

SERVICE



MEMO

Service Memo No. 27

REJUVENATING AND REFINISHING PROCEDURE FOR AIRPLANES FINISHED WITH NITRATE DOPE

We outline the following procedure with the intention of illustrating the refinishing procedure for airplanes which are finished with Nitrate dope and which are to be refinished with Butyrate dope, or "Duraclad".

1. The airplane should be completely dismantled for ease of cleaning and preparation.
2. All fabric surfaces should be thoroughly washed and cleaned to remove all traces of dirt, grease or wax.
3. All fabric surfaces should be carefully water sanded to remove any remaining traces of wax, or dirt, and to remove the outside oxidized surface of the dope.
4. After the fabric surfaces have been water sanded and wiped clean, spray two (2) coats of rejuvenator. Each coat should be heavy enough to thoroughly saturate the dope film. However, it should not be allowed to run.
5. Allow the rejuvenator to dry for approximately eight (8) hours.
6. Spray with two (2) coats of the final finishing material of Butyrate dope, or "Duraclad".
7. If crazing appears in any area, resand the areas smooth and reapply the finishing material.

Note 1: Care should be exercised when refinishing red, as it will bleed through if a different color of finishing material is to be applied over it.

Note 2: If a pressure gun is used to do the work, three (3) parts of rejuvenator should be mixed with one (1) part of retarder.

Note 3: If a suction gun is to be used, mix one (1) part of rejuvenator with one (1) part of retarder.

Note 4: The retarder to be used is a special retarder, put out by the Randolph Products Company, Carlstadt, New Jersey, and it is called Cellusolve Acetate Number X-8975.

Note 5: The rejuvenator to be used is a special rejuvenator, also put out by the Randolph Products Company, Carlstadt, New Jersey, and it is Number 260.

PIPER AIRCRAFT CORPORATION. LOCK HAVEN, PA., U. S. A.

**THE FOLLOWING IS A PROCEDURE FOR REMOVING RINGWORM OR STRAIGHT
CRACKS IN RANDOLPH CELLULOSE ACETATE BUTYRATE DOPE
USING A SPECIAL SOLVENT PIPER CODE 751 500 (Quarts)**

1. Use a stiff brush and work the solvent into the dope film, using a circular motion. This action should be continued until all the dope is removed from the area of the crack. The raw fabric will be showing. The dope should be thoroughly cleaned away from all extremities of the crack for a distance of at least one (1) inch.
2. Allow the surface to dry and then sand smooth. It will automatically "feather" the edges of the dope. Be careful not to sand the raw fabric too severely.
3. Clean very thoroughly the entire surface that will be sprayed when refinishing the effected areas.
4. Build up the area from which the dope was removed by ushing the following procedure:

One coat clear

Sand

Two coats clear

Sand

Three coats clear

Sand

Two coats silver

Sand

Three coats desired color pigmented dope.