BAC5022, Grade C.
F-17.04	Chromic acid anodize per MIL-A-8625, Type 1, but seal in dilute chromate solution per BAC5019, or chromic acid anodize per BAC5019, Class 3.
F-17.041	Chromic acid anodize per MIL-A-8625, Type 1, Class 1, but seal in dilute chromate solution per BAC5019, or chromic acid anodize per BAC5019, Class 3 or Class 5; or boric acid-sulfuric acid anodize per BAC5632, Class 1 or Class 5.
F-17.042	Chromic acid anodize per MIL-A-8625, Type 1, Class 1, but seal in dilute chromate solution per BAC5019, or chromic acid anodize per BAC5019, Class 3; or boric acid-sulfuric acid anodize per BAC5632, Class 1.
F-17.05	Anodize per MIL-A-8625, Type 1 (chromic acid), but seal in dilute chromate solution per BAC5019, or anodize per MIL-A-8625, Type 2 (sulfuric acid).
F-17.06	Hard anodize per BAC5821, Class 1.
F-17.061	Hard anodize per BAC5821, Class 2.
F-17.07	Chemical treat all surfaces per MIL-C-5541, Class 1A or BAC5719, Class A or C.
F-17.08	Chemical treat per MIL-C-5541 (colored film) the interior and exterior surface of tubing.
F-17.09	Use F-17.25.
F-17.10	Manually apply chemical coating per BAC5719, Type 2, Class A.
F-17.11	Manually apply chemical coating per BAC5719, Type 2, Class B.
F-17.12	Anodize magnesium per BAC5734.
F-17.13	Passivate per BAC5625, Type 13 or AMS-QQ-P-35.
F-17.14	Apply BMS 10-82, Type 1, Class 1 low emissivity coating per BAC5881 (SOPM 20-44-01).
F-17.141	Apply BMS 10-82, Type 1, Class 2 hydraulic fluid resistant coating per BAC5881 (SOPM 20-44-01).
F-17.15	Chemical treat per MIL-C-5541, Class 3, or BAC5719, Class D.
F-17.16	Phosphoric acid anodize per BAC5555 plus colorless chemical coating per BAC5719.
F-17.17	Canceled.
F-17.18	Sulfuric acid anodize for ten minutes per BAC5022. Deionized water seal per grade C.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-17.19	Chromic acid anodize at 22 volts and seal in dilute chromate solution per BAC5019.
F-17.20	Chromic acid anodize at 22 volts and deionized water seal per BAC5019, Class 4.
F-17.21	Sulfuric acid anodize per BAC5022, Grade A, but dilute chromate seal per BAC5019.
F-17.22	Sulfuric acid anodize per BAC5022, Grade B, but dilute chromate seal per BAC5019.
F-17.23	Use F-17.25.
F-17.24	Process per BAC5625, Type 3.
F-17.25	Passivate per BAC5625, Method 2. (Replaces F-17.09)
F-17.26	Chemical treat all surfaces per BAC5719, Type 1, Class A.
F-17.27	Chemical treat the interior and exterior surfaces of tubing per BAC5719, Type 1, Class A.
F-17.28	Manually apply Alodine 600 per BAC5719, Type 2, Class A or B (SOPM 20-43-03).
F-17.29	Boric acid - sulfuric acid anodize per BAC5632, Class 1.
F-17.30	Flash hard anodize per BAC5821, Class 2 (0.0002-0.0004 inch thick) and sodium dichromate seal, or sulfuric acid anodize and sodium dichromate seal per MIL-A-8625, Type 2, Class 1 or BAC5022, Grade A.
F-17.31	Boric acid - sulfuric acid anodize per BAC5632, Class 1 or 5, or chromic acid anodize at 22 volts per BAC5019, Class 3 or 5.
F-17.32	Chromic acid anodize at 22 volts and seal in dilute chromate solution per BAC5019, Class 3 only.
F-17.33	Chemical treat per BAC5719, Type 1, Class D.
F-17.34	Chemical treat per BAC5719, Type 1, Class B.
F-17.35	Boric acid-sulfuric acid anodize per BAC5632, Class 1, or chromic acid anodize at 22 volts per BAC5019, Class 3.
F-17.36	Use F-14.886.
F-17.37	Boric acid-sulfuric acid anodize per BAC5632, Class 5, or chromic acid anodize at 22 volts per BAC5019, Class 5.
F-17.38	Apply Alodine 600 per BAC5719, Type 1, Class D.
F-17.39	Boric acid-sulfuric acid anodize per BAC5632, Class 5.
F-17.40	Chemical treat per BAC5719, Class B.
F-17.41	Boric acid-sulfuric acid anodize per BAC5632, Class 1 or 5.
F-17.42	1. Apply satin finish with aluminum oxide or equivalent to the background surface. 2. Sulfuric acid anodize all over per MIL-A-8625, Type 2, Class 2 or BAC5716, Type 2, Class 2. 3. Dye anodized letters, lines, or indicated areas as specified by the overhaul instructions.
F-17.43	Abrasive clean per BAC5625, Method 5.
F-17.44-XXX ^{*[2]}	Anodize per MIL-A-8625, Type 2, Class 2 or BAC5716, Type 2, Class 2.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code

