
British Railways Board
Chief Signal & Telecommunication Engineer's Department

PAINTING SCHEDULE

SIGNAL BOXES AND SIGNAL DEPARTMENT EQUIPMENT

Re-issue November 1973

RECORD OF AMENDMENTS

PAGE NUMBER	DATE OF AMENDMENT	AMENDED BY
31	JULY 1977	
31.	JAN. 1980	

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BRITISH RAILWAYS BOARD

DIRECTOR OF S & T ENGINEERING
REF. 206-66-80

DIRECTOR OF OPERATIONS
REF.MM/S/3/63

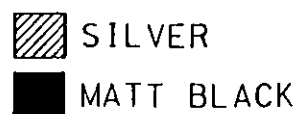
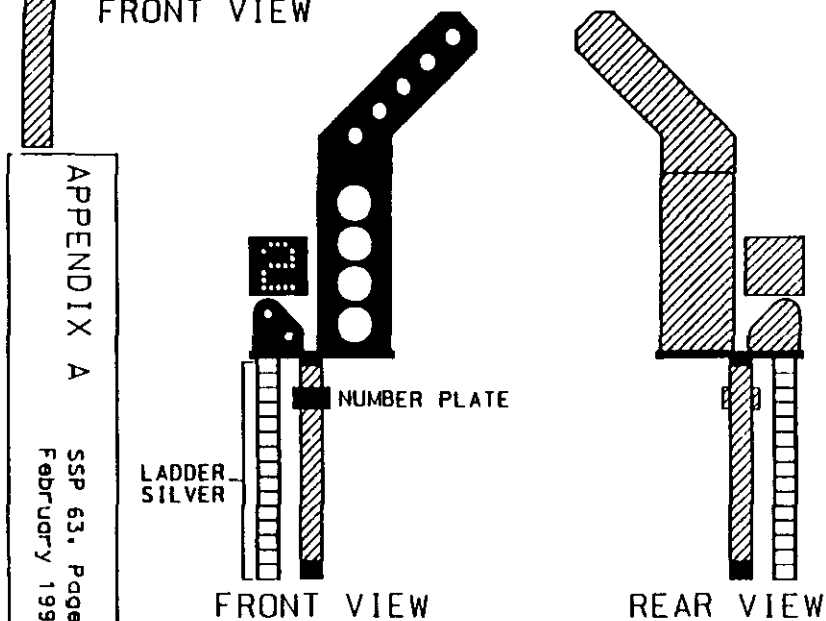
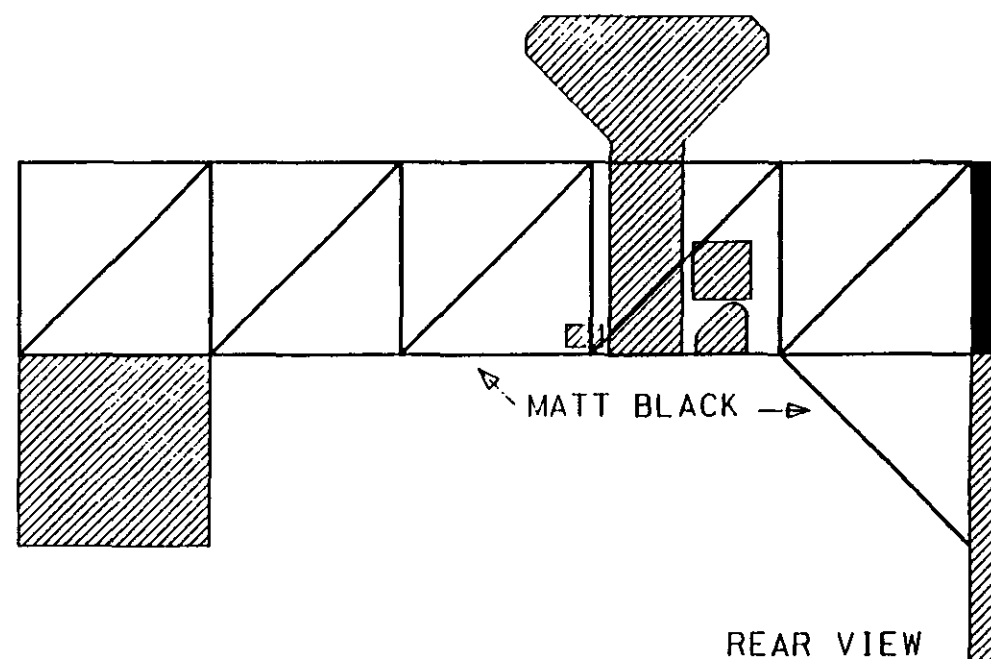
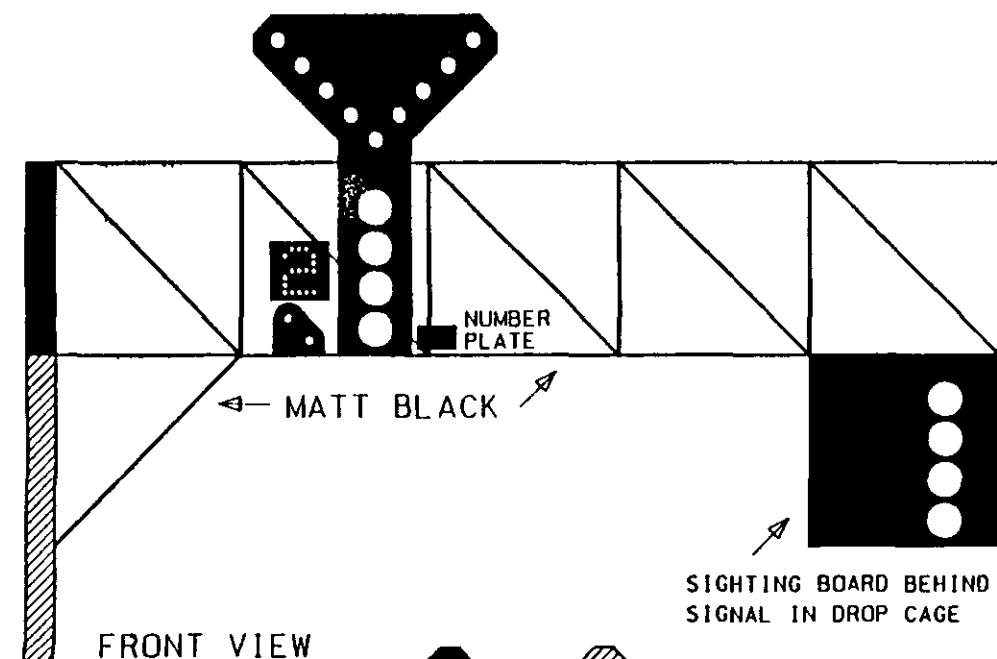
STANDARD No 63
SIGNALLING
PRINCIPLE

