

Chemical Agent Resistant Coating Process Certification

Tulmar P/N	Description	Dwg # / Revision	Qty
Tulmar PO #	Line Item #	Supplier Name / Address	Supplier Packing Slip #

<u>CLEANING</u>	<input type="checkbox"/>	TT-C-490 Method I	<input type="checkbox"/> Other: _____
	<input type="checkbox"/>	TT-C-490 Method III	
<u>PRETREATMENT</u>	<input type="checkbox"/>	Alodine 5200 / 5700	<input type="checkbox"/> MIL-C-8514
	<input type="checkbox"/>	DOD-P-15328	<input type="checkbox"/> MIL-DTL-5541 Type:___ Class:___
	<input type="checkbox"/>	TT-C-490 Type I	<input type="checkbox"/> Other: _____
	<input type="checkbox"/>	MIL-A-8625	
<u>PRIMER</u>	<input type="checkbox"/>	MIL-DTL-53022	Manufacturer: _____
	<input type="checkbox"/>	MIL-DTL-53030	Product: _____
	<input type="checkbox"/>	MIL-DTL-0053084	Batch: _____
	<input type="checkbox"/>	MIL-PRF-23377	<input type="checkbox"/> On the QPL (When directed by the Military spec)
	<input type="checkbox"/>	MIL-PRF-85582	Include batch # for component A and B
	<input type="checkbox"/>	Other:	
<u>TOPCOATING</u>	<input type="checkbox"/>	MIL-C-46168	Manufacturer: _____
	<input type="checkbox"/>	MIL-DTL-53039	Product: _____
	<input type="checkbox"/>	MIL-DTL-64159	Batch: _____
	<input type="checkbox"/>	MIL-P-14105 (Heat)	<input type="checkbox"/> On the QPL (When directed by the Military spec)
	<input type="checkbox"/>	MIL-PRF-22750 (Interior)	Include batch # for component A and B
	<input type="checkbox"/>	Other:	
<u>COLOUR</u>	<input type="checkbox"/>	Green 383, Chip #34094	<input type="checkbox"/> Seafoam Green, Chip #24533
	<input type="checkbox"/>	Tan 686A, Chip #33446	<input type="checkbox"/> Black, Chip #37030
	<input type="checkbox"/>	White, Chip #17925	<input type="checkbox"/> Other:
<u>TESTING</u>	Pass	Fail	Corrosion Resistance: _____
	<input type="checkbox"/>	<input type="checkbox"/> Adhesion Test	(Date of last test)
	<input type="checkbox"/>	<input type="checkbox"/> Dry Film Thickness	
	<input type="checkbox"/>	<input type="checkbox"/> Solvent Wipe	

Supplier can demonstrate compliance with Page 2 of this form : Yes No

Surface treatment processes are free from Hexavalent Chromium : Yes No

Surface treatment processes comply with MIL-DTL-53072 : Yes No

**COPIES OF ORIGINAL MANUFACTURER(S) PAINT AND PRIMER CERTIFICATIONS
MUST BE AVAILABLE UPON REQUEST**

Signature	Name	Date (DD-MM-YY)
Title	Email	Phone #

PROCESS REQUIREMENTS

The supplier shall be able to demonstrate compliance to the following requirements:

1. Ferrous substrate pretreatment and primer application in accordance with TT-C-490.
2. Application of primer procured from the appropriate Qualified Products List.
3. Application of topcoat procured from the appropriate Qualified Products List.
4. Reducers used in coatings must meet MIL-T-81772.
5. CARC application process shall be in accordance with MIL-DTL-53072.
6. Testing must be provided in accordance with the following practices, and may be required as often as once per day, or on every batch of CARC-painted product. Records shall be maintained for all testing.
 - 6.1. Solvent Wipe:
Testing must be performed in accordance with MIL-DTL-53072, paragraph 4.2.3.2. When the coating system is oven-cured, 168 hours of air dry is not necessary. Testing can be performed at the contractor's discretion after it is deemed that full cure has been achieved. MIL-T-81772 Type I solvent can be substituted for methyl ethyl ketone and acetone.
 - 6.2. Dry Film Thickness:
Testing must be performed in accordance with MIL-DTL-53072, paragraph 4.2.3.3.
 - 6.3. Adhesion:
Testing must be performed in accordance with MIL-DTL-53072, paragraph 4.2.3.6.1 after full cure of the coating system. Removal of two or more squares of topcoat or topcoat/primer shall constitute failure.
 - 6.4. Corrosion Resistance:
Provision must be made for salt spray testing in accordance with MIL-DTL-53072, paragraph 4.2.3.7. This testing can be conducted at the contractor's own plant or a third party testing laboratory. Three specimens are to be provided. Where the use of production parts is not practical, sample panels may be used, provided that they accurately represent the production painting process. The salt spray test must be performed to qualify the CARC process. Re-qualification is required when the process has been changed or when directed by Tulmar.