

THE BALDWIN LOCOMOTIVE WORKS

SUPPLEMENT TO SPECIFICATION No.

CLASS 16 48 2/4 E 110 to 121

FOR ATLANTIC COAST LINE R.R. Co.

PAINTING,
LETTERING AND
NUMBERING, ETC.

NUMBERING, LETTERING, STRIPING, ETC., TO BE R.R. Co.'s STANDARD.
DETAILS OF PAINTING SHALL BE IN ACCORDANCE WITH ATTACHED MEMORANDUM DATED DEC. 30, 1937 (THREE PAGES), AND COPY OF THE PAINTING SPECIFICATION (FIVE PAGES) ATTACHED HERETO, GIVING A VERBAL DESCRIPTION OF THE DU PONT DRAWING APPROVED BY MR. L. DELANO, WITH SUBSEQUENT AMPLIFICATIONS DETERMINED BY THE MESSRS. F. S. ROBBINS, G. G. LYNCH, AND H. STEIN OF R. R. Co., AND MESSRS. L. MOFFETT AND C. A. LYNN OF DU PONT Co.

PAINTING STYLE (SPECIAL) AS DRAWING AND SPECIFICATIONS.

PAINTING SCH.- AS SPEC'NS.

ALL DU PONT PAINT MATERIAL ORDERS TO BE SENT TO R. A. PHELPS, DISTRICT MANAGER E. I. DU PONT DE NEMOURS & Co., ATLANTA, GA.

CABS, TENDER TANKS, DOME CASINGS, SAND BOXES, AND CYLINDER CABINGS TO BE PAINTED WITH ~~BLACK~~ DUCO IN ACCORDANCE WITH RECOMMENDATIONS OF E. I. DU PONT DE NEMOURS & Co.'s SPECIFICATIONS HEREWITH.

~~ON THE FRAMES, WHEELS, TRUCKS AND TENDER FRAMES DULUX LOCOMOTIVE BLACK TO BE APPLIED IN ACCORDANCE WITH RECOMMENDATIONS OF E. I. DU PONT DE NEMOURS & Co. (SEE PAGES 21-B AND G)~~

ALL PARTS BELOW RUNNING AND CAB BOARDS OF ENGINE TO BE PAINTED WITH DULUX BLACK.

ALL PARTS UNDER BOTTOM OF WATER TANK TO BE PAINTED WITH DULUX BLACK.

FRONT END PAINT, "STABRITE".

SMOKE STACK TO BE PAINTED WITH "STABRITE" (INSTEAD OF DUCO BLUE.)
(SEE PAGE 21-B)

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SUPPLEMENT TO SPECIFICATION No.

CLASS 16 48 2/4 E 110 TO 121

FOR ATLANTIC COAST LINE R.R. Co.

PAINTING,
LETTERING AND
NUMBERING, ETC.
(CONTINUED)

BOILER TO BE PAINTED ON OUTSIDE WITH ~~A. A. R. SPECIFICATION~~ RED LEAD.

BOILER JACKET TO BE PAINTED ON INSIDE WITH ~~A. A. R. SPEC'N.~~ RED LEAD.

~~TENDER TANK, INSIDE, TO HAVE ONE COAT OF RED LEAD.~~

LOCOMOTIVE NUMBER TO BE PAINTED ON BACK OF TENDER, LOCATED IN THE BLUE BACKGROUND. NUMBER TO BE OF ALUMINUM COLOR. COVERED ON PAGE 21-B

LETTERING AND ROAD NUMBERS AS B. L. W. DRAWINGS (HEREWITH), AS FOLLOWS:

TRACING 17954 - STD. 8" FIGURES FOR USE ON BACK OF TANK.

TRACING 17955 - STD. 8" FIGURES FOR USE ON BACK OF TANK.

TRACING 17956 - STD. 8" FIGURES FOR USE ON BACK OF TANK.

TRACING 81422 - PROPOSED NUMBERS FOR SIDES OF CAB

ROAD NUMBERS PAINTED ON IN ALUMINUM, NOT ON A PLATE.

TRACING 81420 - TENDER MONOGRAM AND STRIPING.

CARD 496 - TENDER MONOGRAM

CARD 7764 - TANK WATER LEVEL INDICATOR (STENCILED ON TANK)

MARK ON TANK SIDES: R. R. Co.'s MONOGRAM (SEE PAGE 21-C)

CLASSIFICATION
PLATES

CLASSIFICATION PLATES FASTENED ON EACH SIDE OF LOCO. ON OUTSIDE OF CYLINDER BY FOUR $\frac{1}{4}$ " MACHINE SCREWS $\frac{3}{4}$ " LONG, ~~SAME AS ON LOCO., B. L. W. CLASS 12 41 1/4 D 170, SEE PHOTOGRAPH 9607,~~ AS SHOWN ON R.R. Co.'s DRAWING D-56-W.

