



AEROSPACE MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.
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AMS 3108B

Superseding AMS 3108A

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PRIMER, OCHER
Phenolic

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1. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

2. TYPE: Semi-gloss baking yellow-tan.

3. APPLICATION: As a prime coating on metal surfaces before enameling.

4. COMPOSITION (By Weight):

4.1 Product:

	min	max
Nonvolatile	60	--
Volatile	--	40

4.1.1 Nonvolatile:

	min	max
Resin	48	50%
Pigment	50	52%

4.1.1.1 Resin: Shall be a thermosetting phenolic type with softening agents added. It shall be free from rosin, rosin derivatives, oils, and cellulose derivatives.

4.1.1.2 Pigment: Shall be a natural ocher.

4.1.2 Volatile: Shall be an organic solvent composed of one or more of the following types of compounds: alcohols, esters, hydrocarbons, and ketones.

5. TECHNICAL REQUIREMENTS: When ASTM methods are specified for determining conformance to the following requirements, tests shall be conducted in accordance with the issue of the ASTM method listed in the latest issue of AMS 2350.

5.1 General: Primer shall be of uniform consistency and free from bubbles, grit, rough particles, floating or caked pigments, and ingredients of respiratory toxicity under normal conditions of use. Component ingredients shall be intimately mixed and processed as required to produce a product which is stable and not subject to abnormal change with age in sealed containers.

5.2 Coarse Particles: Not more than 0.1% by weight of the primer shall be retained on a No. 325 screen, determined in accordance with ASTM D185.

5.3 Flash Point, Tag Closed Tester: Shall be not lower than 60 F (16 C), determined in accordance with ASTM D56.

5.4 Viscosity: Shall be 9 - 13 poises absolute at 77 F (25 C) not less than 24 hr after manufacture.

5.5 Skinning and Livering: Shall be absent in a 1/4-filled closed container after standing for 1 week at room temperature.

5.6 Color: Shall be yellow-tan, characteristic of ocher.