

# British Railways Board

GENERAL INSTRUCTIONS NO. 10A

REVISED JANUARY 1963

COVERING  
THE REPAINTING TREATMENT OF  
REPAIRED FREIGHT STOCK AND CONTAINERS,  
INCLUDING BREAKDOWN TRAIN VEHICLES  
AND  
OTHER SERVICE STOCK.

( THIS DOCUMENT supersedes all previous instructions but is not intended to cover the repainting of privately-owned wagons or wagons on long-term hire to private firms and engaged in special traffics.)

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BRITISH RAILWAYS BOARDGENERAL INSTRUCTIONS No.10AREVISED JANUARY 1963

Covering

THE REPAINTING TREATMENT  
OFREPAIRED FREIGHT STOCK AND CONTAINERS,INCLUDING BREAKDOWN TRAIN VEHICLESANDOTHER SERVICE STOCK

REFERENCE SHOULD BE MADE TO SEPARATE SPECIAL INSTRUCTIONS ISSUED FROM TIME TO TIME BY THE BRITISH RAILWAYS BOARD HEADQUARTERS STIPULATING CERTAIN LIMITATIONS AS TO THE AMOUNT OF PAINTING OF WAGONS REQUIRED

Attention is particularly drawn to Note 3 on page 2 of these General Instructions No.10A. These Instructions provide for existing methods of paint application to the revised liveries and do not cover the new form of Airless Spray Painting employing new type of equipment and paints. Details of this procedure will be issued in due course as a special Supplement to these General Instructions No. 10A.

(THIS DOCUMENT supersedes all previous instructions but is not intended to cover the repainting of privately-owned wagons or wagons on long-term hire to private firms and engaged in special traffics.)



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## FOREWORD

### SCOPE

Wagons having a special interior body lining (such as Bulk Salt Wagons) shall not have any paint applied to these interior surfaces.

The preparatory and painting treatments laid down in these Instructions are designed to afford to the wagons, etc., the same degree of protection as that given to new vehicles painted in accordance with B.R. General Instructions No. 10. but reference should be made to Special Instructions issued from time to time by the British Railways Board stipulating certain limitations to the amount of work which should be carried out - for current Instructions see B.T.C. circular dated 13/12/62.

As the condition of the paintwork on wagons sent for repaint will vary considerably, discretion must be used in dealing with individual wagons, etc., and in order to ensure that the wagons will remain in a satisfactory condition until the next repaint date, authority must be obtained for special work to be carried out in exceptional cases. After repainting, all wagons must be weighed, retared and lettered. Where it appears that a wagon has received special paint treatment in the past, the circumstances should be reported to the Chief Mechanical Engineer, and instructions awaited before proceeding with repainting.

### DESCRIPTION OF PROCESSES AND FIELD OF USE

The painting procedures detailed below cover four distinct and alternative processes.

(i) Oleo Resin Brushing Process (O.B.)

This process should be regarded as the basic process and should always be adopted where spraying facilities are not available and where production arrangements permit overnight drying between coats.

(ii) Oleo Resin Spraying Process (O.S.)

This process may be adopted where facilities permit the use of spray application and production requirements do not necessitate the use of the quicker drying Synthetic Resin Process.

(iii) Synthetic Resin Process (Q.D.)

This process is designed for use where production requirements do not permit the use of (i) O.B. or (ii) O.S. Processes, and should only be adopted in these circumstances. The Q.D. Process is intended primarily for spray application. When this method is used the coatings may be applied at 2 hour intervals although the preceding coat has not reached the "hard dry" condition. When brush application is used 4-6 hours must be allowed between coats. It must be understood that where synthetic resin materials are used they must be used throughout on any given surface and, further, all materials (except lettering paint) used in any one process must be supplied by one and the same firm.

(iv) Chlorinated Rubber Process (Type R)

This process is designed for brush application on special wagons carrying corrosive goods, e.g. Salt, Fertilizer, etc. Spray application of Undercoatings and Finishing Materials may be used if production requirements necessitate this, but it is less satisfactory.

It is essential that where this process is employed the preparatory work is thoroughly carried out and all traces of rust removed, otherwise the degree of protection afforded by this process is limited. Adequate ventilation must be provided when the interior surfaces of the body are painted, alternatively the operator must wear a suitable mask drawing air from outside the vehicle.

Note (1) The Q.D. Process is similarly for use on steel bodies.

Note (2) It is permissible, where shorter drying times than those given by the prescribed materials at the normal temperature are necessary to meet production requirements, to increase the speed of drying by the use of heated drying enclosures. Local conditions will vary the drying conditions required but where temperatures in excess of 80° F. appear to be necessary to give the required drying times, prior approval of the proposed layout must be obtained from the Chief Mechanical Engineer. Under no circumstances must materials other than those specified herein be used for any modification of them carried out by the users.

Note (3) The new form of Airless Spray Painting should be introduced as the plant and materials become available. The specially formulated Airless Spray paints for Bodywork are however unsuitable for application to surfaces which have not in any circumstances be employed on steel which has not been so treated. The procedure laid down in a special Supplement to these General Instructions (No.10A) viz "Supplement to General Instructions No.10A - Airless Spray Painting of Repaired Freight Stock etc" should be followed where appropriate.

Note (4) All screws used for fixing wood etc. forming the interior surfaces of Vans and Containers on which Emulsion Paint is stipulated for use as the finishing process must be "Sherardised".

Note (5) It is essential that all Wood Body Frame members (before encasement) and all subsequently hidden faces of the sheeting forming the Exterior and Interior surfaces of insulated and refrigerated vans and containers, shall receive one coat Aluminium Tinted Gelled Bituminous Solution to B.R. Specification No.32B Item 52 and one coat Gelled Bituminous Solution to B.R. Specification No.32B Item 51.

Note (6) Any rubber or other material used for sealing purposes (e.g. for insulation or draught exclusion) shall not be painted under any circumstances.

## SECTION 0

### (a) PREPARATORY TREATMENT TO BE GIVEN TO ALL METAL OR WOOD MEMBERS AND DETAILS THAT ARE TO BE REPAINTED, FOR ALL CLASSES OF REPAIRED WAGONS, VANS AND CONTAINERS

Whilst it is impossible to lay down a rigid schedule of operations for the pretreatment of repaired wagons since this will depend upon the condition of each individual vehicle, it is emphasised that adequate effort must be applied to ensure the removal of all loose paint, and in the case of metal surfaces, the removal of loose scale and rust prior to the application of any coats of paint.

All surfaces shall be cleaned free from scale, rust, grease, etc., and mechanical methods employing chipping hammers, flexible grinding discs or mechanically operated wire brushes shall be used for this purpose. Where facilities exist, the exterior surfaces of the steel bodies should where appropriate be cleaned by grit or shot-blasting using an approved procedure. Where considerable surface rust, dirt, etc., has to be removed by mechanically-operated wire brushes, suitable anti-dust precautions must be taken, e.g. damping the surfaces to be cleaned with White Spirit before commencing de-rusting operations.