ROAD NUMBERS
AND POSITION

ROAD NUMBERS: 1800 TO 1811

ROAD NUMBER, POSITION: F. NO. PLATE, CAB SIDES, BACK OF TANK.

ROAD NUMBER ON SIDES OF CAB TO BE LOCATED CENTRALLY BETWEEN THE FRONT AND BACK EDGES OF THE CAB WINDOW LONGITUDINALLY, AND CENTRALLY BETWEEN THE TOP OF THE ALUMINUM STRIPE AND BOTTOM OF WINDOW VERTICALLY. FIGURES TO BE 12" IN HEIGHT AS ILLUSTRATED ON PROPOSED NUMBERS FOR SIDE OF CAB, B. L. W. TRACING 81422.

ROAD NUMBERS ON REAR OF TENDERS TO BE LOCATED MIDWAY BETWEEN STRIPE AND REAR HANDHOLD, WITH FIGURES 8" HIGH, AS SHOWN ON B. L. W. TRACING 81524.

December 30, 1937

MEMORANDUM

ATLANTIC COAST LINE RAILROAD COMPANY
Locomotives 16 48 2/4 E-110 to 121

Style of painting to be generally as shown on colored drawing made by DuPont and approved by Mr. Boliano, Chairman of the Board.

Painting to be generally as five page specification furnished by DuPont received with C.A. Lynn's letter December 13, 1937 covering complete Duco system for Atlantic Coast Line Railroad, copy of which is attached hereto. Paint colors, code numbers, and specifications are covered in DuPont Specification attached.

Edge of running board to be striped in aluminum, this stripe to be the full width of running board edge. Stripes to be confined along rounded lower front corner of cab and thence across ^{bottom edge of} cab sides generally as shown on Baldwin Tracing #8142. The ~~width of the stripe~~ and

cab sides should be such that the stripe on line with the aluminum stripe to be applied on the tank sides. ~~Stripe should be at approximately the center of the tank side~~ along front corner of cab, and across sides of cab to be 2" wide.

Aluminum stripe 2" wide to be applied along sides of tank and across back of tank. CENTER OF STRIPE ON TANK SIDES IS TO BE LOCATED 15" ABOVE BOTTOM OF TENDER FRAME, ON LINE WITH THE ALUMINUM STRIPE ON CAB SIDES. ~~as illustrated on B.L.W. Tender Monogram and Striping Tracing #8142.~~

Jacket of locomotive not to be painted, but to be cleaned well before shipment.

Memorandum:

December 30, 1957

Everything above running board and aluminum striping on cab, including cab, cab roof, turret, dome and sand box casing, to be painted with a color that matches the blue pickled finished jacket except hand rails to be painted black, AND SMOKE STACK PAINTED WITH "STABRITZ".

Lower part of locomotive below running board and **CAB BOARD** to be painted with DuPont ^{DuLux} black. (SEE PAGE 21-G)

Band around top of stack, edge of running board, stripe on cab, striping on cylinder casings, driving pistons and wheels, rims of front and back engine truck wheels and of tender wheels to be painted or striped in aluminum, generally as shown on DuPont drawing.

The striping on the cylinder jacket to have square corners on the corners of the stripe. Curves for the inside stripe to have reverse curve as shown in each on DuPont drawing.

All striping, numbering and lettering to be in aluminum, not including the two black stripes which are to be placed at top of tank sides and no including the lettering in the company's monogram on tank sides.

Window sashes and sash millings to be painted in aluminum as recommended by Mr. Lynn of DuPont.

Upper part of tank above the aluminum stripe shall be painted with a color of a color to match the blue pickled finished jacket. The bottom part of tank and tender below the 2" aluminum stripe shall be painted with DuPont Duco black. EXCEPT ALL PARTS UNDER BOTTOM OF WATER TANK TO BE PAINTED WITH DuLUX BLACK.

Two black stripes shall be placed along upper edge of tank as shown on DuPont drawing. These stripes shall be located as near the approved height of standard railroad locomotive as possible, and in no case shall be lower than as shown on DuPont drawing.

Locomotive road number to be painted in aluminum on peak of tender, located near the top in the blue band around the tank.

Figures of road number on front number plate to be aluminum striping on brass.

Memorandum:

December 30, 1937

Apply the Atlantic Coast Line monogram, omitting the names of individual states on center of tank sides by means of a separate baked enameled plate. Monogram to have aluminum background with black letters and black stripes. The plate, to be 45" diameter, is to be made of sheet steel of a gauge suitable to the plate manufacturer, who will use dies to form the plate. Plate to have bolting holes about every 10" or 12" apart, equally spaced around the outer edge of the plate. Plate to be secured to tank with steel studs welded to tank, and with brass nuts on the studs. Washers are to be used to protect the surface of the monogram plate when bolting it into position.