Decoding

F-17.45	Boric-acid-sulfuric acid anodize (BAC5632, Class 1 or Class 5) or chromic acid anodize at 22 volts for 22-35 minutes (BAC5019, Class 1 or Class 5). If you chromic acid anodize, the complete process (which includes surface preparation steps such as cleaning, etching and deoxidizing) must not cause end grain pitting more than 0.001 inch deep in the BSS7219 test on a sample of the same alloy and temper.
F-17.451	(Same as F-17.45, but you can also chromic acid anodize per BAC5019, Class 3.)
F-17.46-XXX ^{1[2]}	Chromic acid anodize (MIL-A-8625, Type 1, Class 2, or BAC5716, Type 1, Class 2, of a color similar to the indicated color.
F-17.47	Apply sol-gel conversion coating (BAC5663, Type 1, Class 1).
F-17.48	Apply sol-gel conversion coating (BAC5663, Type 1, Class 1). Surface roughness requirements for titanium apply after abrasive cleaning.
F-17.49	Abrasive clean per BAC5748 (SOPM 20-30-03).
F-17.50	Boric acid-sulfuric acid anodize (BAC5632, Class 5) or apply chemical conversion coating to all surfaces (MIL-C-5541, Class 1A, or BAC5719, Class A or Class C).
F-17.51	Boric acid-sulfuric acid anodize (BAC5632, Class 1) or apply chemical conversion coating to all surfaces (MIL-C-5541, Class 1A, or BAC5719, Class A or Class C).
F-17.52	Apply sol-gel conversion coating (BAC5665).
F-17.53	Apply sol-gel conversion coating (BAC5665, Type 3). For pretreatment, use only flash etch (BAC5753 Method 2A).
F-17.54	Apply sol-gel conversion coating (BAC5665, Type 1 or 2).
F-17.55	Apply sol-gel conversion coating (BAC5665, Type 1).
F-17.56	Abrasive clean (BAC5748, Type 2, Class 1) with 180 grit or finer aluminum oxide with 30-60 psi air pressure.
F-17.57	Apply sol-gel conversion coating (BAC5665, Type 2). Do not use power tools for abrasive pretreatment.
F-18.01	Manually apply colored chemical coating per BAC5719. Immersion application of colored chemical coating is optional for aluminum spot welded assemblies. Apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-18.02	Phosphate coat per MIL-DTL-16232, Type M, Class 1 and apply lubricant (BAC5008).
F-18.03	Chemical treat the surface per MIL-C-5541, colored film or MIL-A-8625, Type 1 (chromic acid anodize), but seal in dilute chromate solution per BAC5019. Apply two layers of BMS 10-11, Type 1 primer per BAC5736.
F-18.04	Anodize per BAC5019 and apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-18.05	Chemical treat surface per MIL-C-5541 (colored film) or MIL-A-8625, Type 1 (chromic acid anodize), but seal in dilute chromate solution per BAC5019. Apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-18.06	On interior and exterior surfaces, chemical treat per MIL-C-5541 (colored film). Apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-18.07	On interior and exterior surfaces, chemical treat per MIL-C-5541 (colored film) and apply one layer of BMS 10-11, Type 1 primer per BAC5736.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-18.08	Chemical treat per AMS-M-3171, Type 3 or per BAC5609. Apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-18.09	Anodize magnesium per BAC5734 or chemical treat per AMS-M-3171, Type 3 or BAC5609. Apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-18.10	Anodize magnesium per BAC5734 or chemical treat per AMS-M-3171, Type 3 or BAC5609. Apply two layers of BMS 10-11, Type 1 primer per BAC5736.
F-18.12	Abrasive clean the surface per BAC5748 and apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-18.13	Chromic acid anodize per MIL-A-8625, Type 1, but seal in dilute chromate solution per BAC5019. Apply one layer of BMS 10-11, Type 1 primer per BAC5736.
F-18.14	Chemical treat the interior and exterior surfaces of straight or formed tubular parts per MIL-C-5541 (BAC5719, class A or B). Then mask the end fittings and apply the specified primer and enamel on the exterior surfaces. The primer is not necessary on surfaces mating with swaged sleeves or ferrules. Primer is necessary to the end of the tube if the tube will be used with flared fittings.
F-18.18	Boric acid - sulfuric acid anodize per BAC5632, Class 5, or chromic acid anodize per BAC5019, Class 5, and apply one layer of DeSoto 515x346 adhesive primer per BAC5710, Type 60.
F-18.19	Dry abrasive blast per BAC5748. Apply 2 layers of BMS 10-79, Type 3 primer per BAC5882.
F-18.20	Prepare the surface per BAC5748. Apply one layer of BMS 10-79, Type 3 primer per BAC5882.
F-18.21	Anodize magnesium per BAC5734 or chemical treat per BAC5609, Class 1.
F-18.22	1. Abrasive clean (BAC5748). 2. Apply two layers of BMS 10-11, Type 1 primer (BAC5736).
F-18.23	Abrasive clean per BAC5748. Apply two layers of high temperature primer per BAC5710, Type 51.
F-19.01	Apply one layer of BMS 10-20, Type 2 coating per BAC5793.
F-19.02	Apply insulated coating per BAC5710, Type 21.
F-19.03	Clean and coat the interior surface of tubular and hollow parts (open or closed) with MIL-C-11796, Class 1 corrosion preventive compound per BAC5720.
F-19.04	Apply one layer of BMS 10-20, Type 2 coating per BAC5793. Do not mask areas sealed by sealants or O-rings.
F-19.05	Assemble with a thin layer of MIL-C-16173, Grade 2 corrosion preventive compound on the internal and the external mating threads.
F-19.06	Apply a layer of BMS 3-24 grease to the installed control cable per BAC5008 (SOPM 20-50-07).
F-19.07	Canceled.
F-19.08	Apply a thin layer of MIL-G-23827 grease per BAC5008 (SOPM 20-50-07) to all surfaces before installation.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-19.081	Apply a thin layer of BMS 3-33 grease per BAC5008 (SOPM 20-50-07) to all surfaces before installation.
F-19.09	Install with MIL-C-11796, Class 3 corrosion preventive compound on all surfaces.
F-19.10	Apply BMS 3-8 solid film lubricant per BAC5811, Type 8 (SOPM 20-50-08).
F-19.11	Apply MIL-C-11796, Class 3 corrosion preventive compound to all areas of the hole, and the countersink, counterbore, or other recess, and immediately install the fastener or insert.
F-19.12	Clean the interior surface of tubular and hollow parts (open or closed) and apply a layer of BMS 3-24 grease per BAC5720.
F-19.13	Apply BMS 3-24 grease to all ID bore surfaces.
F-19.14	Clean the interior surface of tubular and hollow parts (open or closed) and apply a layer of MIL-G-25013 compound per BAC5720 (SOPM 20-41-03).
F-19.15	Apply MIL-G-25013 compound to all ID bore surfaces.
F-19.16	Install with BMS 3-24 grease on all surfaces.
F-19.17	Install with MIL-G-25013 compound on all surfaces.
F-19.19	Apply epoxy walkway coating per BAC5705, Type 2.
F-19.21	Apply Overwing Emergency Exit Walkway Coating per BAC5705, Type 1.
F-19.22	Apply one layer of BMS 10-20, Type 2 corrosion-inhibiting coating per BAC5793.
