



GCS

FINISH SPECIFICATION  
IMRON WHITE  
1000-0027-01 REV A  
JAN 3, 2018

## **FINISH SPECIFICATION: L3 GCS IMRON WHITE**

### **1.0 SCOPE:**

This specification details the approved color specification color reference numbers for L3-GCS White IMRON finish coating.

### **2.0 ORDER OF PRECEDENCE:**

In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

### **3.0 APPROVED PRIMER(S)/ FILLER(S):**

- 3.1 Sherwin Williams: High Build Polyester Primer Surfacer HDR22
- 3.2 Cromax Premier, LE3404S Urethane Primer Filler Grey – ValueShade 4
- 3.3 Cromax V-2940S DTM Epoxy Primer Gray - ValueShade 4
- 3.4 Spies Hecker Raderal Spray Polyester 3508, Spies Hecker Permasolid Spectro Sealer 5450

### **4.0 APPROVED PAINT(S):**

- 4.1 IMRON FT 2.1+, White, Color 37875 per FED-STD-595

### **5.0 PROCEDURE FOR REWORKING GLOSS FINISHES:**

This procedure is to be used if reworking existing products painted with a gloss finish.

- 5.1 Remove all labels (i.e. serial number, radiation, warning, etc...)
- 5.2 Mask off hardware.
- 5.3 Lightly and evenly scuff all surfaces with 3M Scotch-Brite pad. Being careful not to scuff through the sealing primer.
- 5.4 Clean surface of residue
- 5.5 Paint new Flat Top-Coat

### **6.0 FINISH THICKNESS:**

Thickness should be in accordance with the manufacturer's specifications and should result in even coverage. Areas that contain heatsink fins, bosses, counter-bores, and other profile irregularities may result in a thicker or thinner finish.



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**7.0 QUALITY REQUIREMENTS:**

All finished parts are to be in accordance with applicable L-3 GCS Finished Material Workmanship Standards (L-3 GCS Part Number 1000-0100-01).

**8.0 PACKAGING & DELIVERY REQUIREMENTS:**

All finished parts are to be packaged and delivered per applicable L-3 GCS Packaging Requirements (L-3 GCS Part Number 1000-0101-01).