



SPECIFICATION NO. 1051

COVERING
VITREOUS ENAMELLED SIGNS.

GENERAL REQUIREMENTS

1. The vitreous enamel sign shall be suitable for the purpose described in the title.
2. The finished article shall fully comply with the general requirements indicated at the time of ordering, with regard to design, colour, lettering, dimensions, and position of bolt holes for the attachment of the sign.
3. All units finished in vitreous enamel shall be made of suitable enamelling grade flat steel sheet of low carbon content. The appropriate gauge of metal shall be determined by the size, shape or detail of the unit.
4. The finished sign shall show no evidence of abnormal warping, and manufacturers should pay particular attention to the finishing of edges of plates and inside edges of screw holes.
5. The enamelled surface shall be of even thickness, free from cracks, pinholes, blisters and other surface defects, and shall possess uniform gloss and colour.
6. The vitreous enamel finish for the exterior or exposed surface shall consist of suitable ground and colour coats to satisfy the specified requirements.
7. The back or hidden surface of all panels for station signs etc. shall be finished with one grip coat, (primer), followed by a second coat of backing enamel to satisfy the specified requirements.

SPECIAL REQUIREMENTS

1. The thickness of the vitreous enamel finish shall be of the minimum conducive to good enamelling procedure, and shall under no circumstances exceed 0.5 mm (0.020").

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2. The film shall be acid resistant and unaffected by a 2% solution in distilled water of sulphuric acid, the period of contact between the solution and surface being 60 minutes.
3. The colour of the finished article shall closely match the appropriate shade/s indicated at the time of ordering, and shall be completely lightfast when exposed under conditions encountered on British Rail.
4. Manufacturers will be required to submit for approval representative samples size 30 cm x 30 cm, (12" x 12"), of the process they intend to supply.
5. Specimens submitted for type approval will be subjected to a natural weathering test in an industrial atmosphere. The test will be continued for a minimum period of 1 year, after which the specimens will be examined for evidence of loss of gloss, colour change, chalking, checking, cracking or adhesion failures.

August 1969

B.R. Specification No. 1051