F-19.25	Use F-19.34.
F-19.26	Apply BMS 3-23, Type 2 corrosion inhibiting compound per BAC5877.
F-19.261	Apply BMS 3-29 corrosion preventive compound per BAC5877.
F-19.27	Install the fastener with BMS 5-95 sealant per BAC5000, Method 1 (SOPM 20-50-19).
F-19.34	Apply one coat of BMS 10-79 primer per BAC5882 and 3.0-5.0 mils of BMS 10-60, Type 2 enamel, color BAC7025 gloss gray per BAC5845.
F-19.36	Use F-19.47.
F-19.38	Apply BMS 5-95, Class F sealant as a primer per BAC5710, Type 46.
F-19.39-XXX ^[2]	Apply BMS 10-60, Type 2 gloss enamel per BAC5845.
F-19.40	Apply one coat BMS 10-79, Type 2 primer per BAC5882 (SOPM 20-44-04). Apply BMS 10-60, Type 2 enamel, color 707 grey gloss per BAC5845.
F-19.41-XXX ^[2]	Apply one coat of BMS 10-79, Type 2 primer per BAC5882 (SOPM 20-44-04). Apply BMS 10-60, Type 2 gloss enamel per BAC5845.
F-19.42-XXX ^[2]	Prepare surface and apply one coat of BMS 10-79, Type 2 primer per BAC5882 (SOPM 20-44-04) and two coats of BMS 10-60, Type 2 gloss enamel per BAC5845, except the dry film thickness is to be 2.0-3.0 mils.
F-19.421-XXX ^[2]	(Same as F-19.42-XXX except use BMS 10-60, Type 2 flat enamel).
F-19.43	Apply high temperature primer per BAC5710, Type 51.
F-19.44	Apply one coat of BMS 10-79, Type 2 primer per BAC5882 (SOPM 20-44-04) and apply 2.0-3.0 mils (0.002-0.003 inch) of BMS 10-100 enamel per BAC5797.
F-19.45	Wipe surfaces with BMS 10-11, Type 1 primer per BAC5736.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-19.451	Wipe surface with BMS 10-79, Type 3 primer per BAC5882.
F-19.46	Apply one coat BMS 10-79, Type 2 primer per BAC5882 (SOPM 20-44-04).
F-19.47	Apply one coat BMS 10-79, Type 3 primer per BAC5882 (SOPM 20-44-04).
F-19.48	Install fasteners with BMS 5-95 sealant per BAC5000, Method 2 (Ref SOPM 20-50-19).
F-19.49	Apply two coats of BMS 10-20, Type 2 corrosion inhibiting coating per BAC5793.
F-19.50	Wipe on primer for sulfuric acid anodized and hard anodized surfaces. 1. Prepare the surface per BAC5736 (SOPM 20-41-02) but do not use an abrasive. 2. Apply a large quantity of BMS 10-11, Type 1 primer on the surface and rub it in on the surface with BMS 15-5, Class A cheesecloth. The full area must get the primer. 3. Before the primer dries, carefully remove only the unwanted wet primer with BMS 15-5, Class A cheesecloth.
F-19.51	Install fasteners with BMS 5-26, Type 2 sealant per BAC5000, Method 2 (SOPM 20-50-19).
F-19.511	Install fasteners with BMS 5-26, Type 2 sealant per BAC5000, Method 1 (SOPM 20-50-19).
F-19.512	Install fasteners with BMS 5-26, Type 2 sealant per BAC5000, Method 3 (SOPM 20-50-19).
F-19.513	Install fasteners with BMS 5-45 sealant per BAC5000, Method 1 (SOPM 20-50-19).
F-19.514	Install fasteners with BMS 5-45 sealant per BAC5000, Method 2 (SOPM 20-50-19).
F-19.515	Install fasteners with BMS 5-45 sealant per BAC5000, Method 3 (SOPM 20-50-19).
F-19.52	Prepare surface per BAC5837 (SOPM 20-10-06). Apply 2 layers of BMS 10-103, Type 1 primer per BAC5325, or BMS 10-79, Type 3 primer per BAC5882.
F-19.521	Prepare the surface per BAC5837 (SOPM 20-10-06). Apply one layer of BMS 10-20, Type 2 coating per BAC5793.
F-19.53	Apply primer surfacer per BAC5837 (SOPM 20-10-06) on polyethyl ether ketone (PEEK) plastic.
F-19.54	Edge seal with BMS 5-45, Type 2, Class A (replaces BMS 5-26, Type 2, Class A) sealant per BAC5000 (SOPM 20-50-19).
F-19.55	Apply BMS 5-95, Class F sealant as a primer per BAC5710, Type 56.
F-19.62	Apply one layer of BMS 10-97, Type 1 urethane exterior primer per BAC5629.
F-19.63	Install fasteners with BMS 5-138 carbon-filled sealant per BAC5504, Method 2.
F-19.64	Install fasteners with noncuring primer/sealant per BAC5710, Type 57.
F-19.65	Install nutplates with BMS 5-95 faying surface sealant per BAC5000 (SOPM 20-50-19).
F-19.66	Apply two layers of BMS 10-79, Type 3 primer per BAC5882 (SOPM 20-44-04).
F-19.661	Apply two layers of BMS 10-79, Type 3 primer (0.0010-0.0015 inch thick) per BAC5882 (SOPM 20-44-04).
F-19.67-XXX ^{*[2]}	Apply one layer of MIL-C-83286 enamel per BAC5896.
F-19.68-XXX ^{*[2]}	Apply a second layer of MIL-C-83286 enamel per BAC5896.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-19.69	Apply 2.0-3.0 mils (0.002-0.003 inch) of BMS 10-100 enamel per BAC5797.
F-19.70	Apply one layer of BMS 10-79, Type 3 primer per BAC5882 (SOPM 20-44-04). Apply 2.0-3.0 mils (0.002-0.003 inch) of BMS 10-100 enamel per BAC5797.
F-19.71	Apply a thin layer of BMS 3-27 corrosion preventive compound to indicated surfaces.
F-19.711	Apply a thin layer of BMS 3-27 corrosion preventive compound to the fastener shank and threads before installation.
F-19.72	Apply a 4-8 mil layer of Dinol AV-100B corrosion inhibiting compound to the indicated surfaces per BAC5877 (SOPM 20-41-05)
F-19.73	Apply BMS 3-26, Type 2 corrosion inhibiting compound to the indicated surfaces per BAC5877 (SOPM 20-41-05).
F-19.731	(Same as F-19.73 but coating dry film thickness must be 0.020 inch maximum.)
F-19.74	Edge seal with BMS 5-92, Type 1 adhesive per BAC5000 edge sealing Method 2 (SOPM 20-50-19) before you apply primer.
F-19.75	Edge seal with BMS 5-92, Type 1 adhesive by BAC5000 Method 1 or 3 (SOPM 20-50-19) before you apply primer.
F-19.751	Edge seal by BAC5000 Method 4.
F-19.752	Edge seal by BAC5000 Method 5.
F-19.753	Surface seal by BAC5000 Method 6.
F-19.79-XXX ^[2]	Apply BMS 10-60, Type 2 gloss enamel per BAC5845, but with a dry film thickness of 0.0007-0.0012 inch (0.7-1.2 mils).
F-19.791-XXX ^[2]	Apply BMS 10-60, Type 2 gloss enamel per BAC5845, but with a dry film thickness of 0.0007-0.0012 inch (0.7-1.2 mils). Use only Desothane HS CA8000/BXXX ^[2] base, CA8000B curing solution and CA8000C thinner (all V85570).
F-19.80	Apply high temperature primer per BAC5710, Type 51 (SOPM 20-44-01), but with a dry film thickness of 2.0-3.0 mils.
F-19.81	Apply MIL-L-46010, Type 1 solid film lubricant per BAC5811, Type 6, Class 1 (SOPM 20-50-08).
F-19.82	Apply MIL-L-46010, Type 2 or 3 solid film lubricant per BAC5811, Type 6, Class 3 or 4 (SOPM 20-50-08).
F-19.83	Apply high temperature solid film lubricant per BAC5814. This is a vendor-proprietary coating. Only the vendor (V1P942) can apply it.
F-19.86	Apply BMS 3-35 corrosion inhibiting compound per BAC5877 (SOPM 20-41-05).
F-19.87	Apply BMS 3-23, Type 2, Class 2 corrosion inhibiting compound per BAC5877 (SOPM 20-41-05).
F-19.89	Apply BMS 3-23, Type 2, Class 1 corrosion inhibiting compound per BAC5877 (SOPM 20-41-05).
F-19.90	Apply MIL-L-23398 solid film lubricant per BAC5811, Type 7, Class 1 (SOPM 20-50-08).
F-19.91	Apply BMS 10-60, Type 2 gloss enamel, color 707 gray, per BAC5845 (same as F-19.39-707).

