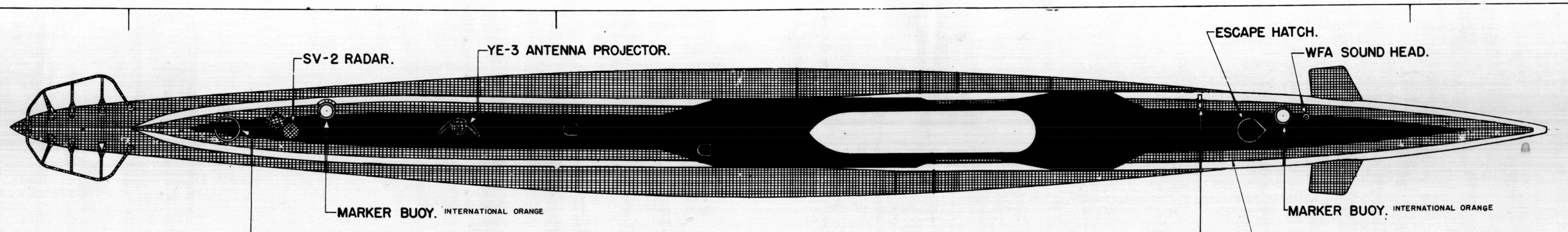
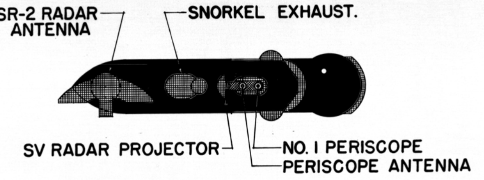
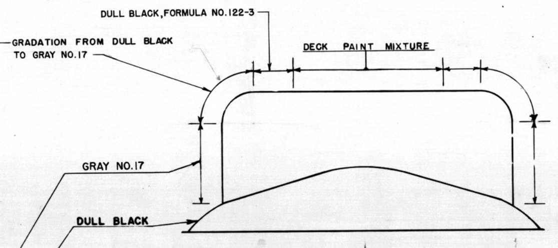
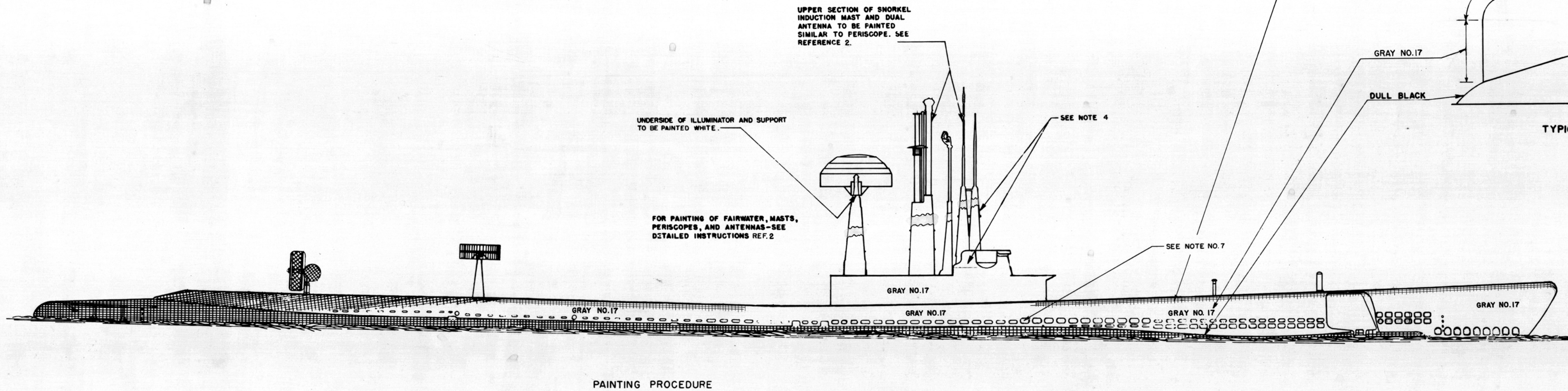
SSR481-S1901-1225634







TYPICAL SECTION



GENERAL NOTES

1. THIS PLAN DRAWN FROM PROFILE OF SS 481. MINOR VARIATIONS IN LOCATIONS OF APPENDAGES ON OTHER VESSELS OF THIS CLASS ARE NOT INDICATED ON THIS PLAN. ALL APPENDAGES TO BE CAMOUFLAGE PAINTED IN ACCORDANCE WITH DIRECTIONS AS NOTED ON THIS PLAN REGARDLESS OF MINOR LOCATION VARIATIONS.

