

THE PENNSYLVANIA RAILROAD

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Instructions for Painting Freight Equipment Cars

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Proper surface preparation is the foundation of successful painting, after which the paint materials must be applied in accordance with good practices. Consequently, it is of the utmost importance that all surfaces be thoroughly cleaned of rust, scale, dirt, grease, oil, deposited chemicals, loose and badly checked paints previously applied, etc., otherwise the applied paint will fail quickly and prematurely. Water in any form which remains behind any paint film will also quickly destroy the paint. Mill scale, resulting after mill production of new steel, which is adhering tightly is often considered a good medium for applying paint, but paint applied over scale formed by weathering action may experience early failure. Consequently, either abrasive blasting or wire brushing and scraping procedures shall be used to prepare the metal surfaces, and such exposed surfaces must be covered solid as soon as possible with approved paint materials as hereinafter specified.

I. GENERAL INSTRUCTIONS

All metal parts of cars must be free from rust, thoroughly cleaned and properly prepared before any paint is applied.

1. Metal on Metal - Riveted Construction:

All surfaces where metal is placed on similar metal must be painted with an approved Freight Car Paste, Acct. 47, Ref. 2393, before assembling.

Where dissimilar metals, such as aluminum and iron, join each other or are lapped over one another, Freight Car Primer, Acct. 47, Ref. 3122, shall be used to separate the two metals.

2. Parts Inaccessible:

All steel and wood surfaces which are not accessible after assembling except the back of wood linings and surfaces to be welded, must be painted before assembling with one coat of Freight Car Primer, Acct. 47, Ref. 3122.

3. Superstructure:

A. Over bare metal, whether new or where all old paint has been removed, and unless otherwise specified, the outer surfaces of sides and ends of the superstructure must be painted with one coat of a freight car primer and two coats of a freight car paint. The inside of the metal superstructure must be painted with one coat of a freight car primer and one coat of a freight car paint, the type of primer and paint depending on the type of car being painted.

In cases where the old paint has not been removed, Prime any bare spots, and apply two coats of freight car paint to the outer surfaces and one coat to the inner surfaces as indicated above.

When any siding is removed, the exposed interior metal surfaces shall be given one coat of Ready-Mixed Freight Car Paint, Acct. 47, Ref. 3149.

B. Car roofs, except Covered Hopper Cars and cars with galvanized roofs, must be painted on both sides with one coat of freight car primer and one coat of a freight car paint. In the case of a new galvanized roof the underside of the roof is not painted, but the top side shall be painted with two coats of Asphaltum Compound (Car Cement), Acct. 47, Ref. 556. After the new galvanized roof sheets have been painted with the car cement, any future painting of them shall be done with a specified freight car paint.

4. Underframes:

A. Side Sills and Side Posts on new box cars and box cars undergoing extensive repairs, where flooring and/or siding is removed, shall be given a coating of Asphaltum Compound (Car Cement), Acct. 47, Ref. 531, by brushing or spraying the side sills to the top and the bottom of the side posts and side sheets for a distance of approximately 12 inches upwards from the butt.

B. The top surface of all underframe details of cars, new or undergoing extensive repairs, which are to have wood floors applied shall be painted with one coat of Asphaltum Compound (Car Cement), Acct. 47, Ref. 531.

5. Flooring:

The flooring joints on stock cars must be painted with one coat of Ready-Mixed Freight Car Paint, Acct. 47, Ref. 3149, except when treated lumber is used.

6. Stenciling:

All stenciling must be done with an approved stenciling paint or enamel unless otherwise authorized.

7. Assembled Underframes, Sides, Ends and Doors:

Before shipping new sub-assemblies such as underframes, car sides, ends, doors, etc., to another point, they must be painted at the point of manufacture with one coat of Freight Car Primer, Acct. 47, Ref. 3122. All other painting must be done at the shops where the car bodies are assembled.

8. Trucks:

On new cars the assembled trucks, new or reconditioned, except wheels, are to be painted with one coat of Hard Drying Black Enamel, Acct. 47, Ref. 2016. In the painting procedures that follow where mention is made to the painting of cars all over, trucks are not included as it is the intention that, except on new cars, the trucks be not painted.

9. Paint Identification:

The identity of the finish coat or coats of paint used (not primers) and number of coats applied must be stenciled in code on the cars in accordance with tracing F-446477, "Code Letters for identification of Paint Manufacturers," and according to the latest lettering arrangement for the class of car painted.

