

MDTS064

DATED 27/05/2000

**SPECIFICATION FOR FIBRE REINFORCED PLASTIC-
TISSUE TREATMENT ON INSIDE SURFACE OF BODY SIDE DOORS
FOR ALL COACHES (A.C. & NON A.C.)**

| NAME | DESIGNATION | SIGNATURE | DATE | LEVEL |
|-------------------|-------------|----------------------|------------|----------|
| MR. MANOJ MEHTA | SE/CAD/CAM | <i>Manoj</i> | 27/05/2000 | PREPARED |
| MR. H.S. SOHANPAL | SME/DI | <i>H.S. Sohanpal</i> | 31/5/2000 | AGREED |
| MR. RAVI NARULA | DY.CME/D | <i>Ravi</i> | 2-6-2000 | REVIEWED |
| MR. A. KHARE | CDE | <i>A. Khare</i> | 3-6-2000 | APPROVED |

| Issue | Details of changes | Date |
|-------|--------------------|--|
| 1.0 | First Issue | 27/05/2000 06/06/2000 <i>H.S. Sohanpal</i> |

Manoj
PREPARED BY

H.S. Sohanpal
AGREED BY

FILE NAME: /USERS2/SHELL/SHELL/MDTS064s2.PRT



310

**SPECIFICATION FOR FIBRE REINFORCED PLASTIC-
TISSUE TREATMENT ON INSIDE SURFACE OF BODY SIDE DOORS
FOR ALL COACHES (A.C. & NON A.C.)**

1. SCOPE:

This schedule covers the requirements of Fibre reinforced plastic (FRP) tissue treatment scheme/procedure on inside surface of body side doors for all types of coaches.

2. SURFACE TREATMENT SCHEME/PROCEDURE:

- 2.1 The door inside surface should be coated with red oxide zinc-chrome primer to IS:2074-1992 to ensure the dry film thickness of 40 micron.
- 2.2 One coat of bituminous emulsion grade-1 of IRS specification P-30-96 should be applied on the complete inside surface including stiffeners.
- 2.3 The following inside surface treatment from bottom of the door up to the height of 600 mm should be carried out.
- 2.3.1 Second coat of bituminous emulsion grade-1 of IRS specification P-30-96 should be applied - (some quantity of ROZ primer is mixed up with bituminous emulsion for the purpose of obtaining - different colour to identity the second coat).
- 2.3.2 Fibre glass tissue to specification ICF/M/D/Spec/-027 is to be laid over the bituminous - emulsion of second coat when it is in wet condition.
- 2.3.3 Proper bonding of fibre glass tissue over the inside surface of the door to be ensured and care should be taken to ensure that no air pockets are left while laying the F.R.P. tissue.
- 2.3.4 Immediately after laying the tissue, bituminous emulsion grade-2 to IRS specification - P-30-96 is to be applied as a final coat.

[Signature]
PREPARED BY



[Signature]
AGREED BY