2. THIS PLAN SUPERSEDES PLAN NO. SSR 419-S1907-935210 ALT 2 PORTSMOUTH PLAN NO. 4111-419.

3. THIS PLAN SUPERSEDED BY PLAN NO. SSR 276-S1901-1367263 FOR VESSELS LISTED UNDER CANCELATION "a".

PAINTING PROCEDURE

1. THE CORRECT USE OF THE SPRAY GUN CANNOT BE OVER EMPHASIZED. "HOW TO USE A SPRAY GUN TO GET SPECIAL CONCEALMENT EFFECTS" ON PAGES 20 TO 27 AND THE DETAILED INFORMATION NECESSARY FOR PAINTING CAMOUFLAGE MEASURE SS17F ON PAGES 64 TO 68 OF REFERENCE 2 SHALL BE REQUIRED READING FOR ALL PAINTERS BEFORE STARTING THIS MEASURE.

2. THE FOLLOWING PAINT SHALL BE USED FOR CAMOUFLAGE PAINTING OF SSR TYPE SUBMARINES IN MEASURE SS17F.

PAINT	FORMULA NO.	STOCK NO.
WHITE	122-82	
GRAY NO. 7	122-7	G52-P-5270-88
GRAY NO. 17	122-17	G52-P-5270-92
GRAY NO. 27	122-27	G52-P-5270-94
GRAY NO. 37	122-37	
DULL BLACK	122-3	G52-P-5270-70
GLOSS BLACK	122-1	G52-P-5270-65
INTERNATIONAL ORANGE		

DECK PAINT MIXTURE (1 PART GRAY NO. 7 FORMULA 122-7 AND 5 PARTS GLOSS BLACK FORMULA 122-1.)

F 3. THE VINYL SYSTEM SHALL CONSIST OF THE FOLLOWING: ONE COAT WASH PRIMER TREATMENT, FORMULA 117; FOUR COATS VINYL PRIMER, FORMULA 119 OR 120; & THREE COATS OF VINYL-ALKYD TOPCOAT, FORMULA 122 OF THE APPROPRIATE COLOR. ON STEEL SURFACES, VINYL PRIMERS 119 OR 120 MAY BE USED TO INSURE COMPLETE COVERAGE OF EACH COAT. ON ALUMINUM SURFACES, ONLY FORMULA 120 SHALL BE USED. TOTAL FILM THICKNESS SHALL BE TEN MILS MINIMUM. DARKENED VINYL PRIMER FORMULA 119 SHALL BE USED BENEATH THE VINYL-ALKYD TOPCOATS ON STEEL SURFACES SUBJECT TO CAMOUFLAGE.

4. THE BASIC SHADE FOR THIS CAMOUFLAGE MEASURE IS GRAY NO. 17, FORM. 122-17. IT SHALL BE APPLIED TO THE VERTICAL SIDES FROM THE PRESSURE HULL TO THE TOPMOST PART OF THE BOAT EXCEPT AS HEREAFTER NOTED AND ILLUSTRATED IN NAVSHIPS 250-374 PAGES 64-68.

5. DECK PAINT MIXTURE SHALL BE APPLIED TO ALL DECKS EXCEPT ON THE ROUNDED EDGES WHERE DULL BLACK FORMULA NO. 122-3 IS USED ASD ILLUSTRATED IN REF. 2. DECK PAINT MIXTURE SHOULD NOT BE USED ON SURFACES THAT ARE INCLINED AT MORE THAN 10 DEGREES FROM THE HORIZONTAL.