10. Lettering:

All lettering shall be in accordance with latest lettering arrangements specified on drawings applicable to the class of freight car being painted.

11. Priming:

All priming work must be done within eight hours after the metal surfaces have been abrasive-blasted when the cars are not kept under cover and within 24 hours when the cars are kept under cover. Cars shall not be abrasive-blasted until these conditions can be met. In no case shall the cars be permitted to become wet between the abrasive blasting and priming operations.

12. Drying:

In the following procedures the drying times between paint coats are given for favorable drying conditions. When unfavorable drying conditions exist, additional time should elapse for drying between coats so that the paint film will be in the same condition as specified under favorable drying conditions.

In addition to the foregoing General Instructions, the following detailed painting procedures are applicable to the various types of freight equipment cars:

II. STANDARD BOX CARS

(Except those abrasive blasted and painted under cover as covered in Section IV).

A. New and Heavy Repairs:

1. Remove all rust, loose scale and loose paint by abrasive blasting, if available; otherwise use scrapers and wire brushes. Remove oil and grease with Petroleum Spirits, Acct. 47, Ref. 2486, and blow the car with clean, dry compressed air to remove any adhering dust particles.

2. To the dry surface and with as little delay as possible, spray the sides, ends, roof and underframe with Freight Car Primer, Acct. 47, Ref. 3122. For galvanized roofs, see section 3-B of the General Instructions.

3. After priming, spray the sides, ends, roof and underframe with one coat of Ready-Mixed Freight Car Paint, Acct. 47, Ref. 3149. Under favorable drying conditions, the first coat of paint can usually be applied over the primer after two hours. For galvanized roofs, see section 3-B of the General Instructions.

4. Spray the sides and ends with a second coat of Ready-Mixed Freight Car Paint, Acct. 47, Ref. 3149. Under favorable drying conditions, this second coat can usually be applied after two hours.

5. Stencil with White Stenciling Paint, Acct. 47, Ref. 2347. Stenciling shall be done anytime after the paint film has dried sufficiently hard to permit the use of a stencil brush without cutting into the paint film.

B. Running Repairs:

If the paint has failed, proceed to prepare the surface as called for under New and Heavy Repairs. If the paint has not failed, prepare the surface and do the painting in the following manner:

1. Remove any rust and loose paint with scrapers and wire brushes. Remove any oil and grease with Petroleum Spirits, Acct. 47, Ref. 2486.

2. With as little delay as possible, prime all bare spots with Freight Car Primer, Acct. 47, Ref. 3122.

3. After priming, spray the sides, ends, roof and underframe with one coat of Ready-Mixed Freight Car Paint, Acct. 47, Ref. 3149. Under favorable drying conditions, this coat of paint can usually be applied over the primer after two hours.

4. Stencil with White Stenciling Paint, Acct. 47, Ref. 2347. Stenciling shall be done anytime after the paint film has dried sufficiently hard to permit the use of a stencil brush without cutting into the paint film.

III. STANDARD HOPPER, GONDOLA, FLAT AND WELL CARS

A. Standard Hopper and Gondola Cars - New, Heavy and Running Repairs:

1. When wood siding of composite gondola cars is removed, the exposed interior metal surfaces of side stakes, diagonal braces, corner posts, etc., shall be painted with one coat of Asphaltum Compound (Car Cement), Acct. 47, Ref. 531.

2. Remove rust, loose scale and loose paint with abrasive blasting, if available; otherwise use scrapers and wire brushes. Remove oil and grease with Petroleum Spirits, Acct. 47, Ref. 2486.

3. New cars must be spray-painted all over, inside and outside, with Freight Car Primer, Acct. 47, Ref. 3122, immediately after preparing the surface for painting. Prime all bare spots with Freight Car Primer, Acct. 47, Ref. 3122, on the outside of cars undergoing heavy and running repairs.

4. After priming, spray all over the inside and outside of hopper and gondola cars with one coat of "Wet-on-Wet" Freight Car Paint, Acct. 47, Ref. 2383. However, when repainting hopper cars which have had no new steel applied, the inside painting is to be omitted if the corners and crevices are still properly protected. Under favorable drying conditions, the first coat of paint can usually be applied over the primer after two hours.