PAINTING OF COLOUR LIGHT SIGNAL HEADS

Signal heads shall be painted matt black as seen from trains to which the signal applies and the remainder of the head shall be painted silver.

Appendix A shows some examples of how to apply this SSP

SSP63, Page 1,
February, 1991



NOTES:-

1. Hoods for all aspects to be painted matt black on all surfaces except the rear which [when visible] will be painted silver.
2. Sides of all equipment shown above to be the same colour as the rear
3. Railings, safety hoops, etc to be matt black.
4. All Ladders to be painted silver.
5. All other forms of signal, [e.g. train drivers crossing indicator lights at level crossings] shall be painted in a similar manner.

AMENDMENTS RECORD AND BRIEFING NOTES.Issue Dated September 1992 : This sheet only - Page 3.

The introduction of a 'silver' painted back for signals was prompted by the desire to assist train drivers. The Rule Book requires a driver to stop his train if he approaches a signal that is not shown or imperfectly shown; Rule Book sections C 6.7. and C 6.8.. In order to do this it is necessary that he should readily be able to distinguish signals applicable to his train from those that apply to the opposite direction.

The need for easy identification of signals is especially important during "stage works" because the driver is presented with more signal heads. If the back of an "out of use" signal is not painted silver the back should have a cross attached in the same manner as the front of the signal.

The colour silver was chosen for the back of signals and the posts because signals painted in that colour stand out better against the background during twilight than ones painted in other colours.

SSP 63 takes precedence over spec. BR 10 and other instructions for the painting of signals; The relevant BR specs are in the process of being updated.

Acceptable silver paints include:-

Silicone alkyd silver finishing paint. BR cat number 28/007001

ALUMINIUM paint to BR spec. 81 item 533 catalogue No 28/44 320.

The galvanized parts of signals need not be painted because a galvanized surface is regarded as being silver; a part which was originally galvanized should be painted silver as required by SSP 63 once the galvanizing has been worn away or damaged.

This SSP shall be applied to all new works and RETROSPECTIVELY at the next repainting opportunity [S & T Committee min 90.241].

