

Altoona, Pa., 1-6-64 KDR/d  
Desk 12

J. L. P. (16)  
A. R. M. (86)  
J. C. W. (42)  
C. A. K. (32)

Herewith revised Section IV dated 1-6-64, comprising Page 9 of Instructions For Painting Freight Equipment Cars at All Shops Other Than Samuel Rea, issued Altoona, Pa., 9-15-60.

The revision involves changing the painting system of covered hopper cars from a three (3) coat system (primer and two (2) top coats) to a one (1) coat direct-to-metal system.

Please arrange immediately to place these new instructions in effect, destroying old Page 9 of instructions now in your possession.

Additional copies of these revised pages are available upon request directly from the Engineer of Tests.

R. E. Franklin.

cc- C.J.Henry (5)  
G.J.H. (3) (This will in effect cancel Ref. 47-649605  
E.J.G. (15) ( which can be removed from the catalog.  
D.W.A. (14)  
J.A.I. (6)  
R.A.W. ~~G.L.B.~~ (4)  
M.A.P.

#### IV. COVERED HOPPER CARS

Unless otherwise specified the following instructions are to be used when painting all covered hopper cars and any steel box cars which are assigned to the alkali trade. Such cars are painted on the exterior only.

##### A. New and Heavy Repairs:

1. Remove all rust, scale and paint by abrasive blasting. Blow the surfaces with clean dry compressed air.

2. Spray-paint the exterior sides, ends, underframes, and roof (if not new galvanized) with one (1) coat of Grey Paint, Direct-to-Metal, Acct. 47, Ref. 646809. The wet film thickness of this coat of paint shall be approximately 6-1/2 mils. This coat of paint shall be applied as soon as possible after blasting, in any case within four (4) hours after the metal surfaces have been blasted. Cars shall not be permitted to become wet between the abrasive blasting and painting operations. Cars shall not be abrasive blasted until these conditions can be met.

3. Spray paint all roofs with Asphaltum Compound, Medium Consistency, Acct. 47, Ref. 170404. In the case of new galvanized roofs the Asphaltum Compound will be applied directly to the bare galvanized surface. To all other roofs the Asphaltum Compound will be applied over the dry, previously applied gray paint. This Asphaltum Compound should be used with pressure pump spray equipment. The coating shall be from 1/8 to 1/4 inch thick. It may be possible to obtain this thickness in one (1) spray application.

4. Stencil with Black Stenciling Paint, Acct. 47, Ref. 655206. Stenciling shall be done any time after the paint has dried sufficiently hard so that the paint film is not marred during the stenciling operation.