5. Spray all over the exterior of hopper cars and the exterior sides and ends of gondola cars a second coat of "Wet-on-Wet" Freight Car Red Paint, Acct. 47, Ref. 2383. Under favorable drying conditions, this second coat of paint can usually be applied in the open after eight hours.

6. Stencil with White Stenciling Paint, Acct. 47, Ref. 2347. Stenciling shall be done anytime after the paint film has dried sufficiently hard to permit the use of a stencil brush without cutting into the paint film.

B. Flat and Well Cars - New, Heavy and Running Repairs:

1. Prepare and clean the metal surface as specified under Standard Hopper and Gondola Cars. Paint all metal parts with two coats of "Wet-on-Wet" Freight Car Paint, Acct. 47, Ref. 2383. Under favorable drying conditions, the second coat of paint can usually be applied in the open after eight hours.

2. Stencil with White Stenciling Paint, Acct. 47, Ref. 2347. Stenciling shall be done anytime after the paint film has dried sufficiently hard to permit the use of a stencil brush without cutting into the paint film.

IV. MERCHANDISE SERVICE CARS AND STANDARD BOX CARS  
ABRASIVE BLASTED AND PAINTED UNDER COVER

All Merchandise Service Cars, and such Standard Box Cars as may be abrasive-blasted and painted under cover, shall be painted with an approved synthetic primer and synthetic enamel in order to give better appearance and durability of the protective coatings. To obtain these results, the metal surfaces must be thoroughly cleaned by abrasive blasting and all painting operations must be done under cover, the priming coat to be applied immediately after the cleaning operation.

A. Merchandise Cars - New and Heavy Repairs:

1. Clean all exterior surfaces by abrasive blasting unless otherwise specified. On new cars only, remove any oil and grease from interior metal surfaces with Petroleum Spirits, Acct. 47, Ref. 2486, and blow with clean, dry compressed air to remove any adhering dust particles.

2. While the cars are indoors and under cover, prime all exterior surfaces by spraying with Synthetic Freight Car Primer, Acct. 47, Ref. 3270, immediately after cleaning. On new cars only, prime all interior metal surfaces with Synthetic Freight Car Primer, Acct. 47, Ref. 3270, immediately after cleaning. For galvanized roofs, see section 3-B of the General Instructions.

3. Spray the exterior sides, ends, roof and underframe with one coat of Synthetic Red Freight Car Enamel, Acct. 47, Ref. 3042. The first coat of enamel can usually be applied over the primer after two hours. For galvanized roofs, see section 3-B of the General Instructions.

4. Spray the exterior sides and ends with a second coat of Synthetic Red Freight Car Enamel, Acct. 47, Ref. 3042. The second coat of enamel may be applied over the first coat of enamel after two hours.

5. Spray the exterior white band with White Enamel, Acct. 47, Ref. 3151. This white band can be applied over the synthetic enamel after four hours.

6. Apply letters, numbers and decorations with Synthetic White Stenciling Enamel, Acct. 47, Ref. 3271, over the red freight car enamel, and over the white band use Red Stencil Paste, Acct. 47, Ref. 3150, for brush application, and for spraying application thin the Red Stencil Paste, Acct. 47, Ref. 3150, with Spray Thinner under Acct. 47, Ref. 2489. All stenciling can be applied after six hours.

7. Spray the interior sides, ends, racks and ceiling, if the roof sheets are not of galvanized construction, with one coat of Ready-Mixed Aluminum Paint, Acct. 47, Ref. 3159.

B. Merchandise Service Cars - Running Repairs:

1. Only touch-up painting is to be done unless the paint has failed and it is necessary to restencil and redecorate. If the paint has failed, the car must be painted as under New and Heavy Repairs, except that it may not be necessary to abrasive-blast the car.

C. Standard Box Cars (Sandblasted and Painted Under Cover) - New and Heavy Repairs:

1. Clean all exterior metal surfaces by abrasive-blasting unless otherwise specified. On new cars only, remove any oil and grease from interior metal surfaces with Petroleum Spirits, Acct. 47, Ref. 2486, and blow with clean, dry compressed air to remove any adhering dust particles.

2. While the cars are indoors and under cover, prime all exterior surfaces by spraying with Synthetic Freight Car Primer, Acct. 47, Ref. 3270, immediately after cleaning. On new cars only, prime all interior metal surfaces with Synthetic Freight Car Primer, Acct. 47, Ref. 3270, immediately after cleaning. For galvanized roofs, see section 3-B of the General Instructions.