PAINING SCHEDULE FOR SIGNAL AND TELECOMMUNICATIONS EQUIPMENT AND HOUSINGS,
INCLUDING SIGNAL BOXES

This schedule supersedes all other instructions concerning the painting of Signal Boxes, Ground Frames, Signal and Telecommunications Apparatus and Equipment and Housings for same, and is issued under the authority of the Chief Signal and Telecommunications Engineer.

The scope of this schedule is defined in sections as follows:

SECTION

- 1) Departmental responsibilities for painting exterior and interior equipment including Signal Boxes. Page 2.
 - 2) Painting of equipment not covered by this schedule. Page 3.
 - 3) Frequency at which maintenance painting is to be carried out. Page 4.
 - 4) Details of surface preparation to be employed for New Work and Maintenance painting. Pages 5-10.
 - 5) Specification details of the Priming, Undercoating and Finishing Paints, to be employed including, Catalogue numbers. Pages 11-12.
- Painting Schedule. New Works. Page 15.
- Painting Schedule. Maintenance Work. Page 43.

SECTION 1. DEPARTMENTAL RESPONSIBILITIES FOR PAINTING EXTERIOR AND INTERIOR EQUIPMENT INCLUDING SIGNALBOXES.

The Signal Engineers Departments will be responsible for ensuring that the cleaning and painting of all Signal and Telecommunication equipment is carried out in accordance with this schedule.

This does not preclude the Civil Engineers Departments from carrying out the work on behalf of the Signal Engineers Department.

The paint employed, the surface preparation and the frequency of painting shall conform to the requirements of this schedule.

Due regard shall be paid to the contents of C.E. Code of Practice Handbook No. 10 which covers methods of surface preparation in greater detail.

CONTRACT WORK

All new Signal & Telecommunications equipment supplied in a part or ready painted condition shall have been treated in accordance with the requirements laid down in the schedule. All paints employed in the painting of Signal & Telecommunications equipment (with the exception of those indicated below) shall be of approved quality and in accordance with the requirements of the relative British Rail Specification. (See note on page 12 for method of obtaining these paints.)

Manufacturers wishing to supply certain items finished with their own painting process may do so provided that they seek guidance in the first instance as to whether the paint process in question meets the required standard, and is compatible with B.R. Paints for subsequent re-coating.

SECTION 2. PAINTING OF MISCELLANEOUS SIGNAL & TELECOMMUNICATION HOUSINGS FOR EQUIPMENT NOT COVERED BY THIS SCHEDULE.

Precise details of suitable painting processes cannot be given, since they will depend on the type of substrate, nature of the equipment, and environment to which they are eventually exposed.

Manufacturers proprietary paint processes will be considered in lieu of specification materials provided that the following information is declared at the time tenders are placed.

- 1) The nature and type of treatment to be given to the substrate.
- 2) The type of paint to be employed, and the number of coats to be applied.
- 3) The dry film thickness given by the paint coats.

In providing this data it will be assumed that the degree of surface preparation will be in accordance with normal good painting practice, and that consideration will have been given where necessary to the selection of paints to cover any special requirements for heat, oil, water or chemical resistance.

Further guidance as to what constitutes satisfactory system may be obtained on application to the Superintendent Surface Coatings Laboratory, Chemical Research Division, BR Research Department, Hartley House, London Road, Derby.

SECTION 3. FREQUENCY OF PAINTING EQUIPMENT

The following is intended as a guide only and the actual period between re-painting will be dictated by circumstances. The final decision must depend on the actual condition of the article requiring painting.

As a general principle the re-painting of signalbox equipment should be carried out simultaneously with the re-painting of the signalbox structure, but this decision may be left to the discretion of the supervisor.

ALL OTHER EQUIPMENT

LOCALITY	INTERVAL
Rural areas	4 - 5 years
Industrial areas	4 years
Installation in heavily polluted areas e.g. tunnels, and installations adjacent to gas and chemical works.	3 years

NOTE

Controlled crossing gates and barriers.

The maximum interval between re-paints should be 5 years, but painting may take place at more frequent intervals if necessary. All targets and reflecting material must be kept in good condition.

Due regard should be paid to the Offices, Shops and Railway Premises Act in the frequency of repainting signalbox interiors.

SECTION 4 SURFACE PREPARATION. NEW WORK

NOTE :- Application of Etch Primers BR 70/11 & 71/4 and 2 hr. overcoatable primer BR 70/7 to be carried out in Booth or well ventilated areas.

