

Drawing Number  
R90528-GGP-STS-MAN-DR-C-000004

C01

| NETWORK RAIL PAINT SPEC FOR NEW METAL WORK FROM NRL3/CIV/040 |                                                 |                                                                                      |                                             |                                                                               |                                                  |
|--------------------------------------------------------------|-------------------------------------------------|--------------------------------------------------------------------------------------|---------------------------------------------|-------------------------------------------------------------------------------|--------------------------------------------------|
| REFERENCE NUMBER                                             | TITLE                                           | SURFACE PREPERATION                                                                  | COAT B (SEALER)                             | COAT C (INTERMEDIATE COAT)                                                    | COAT D (TOP COAT)                                |
| N1                                                           | THERMALLY SPRAYED METAL/EPOXY PROTECTIVE SYSTEM | BLAST-CLEAN TO SA3 ( BS EN ISO 8501-1). SURFACE PROFILE WITHIN THE RANGE OF 70-100um | METAGARD L574 BLAST PRIMER - THICKNESS 20um | SELECT FROM EPIGRIP C402V2 ZINC PHOSPHATE PRIMER/BUILDCOAT - THICKNESS 150um. | RESISTEX C137V2 SPECIAL FINISH - THICKNESS 50um. |

METALWORK NOTES:

- METALWORK REPAIR DIMENSIONS & DETAILS TO BE CONFIRMED BY FABRICATOR PRIOR TO FABRICATION BY MEANS OF TEMPLATING OR SIMILAR
- ALL PLATE SIZES DIMENSION TO SUIT EXISTING FLANGE / WEB / RIVET LAYOUT
- EXISTING RIVET HOLES TO BE CHECKED BY CONTRACTOR FOLLOWING THE REMOVAL OF EXISTING RIVETS
- ALL NEW BOLT HOLES TO BE MIN 2mm GREATER THAN BOLT SIZE
- CUTS MADE TO METALWORK WITH ANGLE GRINDER OR SIMILAR. CONTRACTOR TO CONFIRM
- ALL WATER TRAPS BETWEEN ELEMENTS TO BE FILLED WITH SIKADUR SEALANT PRIOR TO PAINTING

NOTE:-  
LENGTH / SIZES OF TCBS TO SUIT FLANGE / WEB THICKNESS AND RIVET HOLES TO BE CONFIRMED ON SITE

NOTE:-  
SECTIONS OF NEW PLATE THAT WILL BE IN CONTACT WITH TCB HEADS AND WASHERS ARE TO BE CLEAR OF ANY PAINT TO ENSURE THERE IS SUFFICIENT FRICTION BETWEEN THE TWO ELEMENTS

| NETWORK RAIL MAINTENANCE PAINT SPEC FROM NR/L3/CIV/040 |                                                                                                                     |                                                                                                                                                                                                                                                                             |                                                                 |        |                                                                                                                                                                                                                          |                                                                                                                                                                                                                                                                                |
|--------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------|--------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| REFERENCE NUMBER                                       | TITLE                                                                                                               | SUBSTRATE                                                                                                                                                                                                                                                                   | COAT A                                                          | COAT B | COAT C (INTERMEDIATE COAT)                                                                                                                                                                                               | COAT D (TOP COAT)                                                                                                                                                                                                                                                              |
| M24                                                    | PROTECTIVE TREATMENT FOR PATCH REPAIR OF AGED ALKYD EXISTING STRUCTURES USING DURABLE TWO PACK PROTECTIVE TREATMENT | EXISTING IRON OR STEEL WITH AGED ALKYD PROTECTIVE TREATMENT SPOT-BLAST CLEANED TO A SURFACE STANDARD Sa 2 1/2 (BS 7079 PART A1) AND A SURFACE PROFILE MEAN PEAK TO VALLEY HEIGHT OF 75-100µm OR CLEANED USING HAND OR POWER TOOLS ON SURFACE STANDARD Si3 (BS 7079:PART A1) | ITEM 7.1.5 SURFACE TOLERANT EPOXY PRIMER WITH MINIMUM DFT 100µm |        | SELECT FROM THE FOLLOWING WITH DFT MINIMUM 100µm: <ul style="list-style-type: none"><li>- ITEM 7.1.6. SURFACE TOLERANT EPOXY UNDERCOAT (MIO)</li><li>- ITEM 7.1.7. HIGH BUILD SURFACE TOLERANT EPOXY UNDERCOAT</li></ul> | SELECT FROM THE FOLLOWING WITH DFT MINIMUM 50µm: <ul style="list-style-type: none"><li>- ITEM 7.3.1. ACRYLIC URETHANE TOP COAT</li><li>- ITEM 7.3.2. EPOXY ACRYLIC TOP COAT</li><li>- ITEM 7.3.3. FLUOROPOLYMER TOP COAT</li><li>- ITEM 7.3.4. POLYSILOXANE TOP COAT</li></ul> |

NOTE:  
DEVCON PUTTY TO BE USED TO FILL AREAS OF PITTING AND UNEVENNESS FOLLOWING PREPARATION OF FAYING SURFACES.