3. Spray the exterior sides, ends, roof and underframe with one coat of Synthetic Red Freight Car Enamel, Acct. 47, Ref. 3042. The first coat of enamel can usually be applied over the primer after two hours. For galvanized roofs, see section 3-B of the General Instructions.

4. Spray the exterior sides and ends with a second coat of Synthetic Red Freight Car Enamel, Acct. 47, Ref. 3042. The second coat of enamel may be applied over the first coat of enamel after two hours.

5. Stencil with Synthetic White Stenciling Enamel, Acct. 47, Ref. 3271. Stenciling can be applied after six hours.

D. Standard Box Cars Painted Under Cover - Running Repairs (Exterior Only):

If the paint has failed, proceed to prepare the surface as called for under Standard Box Cars (Painted Under Cover) - New and Heavy Repairs. If the paint has not failed, prepare the surface and do the painting in the following manner:

1. Remove any rust and loose paint with scrapers and wire brushes. Remove any oil and grease with Petroleum Spirits, Acct. 47, Ref. 2486.

2. Prime all bare spots with Synthetic Freight Car Primer, Acct. 47, Ref. 3270.

3. Spray the sides, ends, roof and underframe with one coat of Synthetic Red Freight Car Enamel, Acct. 47, Ref. 3042. This coat of enamel can usually be applied over the primer after two hours.

4. Spray the sides and ends with a second coat of Synthetic Red Freight Car Enamel, Acct. 47, Ref. 3042. The second coat of enamel may be applied over the first Coat of enamel after two hours.

5. Stencil with Synthetic White Stenciling Enamel, Acct. 47, Ref. 3271. Stenciling can be applied after six hours.

#### V. 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 Cars, Heavy and Running Repairs:

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

2. As soon as possible, paint the bare, dry metal with Freight Car Primer, Acct. 47, Ref. 3122.

3. Spray-paint the sides, ends, roof, except for new galvanized roofs, and underframe with one coat of Ready-Mixed Alkali-Resisting Red Freight Car Paint, Acct. 47, Ref. 2387, This coat of paint can be applied over the primer after two hours.

4. Spray-paint the sides, ends and roof, except for new galvanized roofs, with a second coat of Ready-Mixed Alkali-Resisting Red Freight Car Paint, Acct. 47, Ref. 2387. Under favorable conditions, the second coat of paint can be applied over the first coat of paint after six hours of drying.

5. Spray-paint the roof, except for now galvanized roofs, with one coat of Clear Alkali-Resisting Varnish, Acct. 47, Ref. 2515. Under favorable conditions, this varnish coat can be applied over the second coat of paint after six hours of drying.

6. New galvanized roofs must be spray-painted with two coats of Asphaltum Compound (Car Cement), Acct. 47, Ref, 556. The car cement dry film thickness should be approximately 1/4 inch.

7. Stencil the car with Synthetic White Stenciling Enamel, Acct. 47, Ref. 3271. Stenciling may be applied after six hours.

#### VI. STOCK CARS

##### A. New Cars and Heavy Repairs - Exterior:

1. Remove rust, loose scale and any loose paint with scrapers and wire brushes.

2. Spray paint the sides, ends and roof with one coat of Ready-Mixed Freight Car Paint, Acct. 47, Ref. 3149.

3. Spray-paint the sides, ends and roof with a second coat, of Ready-Mixed Freight Car Paint, Acct. 47, Ref. 3149. Under favorable drying conditions, this second coat can usually be applied over the first coat, after two hours.

4. Stencil the car with White Stencil Paint, Acct. 47, Ref, 2347. Stenciling shall be done anytime after the paint film has dried sufficiently hard to permit the use of a stencil brush without cutting into the paint film.

5. Spray the underframe and attached parts with two coats of Asphaltum Compound (Car Cement), Acct. 47, Ref. 531. The trucks must be protected during this painting operation to avoid depositing any car cement on the trucks.

B. New Cars and Heavy Repairs - Interior:

1. Remove rust, loose scale and any loose paint with scrapers and wire brushes.

2. Spray-paint the sides, ends and underside of roof with one coat of Asphaltum Compound (Car Cement), Acct. 47, Ref. 531.

