



ESTABLISHED ON THE NORTH YORKSHIRE MOORS RAILWAY

Specification for glazing body side lights on Gresley coaches

All rebates to be cleaned and free of tacks, then to be sealed with one coat Gold Size and one coat Yacht Varnish. Interior surfaces to be cleaned and varnished or painted as appropriate.

Toughened 6mm glass to the current BS to be used in all main saloon and corridor lights, white laminated 8mm glass to be used in toilet compartments. Standard opening light frames to use laminated 6mm glass. Toilet hinged fan light to be white laminated glass with clear ellipse in centre of pane.

All glass sizes to allow 3mm tolerance all round (6mm smaller than opening).

Compartment or saloon lights to have glass bedded on to rebates with 12mm x 3mm black self adhesive foam glazing tape, toilet compartment or kitchen lights to use 12mm x 3mm preformed Butyl glazing mastic.

Glass to sit on two or three 10mm x 3mm plastic glazing packs on bottom rebate, one of same or slightly thinner to be inserted in sides of pane, central to height.

Beads to be bedded onto glass with 12mm x 3mm Teak coloured preformed Butyl glazing mastic, beads to be of York, Doncaster pattern or 5/8" quadrant as appropriate to vehicle type and builder. Joint between bead and coach frame to be sealed with a Teak coloured acrylic mastic. Beads to be secured with Brass 8 x 1½" raised head wood screws, spaced approximate to originals.

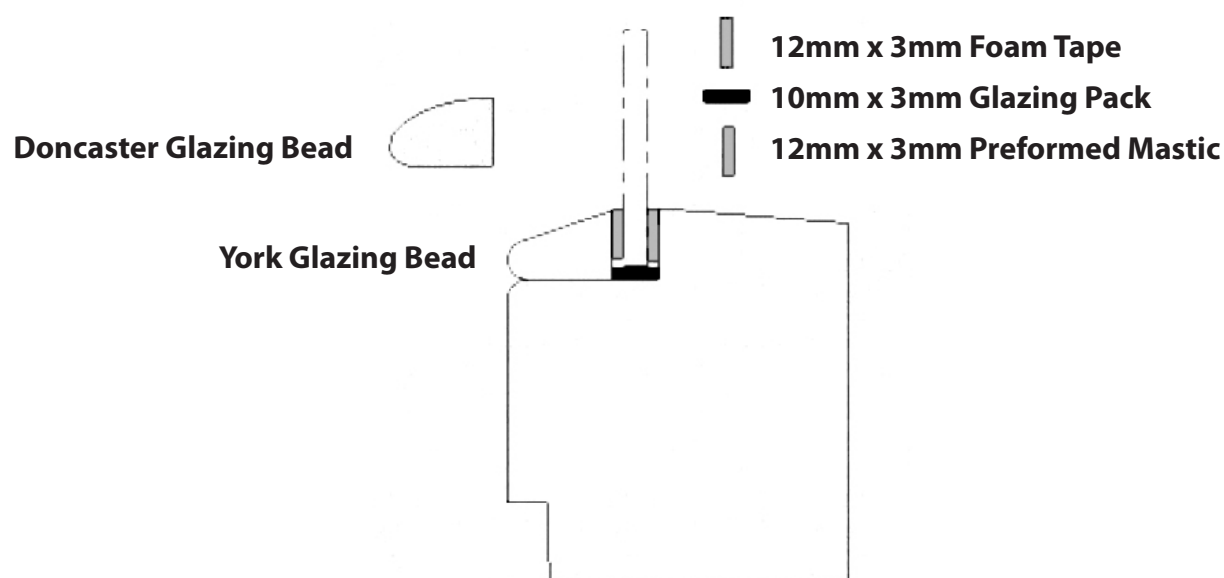


fig.i Section through waist rail

Where a main light is to be bedded into a sliding light frame the foam tape is to be run up to the top of the groove, the groove is then to be filled with a Black high modulus Silicone mastic immediately prior to glazing. The Glass is to be pushed up into the Groove, so as the excess mastic squashes out. When the Silicone has well cured, the excess is to be trimmed with a sharp knife and removed from the glass by means of a sharp scraper.

The small panes in the sliding light frames are to be bedded in Black high modulus Silicone mastic. The sashes should be allowed to cure flat on a bench, the excess Silicone is to be removed prior to the sashes being returned to the frames.

On L.N.E.R.C.A. contracts all the above specifications shall be followed except where agreement is made in writing before work commences.