It is essential that the interval between cleaning and painting operations shall be short, in the case of shot or grit-blasted surfaces within 4 hours, and in all cases the priming coat must be applied before rusting can recommence. Any new metal or wood parts that are used shall have the surfaces(\*) suitably prepared for painting and shall then be given one coat of the primer or undercoating paint as indicated in the appropriate section of these Instructions.

\* Details of the methods to be followed in preparing new metal and wood parts for painting are contained in General Instructions No.10.

### (b) Special Preparatory Treatment for Wagons Employed in Carrying Corrosive Freight (e.g. Salt, Fertiliser etc.) before Repainting

The whole of the wagon must be hosed down thoroughly to remove all the water soluble residue. The surfaces should be scrubbed thoroughly under running or hot water; where available high pressure water should be employed. The interior surfaces must receive the same preparatory treatment as the outside and the underframe, undergear and brakegear should be similarly dealt with.

After the removal of all rust, scale and loose paint, the wagon must be allowed to dry out thoroughly, assisted, if necessary, by the use of compressed air to dislodge water from all recesses and ledges. Touch in all bare areas of steel with one coat of Primer as indicated in the appropriate section of these Instructions.

### (c) Treatment of Welds

After welding has been completed, all welding slag and flux residues must be completely removed, all welds thoroughly wire brushed, and these areas then touched in with one coat of Primer for Metal to B.R. Specification No.32B, Item 1. The interval between cleaning and painting must in no case exceed eight hours.

## Preformed Protective Tape

Where the top surfaces of the upper flanges of the underframe members have been covered with preformed protective Tape this shall NOT be removed during preparatory cleaning operations if it is in sound condition.

### SECTION 1

#### REPAINTING OF OPEN WAGONS AND COVERED VANS, INCLUDING BRAKE VANS AND TENDERS, CONFLATS, BANANA VANS, CATTLE WAGONS ETC. BUT EXCLUDING VEHICLES ENGAGED IN SPECIAL TRAFFICS, SERVICE AND BREAKDOWN TRAIN VEHICLES

Attention is drawn to the preparatory treatment for all wood or metal surfaces (Section 0) prior to the commencement of any painting operations.

#### PART 1. UNDERFRAMES, UNDERGEAR, BRAKE GEAR AND BOGIES, WHERE APPLICABLE (EXCLUDING PIPE ENDS)

##### (a) Steel Underframes of Wood and Steel Floored Open Wagons, Underside of Steel Floors and Both Sides of Steel Plate covering the Body Floor Framing of Shock Absorbing Wagons

(i) Apply one coat Freight Stock Red Primer/Undercoating Paint to B.R. Specification No. 32B, Item 15, to all surfaces except the top surfaces of upper flange of Underframe members of open Wood floored wagons.

Apply one coat Gelled Bituminous Solution to B.R. Specification No.32B, Item 51\* to all surfaces except the top surfaces of upper flange of underframe members of open Wood floored wagons.

##### (ii) Top Surfaces of Upper flange of Underframe Members of open Wood Floored Wagons

Note. These operations shall be carried out after the painting treatment given in (i) has been completed and shall apply only to areas not previously treated or from which damaged tape has been removed.

Apply one coat "Flangeprep" to B.R. Specification No.50 Item 1.

Apply immediately Preformed Protective Tape to B.R. Specification No. 50 Item 2 of appropriate size for the flange width, with the non-sticky side uppermost, ensuring correct alignment and absence of airpockets below the tape. The tape should overhang free flange edges by at least  $\frac{1}{2}$ " and any joints should overlap by approximately 1".

##### (b) Steel Underframes of other Wagons, together with Undergear, Brake Gear and Bogies of all vehicles.

Apply one coat Gelled Bituminous Solution to B.R. Specification No.32B, Item 51.

##### (c) Wooden Underframes

No painting required

\* The Gelled Bituminous Solution should be applied at a wet film thickness of not less than 10 Thous. of an inch per coat to give effective protection. This applies throughout these instructions wherever the use of this material is stipulated.



PART 2

WHEELS

No treatment required.

PART 3

AXLES AND AXLEBOXES

Apply one coat Black Lacquer to B.R. Specification No.32B Item 50 (except front plate of Roller Bearing Axleboxes which should have one coat of Yellow Lining Paint to B.R. Specification No.32B item 43, and a red horizontal stripe 1½ inches wide.)

PART 4

METAL AND WOOD BODIES ON STEEL UNDERFRAME:  
EXTERIOR SIDES AND ENDS (INCLUDING SIDE RAILS  
OF WOOD BODIES WHERE FITTED)

Table 1.1 Coatings to be Applied

METAL BODIES

Type of Vehicle	Type of Process	Description of Material	B.R.Paint Specn.	
			No.	Item
Unfitted and fitted Stock including "Through-piped" Vehicles	O.B.	1 coat Freight Stock Red Primer/Undercoating Paint	32B	15
		1 coat Freight Stock Red Finishing Paint	32B	16
	O.S.	1 coat Freight Stock Red Primer/Undercoating Paint (for Spray Application)	32B	15
		1 coat Freight Stock Red Finishing Paint (for Spray Application)	32B	16
	O.D.	1 coat Freight Stock Red Primer/Undercoating Paint (Syn.)	32B	31
		1 coat Freight Stock Red Finishing Paint (Syn.)	32B	32

WOOD BODIES

Unfitted and fitted Stock including "Through-piped" Vehicles	O.B.	Apply to outer surface of any new sheeting 1 coat	32B	15
	or	Freight Stock Red Primer/Undercoating Paint		
	O.S.	Apply all over body exterior 1 coat Freight Stock Red Finishing Paint	32B	16

WOOD BODIES ON WOODEN UNDERFRAMES - NO PAINTING REQUIRED.

PART 5.

LETTERING & MARKING - To be in accordance with revised instructions issued April, 1963.

Table 2.1 Coatings to be Applied

Type of Vehicle	Description of Material	B.R.Paint Specn.	
		No.	Item
Unfitted and Fitted Stock including "Through-piped" Vehicles.	White Lettering Paint.	32B	42

PART 6.

