

# SERVICE LETTER

Stinson Division  
Consolidated Vultee Aircraft Corporation  
Wayne, Michigan

To: Distributors, Direct Factory Dealers and  
Distributor's Dealers

Letter No. 58

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Title: Field Refinishing Procedure

Date: May 15, 1947

Gentlemen:

The procedure outlined below should be followed in repairing paint failure on metal surfaces. If only a section of the metal surface is to be painted, follow the instructions concerning paint removal outlined under paragraph No. 1. If the entire metal surface is to be repainted, remove all the paint with the use of a standard high-quality wax-free paint remover.

1. With a scraper, wire brush or other suitable means, carefully remove all loosely adhering finish adjacent to the damaged or peeled area.
2. Sand the entire exposed metal area with No. 360 or No. 400 waterproof sandpaper, either dry or wet with residue free naptha. Feather edge the area by sanding lightly along the edges to smooth them off.
3. Treat the metal surface with a good phosphoric acid base cleaner, such as Metalprop (Neilson Chemical Company, 6564 Benson Street, Detroit, Michigan) or Deoxidine (American Chemical Paint Company, Ambler, Pennsylvania). Use a wipe-off type cleaner and dilute for use and apply according to the manufacturer's directions. Allow to remain on the metal for three to four minutes, wet again with the acid - cleaning agent, and immediately wipe dry with clean cloths. Be sure to remove all acid from cracks, crevices, etc., where sections join. Follow with a wipe using an equal parts mixture of alcohol and water, using new clean cloths.
4. Spray a thin coat (not over 0.5 mil, metal should be plainly visible, and coat has a greenish color) of DuPont No. 63-1016 Zinc Chromate Primer (or equivalent), reduced one volume of primer with three volumes of DuPont T-8806 Thinner (or equivalent). Allow to dry at least one hour.
5. On planes prior to serial 108-2443 the metal parts were not treated by the Alodine Process, and it is recommended that the following be done:

Spray a wet coat of DuPont No. 233-1567 Dark Gray Primer Surfacer, reduced one part of dark gray with one part (equal parts) of DuPont 3614 Thinner. Allow to dry at least thirty minutes.
6. Spray a wet coat of the proper color lacquer topcoat reduced equal parts with thinner. Allow to dry thirty minutes. Spray a second coat of the lacquer reduced in the same manner.

7. Refinished area may be rubbed and polished, if desired, after twenty-four hours' air drying.

CAUTION: Do not attempt to speed up the drying times shown between finishing operations. Failure to observe these times will result in further flaking and peeling difficulties.

Be sure to use correct thinners as listed on page 1.

Stir all materials thoroughly before reducing and spraying.

Brush applicator may be used for extremely small areas. Spray is preferred procedure in all other instances.

DuPont No. 233-1567 Surfacer and 3614 Thinner may be ordered from us in one gallon minimums.

Yours very truly,

Stinson Division  
Consolidated Vultee Aircraft Corporation

George Martin  
Service Manager