6. DULL BLACK FORMULA 122-3 SHALL BE APPLIED TO ALL ROUNDED SURFACES FACING GENERALLY UPWARD, INCLUDING THE ROUNDED EDGES OF DECKS, THE UPTURNED ROUNDED SURFACES OF RADAR, THE ROUNDED TOP OF SONAR DOMES, ALL HANDRAILS, THE TOP OF THE PRESSURE HULLS, AND TANKS BETWEEN THE LOW WATER LINE AND SUPERSTRUCTURE. DULL BLACK NO. 122-3 IS USED FOR SPATTER GRADATION AS SHOWN ON PAGES 64-68 OF NAVSHIPS 250-374.

7. GRAY NO. 27 FORMULA 122-27 SHALL BE APPLIED TO ALL OF THE VERTICAL OR NEARLY VERTICAL SURFACES THAT ARE INSIDE OF THE BRIDGE STRUCTURE AND TO ALL SURFACES 6 INCHES OR MORE INSIDE LIMBER HOLES THAT CAN BE REACHED BY A PAINTER STATIONED NEAR THE WATER LINE OUTSIDE THE BOAT, AND TO THE TOP OF THE HULL THAT IS COVERED WITH THE SUPERSTUCTURE.

8. GRAY NO. 27 FORMULA 122-27 SHALL ALSO BE USED INSIDE THE BRIDGE WHERE WHITE OR DECK BLACK DO NOT APPLY.

9. GRAY NO. 27 FORMULA 122-27 SHALL BE APPLIED IN SOLID COAT TO PERISCOPE NECKS AND STREAMLINED PERISCOPE FAIRINGS AS THE BACKGROUND SHADE FOR DARK SPOTTING.

10. GRAY NO. 7 FORMULA NO. 122-7 SHALL BE USED FOR THE DARK SPOTS ON PERISCOPE NECKS AND FAIRINGS. HOW TO PAINT PERISCOPES IS DESCRIBED IN REF 2 PAGE 24.

11. WHITE NO. 122-82 SHALL BE APPLIED IN SOLID COAT TO THE OVERHEAD AND ALL OTHER AREAS OF THE BRIDGE EXCEPT THOSE PORTIONS WHICH MAY BECOME EXPOSED TO THE DIRECT RAYS OF THE SUN.

12. WHITE NO. 122-82 SHALL BE APPLIED TO THE INTERIOR OF THE SUPERSTRUCTURE ABOVE THE HULL AND BELOW THE MAIN DECK (FORWARD OF THE CONNING TOWER) INCLUDING THE UNDERSIDE OF THE MAIN DECK AND THE INTERIOR OF THE SIDES. AFT OF THE CONNING TOWER, INSIDE THE SUPERSTUCTURE, IS UNIMPORTANT. WHITE SHALL NOT BE APPLIED TO THE TOP OF THE HULL, EVEN BENEATH THE MAIN DECK.

13. SNORKEL EXHAUST BAFFLE PLATES (WHERE APPLICABLE): THE TOP OF THESE PLATES, THAT IS, THE HORIZONAL SURFACE WHICH FACE UPWARD, SHALL BE PAINTED BY BRUSH WITH DULL BLACK NO. 122-3, THE UNDER SIDE OF THESE PLATES SHALL BE PAINTED BY BRUSH WITH PURE WHITE, FORMULA NO. 122-82.

14. SHIPS NO. SHALL BE PAINTED ON THE FAIRWATER IN WHITE FORMULA 122-82, WITHOUT SHADING, AND LOCATED IN ACCORDANCE WITH STD PLAN BU NO. S2804-860346.

15. PAINT REFLECTING SURFACES OF NAVIGATIONAL LIGHTS GLOSSY BLACK NO. 122-1.

16. PARTICULAR CAUTION SHALL BE EXERCISED TO:
A. THOROUGHLY CLEAN SURFACE BEFORE PAINTING.
B. A KETONE SOLVENT (METHYL ISOBUTYL KETONE OR METHYL ETHYL KETONE OR A 50-50 MIXTURE OF KETONE & XYLOL) SHALL ALWAYS BE USED (ONLY WHEN NECESSARY) FOR THINNING PAINTS.

17. BARE SPOTS, RESULTANT FROM PEELING, MATERIALLY INCREASE EXPOSURE TO DETECTION BY ELECTRONIC OR MAGNETIC DEVICES AS WELL AS BY VISUAL MEANS.