VACUUM PIPE ENDS

Table 3.1 Coatings to be Applied

Type of Vehicle	Type of Process	Description-of Material	B.R.Paint Specn.	
			No.	Item
Fitted Stock	O.B.	1 coat Freight Stock Red Finishing Paint	32B	16
	O.S.	1 coat Freight Stock Red Finishing Paint (for spray Application)	32B	16
	Q.D.	1 coat Freight Stock Red Finishing Paint (Syn.)	32B	32
"Through-Piped" Stock	O.B.	1 coat White Lettering Paint	32B	42
	O.S.	1 coat White Lettering Paint	32B	42
	Q.D.	1 coat Freight Stock White Marking Paint (Syn.)	32B	34

NOTE. When new Vacuum Pipe Ends are fitted they should be given one coat Freight Stock Red Primer/Undercoating Paint to B.R. Specification No.32B, Item 15 before the finishing coat indicated above. Also new pipes in the case of "Through-Piped" Vehicles should be given one coat Freight Stock Grey Primer/Undercoating Paint to B.R. Specification No.32B, Item 17 before finishing with the white Lettering Paint.

PART 7.

ROOFS

(i) Repaint

The roofs of all covered stock not covered by a Proprietary Process or specially prepared Roofing Canvas shall, where stripping is unnecessary, receive one coat Finishing Coat Roof Paint to B.R. Specification No.32B, Item 14, after any loosely adherent dirt etc., has been removed.

Roofs constructed of translucent materials are not to be painted, but cleaned only with suitable detergent and water.

(ii) Recanvassed

Apply one coat Wagon Primer for Wood to B.R. Specification No.32B, Item 3, to any new wood. Stop as necessary with Putty to B.R. Specification No.32B, Item 5. Apply one coat Jointing Paste to B.R. Specification No.32B, Item 6.

After the canvas has been stretched on and properly bedded, apply one coat Roof Canvas Dressing to B.R. Specification No.32B, Item 7.

Apply one coat 1st Coat Roof Paint to B.R. Specification No.32B, Item 13.

Apply one coat Finishing Coat Roof Paint to B.R. Specification No.32B, Item 14.

(iii) Where Covered by a Proprietary Process

The repair of Roofs covered by a proprietary process should be dealt with in accordance with instructions issued by the manufacturers concerned.

(iv) Where Covered by a Specially Prepared Roofing Canvas

Roofs covered by a Specially Prepared Canvas shall, after removal of any loosely adherent dirt, etc., and repairing as may be necessary, be given one coat Finishing Coat Roof Paint to B.R. Specification No.32B, Item 14.

PART 8. BODY INTERIOR

Table 4.1 Coatings to be Applied

Type of Vehicle	Area to be Treated	Description of Materials	B.R.Paint Specn.	
			No.	Item
Brake Vans and Freight Stock Vehicles Carrying Train Crews	Ceiling and Upper Walls	1 coat Stone Colour Finishing Paint for Interiors	32B	20
	Lower Walls to a height of approx. 3'6".	1 coat Freight Stock Red Finishing	32B	16
Banana Vans	Wood Panels (Exposed Surfaces)	1 coat P.V.A. Pale Cream Emulsion Paint (Matt Finish)	32B	74
		1 coat P.V.A. Cream Emulsion Paint (Eggshell Gloss Finish)	32B	75
Bogie Bolster Wagons and Conflats	Interior of Steel Body Sides and Ends	As for Exterior Surfaces as shown in Part 4 Table 1.1		
Other open Wagons Wood or Steel	NO TREATMENT			

## SECTION 2

### REPAINTING OF SERVICE VEHICLES (OTHER THAN BREAKDOWN TRAIN VEHICLES)

Attention is drawn to the Preparatory Treatment for all wood or metal surfaces (Section 0) prior to the commencement of any painting operations.

#### PART 1. UNDERFRAMES, UNDERGEAR, BRAKE GEAR AND BOGIES WHERE APPLICABLE (EXCLUDING PIPE ENDS)

##### (a) (i) Steel Underframes of Wood and Steel Floored Open Wagons, and Underside of Steel Floors

Apply one coat Freight Stock Red Primer/  
Undercoating Paint to B.R. Specification No.32B Item 15 to  
all surfaces except the top surfaces of upper flange of  
Underframe members of open Wood floored wagons.

Apply one coat Gelled Bituminous Solution to B.R.  
Specification No.32B Item 51 to all surfaces except the top  
surfaces of upper flange of Underframe members of open Wood  
floored wagons.

##### (ii) Top Surfaces of Upper flange of Underframe Members of open Wood Floored Wagons.

Note. These operations shall be carried out  
after the painting treatment given in (i) has been completed  
and shall apply only to areas not previously treated or  
from which damaged tape has been removed.

Apply one coat "Flangeprep" to B.R. Specification  
No.50 Item 1.

Apply immediately Preformed Protective Tape to B.R.  
Specification No. 50 Item 2 of appropriate size for the flange  
width, with the non-sticky side uppermost, ensuring correct  
alignment and absence of airpockets below the tape. The tape  
should overhang free flange edges by at least  $\frac{1}{2}$ " and any  
joints should overlap by approximately 1".

##### (b) Steel Underframes of Other Vehicles, together with Undergear, Brake Gear and Bogies of all vehicles

Apply one coat Gelled Bituminous Solution to B.R.  
Specification No.32B, Item 51.

##### (c) Wooden Underframes

No painting required.

#### PART 2. WHEELS

No treatment is required.

#### PART 3. AXLES AND AXLEBOXES

Apply one coat Black Lacquer to B.R. Specification  
No.32B, Item 50. (except front plate of Roller Bearing Axleboxes  
which should have one coat of Yellow Lining Paint to B.R.  
Specification No.32B Item 43, and a red horizontal stripe  $1\frac{1}{2}$   
inches wide).

PART 4. METAL AND WOOD BODIES ON STEEL UNDERFRAMES EXTERIOR. SIDES AND ENDS

Table 1.2 Coatings to be Applied

Type of Vehicle	Description of Material	B.R. Paint Specn.	
		No.	Item
Carriage Stock Design	1 coat Freight Stock Grey Primer/Undercoating Paint	32B	17
	1 coat Olive Drab Finishing Paint	32B	37
	1 coat Exterior Finishing Varnish (Syn.) after any necessary lettering etc. has been applied.	32B.	33
Freight Stock Design	1 coat Freight Stock Grey Primer/Undercoating Paint	32B	17
	1 coat Olive Drab Finishing Paint	32B	37

Wood Bodies on Wooden Underframes - No painting required.

PART 5. LETTERING AND MARKING - To be in accordance with revised instructions issued April, 1963.

Apply where necessary White Lettering Paint to B.R. Specification No. 32B, Item 42.