A) STEELWORK

- 1) Steelwork which is to be manually cleaned by wire brushing and chipping.

Steel plate and castings shall be cleaned free from dirt and grease and all rust and loose scale removed by wire brushing and/or chipping using power operated tools wherever possible. In no case shall steel which is heavily pitted or rusted be used.

Prior to painting the steel shall be cleaned free from all dirt and grease using a suitable solvent and one coat of Primer to Specification No. 70 item 13 or item 15 applied as soon as possible. In no case should the treated steel be stored in an unpainted condition.

- 2) Steel plate which is to be phosphated by an immersion or brush process.

Clean and rust-free steel plate free from millscale may be phosphated by an immersion process to BS 3189 Type 2 (Medium Weight, phosphate coating 4.5 g/sq m min., 7.5 g/sq m Max). Alternatively where a suitable immersion process is not available brush phosphating of the steel which has been satisfactorily degreased may be carried out using a brush applied phosphating solution to BR Spec. 62 Item 47.

Treated steel plate shall be given one coat of Primer to BR Spec. 70, Item 13 or Item 15 before completion of the painting process indicated in the schedule. (or BR Spec. 70 Item 64 or Item 65 if the finish coat is to be Chlorinated Rubber Paint).

- 3) Steelwork which is required to be grit or shot blasted.

Structural steelwork shall be grit or shot blasted to BS 4232 Second Quality Finish and within four hours of blasting given one coat of Blast Primer to Specification No 70 Items 12A or 12B. Steelwork which is heavily pitted or rusted must not be used.

Steelwork which has been primed with Blast Primer to Item 12A and stored outside must not be painted without first ensuring that any contaminants or corrosion products are removed from the surface.

- 4) Steelwork which is to be metal spray coated.

Metal Spray (Aluminium or Zinc) may be employed with advantage where long term protection is required. Preference should be given to Aluminium. In all cases the manufacturers guidance should be sought to ensure that surface preparation (grit blast) has been adequately carried out, and that the metal spray has been uniformly applied and is firmly adherent to the substrate.

The metal spray coating requires immediate protection and should be given as soon as possible one coat of Etch Primer to Specification 70 Item 11.

B) ALUMINIUM SHEET & EXTRUSIONS

Adhesion of paint to aluminium or its alloys is significantly more sensitive in comparison to steel surfaces.

Chemical immersion treatments are preferred but where these are not available particular care must be taken to abrade the surface uniformly using wet/dry carborundum paper, Grade 180, followed by thorough degreasing and washing with water containing a suitable detergent.

If solvents such as White Spirit are employed for cleaning, frequent changing of the cloth used in the cleaning operation will be necessary to ensure that all grease and dirt is removed, and not spread in a thin film over the surface.

When the surface is dry the aluminium should be given one coat of Etch Primer to Specification No. 71 Item 4 before the completion of the Painting process detailed in the schedule.

C) ALUMINIUM CASTINGS, & STEEL ELECTROPLATED ZINC PASSIVATED

BS 1706 CLASS B

The surface of the casting should be cleaned free from any grease and dirt and then given one coat of Etch Primer to Specification No 71 Item 4 before the completion of the painting process detailed in the schedule.

D) CADMIUM, BRASS, BRONZE, COPPER

Where painting is required, the surface of the metal should be lightly roughened with a "Scotchbrite" cleaning pad and White Spirit, cleaned free from grease and dirt and one coat of Etch Primer to Specification No 70 Item 11 applied prior to the completion of the painting process detailed in the schedule.

E) STEEL, GALVANISED, HOT DIP TO BS. 729

All hot dip galvanised steel surfaces shall be either cleaned free from grease and dirt and treated with a mordant solution, BR Spec 62, Item 47 or allowed to weather to a dull grey finish before carrying out the paint treatment detailed in the schedule.

The mordant panel wash should be applied to the surface of the metal by means of a clean well worn paint brush and the work set aside to dry. Galvanised iron may be treated at makers Works to prevent the formation of white rust during storage, and this coating may cause difficulty in the phosphating or conversion treatment. If it can be seen that the galvanised surface is not being converted satisfactorily the sheet must be suitably abraded using "Scotchbrite" pads to remove the invisible protective coating and then re-treated.

In the case of the mordant wash the surface should assume a black colour, and if this does not occur even after abrading the surface it is an indication that the panel wash has lost its activity and has become ineffective and must be discarded.

Mordant Panel Wash is available ready for use against Specification No 62 Item 47 but must on no account be placed in metal containers either for storage or immediate use.