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-19.92	Apply a thin layer of BMS 3-38 corrosion preventive compound to the fastener shank and threads before installation.
F-19.95	Apply one layer of BMS 10-123, Type 1 primer (BAC5357).
F-19.951	Apply two layers of BMS 10-123, Type 1 primer (BAC5357).
F-20.01	Mask as indicated by the overhaul instructions and apply one coat of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
F-20.02	Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
F-20.03	Apply two layers BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02).
F-20.04 ^{*[1]}	Apply wet BMS 10-11, Type 1 primer (mixed per BAC5736) to all areas of the hole, and any countersink, counterbore, or other recess, and immediately install the fastener or insert, but if the fastener is installed into an insert or other location where easy removal of the fastener is necessary, use corrosion preventive compound MIL-C-11796, Class 3 and not this primer.
F-20.05	Install with wet or dry BMS 10-11, Type 1 primer mixed per BAC5736 (SOPM 20-41-02). If these are shims, remove the unwanted laminations before you apply the primer.
F-20.06 ^{*[1]}	Assemble with wet BMS 10-11, Type 1 primer mixed per BAC5736 (SOPM 20-41-02).
F-20.07	(Same as F-20.04 but use MIL-P-8585, color Y primer, not BMS 10-11, Type 1 primer.)
F-20.08	Apply two coats of MIL-P-8585, color Y primer per MIL-P-6808 or BAC5706.
F-20.09	Apply one coat of BMS 10-11, Type 1 yellow primer per BAC5736 (SOPM 20-41-02).
F-20.10	Apply 2 coats BMS 10-11, Type 1 yellow primer per BAC5736 (SOPM 20-41-02).
F-20.20	Apply wet BMS 10-11, Type 1 primer (mixed per BAC5736) to all areas of the hole and any countersink, counterbore, or other recess, and immediately install the fastener or insert.
F-20.201	Apply BMS 10-11, Type 1 primer per BAC5736 to all areas of the hole and any countersink, counterbore, or other recess, and when dry, install the fastener or insert.
F-20.202	Apply BMS 10-79, Type 3 primer per BAC5882 to all areas of the hole and any countersink, counterbore, or other recess, and when dry, install the fastener or insert.
F-20.26	Apply BMS 5-89 corrosion inhibiting adhesive primer (BAC5514-589) before you bond the part.
F-20.261	Apply BMS 5-89, Type 2 corrosion inhibiting adhesive primer (BAC5514-589) before you bond the part.
F-20.30	Use F-19.47.
F-20.31	Phosphoric acid anodize per BAC5555.
F-20.32-XXX ^{*[2]}	Apply Alodine 1200S, BMS 10-79 primer and BMS 10-60, Type 2 gloss enamel.
F-20.33-XXX ^{*[2]}	Apply Alodine 1200S, BMS 10-79 primer and BMS 10-60, Type 2 flat enamel.
F-20.34	Apply BMS 10-60, Type 2 aluminized enamel, color BAC9184, and BMS 10-60, Type 2 clear enamel per BAC5845.
F-20.35-XXX ^{*[2]}	Apply Alodine 1200S, BMS 10-79, Type 2 primer and BMS 10-60, Type 2 gloss enamel.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code