PART 6. VACUUM PIPE ENDS

Table 2.2 Coatings to be Applied

Type of Vehicle	Type of Process	Description of Material	B.R. Paint Specn.	
			No.	Item
Fitted Vehicles	O.B.	1 coat Freight Stock Red Finishing Paint	32B	16
	O.S.	1 coat Freight Stock Red Finishing Paint (for Spray Application)	32B	16
	Q.D.	1 coat Freight Stock Red Finishing Paint (Syn.)	32B	32
Through Piped Vehicles	O.B.	1 coat White Lettering Paint	32B	42
	O.S.	1 coat White Lettering Paint	32B	42
	Q.D.	1 coat Freight Stock White Marking Paint (Syn.)	32B	34

NOTE. When new Vacuum Pipe Ends are fitted they should be given one coat Freight Stock Red Primer/Undercoating Paint to B.R. Specification No. 32B, Item 15, before the finishing coat indicated above. Also new pipes in the case of "Through-Piped" Vehicles should be given one coat of Freight Stock Grey Primer/Undercoating Paint to B.R. Specification No. 32B, Item 17 before finishing with the White Lettering Paint.

PART 7. ROOFS

(i) Repaint

Roofs of all covered stock not covered by a Proprietary Process, or specially prepared Roofing Canvas shall, where stripping is unnecessary, receive one coat Finishing Coat Roof Paint to B.R. Specification No.32B, Item 14 after any loosely adherent dirt etc., has been removed.

(ii) Recanvassed

Apply one coat Wagon Primer for Wood to B.R. Specification No.32B, Item 3, to any new wood. Stop up as necessary with Putty to B.R. Specification No.32B, Item 5.

Apply one coat Jointing Paste to B.R. Specification No.32B, Item 6.

After the canvas has been stretched on and properly bedded, apply one coat Roof Canvas Dressing to B.R. Specification No.32B, Item 7.

Apply one coat 1st Coat Roof Paint to B.R. Specification No.32B, Item 13.

Apply one coat Finishing Coat Roof Paint to B.R. Specification No.32B, Item 14.

(iii) Where covered by a Proprietary Process

The repair of roofs treated with a Proprietary Process should be dealt with in accordance with instructions issued by the manufacturers concerned.

(iv) Where covered by a Specially Prepared Roofing Canvas

Roofs covered by a Specially Prepared Canvas shall after removal of any loosely adherent dirt, etc., and repairing as may be necessary, be given one coat Finishing Coat Roof Paint to B.R. Specification No.32B, Item 14.

PART 8. BODY INTERIOR (COVERED VEHICLES)

(i) Ceiling and Upper Walls

Apply one coat Stone Colour Finishing Paint to B.R. Specification No.32B, Item 20.

(ii) Lower Walls to a Height of 3'6"

Apply one coat Freight Stock Red Finishing Paint to B.R. Specification No.32B, Item 16.

### SECTION 3

#### REPAINTING OF BREAKDOWN TRAIN VEHICLES OF PASSENGER OR FREIGHT STOCK DESIGN

Attention is drawn to the Preparatory Treatment required for all wood or metal surfaces (Section 0) prior to the commencement of any painting operations.

#### PART 1. UNDERFRAMES, UNDERGEAR, BRAKEGEAR AND BOGIES WHERE APPLICABLE (EXCLUDING PIPE ENDS)

##### (a) (i) Steel Underframes of Wood and Steel Floored Open Wagons, and Underside of Steel Floors

Apply one coat Freight Stock Red Primer/Undercoating Paint to B.R. Specification No.32B, Item 15 to all surfaces except the top surfaces of upper flange of Underframe members of open Wood floored wagons.

Apply one coat Gelled Bituminous Solution to B.R. Specification No.32B Item 51 to all surfaces except the top surfaces of upper flange of Underframe members of open Wood floored wagons.

##### (ii) Top Surfaces of Upper flange of Underframe Members of open Wood Floored Wagons

NOTE. These operations shall be carried out after the painting treatment given in (i) has been completed and shall apply only to areas not previously treated or from which damaged tape has been removed.

Apply one coat "Flangeprep" to B.R. Specification No. 50 Item 1.

Apply immediately Preformed Protective Tape to B.R. Specification No.50 Item 2 of appropriate size for the flange width, with the non-sticky side uppermost, ensuring correct alignment and absence of airpockets below the tape. The tape should overhang free flange edges by at least  $\frac{1}{2}$ " and any joints should overlap by approximately 1".

##### (b) Steel Underframes of Other Vehicles, together with Undergear, Brakegear and Bogies of all vehicles

Apply one coat Gelled Bituminous Solution to B.R. Specification No.32B, Item 51.

##### (c) Wooden Underframes

No painting required.

#### PART 2. WHEELS

No treatment is required.

#### PART 3. AXLES AND AXLEBOXES

Apply one coat Black Lacquer to B.R. Specification No.32B Item 50 (except front plate of Roller Bearing Axleboxes which should have one coat of Yellow Lining Paint to B.R. Specification No.32B, Item 43 and a red horizontal stripe  $1\frac{1}{2}$  inches wide.)

PART 4. METAL AND WOOD BODIES, EXTERIOR SIDES AND ENDS

Table 1.3 Coatings to be Applied

Type of Vehicle	Type of Body	Type of Process	Description of Material	B.R. PAINT Specn.	
				No.	Item
Breakdown Train Vehicles of Passenger Stock Design	Metal	O.B. or O.S.	Apply 1 coat Pink Under-coating Paint	32B	9
			Apply 1 coat Red Enamel	32B	10
			Apply 1 coat Exterior Finishing Varnish for Carriages (after lettering as necessary)	32B	23
	Wood	O.B. or O.S.	Apply to outer surface of any new sheeting 1 coat Wagon Primer for Wood	32B	3
			Apply all over body exterior 1 coat Red Enamel	32B	10
			Apply all over body exterior 1 coat Exterior Finishing Varnish for Carriages (after lettering as necessary)	32B	23
Breakdown Train Vehicles Of Freight Stock Design	Metal	O.B. or O.S.	Apply 1 coat Pink Under-coating Paint	32B	9
			Apply 1 coat Red Enamel	32B	10
	Wood	O.B.	Apply to outer surface of any new sheeting 1 coat Wagon Primer for Wood	32B	3
			Apply all over body exterior 1 coat Red Enamel	32B	10

PART 5. LETTERING AND MARKING - To be in accordance with revised instructions issued April, 1963.

Apply where necessary White Lettering Paint to B.R. Specification No.32B, Item 42 before varnishing.

PART 6. VACUUM PIPE ENDS

Table 2.3 Coatings to be Applied

Type of Vehicle	Type of Process	Description of Material	B.R. Paint Specn.	
			No.	Item
Fitted Vehicles	O.B.	1 coat Freight Stock Red Finishing Paint	32B	16
	O.S.	1 coat Freight Stock Red Finishing Paint (for Spray Application)	32B	16
	Q.D.	1 coat Freight Stock Red Finishing Paint (Syn.)	32B	32
Through Piped Vehicles	O.B.	1 coat White Lettering Paint	32B	42
	O.S.	1 coat White Lettering Paint	32B	42
	Q.D.	1 coat Freight Stock White Marking Paint (Syn.)	32B	34



Note. When new vacuum pipe ends are fitted they should be given 1 coat Freight Stock Red Primer/Undercoating Paint to B.R. Specification No.32B, Item 15 before the finishing coat indicated above. Also new pipes in the case of "Through-piped" vehicles should be given 1 coat Freight Stock Grey Primer/Undercoating Paint to B.R. Specification No.32B, Item 17, before finishing with the White Lettering Paint.