ZINC PANEL WASH

Ortho-Phosphoric Acid S.G. 1.70.	4.5 litres (one gallon)
Cellusolve (Ethyl).	18.0 litres (four gallons)
Industrial Methylated Spirit 61 O.P.	18.0 litres (four gallons)
Copper Carbonate (Commercial)	0.9 Kg (two pounds)
Water.	50.0 litres (eleven gallons)

The Zinc Panel Wash should be applied to the surface of the metal by means of a clean well worn paintbrush and the work set aside to dry. The surface should immediately assume a black colour, if this does not occur it is an indication that the Panel Wash has lost its activity and has become ineffective and must be discarded. After allowing the surface of the metal to dry thoroughly apply one coat of approved priming paint.

F) INSULATING BOARDS, HARDBOARDS, PLASTERBOARDS.

The boards may possess an absorbent surface and emulsion paints, and semi-gloss paints afford a more satisfactory degree of finish than full gloss paints. The first coat of paint applied should be thinned down to seal the surface.

G) WOODWORK

Unless otherwise specified all fully machined joinery work which is intended to be painted should receive one coat of approved Primer before delivery. It is particularly important that end grain be treated. If it is necessary to cut the joinery during fitting all cut surfaces and subsequently hidden surfaces should be painted with an approved Priming Paint before fixing. All knots should be primed with Knotting. Impregnated wood or wood which is subsequently to receive a preservative treatment must not be painted. Cedar wood cladding should receive a minimum of two coats of approved Water Resistant Sealer after erection.

H) BRICKWORK, CEMENT, CONCRETE, PLASTER.

All surfaces which are to be painted must be dry and clean and should receive two coats of approved Alkali Resistant Primer prior to the application of any decorative gloss paint. Exterior quality emulsion paints may, however, be applied direct to the surfaces without the need to apply the Primer. Care must be taken to ensure that porous surfaces are suitably sealed with an appropriate sealer before the normal emulsion paint coats are applied.

SPRAY PAINTING.

Where spray painting may be utilised to advantage, the Micaceous Iron Ore and Chlorinated Rubber Brush Paints referred to in this schedule may be replaced by equivalent spraying grades.

For relevant Item and Catalogue Numbers see Section 5 Page 11.

ANTI-CONDENSATION PAINTS

To limit condensation in lineside cabinets and other exposed equipment it is necessary to apply to the interior surface of the case an approved anti-condensation paint.

It must be emphasized that this material must only be applied as an additional coating to the protective paint system indicated in this schedule.

MAINTENANCE PAINTING. SURFACE PREPARATION.

a) STEELWORK EXTERIOR.

All rust, loose scale and corrosion products and loosely adherent paint films must be removed by chipping and wire brushing. Dust off all loose dirt and debris and ensure the surface is clean and free from oil and grease and immediately apply the appropriate approved Priming Paint to all bare areas. Apply Undercoating and Finishing Paints as necessary to the cleaned and primed areas.

b) ALUMINIUM SHEET AND EXTRUSIONS.

Remove all loosely adherent paint and any corrosion products which have formed on the bared areas. Apply one coat of approved Etch Primer to the cleaned areas followed by one coat of finishing paint all over.

c) ALUMINIUM CASTINGS AND SPRAYED METAL.

Remove all loosely adherent paint and any corrosion products which have formed on bared areas. Apply one coat of approved Etch Primer to the cleaned areas followed by one coat of finishing paint all over.

d) CADMIUM, BRASS, BRONZE.

Remove all loosely adherent paints and any corrosion products which have formed on bared areas. Apply one coat of approved Etch Primer to the cleaned areas followed by one coat of finishing paint all over.

e) GALVANISED IRON.

Remove all loosely adherent paints and wash off all soluble corrosion products. Where rusting has commenced clean the surface and apply one coat of approved Zinc Rich Primer. Apply one coat of approved Etch Primer followed by appropriate finishing paints.

Ø Use 'Scotchbrite' pads

Continued....

f) INSULATING BOARDS, HARDBOARDS, PLASTERBOARDS.

Remove all loosely adherent paints. Apply one coat of finishing paint all over.

g) WOODWORK.

Where woodwork has been badly softened by exposure it should be cut out and repairs made with suitable primed sound wood. Where flaking of the paint has occurred over a limited area, and the adhesion of the remainder appears to be sound it will be sufficient to remove the loose paint carefully feathering the edges adjacent to the sound paint and to patch prime at once followed by application of decorative finishes. Where a preservative treatment has previously been employed a further coat may be applied with advantage.

h) BRICKWORK, CEMENT, CONCRETE.