Decoding

F-20.36-XXX ^{*[2]}	Apply Alodine 1200S, BMS 10-79, Type 2 primer and BMS 10-60, Type 2 flat enamel.
F-20.37-XXX ^{*[2]}	Apply Alodine 1000, BMS 10-79, Type 2 primer and BMS 10-60, Type 2 gloss enamel.
F-20.38-XXX ^{*[2]}	Apply Alodine 1000, BMS 10-79, Type 2 primer and BMS 10-60, Type 2 flat enamel.
F-20.46-XXX	Apply one layer of BMS 10-79, Type 2 primer per BAC5882. Then apply one coat BMS 10-60, Type 2 enamel.
F-20.47	Apply BMS 5-137, Type 1 adhesive primer per BAC5514-5137.
F-20.471	Apply BMS 5-70, Type 1 adhesive primer per BAC5514-570.
F-20.48	Apply one layer of BMS 10-11, Type 1 primer per BAC5736 to interior and exterior surfaces. If this is a tube or a duct, give protection to the ends per BAC5001-1.
F-20.49	Apply one layer of BMS 10-11, Type 1 primer per BAC5736 to exterior surfaces only. If this is a tube or a duct, give protection to the ends per BAC 5001-1.
F-20.491	Apply two layers of BMS 10-11, Type 1 primer per BAC5736 to exterior surfaces only.
F-20.55	Apply two layers BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02) to interior, and exterior surfaces.
F-20.56-XXX ^{*[2]}	Apply BMS 10-60, Type 2 gloss enamel per BAC5845, but with a dry film thickness of 10.0-12.0 mils (0.010-0.012 inch).
F-20.57	Apply BMS 5-42, Type 1 adhesive primer per BACC5514-542.
F-20.62	Apply BMS 10-72, Type 8 primer.
F-20.63-XXX ^{*[2]}	Apply BMS 10-72, Type 8 gloss enamel.
F-20.64-XXX ^{*[2]}	Apply BMS 10-72, Type 8 flat enamel.
F-20.65-XXX ^{*[2]}	Apply BMS 10-72, Type 9 primer.
F-20.66-XXX ^{*[2]}	Apply BMS 10-72, Type 9 gloss enamel.
F-20.67-XXX ^{*[2]}	Apply BMS 10-72, Type 9 flat enamel.
F-20.68	Apply one layer of BMS 10-118 primer per BAC5325.
F-20.681	Apply one layer of BMS 10-118, Type 1 primer per BAC5325.
F-20.682	Apply one layer of BMS 10-118, Type 2 primer per BAC5325.
F-20.70	Apply BMS 10-118 primer, BMS 10-120 intermediate layer, and BMS 10-126 Type 2 RTG topcoat per BAC5358.
F-20.71-XXX ^{*[2]}	Apply BMS 10-125 Type 1 gloss decorative topcoat.
F-20.73	Apply BMS 10-126 Type 2 RTG topcoat per BAC5845.
F-20.74	Apply one layer of BMS 10-120, Type 1 coating per BAC5250.
F-20.75-XXX ^{*[2]}	Apply BMS 10-125 Type 2 flat decorative topcoat.
F-20.76-XXX ^{*[2]}	Apply BMS 10-125 Type 3 gloss decorative topcoat.
F-20.760	Apply BMS 10-125 Type 3 gloss decorative topcoat. This is the pigmented clear coat, product code CA8800/IS92005.
F-20.761	Apply BMS 10-125 Type 3 gloss decorative topcoat. This is the pigmented clear coat, product code CA8800/IS92006.
F-20.77-XXX ^{*[2]}	Apply BMS 10-125 Type 3 flat decorative topcoat.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code

Decoding

F-20.78-XXX ^[2]

Apply BMS 10-125 Type 2 gloss decorative topcoat.