18. OTHER THAN AS REQUIRED FOR SHADING, THREE COATS OF CAMOUFLAGE PAINT SHALL BE APPLIED OVER THE PRESERVATIVE AND PREPARATION COATINGS.

AUTHORITY:

NAVSHIPS 250-374 (SHIP CONCEALMENT CAMOUFLAGE INSTRUCTIONS)

LIST OF MATERIAL

QUANTITY FOR ONE VESSEL

PC NO	NAME	MAT'L	SPEC NO.	PAT. OR DWG NO.	SOURCE	REMARKS

REFERENCES

NO.	TITLE	BUSHIPS NO.	PORTS NO.
F 3	SUBMARINE PAINTING INSTRUCTIONS	BUSHIPS INST 9190.7 OF 10 NOV 1953	
2	SHIP CONCEALMENT CAMOUFLAGE INSTRUCTIONS	NAVSHIPS 250-374	
1	PAINTING SCHEDULE	SSR419-S1901-935209 ALT. 3	4110-419

APPLIES TO

"a" ~~267~~	489	
"a" ~~269~~		
"a" ~~270~~		
"a" ~~271~~		
"a" ~~272~~		
"a" ~~274~~		
312		
419		
481		

THREADS
ALL THREADS TO BE NAT'L STD COARSE
THREAD FITS { STUDS-SETTING END FITS / ALL OTHERS FIT 3
UNLESS ESPECIALLY MARKED

FINISHES
ALL SURFACE FINISHES INDICATED ARE IN ACCORDANCE WITH MIL. STD-10

WELDING SYMBOLS IN ACCORDANCE WITH JAN. STD 19

REVISION	DATE	DESCRIPTION	BY	APPVD
F	6/2/54	MOD. PROCEDURE NOTE 3 & ADDED REF 3 IN ACCORDANCE WITH BUSHIPS LTR SS/S19(374) SER 374-22 OF 29 APR 1954 (49820)	WM LM	
E	3/6/54	MODIFIED NOTES TO CONFORM WITH COMSUBLANT INSTRUCTIONS 09190.1B 403 SER 0315 OF 17 FEB 1954 & CHANGED CLASSIFICATION FROM CONFIDENTIAL TO UNCLASSIFIED & MADE GENERAL CHANGES IN ACCORDANCE WITH BUSHIPS LTR C-ALL/VISUAL (374) SER 374-02 OF 4 FEB 1954	LM	
D	12/30/53	CHANGED CLASSIFICATION FROM RESTRICTED TO CONFIDENTIAL IN ACCORDANCE WITH BUSHIPS CONF. LTR. ALL/VISUAL (374) SER 374-035 OF 27 NOV 1953.	TRW	
C	10/2/53	CHANGED CLASSIFICATION FROM CONFIDENTIAL TO RESTRICTED, ADDED GENERAL NOTE 3, AND MADE GENERAL CHANGES TO CONFORM WITH BUSHIPS LTR S19 (374-533) SER 374-53 DATED 31 AUG 53	TRW H.E.S.	
B	6/3/52	CHANGED GENERAL NOTE NO. 2 IN ACCORDANCE WITH BUSHIPS RESTRICTED LTR SS/S1 (533) Ser. 533-1299 OF 14 MAY 1953	H.E.S.	

NAVAL SHIPYARD
PORTSMOUTH, N. H.

SSR
CAMOUFLAGE PAINTING

EXAMINED

OFFICIAL	SIGNATURE
TECHNICAL OFFICER	D. H. Kem
HEAD ENGINEER	Malk
SECT. HEAD	E. E. Tucker
GROUP HEAD	O. S. Torrington
UNIT HEAD	F. W. Lane
CHECKED	
TRACED	
DRAWN	R. L. Maynard

APPROVED D. H. Kem For DESIGN SUPERINTENDENT DATE 1/21/53

APPROVED BY DATE
NAVY DEPARTMENT BU. OF SHIPS
LETTER FS/L4-3(503), FS/L9-2, EN28/A2-6, SER. 503-8 OF 28 FEB. 1951

BU. OF SHIPS NO. SSR481-S1901-1225634 ALT. F

SCALE — SHEET 1 OF 1

PRINTS ISSUED

CODE 252 A

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