FAYING SURFACES TO BE PREP'D TO SA2½ (0.5-09µ). WHERE CORROSION TO FAYING SURFACE CANNOT BE PREVENTED BY MASKING IN THE SHORT TERM, FAYING SURFACES ARE TO BE PREPARED WITH BLAST PRIMER COMPATIBLE WITH CHOSEN PAINT SYSTEM.

PRIMER TO PROVIDE MINIMUM SLIP FACTOR OF 0.45µ AS PER NR/CIV/SD/800 REV F.

NOTE:  
SECTIONS OF THE NEW PLATE THAT WILL BE IN CONTACT WITH BOLT HEADS AND WASHERS ARE TO BE CLEAR OF ANY PAINT TO ENSURE THERE IS SUFFICIENT FRICTION BETWEEN THE TWO ELEMENTS.

NOTE:  
REPAIRS TO UNDERTAKEN IN ACCORDANCE WITH TECHNICAL USER MANUAL

NOTE:  
PREPARATION & PAINTING OF NEW STEELWORK IS TO BE UNDERTAKEN OFF SITE PRIOR TO BEING BROUGHT TO SITE.

| APPROVED FOR CONSTRUCTION |              |                                                                                                                                                                                                                                                                                    |      |
|---------------------------|--------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|
|                           | PRINTED NAME | SIGNATURE                                                                                                                                                                                                                                                                          | DATE |
| NETWORK RAIL              |              |                                                                                                                                                                                                                                                                                    |      |
| C.E.M                     |              | <div><div><div><div><div></div><div>Ricky Bailey</div></div><div><div>Digitally signed by Ricky Bailey<br/>DN: cn=Ricky Bailey, o=GB,<br/>ou=AMCO GIFFEN, ou=HW&amp;C,<br/>email=Ricky.Bailey@amcogiffen.co.uk<br/>Date: 2024.08.09 13:59:58 +01'00'</div></div></div></div></div> |      |

KEY

EXISTING

EXISTING TO BE MODIFIED

PROPOSED

TO BE REMOVED

HAZARD

DEFECT

|                           |          |                           |       |      |             |
|---------------------------|----------|---------------------------|-------|------|-------------|
| C01                       | 09/08/24 | APPROVED FOR CONSTRUCTION | Z.H   | J.H  | R.G         |
| B02                       | 07/06/24 | ISSUED FOR INFORMATION    | Z.H   | J.H  | R.G         |
| B01                       | 15/07/24 | ISSUED FOR INFORMATION    | Z.H   | J.H  | R.G         |
| Rev                       | Date     | Description of Revisions  | Drawn | Chkd | Appr        |
| Status                    |          |                           |       |      | Subsibility |
| APPROVED FOR CONSTRUCTION |          |                           |       |      | S4          |

Network Rail

Contractor(s)

AMCO GIFFEN

GGP CONSULT

Project

MANCHESTER PICCADILY TRAIN SHED ROOF REPAIR

Drawing Title

NOTES & PAINT SPECIFICATIONS

|                       |             |                                |             |      |          |
|-----------------------|-------------|--------------------------------|-------------|------|----------|
| Designed              | W. WANG     | Signed                         | <div></div> | Date | 09/08/24 |
| Drawn                 | Z. HUNT     | Signed                         | <div></div> | Date | 09/08/24 |
| Checked               | J. HARTLEY  | Signed                         | <div></div> | Date | 09/08/24 |
| Approved              | R. GALLOWAY | Signed                         | <div></div> | Date | 09/08/24 |
| Scales(s)             |             | AS SHOWN @A1                   |             |      |          |
| Alternative Reference |             | N/A                            |             |      |          |
| Drawing Number        |             | R90528-GGP-STS-MAN-DR-C-000004 |             |      |          |

ELR & Mileage

CMP2 188m 1562yds

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Revision C01

APPROVED FOR CONSTRUCTION

Sheet Size A1 594 x 841