## PART 7. ROOFS

### (i) Repaint

Roofs of all covered stock not covered by a Proprietary Process or specially prepared Roofing Canvas, shall, where stripping is unnecessary, receive one coat **Finishing Coat Roof** Paint to B.R. Specification No.32B, Item 14, after any loosely adherent dirt, etc. has been removed.

### (ii) Recanvassed

Apply one coat Wagon Primer for Wood to B.R. Specification No.32B, Item 3, to any new wood.

Stop up as necessary with Putty to B.R. Specification No.32B, Item 5.

Apply one coat Jointing Paste to B.R. Specification No.32B, Item 6.

After the canvas has been stretched on and properly bedded, apply one coat Roof Canvas Dressing to B.R. Specification No.32B, Item 7.

Apply one coat First Coat Roof Paint to B.R. Specification No.32B, Item 13.

Apply one coat Finishing Coat Roof Paint to B.R. Specification No.32B, Item 14.

### (iii) Where covered by a Proprietary Process

The repair of wagons treated with a Proprietary Process should be dealt with in accordance with instructions issued by the manufacturer concerned.

### (iv) Where Covered by a Specially Prepared Roofing Canvas

Roofs covered by a Specially Prepared Canvas shall, after removal of any loosely adherent dirt, etc., and repairing as may be necessary, be given one coat Finishing Coat Roof Paint to B.R. Specification No.32B, Item 14.

## PART 8. BODY INTERIOR (COVERED VEHICLES)

### (i) Ceiling and Upper Walls

Apply one coat Stone Colour Finishing Paint to B.R. Specification No.32B, Item 20.

### (ii) Lower Walls to a Height of 3'6"

Apply one coat Freight Stock Red Finishing Paint to B.R. Specification No.32B, Item 16.

SECTION 4

REPAINTING OF REFRIGERATED AND INSULATED  
WAGONS (EXCEPT BANANA VANS) AND FISH VANS.

Attention is drawn to the Preparatory Treatment required for all wood or metal surfaces (Section 0) prior to the commencement of any painting operations.

PART 1. UNDERFRAME, UNDERGEAR AND BRAKEGEAR (EXCLUDING PIPE ENDS)

Apply one coat Gelled Bituminous Solution to B.R. Specification No.32B, Item 51.

PART 2. WHEELS

No treatment required.

PART 3. AXLES AND AXLEBOXES

Apply one coat Black Lacquer to B.R. Specification No.32B Item 50 (except front plate of Roller Bearing Axleboxes which should have one coat of Yellow Lining Paint to B.R. Specification No.32B, Item 43, and a red horizontal stripe 1½ inches wide.)

PART 4. METAL AND WOOD BODIES, EXTERIOR SIDES AND ENDS

Apply one coat White Undercoating Paint to B.R. Specification No.32B, Item 12, or where spray application is used apply one coat White Sealer/Undercoating Paint (Syn.) to B.R. Specification No.32B, Item 35.

Apply one coat Ice Blue Enamel (Syn.) to B.R. Specification No.32B, Item 24.

PART 5. LETTERING AND MARKING - To be in accordance with revised instructions issued April, 1963.

Apply where necessary White Marking Paint (Syn.) to B.R. Specification No.32B, Item 34.

PART 6. VACUUM PIPE ENDS

Table 1.4 Coatings to be Applied

Type of Vehicle	Type of Process	Description of Material	B.R.Paint Specn.	
			No.	Item
Fitted Vehicles	O.B.	1 coat Freight Stock Red Finishing Paint	32B	16
	O.S.	1 coat Freight Stock Red Finishing Paint (for Spray Application)	32B	16
	Q.D.	1 coat Freight Stock Red Finishing Paint (Syn.)	32B	32
Through Piped Vehicles	O.B.	1 coat White Lettering Paint	32B	42
	O.S.	1 coat White Lettering Paint	32B	42
	Q.D.	1 coat Freight Stock White Marking Paint (Syn.)	32B	34

NOTE When new Vacuum Pipe Ends are fitted they should be given one coat Freight Stock Red Primer/Undercoating Paint to B.R. Specification No.32B, Item 15 before the finishing coat indicated above. Also new pipes in the case of "Through-Piped" vehicles should be given one coat Freight Stock Grey Primer/ Undercoating Paint to B.R. Specification No.32B, Item 17 before finishing with the White Lettering Paint.

PART 7. ROOFS

(i) Repaint

Roofs not covered by a Proprietary Process or specially prepared Roofing Canvas shall, where stripping is unnecessary, receive one coat Finishing Coat Roof Paint to B.R. Specification No.32B, Item 14, after any loosely adherent dirt etc., has been removed.

(ii) Recanvassed

Apply one coat Wagon Primer for Wood to B.R. Specification No.32B, Item 3, to new wood only. Stop up as necessary with Putty to B.R. Specification No.32B, Item 5. Apply one coat jointing Paste to B.R. Specification No.32B, Item 6.

After the canvas has been stretched on and properly bedded, apply one coat Roof Canvas Dressing to B.R. Specification No.32B, Item 7. Apply one coat 1st Coat Roof Paint to B.R. Specification No. 32B, Item 13. Apply one coat Finishing Coat Roof Paint to B.R. Specification No.32B, Item 14.

(iii) Where Covered by a Proprietary Process

The repair of wagons treated with a Proprietary Process should be dealt with in accordance with instructions issued by the manufacturers concerned.

(iv) Where Covered by a Specially Prepared Roofing Canvas

Roofs covered by a Specially Prepared Canvas shall, after removal of any loosely adherent dirt, etc., and repairing as may be necessary, be given one coat Finishing Coat Roof Paint to B.R. Specification No.32B, Item 14.

PART 8. BODY INTERIOR (SEE NOTE 4 IN FOREWORD TO THESE INSTRUCTIONS)

Table 2.4 Coatings to be Applied

Area to be Treated	Description of Material	B.R.Paint Specn.	
		No.	Item
Metal Panels (exposed surfaces)	No treatment	-	-
Wood Panels (exposed surfaces)	1 coat P.V.A. Pale Cream Emulsion Paint, Matt Finish	- 32B	74
	1 coat P.V.A. Pale Cream Emulsion Paint, Eggshell Gloss Finish	32B	75

## SECTION 5

### REPAINTING OF SODA ASH, FERTILIZER AND SALT WAGONS (OTHER THAN AIR PRESSURE DISCHARGE)

Attention is drawn to the Special Preparatory Treatment required (Section 0) before the commencement of any painting operations.