F-21.01

Canceled.

F-21.02

Apply one layer of BMS 10-11, Type 2 enamel, color 707 gray gloss per BAC5736 (SOPM 20-41-02).

F-21.03

Apply one layer of BMS 10-11, Type 2 enamel, color 702 white gloss per BAC5736 (SOPM 20-41-02).

F-21.031

(Same as F-21.03 but with dry film thickness to be 0.002-0.003 inch.)

F-21.04

Apply one layer of corona suppressive coating per BAC5710, Type 31. (SOPM 20-44-01)

F-21.091

Treat aluminum surfaces per MIL-C-5541 (colored film) or MIL-A-8625, Type 1 (chromic acid anodize) but seal in dilute chromate solution per BAC5019. Apply one layer of BMS 10-11, Type 1 primer per BAC5736 (SOPM 20-41-02) and one layer of gray Teflon paint per BAC5710, Type 27 (SOPM 20-44-01).

F-21.12

Touch-up of Unpainted Areas

1. Clean and manually apply colored chemical conversion coating to the bare aluminum surfaces per BAC5719 (SOPM 20-43-03). Treatment of fastener heads is not necessary.

2. Reactivate area to be touched up per BAC5736 (SOPM 20-41-02).

3. Touch up fastener heads, damaged paint, and bare areas with BMS 10-11, Type 1 yellow primer (green is optional) and BMS 10-11, Type 2 enamel, color 702 white gloss per BAC5736 (SOPM 20-41-02).

F-21.121

1. Clean and manually apply colored chemical conversion coating to the bare aluminum surfaces per BAC5719, Type 2, Class A (SOPM 20-43-03). Treatment of fasteners is not necessary.

2. Reactivate areas to be touched up per BAC5736 (SOPM 20-41-02).

3. Touch up fasteners, damaged paint, and bared areas with BMS 10-11, Type 1, yellow primer in accordance with BAC5736 (SOPM 20-41-02).

F-21.13-XXX ^[2]

Apply primer and non-reflective coating per BAC5755, Type 16.

F-21.14

Apply primer and nylon coating per BAC5710, Type 49 (SOPM 20-44-01), of the color and thickness as specified by the overhaul instructions.

F-21.15

Apply one layer of BMS 10-11, Type 2, color 702 white gloss enamel per BAC5736 (SOPM 20-41-02), 0.0005-0.0010 inch thick. When you paint assemblies, this thickness is necessary only on surfaces which the spray equipment can get at.

F-21.16

Touch-up of Unpainted Areas

1. Clean and chemical treat bare aluminum surfaces per BAC5719, Type 2, Class A. (SOPM 20-43-03) Treatment of fastener heads is not necessary.

2. Reactivate the area to be touched up per BAC5736 (SOPM 20-41-02).

3. Touch up fastener heads, damaged paint, and bare areas with BMS 10-11, Type 1 yellow primer and BMS 10-11, Type 2 enamel, color 702 white gloss per BAC5736 (SOPM 20-41-02).

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-21.17	Apply one layer of BMS 10-11, Type 2 enamel, color 702 white gloss per BAC5736 (SOPM 20-41-02). When you paint assemblies, this thickness is necessary only on surfaces which the spray equipment can get at.
F-21.18	Chromic acid anodize at 22 volts and seal in dilute chromate solution per BAC5019, Class 3 (SOPM 20-43-01). Apply BMS 10-11, Type 1 primer plus BMS 10-11, Type 2 enamel, color 702 white per BAC5736 (SOPM 20-41-02).
F-21.19	Chemical treat per MIL-C-5541 (colored film), apply DeSoto Hi-temperature polyurethane primer per BAC5710, Type 51 (SOPM 20-44-01), and DeSoto Hi-temperature epoxy enamel per BAC5710, Type 53 (SOPM 20-44-01).
F-21.20	Apply high temperature enamel per BAC5710, Type 53 (SOPM 20-44-01).
F-21.25	Apply one layer of BMS 10-11, Type 2 gloss enamel color 702 white per BAC5736 (SOPM 20-41-02). No substitutions are permitted.
F-21.26-XXX ^{*[2]}	Apply one layer of BMS 10-11, Type 2 flat enamel per BAC5736 (SOPM 20-41-02).
F-21.27-XXX	Apply one layer of BMS 10-11, Type 2 semigloss enamel per BAC5736 (SOPM 20-41-02).
F-21.28-XXX	Apply one layer of BMS 10-11, Type 2 gloss enamel per BAC5736 (SOPM 20-41-02).
F-21.33	Touch-up of Unpainted Areas 1. Clean and chemical treat bare aluminum surfaces per BAC5719, Type 2, Class A (SOPM 20-43-03). Treatment of fastener heads is not necessary. 2. Reactivate the area to be touched up per BAC5736 (SOPM 20-41-02). 3. Touch up fastener heads, damaged paint, and bare areas with BMS 10-11, Type 1 yellow primer and BMS 10-60, Type 1 color 707 gray enamel.
F-21.34	Apply clear hydraulic fluid resistant coating per BAC5710, Type 41 (SOPM 20-44-01).
F-21.37	Apply primer and polyphenylene sulfide (PTFE) coating per BAC5710, Type 47 (SOPM 20-44-01).
F-22.01-XXX ^{*[2]*[3]*[4]}	Apply three layers of Hi-Speed flat lacquer (1-1-1-XXX, 1-7-1-XXX, 1-71-1-XXX) per BAC5755.
F-22.02-XXX ^{*[2]*[3]}	Apply textured Hi-Speed semi-gloss lacquer (1-1-2-XXX, texture A) per BAC5755.
F-22.03	Use F-22.32-7144.
F-22.04	Use F-22.06-7144.
F-22.05-XXX ^{*[2]}	Apply BMS 10-83, Type 1 primer per BAC5755, Type 3. Apply BMS 10-83, Type 2 enamel, per BAC5755, Type 4.
F-22.06-XXX ^{*[2]}	Apply BMS 10-83, Type 2 enamel per BAC5755, Type 4.
F-22.07-XXX ^{*[2]}	Apply BMS 10-83, Type 1 primer per BAC5755, Type 3. Apply BMS 10-83, Type 2 enamel, Texture C per BAC5755.
F-22.23-XXX ^{*[2]}	Apply BMS 10-83, Type 1 primer per BAC5755, Type 3. Apply BMS 10-83, Type 2 enamel per BAC5755, Type 4, Texture E.
F-22.25-XXX ^{*[2]}	Apply BMS 10-83, Type 2 enamel per BAC5755, Type 4, Texture E.
F-22.26-XXX ^{*[2]}	Apply BMS 10-83, Type 1 primer per BAC5755, Type 3. Apply BMS 10-83, Type 3 enamel, Texture C per BAC5755, Type 4.

