



Elimination and Replacement of Primer and Paint Part Numbers

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PURPOSE & SCOPE

This Internal Specification (IS) authorizes the replacement of various discontinued and inferior-performing primer and paint formulations. The purpose of these replacements is to:

1. Eliminate the use of Rust-Oleum primers and topcoats due to substandard environmental performance. The polyurethane topcoat to be used as the replacement is 7912239-XXX, where XXX is the drawing suffix most closely corresponding to the matching AMS-STD-595 color. The epoxy primer to be used as the replacement is 40010343-000 (MIL-PRF-23377 Type I, Class N) or alternate primer MIL-P-24441/20. See Tables 1, 2 and 3 for specific details.
2. Eliminate the use of M23377-1C-004Q primer which is formulated to contain hexavalent chromium (strontium chromate) per MIL-PRF-23377 Type I, Class C2. The primer to be used as the replacement is 40010343-000 (MIL-PRF-23377 Type I, Class N) or MIL-P-24441/20, except where another primer is specifically required by contract.
3. Eliminate the use of Mil-P-53022 primer, which is not compatible with the processes, equipment, and environmental conditions of the CSW paint shop. The primer to be used as the replacement is 40010343-000 (MIL-PRF-23377 Type I, Class N) or MIL-P-24441/20, except where another primer is specifically required by contract.
4. Eliminate the use of TT-P-1757 primer number 7914051-XXX, which may be formulated to contain hexavalent chromium (zinc chromate) per TT-P-1757, Class C2. The requirement in 7914075-XXX for a “yellow” color implies a chromated formulation. This is a single-component, alkyd-based primer, which also provides inferior environmental protection when compared to the two-component epoxy primer options. The primer to be used as the replacement is epoxy primer 40010343-000 (MIL-PRF-23377 Type I, Class N) or epoxy primer MIL-P-24441/20, except where another primer is specifically required by contract.
5. Eliminate the use of TT-E-527 topcoat material number 7910840-XXX. This is a single- component, flat, alkyd-based top coat, which provides inferior environmental protection when compared to the two-component polyurethane top coat option. Furthermore, this specification was cancelled on July 26, 1999 without replacement. The top coat to be used as the replacement is 7912239-XXX, where XXX is the drawing suffix corresponding to the matching AMS-STD-595 color. It shall be used except where another top coat is specifically required by contract.
6. Eliminate the use of TT-E-529 topcoat material number 7910766-XXX. This is a single- component, semi-gloss, alkyd-based top coat, which provides inferior environmental protection when compared to the two-component polyurethane top coat option. Furthermore, this specification was cancelled on July 23, 1999.

The top coat to be used as the replacement is 7912239-XXX, where XXX is the drawing suffix corresponding to the matching AMS-STD-595 color. It shall be used except where another top coat is specifically required by contract.

- Eliminate the use of TT-E-489 topcoat material number 7910839-XXX. This is a single- component, gloss, alkyd-based top coat, which provides inferior environmental protection when compared to the two-component polyurethane top coat option. Furthermore, this specification was cancelled on July 30, 1999 without a specific replacement. The top coat to be used as the replacement is 7912239-XXX, where XXX is the drawing suffix corresponding to the matching AMS-STD-595 color. It shall be used except where another top coat is specifically required by contract.

This internal specification is applicable to all CSW Bills of Material (BOM's) and drawings and shall take precedence over all other existing CSW drawings, policies, or procedures. Break in shall be as follows:

- Effective immediately, each Rust-Oleum part number shall be replaced by the appropriate CSW material number(s) as shown in Tables 1, 2, and 3.
- Replacement of the M23377-1C-004Q and MIL-P-53022 primers shall begin as of May 27, 2008.
- Replacement of TT-P-1757 alkyd primer and TT-E-527 alkyd topcoat shall begin as of February 14, 2012.
- Replacement of TT-E-529 and TT-E-489 alkyd topcoats shall begin as of August 31, 2014.

The Paint Contact in Component Engineering shall be responsible for the review and update of this IS.

It is the responsibility of the Paint Contact in Component Engineering to coordinate reviews and updates of this specification with the Paint Shop Process Engineer. It is the responsibility of the Paint Shop Process Engineer to work with and direct Paint Shop personnel to implement the substitutions as contained herein. It is also the responsibility of Supply Chain Management personnel to prevent future orders of items earmarked for replacement/elimination.