#### PART 1. UNDERFRAME, UNDERGEAR AND BRAKEGEAR (EXCLUDING PIPE ENDS)

Apply one coat Gelled Bituminous Solution to B.R. Specification No.32B, Item 51.

#### PART 2. WHEELS

No treatment is required.

#### PART 3. AXLES AND AXLEBOXES

Apply one coat Black Finishing Paint (Type R) to B.R. Specification No.32B, Item 85 (except front plate of Roller Bearing Axleboxes which should have one coat of Yellow Lining Paint to B.R. Specification No.32B Item 43 and a red horizontal stripe 1½ inches wide.

#### PART 4. STEEL BODIES EXTERIOR

Table 1.5 Coatings to be Applied

Type of Vehicle	Description of Materials	B.R.Paint Specn.	
		No.	Item
Unfitted and fitted Stock (including "Through-Piped" Wagons)	Touch up any bare metal with Primer for metal (Type R)	32B	80
	1 coat Freight Stock Red Undercoating Paint (Type R)	32B	83
	1 coat Freight Stock Grey Undercoating Paint (Type R)	32B	81
	1 coat Freight Stock Red Finishing Paint (Type R)	32B	84

PART 5. LETTERING AND MARKING - To be in accordance with revised instructions issued April, 1963.

Table 2.5 Coatings to be Applied

Type of Vehicle	Description of Material	B.R.Paint Specn.	
		No.	Item
Unfitted and fitted Wagons including "Through-Piped" Wagons	White Lettering Paint (Type R)	32B	86

PART 6. VACUUM PIPE ENDS

Table 3.5 Coatings to be Applied

Type of Vehicle	Description of Material	B.R. Paint Specn.	
		No.	Item
Fitted Wagons	1 coat Freight Stock Red Finishing Paint (Type R)	32B	84
"Through-Piped" Wagons	1 coat White Lettering Paint (Type R)	32B	86

NOTE. When new Vacuum Pipe Ends are fitted they should be given one coat Freight Stock Red Undercoating Paint (Type R) to B.R. Specification No.32B, Item 83 before the finishing coat indicated above. Also new pipes in the case of "Through-Piped" vehicles should be given one coat Freight Stock Grey Undercoating Paint (Type R) to B.R. Specification No.32B, Item 81 before finishing with the White Lettering Paint.

PART 7. ROOFS

Where applicable - Apply same treatment as given for Body Exterior.

PART 8. BODY INTERIOR (APPLICABLE TO METAL BODIES OF FERTILIZER AND SALT WAGONS ONLY)

Touch in any bare metal with Primer for Metal (Type R) to B.R. Specification No.32B, Item 80. Apply one coat Freight Stock Red Undercoating Paint (Type R) to B.R. Specification No.32B, Item 83. Apply one coat Freight Stock Grey Finishing Paint (Type R) to B.R. Specification No.32B, Item 82. Apply one coat Freight Stock Red Finishing Paint (Type R) to B.R. Specification No.32B, Item 84.

SECTION 6

REPAINTING OF TANK WAGONS FOR THE CONVEYANCE OF TAR,  
CREOSOTE AND OIL GAS

Attention is drawn to the Preparatory Treatment required for all metal surfaces (Section 0) prior to the commencement of any painting operations.

PART 1. UNDERFRAME, UNDERGEAR AND BRAKEGEAR (EXCLUDING PIPE ENDS)

Apply one coat Gelled Bituminous Solution to B.R. Specification No.32B, Item 51.

PART 2. WHEELS

No treatment required.

PART 3. AXLES AND AXLEBOXES

Apply one coat Black Lacquer to B.R. Specification No.32B, Item 50(except front plate of Roller Bearing Axleboxes which should have one coat of Yellow Lining Paint to B.R. Specification No.32B item 43 and a red horizontal stripe 1½ inches wide.)

PART 4. BODY EXTERIOR

Apply two coats Black Lacquer to B.R. Specification No.32B, Item 50.

PART 5. LETTERING AND MARKING - To be in accordance with revised instructions issued April, 1963.

Apply any letters that may be necessary using White Lettering Paint to B.R. Specification No. 32B Item 42.

PART 6. VACUUM PIPES

Table 1.6 Coatings to be Applied

Type of Vehicle	Type of Process	Description of Material	B.R.Paint Specn.	
			No.	Item
Fitted Wagons	O.B.	1 coat Freight Stock Red Finishing Paint	32B	16
	O.S.	1 coat Freight Stock Red Finishing Paint for Spray Application	32B	16
	Q.D.	1 coat Freight Stock Red Finishing Paint (Syn.)	32B	32
Through Piped Wagons	O.B.	1 coat White Lettering Paint	32B	42
	O.S.	1 coat White Lettering Paint	32B	42
	Q.D.	1 coat Freight Stock White Marking Paint (Syn.)	32B	34

NOTE. When new Vacuum Pipe Ends are fitted they should be given one coat Freight Stock Red Primer/Undercoating Paint to B.R. Specification No.32B, Item 15 before the finishing coat indicated above. Also new pipes in the case of "Through-Piped" vehicles should be given one coat Freight Stock Grey Primer/Undercoating Paint to B.R. Specification No. 32B Item 17, before finishing with the White Lettering Paint.

PART 7. ROOFS

Not applicable.

PART 8. BODY INTERIOR

Not applicable.

SECTION 7

REPAINTING OF BULK GRAIN WAGONS

Attention is drawn to the Preparatory Treatment required for all metal surfaces (Section 0) prior to the commencement of any painting operations.

PART 1. UNDERFRAME, UNDERGEAR AND BRAKEGEAR (EXCLUDING PIPE ENDS)

Apply one coat Gelled Bituminous Solution to B.R. Specification No.32B, Item 51.

PART 2. WHEELS

No treatment is required.

PART 3. AXLES AND AXLEBOXES

Apply one coat Black Lacquer to B.R. Specification No.32B, Item 50.

PART 4. BODY EXTERIOR

Table 1.7 Coatings to be Applied

Type of Vehicle	Type of Process	Description of Material	B.R.Paint Specn.	
			No.	Item
Unfitted and Fitted Wagons including Through Piped Wagons	O.B.	1 coat Freight Stock Red Primer/Undercoating Paint	32B	15
		1 coat Freight Stock Red Finishing Paint	32B	16
	O.S.	1 coat Freight Stock Red Primer/Undercoating Paint (for Spray Application)	32B	15
		1 coat Freight Stock Red Finishing Paint (for Spray Application)	32B	16
	Q.D.	1 coat Freight Stock Red Primer/Undercoating Paint (Syn.)	32B	31
		1 coat Freight Stock Red Finishing Paint (Syn.)	32B	32

PART 5. LETTERING AND MARKING - To be in accordance with revised instructions issued April, 1963.