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-22.29	Apply BMS 10-83, Type 4 primer per BAC5755, Type 12.
F-22.30	Apply BMS 10-83, Type 1 primer per BAC5755, Type 3.
F-22.31	Apply BMS 10-83, Type 2 enamel, per BAC5755, Type 4, Texture C.
F-22.32-XXX ^[2]	Apply BMS 10-83, Type 3 enamel per BAC5755, Type 4.
F-22.33-XXX ^[2]	Apply BMS 10-83, Type 3 enamel, per BAC5755, Type 4, Texture C.
F-22.34	Apply BMS 10-83, Type 3 enamel, per BAC5755, Type 4, Texture E.
F-22.35	Apply adhesive primer per BAC5710, Type 60.
F-22.36-XXX ^[2]	Apply BMS 10-110, Type 1, Class 1 coating per BAC5755, Type 14.
F-22.37-XXX ^[2]	Apply BMS 10-83, Type 2 enamel per BAC5755, Type 4, Texture G.
F-22.38-XXX ^[2]	Apply one layer of BMS 10-110, Type 2, Class 2 coating per BAC5755, Type 13.
F-22.39-XXX ^[2]	Apply more than one layer of BMS 10-110, Type 2, Class 2 coating per BAC5755, Type 13, to get the thickness specified by the overhaul instructions.
F-24.02	Apply BMS 14-4, Type 1 protective coating per BAC5840 (SOPM 20-50-13).
F-24.03	Apply BMS 14-4, Type 2 protective coating per BAC5840 (SOPM 20-50-13).
F-24.04	Apply BMS 14-4, Type 1 protective coating per BAC5840 (SOPM 20-50-13), cured at 350-400°F for 26 hr.
F-24.05	Dry abrasive blast per BAC5748, Type 2, Class 1 (SOPM 20-30-03) and apply ion vapor deposited aluminum coating per MIL-C-83488, Type 1 Class 1.
F-24.06	Dry abrasive blast per BAC5748, Type 2, Class 1 (SOPM 20-30-03) and apply ion vapor deposited aluminum coating per MIL-C-83488, Type 2, Class 1.
F-24.07	Dry abrasive blast clean per BAC5748, Type 2, Class 1 (SOPM 20-30-03) and apply ion vapor deposited (IVD) aluminum coating per MIL-C-83488, Type 2, Class 1. Before application of the supplementary chromate treatment, glass bead peen the IVD coating with Size 10 bead per MIL-G-9954 at 40 psi until the grey matte surface is shiny.
F-24.08	Dry abrasive blast clean per BAC5748, Type 2, Class 1 (SOPM 20-30-03) and apply ion vapor deposited (IVD) aluminum coating per MIL-C-83488, Type 1, Class 1. Glass bead peen the IVD coating with Size 10 bead per MIL-G-9954 at 40 psi until the grey matte surface is shiny.
F-24.09	Dry abrasive blast clean per BAC5748, Type 2, Class 1 (SOPM 20-30-03) and apply ion vapor deposited (IVD) aluminum coating per MIL-C-83488, Type 1, Class 1. Glass bead peen the IVD coating with Size 10 bead per MIL-G-9954 at 40 psi until the grey matte surface is shiny. Apply Sermetel 985 topcoat per BAC5840. The cured coating must be resistant to the fingernails.
F-25.01	Apply no finish, but temporary coatings can be applied as necessary for protection during handling, transportation and storage (BAC5034 or SOPM 20-44-02).
F-25.05	Apply no finish. Remove scale or unwanted metal contamination by cleaning per BAC5758 before assembly.
F-25.06	Apply no finish, but apply temporary coatings as necessary for protection during handling, transportation and storage (BAC5034 or SOPM 20-44-02).

