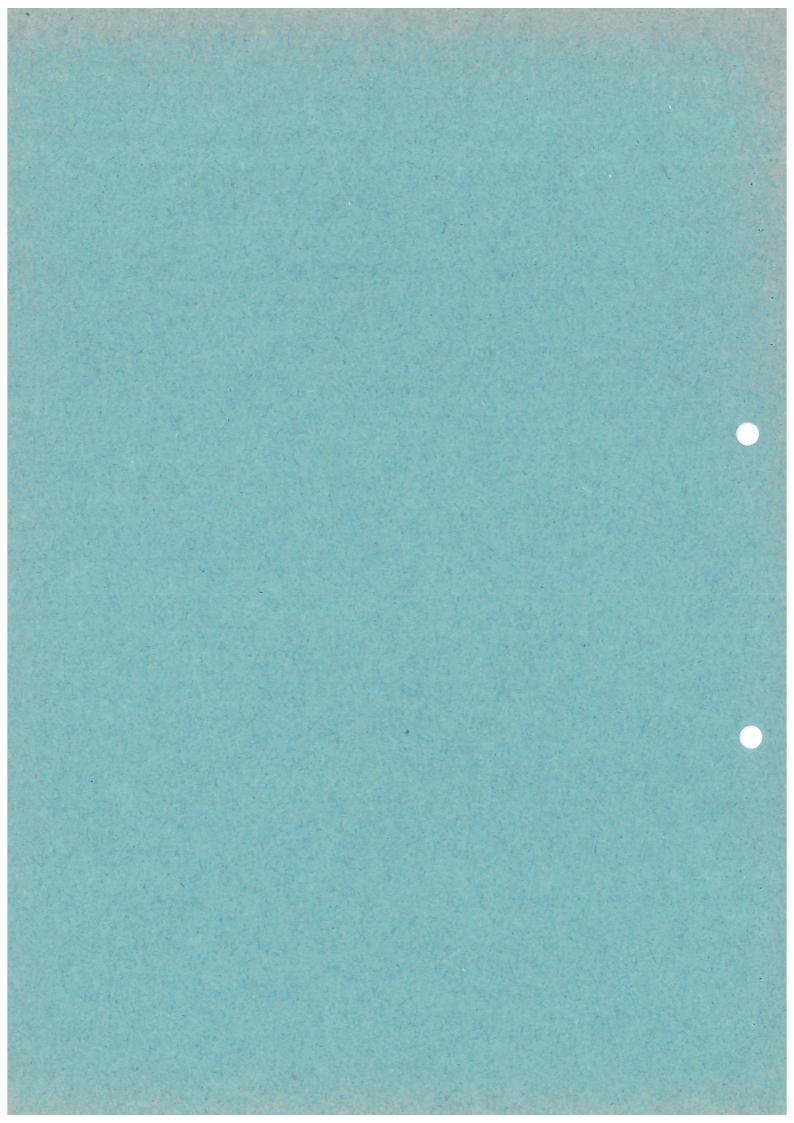
British Railways Board

Mechanical & Electrical Engineer's Department

BONDING OF MOQUETTE TO PLYWOOD & METAL





PROCESS SPECIFICATION CEPS 1058

BONDING OF MOQUETTE TO PLYWOOD AND METAL PASSENGER ROLLING STOCK

1. GENERAL

To maintain the fire retardant characteristics of items covered with moquette used in Passenger Rolling Stock interiors, the adhesive bonding the moquette to the substrate shall be 'Swifts S87A' supplied by Swift Chemical Company, Industrial Adhesive Division, Ashford, Middlesex. No other adhesive may be used without written consent of the Chief Mechanical and Electrical Engineer, British Railways Board, Railway Technical Centre, Derby.

2. DESCRIPTION

The adhesive is a Plasticised Styrene - Butadiene Rubber type in flammable solvents. It has a low viscosity (approx. 1-2 poise) to ensure good sprayability, and is highly fire retardant in the dry state.