Table 2.7 Coatings to be Applied

Type of Vehicle	Description of Material	B.R.Paint Specn.	
		No.	Item
Unfitted and Fitted Wagons including Through-Piped Wagons	White Lettering Paint	32B	42



PART 6. VACUUM PIPE ENDS

Table 3.7 Coatings to be Applied

Type of Vehicle	Type of Process	Description of Material	B.R. Paint Specn.	
			No.	Item
Fitted Wagons	O.B.	1 coat Freight Stock Red Finishing Paint	32B	16
	O.S.	1 coat Freight Stock Red Finishing Paint for Spray Application	32B	16
	Q.D.	1 coat Freight Stock Red Finishing Paint (Syn.)	32B	32
Through-Piped Wagons	O.B.	1 coat White Lettering Paint	32B	42
	O.S.	1 coat White Lettering Paint	32B	42
	Q.D.	1 coat Freight Stock White Marking Paint (Syn.)	32B	34

NOTE. When new Vacuum Pipe Ends are fitted they should be given one coat Freight Stock Red Primer/Undercoating Paint to B.R. Specification No.32B, Item 15, before the finishing coat indicated above. Also new pipes in the case of Through-Piped vehicles should be given one coat Freight Stock Grey Primer/Undercoating Paint to B.R. Specification No.32B, Item 17 before finishing with the White Lettering Paint.

PART 7. ROOFS

Where applicable - Apply same treatment as given for Body Exterior.

PART 8. BODY INTERIOR

Repaint Loading Line using White Lettering Paint to B.R. Specification No.32B, Item 42.

SECTION 8

REPAINTING OF CEMENT WAGONS, (AIR PRESSURE DISCHARGE) INCLUDING THOSE MODIFIED TO CARRY FULLER'S EARTH, ALUMINA ETC.

Attention is drawn to the Special Preparatory Treatment required (Section 0) prior to the commencement of any painting operations.

PART 1. UNDERFRAME, UNDERGEAR AND BRAKEGEAR (EXCLUDING PIPE ENDS)

Apply one coat Gelled Bituminous Solution to B.R. Specification No.32B, Item 51.

PART 2. WHEELS

No treatment is required.

PART 3. AXLES AND AXLEBOXES

Apply one coat Black Finishing Paint (Syn.) to B.R. Specification No.32B, Item 28.(except front plate of Roller Bearing Axleboxes which should have one coat of Yellow Lining Paint to B.R. Specification No.32B Item 43 and with a red horizontal stripe 1½" wide.)

PART 4. BODY EXTERIOR

Table 1.8 Coatings to be Applied

Type of Vehicle	Description of Material	B.R.Paint Specn.	
		No.	Item
Unfitted and Fitted Wagons including Through-Piped Wagons	1 coat Freight Stock Red Primer/ Undercoating Paint (Syn.)	32B.	31
	1 coat Freight Stock Red Finishing Paint (Syn.)	32B	32

PART 5. LETTERING AND MARKING - To be in accordance with revised instructions issued April, 1963.

Table 2.8 Coatings to be Applied

Type of Vehicle	Description of Material	B.R.Paint Specn.	
		No.	Item
Unfitted and Fitted Wagons	White Lettering Paint	32B	42

PART 6. VACUUM PIPE ENDS

Table 3.8 Coatings to be Applied

Type of Vehicle	Type of Process	Description of Material	B.R. Paint Specn.	
			No.	Item
Fitted Wagons	O.B.	1 coat Freight Stock Red Finishing Paint	32B	16
	O.S.	1 coat Freight Stock Red Finishing Paint (for Spray Application)	32B	16
	Q.D.	1 coat Freight Stock Red Finishing Paint (Syn.)	32B	32
Through Piped Wagons	O.B.	1 coat White Lettering Paint	32B	42
	O.S.	1 coat White Lettering Paint	32B	42
	Q.D.	1 coat Freight Stock White Marking Paint (Syn.)	32B	34

NOTE. When new Vacuum Pipe Ends are fitted they should be given one coat Freight Stock Red Primer/Undercoating Paint to B.R. Specification No.32B, Item 15, before the finishing coat indicated above. Also new pipes in the case of Through-Piped vehicles should be given one coat Freight Stock Grey Primer/Undercoating Paint to B.R. Specification No.32B, Item 17, before finishing with the White Lettering Paint.

PART 7. ROOFS

Where applicable - Apply same treatment as given for Body Exterior.

PART 8. BODY INTERIOR

Apply one coat Freight Stock Grey Finishing Paint (Syn.) to B.R. Specification No.32B, Item 30.

Apply one coat Finishing Varnish (Syn.) to B.R. Specification No. 32B, Item 33.

SECTION 9

REPAINTING OF COVHOPS

Attention is drawn to the Special Preparatory Treatment required for all metal surfaces (Section 0) before the commencement of any painting operations.

PART 1. UNDERFRAME, UNDERGEAR AND BRAKEGEAR (EXCLUDING PIPE ENDS)

Apply one coat of Gelled Bituminous Solution to B.R. Specification No. 32B, Item 51.

PART 2. WHEELS

No treatment is required.

PART 3. AXLES AND AXLEBOXES

Apply one coat Black Lacquer to B.R. Specification No. 32B Item 50 (except front plate of Roller Bearing Axleboxes which should have one coat of Yellow Lining Paint to B.R. Specification No. 32B Item 43, and a red horizontal stripe 1½ inches wide).

PART 4. BODY EXTERIOR

Table 1.9 Coatings to be Applied

Type of Vehicle	Description of Materials	B.R. Paint Specn.	
		No.	Item
Unfitted and Fitted (including "Through-Piped" Wagons)	Touch up any bare metal with Primer for Metal (Type R)	32B	80
	1 coat Freight Stock Red Undercoating Paint (Type R)	32B	83
	1 coat Freight Stock Grey Undercoating Paint (Type R)	32B	81
	1 coat Freight Stock Red Finishing Paint (Type R)	32B	84

PART 5. LETTERING AND MARKING - To be in accordance with revised instructions issued April, 1963.