VII. CABIN CARS

A. New Cars and Heavy Repairs - Exterior, (Painted Under Cover):

1. Remove rust, loose scale and any loose paint by abrasive-blasting. Blow the surfaces dry, using clean, dry compressed air. After the surfaces have been properly prepared, all of the following painting procedures must be done under cover.

2. To the dry surface and with as little delay as possible spray all bare metal with Synthetic Freight Car Primer, Acct. 47, Ref. 3270.

3. Spray-paint the sides, ends and underframe with one coat of Synthetic Red Freight Car Enamel, Acct. 47, Ref. 3042. Under favorable drying conditions, the first coat of enamel can usually be applied over the primer after two hours.

4. Spray-paint the sides and ends with a second coat of Synthetic Red Freight Car Enamel, Acct. 47, Ref. 3042. Under favorable drying conditions, the second coat of enamel may be applied after two hours.

5. Stencil the car with Synthetic White Stenciling Enamel, Acct. 47, Ref. 3271. Stenciling can be applied after six hours.

6. Apply two coats of Asphaltum Compound (Car Cement), Acct. 47, Ref. 556, to the roof, including the cupola. The first coat need not be thoroughly dry before the second coat is applied.

7. Apply two coats of Full Gloss Yellow Enamel, Acct. 47, Ref. 2617, to the vertical handholds on the corners and to the curved handholds on the car body at the four corners of the cabin car. The second coat of enamel can usually be applied over the first coat of enamel after four hours of drying.

B. Running Repairs - Exterior, (Not Painted Under Cover):

1. Remove rust, loose scale and any loose paint with scrapers and wire brushes. Remove any oil and grease with Petroleum Spirits, Acct. 47, Ref. 2486.

2. With as little delay as possible, prime all bare spots with Freight Car Primer, Acct. 47, Ref. 3122.

3. After priming, spray the sides, ends and underframe with one coat of Ready-Mixed Freight Car Paint, Acct. 47, Ref. 3149. Under favorable drying conditions this coat of paint can usually be applied over the primer after two hours.

4. Stencil with White Stenciling Paint, Acct. 47, Ref. 2347. Stenciling shall be done anytime after the paint film has dried sufficiently hard to permit the use of a stencil brush without cutting into the paint film.

5. Apply one coat of Asphaltum Compound (Car Cement), Acct. 47, Ref. 556, to the roof, including the cupola.

6. Apply two coats of Full Gloss Yellow Enamel, Acct. 47, Ref. 2617, to the vertical handholds on the corners and to the curved handholds on the car body at the four corners of the cabin car. The second coat of enamel can usually be applied over the first coat of enamel after four hours of drying.

C. New Cars, Heavy and Running Repairs - Interior:

1. Remove rust, loose scale and any loose paint with scrapers and wire brushes. Remove any oil and grease with Petroleum Spirits, Acct. 47, Ref. 2486.

2. Prime the wood trim and Masonite lining with one coat of Shellac, Acct. 47, Ref. 2440.

3. Apply two coats of P. O. Green Enamel, Acct. 47, Ref. 3119, to the walls; from floor to and including window sills; the lockers, interior and exterior; seat frames; lower bunks; table and sink, except tops; end doors and frames; bulkhead corner posts to the ceiling, and the cupola seats, including armrests and sides to and including cupola side window sills and safety rail. The second coat of enamel can usually be applied over the first coat of enamel after six hours of drying.

4. Apply two coats of Cream Enamel, Acct. 47, Ref. 3047, to the remainder of the interior above window sills, including the bottoms of upper bunks and the ceilings. The second coat of enamel can usually be applied over the first coat of enamel after six hours of drying.

5. Apply two coats of Quick Drying Floor Enamel, P.R.R. shade, Acct. 47, Ref. 2334, to the floors. The second coat of enamel can usually be applied over the first coat of enamel after four hours of drying.

6. No paint is to be applied to any stainless steel parts or aluminum window sashes.

VIII. MAINTENANCE OF WAY CARS

A. Steel Cars - Heavy and Light Repairs (Exterior Only):

1. Remove rust, loose scale and any loose paint by abrasive-blasting, if available; otherwise clean with scrapers and wire brushes. Remove any oil and grease with Petroleum Spirits, Acct. 47, Ref. 2486. Blow the surfaces dry, using clean, dry compressed air.

2. To the dry surfaces and with as little delay as possible spray the bare, dry metal of the sides, ends, roof and underframe with one coat of Freight Car Primer, Acct. 47, Ref. 3122.