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

Code	Decoding
F-25.07	Control the environmental exposure of unpainted in-process composite details and assemblies per BAC5360. Apply temporary coatings as necessary for protection during handling, transportation and storage (BAC5034 or SOPM 20-44-02).
F-30.004-XXX	Apply Aquadex waterborne urethane dispersion per BAC5755, Type 3, with the following exceptions: 1. Substitute Aquadex for BMS 10-83, Type 1. 2. Air dry the applied Aquadex at a minimum of 65°F for a minimum of 60 minutes.
F-30.005	Apply polyurethane rain erosion coating per BAC5710, Type 48, but with a dry film thickness of 0.008 to 0.012 inch.
F-30.006	1. Abrasive clean per BAC5748 with clean aluminum oxide abrasive. 2. Vapor degrease per BAC5408. To prevent caught solutions, do not substitute aqueous cleaning procedures such as BAC5749, BAC5763, or BAC5765. 3. Apply chemical conversion coating per MIL-C-5541, Class 1A, or BAC5719, Class A or C, but without more surface preparation. If the part has contamination, clean it again per steps 1 and 2.
F-30.010	Apply BMS 10-85, Type 1, Class A or Class B aluminum pigmented coating.
F-30.015	Anodize per AMS 2488, Type 2.
F-30.019	Apply Pilkington Aerospace Inc. (PAI) SS-6782 acrylic hard coating per PAI specification PS-571, to agree with PAI specification SMS-024. This is a vendor-proprietary coating. Only the vendor (VU1610) can apply it.
F-30.021	Apply PPG Aerospace Solgard III acrylic hard coating per PPG specification IST 09-005-121, to agree with PPG specification PMS-003-005-SOLG. This is a vendor-proprietary coating. Only the vendor (VKF595) can apply it.

*[1] For wet installation, do not use BMS 10-11, Type 1, grade B (chlorinated solvent) primer. Use BMS 10-11, Type 1, grade A (conventional solvent) primer or BAC5710, Type 59, instead.

*[2] The color is indicated by the dash number (-XXX) of the finish code. This will be in the applicable overhaul instructions. Three or four-digit dash numbers are Boeing colors and are in D-14080 or D-14080-1. Five-digit dash numbers that start with 1, 2, or 3 are Federal colors and are in FED-STD-595. Five-digit numbers that start with 4 thru 9 are Boeing colors and are available through the Payload Automated Color and Material System (PACMS), which replaces documents D-14080 and D-14080-1. PACMS is available on the internal Boeing web site <http://pacms.ca.boeing.com/selcolor.htm> and equivalent data is under review for access on myboeingfleet.com.

*[3] When you see a code of the form X-X-X-XXX it gives data for the coating as shown in Figure 1.

*[4] When you see a 7 at the second part of the code:

X - 7 - X - XXX identifies a coating made only by Boeing. No other vendor makes it.

X - 7X - X - XXX identifies a coating made by Boeing from X manufacturer's base materials and necessary tinting pigments. The code for the X after the 7 is the same as the Source or Manufacturer code in *[3].

20-41-01



STANDARD OVERHAUL PRACTICES MANUAL

X - X - X - XXX

Boeing color number as given in D-14080 or D-14080-1.

Sheen or gloss

1 - Flat; 5 units or below measured on a 60-degree glossmeter for Hi-Speed lacquer. For other coatings, refer to the applicable specification.

NOTE: 1F is BMS 10-83, Type 5, flat.

2 - Semigloss; range from 25 to 40 units measured on a 60-degree glossmeter for Hi-Speed lacquer. For other coatings, refer to the applicable specification.

3 - Gloss; above 65 units measured on a 60-degree glossmeter for Hi-Speed lacquer. For other coatings, refer to the applicable specification.

Source or manufacturer:

- 1 - Sherwin Williams Co., V54634
- 2 - DuPont, V73925 (Obsolete)
- 3 - PPG Industries, Inc., V47695 (Obsolete)
- 4 - Kop-Coat (replaces Koppers), V71191 (Obsolete)
- 5 - Fuller - O'Brien Corp., V72556 (Obsolete)
- 6 - Flint Ink Corp., V86045 (Obsolete)
- 7 - Boeing Paint Tinting Facility, V81205 - See *[4]
- 8 - Akzo Coatings America, Inc., Sikkens Aerospace Finishes Div., V98502
- 9 - Courtaulds Aerospace (replaces DeSoto, Inc.) V85570
- 10 - Minnesota Mining & Mfg. (3M), V76381 (Obsolete)
- 11 - Dow Corning, V71984 (Obsolete)
- 12 - Reliance Universal, Inc., V86755
- 13 - Grow Group, Inc., U.S. Paint Div., V90608
- 14 - Sterling Paint and Lacquer Mfg. Co., V60003
- 15 - Crown Metro, V06367
- 16 - Mankiewicz Coatings, V32XV5

Coating Data
Figure 1 (Sheet 1 of 2)

20-41-01

**STANDARD OVERHAUL PRACTICES MANUAL**

X - X - X - XXX (cont)



Quality of Coating:

- 1 - Interior Decorative Coating, Spray-on, Hi-Speed Type quality
- 2 - Interior Decorative Coating, Silk Screen Type
- 3 - Epoxy Enamel, BMS 10-11, Type 2 quality
- 4 - Gloss Lacquer, MIL-L-7178 quality
- 5 - Lusterless Lacquer, TT-L-20
- 6 - Flexible Lacquer for use on vinyl extrusions or other flexible surfaces
- 7 - Acrylic coatings
- 8 - Alkyd Enamel coatings, BMS 10-4 (Obsolete)
- 9 - Silicone Elastomer
- 10 - Miscellaneous
- 11 - Interior Decorative Waterbase, BMS 10-55
- 12 - Polyurethane Enamel, BMS 10-60, Type 1
- 13 - Polyurethane Enamel, BMS 10-72
- 14 - Flexible Polyurethane Enamel, BMS 10-60, Type 2
- 15 - Polyurethane Enamel, BMS 10-83
- 16 - Polyurethane Enamel, BMS 10-60, Type 1 and 2
- 17 - Polyurethane Enamel, BMS 10-60, Type 1 and 2, and BMS 10-72, Type 9

Coating Data
Figure 1 (Sheet 2 of 2)

20-41-01