All loose paint and efflorescent material should be removed by wire brushing and the surface made good. Apply one coat of approved Alkali Resisting Primer, or proprietary brand sealer.

SPRAY PAINTING

Where spray painting may be utilised to advantage, the Micaceous Iron Ore and Chlorinated Rubber Brush Paints referred to in this schedule may be replaced by equivalent spraying grades.

For relevant Item and Catalogue Numbers see Section 5 Page 11.

ANTI-CONDENSATION PAINTS

Interior surfaces of Lineside cabinets previously treated with an anti-condensation paint and in sound condition shall not be re-painted.

Where corrosion is evident the coating shall be removed and the surface re-painted and a new coat of anti-condensation paint applied.



SECTION 5. LIST OF APPROVED MATERIALS.

B.R. SPECIFICATION NO. 70.

SECTION 1. PRIMING PAINTS.

CATALOGUE NO. 28

Item 1. Alkali Resistant Primer.	63000
Item 2. Wood Primer. Lead free.	63007
Item 7. Two hour overcoatable lead free brush primer.	6120
Item 8. Two hour overcoatable lead free airless spray primer.	6121
Item 9. Zinc Rich Primer. Single pack.	63022
Item 10. Heavy duty Zinc Rich Primer. Two pack.	63023
Item 11. Etch Primer. Single pack.	63024
Item 12. Blast Primer. Two pack.	63025
Item 13. Primer Undercoating brush paint for steelwork.	63026
Item 14. Undercoating brush paint for steelwork.	63027
Item 15. Primer Undercoating airless spray paint for steelwork.	63028
Item 16. Undercoating airless spray paint for steelwork.	63030

SECTION 2. MICACEOUS IRON OXIDE PAINTS.

Item 21. M.I.O. brush paint steel grey.	6140
Item 22. M.I.O. brush paint silver grey.	6141
Item 23. M.I.O. brush paint green shade.	6143
Item 24. M.I.O. brush paint blue shade.	6142
Item 25. M.I.O. brush paint black shade.	6144
Item 26. M.I.O. airless spray paint steel grey.	6125
Item 27. M.I.O. airless spray paint silver grey.	6126
Item 28. M.I.O. airless spray paint green shade.	6127
Item 29. M.I.O. airless spray paint blue shade.	6128
Item 30. M.I.O. airless spray paint black shade.	6129

SECTION 3. BITUMINOUS MATERIALS FOR STRUCTURES.

Item 41. Black gelled bituminous solution brush paint.	520
Item 42. Aluminium tinted gelled bituminous solution brush paint.	530
Item 43. Black gelled bituminous solution airless spray paint.	570
Item 44. Aluminium tinted bituminous solution airless spray paint.	580
Item 45. Bituminous solution.	500
Item 46. Black bituminous emulsion.	540
Item 47. Red bituminous emulsion.	550

SECTION 4. EPOXIDE PITCH COATINGS.

Item 50. First coat brown epoxy pitch. Two pack.	5187
Item 51. Second coat black epoxy pitch. Two pack.	5188

SECTION 5. CHLORINATED RUBBER PAINTS. /

Item 60. High build chlorinated rubber first coat brush paint.	5071
Item 61. High build chlorinated rubber first coat airless spray paint.	5072
Item 62. Chlorinated rubber second coat finishing brush paint.	5073
Item 63. Chlorinated rubber second coat finishing airless spray paint.	5074

SECTION 6. CLEANING SOLVENTS.

Item 70. Cleaning solvent for Items 7, 8, 9 and 10.	6130
Item 71. Cleaning solvent for Items 50 and 51.	6133
Item 72. Cleaning solvent for Items 60, 61, 62 and 63.	6134

/ Colour to be specified on order.

SPECIFICATION NO. 71 (EXTRACT).

