

SERVICE

MEMO

650825

Service Memo No. 70C
(Supersedes Service Memo No. 70B)

APPLICATION OF RANDACRYL LACQUER

We outline the following procedure with the intention of illustrating the refinishing procedure for airplanes with enamel type finish and airplanes finished with acrylic lacquer.

Procedure For Airplanes With Enamel Type Finish

1. Remove all finish from the metal surfaces of the aircraft with Rand-O-Strip B-5000 following the directions on the can.
2. Apply one coat of Randolph Wash Primer following the directions on the can and taking care to apply a thin but wet coat.
3. Recoat after one hour and before forty-eight hours with one full wet coat Randolph Zinc Chromate Primer #656.
4. After an overnight dry, rub down the surface with clean dry Kraft paper. Tack rag. Then apply three coats of Randacryl in the color of your choice thinning with Randacryl Thinner B-0161 in the ratio of 1-1/4 parts thinner to 1 part Randacryl. Both aircraft surface temperature and air temperature should be above 70⁰ F when spraying Randacryl. Allow at least one-half hour drying time between coats. The gloss of the final coat can be improved by using Randacryl Retarder B-5276 in the proportion of about one-fourth of the thinner used.
5. This completes the finish. When taping a completed finish for application of trim colors or for any other reason, a full overnight dry should be allowed if retarder has been used to flow out the top coat. It is always best to remove tape as soon as the other colors have been applied.

Procedure For Airplanes Finished With Acrylic Lacquer

1. Rub down the surface with clean dry Kraft paper. (Ascertain that the surface is thoroughly cleaned, wax removed, etc.) Tack rag. Then apply three coats of Randacryl in the color of your choice thinning with Randacryl Thinner B-0161 in the ratio of 1-1/4 parts thinner to 1 part Randacryl. Both aircraft surface temperature and air temperature should be above 70⁰ F when spraying Randacryl. Allow at least one-half hour drying time between coats. The gloss of the final coat can be improved by using Randacryl Retarder B-5276 in the proportion of about one-fourth of the thinner used.
2. This completes the finish. When taping a completed finish for application of trim colors or for any other reason, a full overnight dry should be allowed if retarder has been used to flow out the top coat. It is always best to remove tape as soon as the other colors have been applied.

(over)

TOUCH-UP DIRECTIONS

- T-1. If only a small area on the aircraft is to be finished and it is not desired to strip the old finish from the aircraft, wash the area to remove thoroughly all wax, grease and dirt.
- T-2. Sand area lightly.
- T-3. Apply a light coat of Randolph Zinc Chromate Primer. Or where bare metal shows, prime according to directions under procedure for airplanes with enamel type finish #2 and #3 above. Or Randolph Epibond Primer can be used on bare metal areas.
- T-4. PLEASE NOTE: When coating over any finish with Randacryl, the system should be tested on a small area before proceeding.
- T-5. Follow directions above to complete your Randacryl finish.

NOTICE

Randacryl is not intended for use on fabric or directly over enamels.

A RECOMMENDED RANDOLPH FINISHING SYSTEM FOR AIRCRAFT
ENGAGED IN AGRICULTURAL ACTIVITIES

The cleaned metal surface should be coated with Epibond Primer (2-component Epoxy Finish).

INSTRUCTIONS FOR USE

Mix equal parts of Epibond Primer #-2248 with Epibond Mixing Component W-2249. Allow to stand for 1/2 hour before using.

Apply a thin wet coat

Air Dry to Handle - 2 to 3 hours

Dry Hard - Overnight

Pot Life - Approx. 24 hours.

This primer, when completely through dried, (48 to 72 hours), will not be softened by dope solvents nor any of the commonly used agricultural chemicals. Hence, it is advantageous on steel tubing, aluminum and magnesium surfaces. It offers excellent adhesion for top coats of finishing material.

All metal surfaces (cowlings, struts, fairings, etc.) should be top coated with Randacryl (a proprietary acrylic formulation). Randacryl resists the action of agricultural chemicals as well as any currently conceived finishing material, while possessing excellent gloss, gloss retention and flexibility. All of these characteristics produce a finish that has excellent outdoor durability.

All fabric surfaces can be treated with Randolph Butyrate Finishes: Experience indicates that the Randolph Butyrate formulations resist most of the agricultural chemicals currently being dispersed from aircraft. The suggested methods of application are described in the Refinishing Manual.