3. Spray-paint the sides, ends and roof with one coat of Structural Gray Paint, Acct. 47, Ref. 2236. This coat of paint can be applied over the primer after two hours of drying.

4. Spray-paint the sides and ends with a second coat of Structural Gray Paint, Acct. 47, Ref. 2236. The second coat shall not be applied until assured that the first coat is thoroughly dry. Under favorable drying conditions, this will require approximately eight hours of drying.

5. Stencil the car with Lamp Black, Acct. 47, Ref. 2012. Black Enamel, Acct. 47, Ref. 3074, should be used for spray stenciling operations. Stenciling may usually be done after ten hours of drying time, in any case not before the paint has dried sufficiently hard to permit use of a stencil brush without cutting into the paint film.

6. The underframe and equipment under the body of the car shall be given a finishing coat of Quick-Drying Black Enamel, Acct. 47, Ref. 2218.

B. Wooden Cars - Heavy and Light Repairs:

1. Remove rust, loose scale and loose paint with scrapers and wire brushes.

2. Prime bare wood with Aluminum Paint, Acct. 47, Ref. 2313, and the bare, dry metal with Freight Car Primer, Acct. 47, Ref. 3122.

3. Spray-paint the sides, ends and roof with one coat of Structural Gray Paint, Acct. 47, Ref. 2236. This coat of paint can be applied over the primer coat after four hours of drying.

4. Spray-paint the sides and ends with a second coat of Structural Gray Paint, Acct. 47, Ref. 2236. The second coat shall not be applied until assured that the first coat is thoroughly dry. Under favorable drying conditions this will require approximately eight hours of drying.

5. Stencil the car with Lamp Black, Acct. 47, Ref. 2012. Black Enamel, Acct. 47, Ref. 3074, should be used for spray stenciling operations. Stenciling may usually be done after ten hours of drying time, but in any case not before the paint has dried sufficiently hard to permit use of a stencil brush without cutting into the paint film.

6. The underframe and equipment under the body of the car shall be given a finishing coat of Quick Drying Black Enamel, Acct. 47, Ref. 2218.

C. Interior Painting:

Due to the multiplicity and arrangement of the interiors of Maintenance of Way cars, no attempt has been made to include their interior painting and these cars shall be painted in accordance with separate instructions.

The following table lists, under their Account and Reference numbers, the description of approved materials covered by these instructions:

<u>Account &amp; Reference Number</u>	<u>Standard Catalogue Description of Approved Materials</u>
47-531	Compound, Asphaltum, thinned.
47-556	Compound, Asphaltum.
47-2012	Black, Lamp, in oil.
47-2016	Black, Locomotive, Hard Drying.
47-2218	Enamel, Black, Quick Drying, P.R.R. No. 100.
47-2236	Paint, Structural, Gray, Mixed, finishing coat.
47-2313	Paint, Aluminum, exterior exposure.
47-2334	Floor Enamel, Quick Drying, P.R.R. Shade.
47-2347	Paint, White, Stenciling.
47-2383	Paint, Standard Freight Car Red, "B" mixed, "Wet-on-Wet."
47-2387	Red, Freight Car, Mixed, Alkali-Resisting.
47-2393	Red, Standard Freight Car, in paste.
47-2440	Shellac, Orange.
47-2486	Turpentine Substitute (Petroleum Spirits).
47-2489	Thinner, Spray Application.
47-2515	Varnish, Clear Alkali-Resisting, roof finish.
47-2617	Enamel, Yellow, water and steam line.
47-3042	Enamel, Freight Car, Red, Synthetic, Tentative Spec. 12-1-51.
47-3047	Enamel, Cream.
47-3074	Enamel, Black, Quick Drying; Full Gloss.
47-3119	Enamel, P. O. Green.
47-3122	Primer, Freight Car, Tentative Spec. 12-1-51.
47-3149	Paint, Freight Car, Red, Ready-Mixed, Tentative Spec. 12-1-51.
47-3150	Red, Freight Car, Stenciling, in paste.
47-3151	Enamel, White, Exterior.
47-3159	Paint, Aluminum, Ready-Mixed.
47-3270	Primer, Freight Car, Synthetic, Tentative Spec. 12-1-51.
47-3271	Enamel, Stenciling, White, Synthetic, Tentative Spec. 12-1-51.

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