MATERIAL		CATALOGUE NO. 28/
Item 20	Chromated jointing compound	36800
Item 29	Black undercoating brush paint	22575
Item 39	Black uroalkyd finishing paint	6048
Item 84	Quick drying white band paint	44615
Item 86	Black gloss lettering paint	850
Item 90	Light orange identification colour B.S.C. No. 557	44200
Item 91	Signal red identification colour B.S.C. No. 537	44210
Item 92	Light brown identification colour B.S.C. No. 410	44220
Item 93	French blue identification colour B.S.C. No. 166	44230
Item 94	Grass green identification colour B.S.C. No. 218	44240
Item 95	Salmon pink identification colour B.S.C. No. 447	44250
Item 96	Golden yellow identification colour B.S.C. No. 356	44260
Item 97	Eau-de-nil identification colour B.S.C. No. 216	44307
Item 98	Aircraft grey identification colour B.S.C. No. 627	44370
Item 99	Aircraft blue identification colour B.S.C. No. 108	44270
Item 100	Dark brown identification colour B.S.C. No. 412	44280
Item 101	White identification colour	44300
Item 102	Black identification colour	44290
Item 103	Aluminium identification colour	44320
Item 108	Middle brown identification colour B.S.C. No. 411	44565
Item 109	Brilliant green identification colour B.S.C. No. 221	44570

SPECIFICATION NO. 56A ø

MATERIAL

CATALOGUE NO. 28/

Section 9.1	Undercoating Paints for high gloss alkyd finishing paints.	110000 et seq
Section 9.2	High gloss alkyd finishing paints	110200 et seq
Section 9.3	Semi-gloss paints for interior use	110400 et seq
Section 9.4	Emulsion Paints	110600 et seq
Section 9.5	One pack polyurethane gloss paints	110800

ø B.S.4800 Colour to be specified on order.

SPECIFICATION NO. 62

MATERIAL

Item 2	Anti-Condensation paint	5017
Item 27	Stoving Paints and Thinners	5413-24
Item 54	Q.D. Paint for Relay cases	5363

CLASSIFICATION NO. 28 PART III

General Purpose Shellac Varnish

Black Packyderm 460	76700
Black Hymeg A.D.8.	76293

METHOD OF OBTAINING APPROVED MATERIALS - NOTE FOR MANUFACTURERS

Manufacturers wishing to obtain approved materials should contact

Supplies Manager
British Railways Board
Railway Technical Centre
DERBY DE2 8UP
Telephone (STD 0332) 42442 Ext. 3477/3491
Telex 37367

quoting specification No., item/section No. and catalogue No. of each material required. They will be advised of the approved supplier of each material.

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REVISED JULY 1977

SIGNAL BOXES AND SIGNAL EQUIPMENT
PAINTING SCHEDULE
NEW WORK

Signal Boxes
Exterior and
Interior Structure

PART	DETAIL OR TYPE OF SURFACE TO BE PAINTED	SURFACE TREATMENT AND METHOD	MATERIAL B.R. SPECIFICATION AND ITEM			REMARKS
			PRIMER	UNDERCOAT	FINISHING	
Signal Box Exterior and Interior Structure	Woodwork	4G	Lead Free Wood Primer 70/2	Undercoating Paint 56A Section 9.1	Finishing Paint 56A Section 9.2	Colour of Finishing Paints to Specification No. 56 to be to B.S. 4800 Colour Range, and to be indicated at time of ordering. Colour may vary with Regional Architect Requirements.
	Steelwork	4A	2 Hr overcoatable primer 70/7	Undercoating Paint 56A Section 9.1	Finishing Paint 56A Section 9.2	
	Galvanised Iron	4E	Allow to weather or Mordant Wash	Undercoating Paint 56A Section 9.1	Finishing Paint 56A Section 9.2	
	Aluminium	4B	Etch Primer 70/11	Undercoating Paint 56A Section 9.1	Finishing Paint 56A Section 9.2	
	Brickwork Concrete Cement	))) 4H	Alkaline Surfaces Alkali Resisting Primer 70/1 (except where emulsion paint is to be applied)	Emulsion Paint Sealer or Proprietary Process Spec.62	Emulsion Paint 56A Section 9.4	Treatment to be carried out if painting is specified. Approved proprietary masonry finishes are available as an alternative to emulsion paint.
Signal Box Exterior Structure	Cedar Wood Cladding Self-coloured Plastic surfaces		None	None	2 Coats "Watertite" Sealer	Do not paint

SIGNAL BOXES AND SIGNAL EQUIPMENT
PAINTING SCHEDULE
NEW WORK

Signal Box
Exterior
Structure
(continued)

PART	DETAIL OR TYPE OF SURFACE TO BE PAINTED	SURFACE TREATMENT AND METHOD	MATERIAL B.R. SPECIFICATION AND ITEM			REMARKS
			PRIMER	UNDERCOAT	FINISHING	
Signal Box Exterior Structure (Continued)	Stoneblock.Pebbledash					Do not paint
	<u>Nameplates</u>					
	Stove enamelled	Quality In	Accordance with B	R. 1050		Design in accordance with appropriate drawings.
	Vitreous enamelled	Quality In	Accordance with B	R. 1051		
	Self-Adhesive Plastic	Quality IN	Accordance with B	R. 1052		