Table 2.9 Coatings to be Applied

Type of Vehicle	Description of Materials	B.R. Paint Specn.	
		No.	Item
Unfitted and Fitted Wagons	White Lettering Paint (Type R)	32B	86

PART 6. VACUUM PIPE ENDS

Table 3.9 Coatings to be Applied

Type of Vehicle	Type of Process	Description of Material	B.R.Paint Specn.	
			No.	Item
Fitted Wagons	O.B.	1 coat Freight Stock Red Finishing Paint	32B	16
	O.S.	1 coat Freight Stock Red Finishing Paint (for Spray Application)	32B	16
	Q.D.	1 coat Freight Stock Red Finishing Paint (Syn.)	32B	32
Through Piped Wagons	O.B.	1 coat White Lettering Paint	32B	42
	O.S.	1 coat White Lettering Paint	32B	42
	Q.D.	1 coat Freight Stock White Marking Paint (Syn.)	32B	34

**NOTE** When new Vacuum Pipe Ends are fitted they should be given one coat Freight Stock Red Primer/Undercoating Paint to B.R. Specification No.32B, Item 15, before the finishing coat indicated above. Also new pipes in the case of Through-Piped vehicles should be given one coat Freight Stock Grey Primer/ Undercoating Paint to B.R. Specification No.32B, Item 17, before finishing with the White Lettering Paint.

PART 7. ROOFS

Where applicable - Apply same treatment as given for Body Exterior.

PART 8. BODY INTERIOR

To the top portion of the interior down to 3 feet below the Cant Rail.

Apply one coat Freight Stock Red Finishing Paint (Syn.) to B.R. Specification No.32B, Item 32.

SECTION 10

REPAINTING OF CONTAINERS INCLUDING OPEN; INSULATED;  
VENTILATED; PRESSURISED; BOTTOM DOOR BULK MATERIAL, AND  
COVERED CONTAINERS OTHER THAN INSULATED (METAL OR WOOD)

Attention is drawn to the Preparatory Treatment required for all wood or metal surfaces (Section 0) prior to the commencement of any painting operations.

PART 1. UNDERFRAMES, UNDERGEAR AND BRAKEGEAR

Not applicable.

PART 2. WHEELS

Not applicable.

PART 3. AXLES AND AXLEBOXES

Not applicable.

PART 4. BODY EXTERIOR SIDES AND ENDS (Certain containers of Alloy Construction shall not be painted)

Table 1.10 Coatings to be Applied

Type of Vehicle	Type of Process	Description of Material	B.R.Paint Specn.		
			No.	Item	
Open Containers (Metal or Wood)	O.B.	Touch in any bare area with Freight Stock Red Primer/ Undercoating Paint 1 coat Freight Stock Red Finishing Paint	32B	15	
			32B	16	
		O.S.	Touch in any bare area with Freight Stock Red Primer/ Undercoating Paint 1 coat Freight Stock Red Finishing Paint for Spray Application	32B	15
	32B			16	
	Q.D.	Touch in any bare area with Freight Stock Red Primer/ Undercoating Paint (Syn.) 1 coat Freight Stock Red Finishing Paint (Syn.)	32B	31	
			32B	32	
	Insulated Ventilated and Pressurised Containers (Metal or Wood)		Touch in any bare metal with Primer for Metal or bare wood with Primer for wood 2 coats White Undercoating Paint or where spray application is in use apply 2 coats White Sealer/Undercoating Paint (Syn.) 1 coat Ice Blue Enamel (Syn.)	32B	1
				32B	2
				32B	12
32B				35	
32B				24	

Table 1.10 Coatings to be Applied (contd)

Type of Vehicle	Type of Process	Description of Material	B.R.Paint Specn.	
			No.	Item
Covered Containers other than Insulated, Ventilated, Pressurised, or Bottom Door Bulk Material Containers (Metal or Wood)		Touch in any bare metal with Primer for Metal or bare wood with Primer for Wood	32B	1
		1 coat Freight Stock Red	32B	2
		Primer/Undercoating Paint	32B	15
		1 coat Freight Stock Red	32B	32
		Finishing Paint (Syn.)	32B	33
Bottom Door Bulk Material Containers		Letter then 1 coat Exterior Finishing Varnish (Syn.)	32B	
		Touch in any bare metal with Freight Stock Grey Primer/Undercoating Paint (Syn.)	32B	29
		1 coat Freight Stock Grey Finishing Paint (Syn.)	32B	30

PART 5. LETTERING AND MARKING - To be in accordance with revised instructions issued April 1963

Table 2.10 Coatings to be Applied

Type of Vehicle	Description of Material	B.R.Paint Specn.	
		No.	Item
Bottom Door Bulk Material Containers	White Lettering Paint, applied over a black panel obtained by coating an appropriate area to carry letters and figures, with Black Finishing Paint (Syn.) to BR.Spec 32B Item 28)	32B	42
		<del>32B</del>	<del>28</del>
Insulated Ventilated and Pressurised Containers (Metal or Wood)	Freight Stock White Marking Paint (Syn.)	32B	34
Containers other than above (Metal or Wood)	White Lettering Paint	32B	42

PART 6. VACUUM PIPE ENDS

Not applicable.

PART 7. ROOFS

(i) Repaint

The roof shall, where not covered by a Proprietary Process and where stripping is unnecessary, receive one coat of Finishing Coat Roof Paint to B.R. Specification No. 32B, Item 14 after any loosely adherent dirt, etc., has been removed.

PART 7. ROOFS (contd)

(ii) Recanvassed

Apply one coat Wagon Primer for Wood to B.R. Specification No.32B, Item 3, to any new wood.

Stop up as necessary with Putty to B.R. Specification No.32B, Item 5.

Apply one coat Jointing Paste to B.R. Specification No. 32B, Item 6.

After the canvas has been stretched on and properly bedded; apply one coat Roof Canvas Dressing to B.R. Specification No. 32B, Item 7.

Apply one coat 1st Coat Roof Paint to B.R. Specification No. 32B, Item 13.

Apply one coat Finishing Coat Roof Paint to B.R. Specification No. 32B, Item 14.

(iii) Where covered by a Proprietary Process

The repair of containers treated with a Proprietary Process should be dealt with in accordance with instructions issued by the Manufacturer concerned.

(iv) Where covered by a Specially Prepared Canvas

Roofs covered by a Specially Prepared Canvas shall, after removal of any loosely adherent dirt, etc., and repairing as may be necessary, be given one coat of Finishing Coat Roof Paint to B.R. Specification No.32B, Item 14.

PART 8. BODY INTERIOR (See Note (4) in Foreword to these Instructions.

Table 3.10 Coatings to be Applied

Type of Container	Area to be Treated	Description of Material	B.R. Paint Specn.	
			No.	Item
Open Container	-	No treatment	-	-
Insulated Ventilated Pressurised Containers	Metal Panels, Exposed surfaces	No treatment	-	-
	Wood Panels, Exposed surfaces	1 coat P.V.A. Pale Cream Emulsion Paint Matt Finish followed by 1 coat P.V.A. Pale Cream Emulsion Paint Eggshell Gloss Finish	32B	74
			32B	75



Type of Container	Area to be Treated	Description of Material	B.R. Paint Specn. No. Item	
Bottom Door Bulk Material Containers	-	No treatment	-	-
Covered Containers other than Insulated Ventilated and Pressured	Wood Panels	No treatment	-	-
	Metal Panels	No treatment	-	-