3. APPLICATION

Immediately before use the adhesive must be very thoroughly mixed to ensure even dispersion of the fire retardant chemicals throughout the adhesive. The adhesive must be spray applied to the substrate only, giving a generous coating at a rate of approximately 3 sq m/litre or 150 sq ft/gallon. A standard paint spray gun using low pressure air is suitable.

The moquette and substrate must be brought together whilst the adhesive is still in a soft tacky state, to enable the adhesive to just penetrate the rear surface of the moquette without soaking through, and tacky enough to hold it to the substrate. The surface of the moquette must be left exposed in a flame free environment during the drying time of approximately 8 hours at $65^{\circ}F$ to allow the solvents to evaporate.

For clean up Swifts 'Solvent B' should be used.

4. SAFETY

The solvents contained in this adhesive are Acetone and Hexane and are highly flammable with a flash point below $73^{\circ}F$. They have a combined Threshold Limit Value (TLV) of 100 ppm.

The adhesive must be used and stored in restricted NO SMOKING, flameproof areas, and applied in a booth which has adequate and suitable fume extraction plant, as should the drying area. The fumes are non-toxic but ingestion of the adhesive or its solvents should be avoided, and the consumption and storage of food or drink should be prohibited when it is handled or used. Contact with skin/eyes must be avoided, and it is recommended that suitable goggles, gloves and barrier cream be used. If skin contact does occur, solvents should not be used to remove it from the skin.

PROCESS SECCEPTORE OFF INS

LOTTE OF THE STATE OF THE PARTY OF THE PARTY

To exceed the fire considers exercised so these consend with more than and the solution of the solution of the solution of the constant of the

XDITHIEL CA

The more live is a Planticised Divione - Butadiene Aubber supe in languable solvents. It has a low wisconing (approx 1-2 prios) to contruyour aprayorities, and is highly life retardant in the doctorie.

100

Introdicate before use the adhesive must be very thoroughly also the charten ever disposalies of the intendence charten the charten explicate the schericate make alone for appear applied to the schericate make as given a charten of approximately 3 of charten or standard paint approximately 1 of charten are the charten as frighties. A standard paint approximately los presence are the nutronia.

The apprecia and autotrate must be brought together whilst the attention of a cold tracky state, to enable the adherive to just programs the read surface of the appreciate without souting through, and such enough to hold it to the substract. The surface of the approve above the test compared in a flami- [the environment during the drying size of appreciation tells of mounts at 60 F to allow the solvened to evaporate.

Her obeca og bodins 'Stragelis' selekt po asete mel.

The spirance contained in this adherive are Approuse and Nexuns are art are prigning distances and other prigning distances of the contained t

The entractive most be used and stored in redicioned 90 Settles.

If accuracy areas, and applied in a booth which has storpast, and fultable time extraction plant, as should the drying news. The fines are accurate to a continuous of the solvenes should be aveited, and the continuous on assume of lood or dries anothed be probled under the backet of a skiniege must be avoided, and it is incommended that outtable popular, ginnes and beside creams be used. If skin contact does occur, solvents spould not be seen to prove the from the skin.

5. SHELF LIFE

When stored in sealed containers at normal temperatures, Swifts S87A adhesive has a shelf life of approximately 6 months.

The exemplatron below to began a per

PROCESS SPECIFICATION. CEPS 1058

BONDING OF MOQUETTE TO PLYWOOD AND METAL PASSENGER ROLLING STOCK.

AMENDMENTS.

DATE

MAY 1980

AMENDMENT

Original Issue

Chief Mechanical and Electrical Engineer British Railways Board Railway Technical Centre Derby AND A STATE AND THE PARTY OF TH

AND THE RESIDENCE OF STREET, AND STREET, A

ATPENDING SERVICE

numer Indiana

DROI YANG

min's Mermanical and Electrical Engineer leftsich Rallwaye Board balkway Technical Contex