INTERNAL SPECIFICATION

Rust-Oleum part numbers will be replaced according to **Table 1** for **Gloss White**, **Table 2** for **Gloss Gray**, and **Table 3** for **Gloss Red**.

Table 1 : Rust-Oleum Gloss White Replacement Part Numbers

Gloss White			
Replace Primer	2842749-000	With	40010343-000 or alternate, MIL-P-24441/20
Do not use Primer Activator	2842750-000		
Replace Paint Resin and Paint Activator	2842747-000	With	7912239-017 (kit)
	2842748-000		

Table 2 : Rust-Oleum Gloss Gray Replacement Part Numbers

Gloss Gray			
Replace Primer	2842749-000	With	40010343-000 or alternate, MIL-P-24441/20
Do not use Primer Activator	2842750-000		
Replace Paint Resin and Paint Activator	2842747-001	With	7912239-034 (kit)
	2842748-000		

Table 3 : Rust-Oleum Gloss Red Replacement Part Numbers

Gloss Red			
Replace Primer	2842749-000	With	40010343-000 or alternate, MIL-P-24441/20
Do not use Primer Activator	2842750-000		
Replace Paint Resin and Paint Activator	2842747-002	With	7912239-033 (kit)
	2842748-000		

END OF DOCUMENT

DOCUMENT INFORMATION

Responsible Organization: Component Engineering

Function/Sub-function: NA

Governing Document(s): Y-001, Quality Management System

Subordinate Document(s): NA

Related Document(s): 2842747, Rust-Oleum Aliphatic Polyurethane Enamel Resin
 2842748, Rust-Oleum Activator Component for Resin
 2842749, Rust-Oleum Epoxy Primer Resin
 2842750, Rust-Oleum Activator Component for Primer
 MIL-P-53022, Primer, Epoxy Coating Corrosion Inhibiting
 M23377-1C-004Q, Primer, Chromated Epoxy Polyamide
 7912239, Polyurethane Coating: MIL-PRF-85285
 7910840, Enamel, Lusterless, TT-E-527
 7910766, Enamel -- Semigloss, TT-E-529
 7910039, Enamel, Gloss, TT-E-489
 AMS-STD-595, Colors used in Government Procurement
 40010343, Primer Coating, Non-Chromated Epoxy-Polyamide: MIL-PRF-23377
 MIL-P-24441/20, Paint, Epoxy-Polyamide, Green Primer, Formula 150, Type III

Related Training: NA

Approval Requirements: Document Control Administrator
 Manager, Component Engineering
 Paint Shop Process Engineer
 Engineering Representative
 Quality Representative
 Operations Representative

Review Requirements: DCMA

Revision History Summary

Revision #	Description of Change	Date
00	Initial release	06-15-2006

Revision #	Description of Change	Date
01	24 Month review. The Paint Shop is actively working with Standards Engineering to qualify a non-toxic version of MIL-PRF-23377. During the interim, there are two primers that may be used as acceptable replacements to M23377-1C-004Q. These are listed on this updated revision of the internal spec.	11-05-2008
02	A less-toxic version of MIL-PRF-23377 has been qualified for use and is known as 40010343-000. It has also come to our attention in Component Engineering that the wash primer (DOD-P-15328) is also chromated and therefore MIL-P-53022 requires substitution. 40009369-000 has been removed from this document due to its poor performance.	12-15-2008
03	24 Month review. Changed contact name. Added TT-P-1757 & TT-E-527 to Purpose and Scope.	2/14/2012
NA	Updated legacy terms with new system terms. Changed part numbers with a "+" to a "-". Changes made indicated in blue text. No revision upgrade necessary.	11/08/2013
04	Changed title and contact name. Overall update to clarify and bring document into compliance with the latest data and to satisfy CAR 0640120130101 (CAPA 130217). Modified approval requirements. Moved subordinate documents to related documents. Changes are indicated with blue text.	9/25/2014
05	Added specification content to latest approved template. Changed from "FED-STD-595" to "AMS-FED-595" throughout document. Change from "L-3 CS-W" to "CSW".	9/30/2025