SIGNAL BOXES AND SIGNAL EQUIPMENT
PAINTING SCHEDULE
NEW WORK

Signal Box
Interior Structure
Underfloor
Equipment

PART	DETAIL OR TYPE OF SURFACE TO BE PAINTED	SURFACE TREATMENT AND METHOD	MATERIAL B.R. SPECIFICATION AND ITEM			REMARKS
			PRIMER	UNDERCOAT	FINISHING	
Signal Box Interior Structure Underfloor Equipment	Locking Frame and ancilliary framework	4A	2 Hr overcoatable Primer. 70/7	Black Micaceous Iron Ore 70/25	Silver Grey Micaceous Iron Ore Paint 70/22	
	Electric Lock and/or Circuit Controllers.	4A	2 Hr overcoatable Primer. 70/7	Undercoating Paint 56A Section 9.1	Finishing Paint 56A Section 9.5	
	Protective covers and casings to cable terminations.	4A	2 Hr overcoatable Primer. 70/7	Undercoating Paint 56A Section 9.1	Finishing Paint 56A Section 9.5	
	<u>Racks Relay and Terminal.</u>					
	a) Steel	4A	2 Hr overcoatable Primer. 70/7	Undercoating Paint 56A Section 9.1	Finishing Paint 56A Section 9.5	Manufacturers stove enamelled systems are acceptable provided that the steel has been suitably primed.
	b) Wood	4G	Lead free Wood Primer. 70/2 or Sealer 70/147	Undercoating Paint 56A Section 9.1 None	Finishing Paint 56A Section 9.5 Gloss Finishing 71/148	
	<u>Battery Shelves</u>					
	a) Steel	4A	2 Hr overcoatable Primer. 70/7	Chlorinated Rubber 70/60	Chlorinated Rubber 70/62	) Allow 24 hours between coats.)))
	b) Wood	4G	None	Chlorinated Rubber 70/60	Chlorinated Rubber 70/62	
				18.		

REVISED JULY 1977

SIGNAL BOXES AND SIGNAL EQUIPMENT

PAINTING SCHEDULE

NEW WORK

Signal Box
Interior Operating
Floor Equipment

PART	DETAIL OR TYPE OF SURFACE TO BE PAINTED	SURFACE TREATMENT AND METHOD	MATERIAL B.R. SPECIFICATION AND ITEM			REMARKS
			PRIMER	UNDERCOAT	FINISHING	
Signal Box Interior Operating Floor Equipment	<u>Levers</u> Distant Signal	Clean Down	2 Hr overcoatable Primer. 70/7	White Undercoat- ing Paint 71/30	Yellow Finishing Paint. No. 356 71/96	Any lever which is released from another Signal box, e.g. Clear release or underbolt to have a (75 mm) 3" horizontal white band half way down lever. In cases of levers painted in alternate stripes, these to commence black or brown at the quadrant end of lever. In cases where a lever controls two functions e.g. F.P. Lock working with points or intermediate block home and distant signals both colours to be used. The colour used on the top half of lever to represent that apparatus moving first.
	Stop Signal, ground signal, Route lever (controlling route indicator).	Clean Down	2 Hr overcoat- able primer, 70/7	White Undercoat- ing Paint. 71/30	Red Finishing Paint No. 537 71/91	
	F.P. Locks, Clearance Bar, Economic Points	Clean Down	2 Hr overcoat- able primer, 70/7	Grey Undercoating 71/26	Blue Finishing Paint No. 166 71/93	
	Points, Scotchies, Derailers	Clean Down	2 Hr overcoat- able primer 70/7	Grey Undercoating 71/26	Black Finishing Paint 71/102	
	Barriers, Wicket gates, Gate stops or locks, bridge locks, Turntable locks.	Clean Down	2 Hr overcoat- able primer 70/7	Grey Undercoating 71/26	Brown Finishing Paint No. 411 71/108	
	Gongs, Asking Levers	Clean Down	2 Hr overcoat- able primer 70/7	Grey Undercoating 71/26	Green Finishing Paint No. 221 71/109	
	Lever Collars	Clean Down	2 Hr overcoat- able primer 70/7	White Under- coating Paint 71/30	Red Finishing Paint No. 537 71/91	Alternative finishing colours and lettering to be specified in accordance with local requirements.



Documents

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