Monogram plates are to be procured from Allen-Morrison Steam Laundry Inc., Lynchburg, Virginia.

Engineering Department have prepared tracing #80991 showing tank with 45" monogram plate. This has been approved by Mr. Robbins.

Location of road numbers on cab ^{Sides} and arrangement of same to be as shown on Baldwin tracing #81422. Road numbers to be painted on in aluminum ~~on~~ (not by means of a separate plate).

No patent plates are to be applied on smokebox or on the inside walls of the cab. All patent plates are to be shipped loose to Railroad Company in cab tool box.

Tender badge plate as shown on B.M.V. Card 1798 to be applied on tender tank.

Builder's plate on smokebox to be applied on cast iron block so as to bring plate out on a level with the smokebox jacket making a neat job of the jacket.

H. T. Gordon.

H.T.G.

7-10-47
Spec'd with C.A. Lyons
Ver. of Dec. 15, 1947

SPECIFICATIONS COVERING THE
COMPLETE "DUCCO" SYSTEM
FOR

16-2107-2100-113

ATLANTIC COAST LINE RAILROAD

LOCOMOTIVE PROPER AND TANK EQUIPMENT

BALDWIN LOCOMOTIVE WORKS

FIRST DAY - FIRST OPERATION:-

Immediately after sandblasting, apply by brush or spray, one even coat of Dark Oxide Primer for "Ducco", 475-40541. This Primer should be allowed to dry overnight.

SECOND DAY - SECOND OPERATION:-

Apply by brush or spray one even coat of Dark Surfacer for "Ducco", 477-41050. Allow to dry overnight.

THIRD DAY - THIRD OPERATION:-

Putty all major imperfections of the surface with Hard Putty for "Ducco", 563-99475. When filling deep indentations, the practice of applying two thin coats rather than one heavy coat will prevent both surface drying and shrinkage. Allow to dry overnight.

FOURTH DAY - FOURTH OPERATION:-

Knife in entire surface with Dark Glazing Composition for "Ducco", 563-90162, using standard 3" glazing knife. Avoid excessively heavy coats in order to secure a thoroughly dry film.

FIFTH DAY - FIFTH OPERATION:-

Apply by brush or spray one even coat of Dark Surfacer for "Ducco", 477-41050. Allow to dry overnight.

NOTE: If surface to be filled is unusually rough or pitted, the option may be exercised of applying additional coats of either the Surfacer or Glazing Composition, in order to secure a smooth surface after the sanding operation. The use of a Surfacer for "Ducco" is recommended for these applications due to the flowing out and leveling properties of this material compared to the service obtained by Glazing Composition.

SIXTH DAY - SIXTH OPERATION:-

Wet sand surface with a suitable fineness of wet-or-dry sandpaper, or rubbing stone. Let job dry out overnight, blowing all trapped water out of recesses and crevices with an air hose.

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SEVENTH DAY - SEVENTH OPERATION:

Dust off sanded surface and apply by spray one coat of "Duco" Pyroxylin Surfacer, 233-1567, thin to spraying consistency with "Duco" Thinner, No. 3601, (about two parts of Surfacer to one part of Thinner). Use only enough thinner to get satisfactory leveling after application. Let dry about 1/2 hours.

SEVENTH DAY - EIGHTH OPERATION:

Scuff the "Duco" Pyroxylin Surfacer to remove all "nibs" and then spot-spray all projected areas such as rivets, rounded corners, hand holds, etc. which receive extra wear with "Duco" Finishing Material, colors to be applied as in color scheme sketch. The reduction of the "Duco" colors is recommended in the proportions of not more than four parts of "Duco" to six parts of "Duco" Thinner No. 3601. (See note on application of metallic finish).

Apply one full even spray coat of "Duco" colors, allowing 1/2 hour for drying before application of succeeding coats.

Apply second full spray coat of "Duco" colors.

Apply third full spray coat of "Duco" color coats if depth of color is desired or warranted by general finishing practice.

NOTE: The finishing colors selected are "Duco" Black, No. 259-2048, and "Duco" Gray (Metallic) No. 259-32284. This enamel should be mixed in the following proportions with the specified aluminum paste to obtain the desired metallic effect:-

"Duco" Gray, 259-32284	100 lbs.
Aluminum Paste, W-136	12 1/2 oz.

or

"Duco" Gray, 259-32284	5 gals.
Aluminum Paste, W-136	4 1/2 oz.

These proportions are on the basis of unthinned "Duco" 259-32284.

In order to arrive at the proper color the aluminum paste must be accurately measured and thoroughly mixed with the proper amount of "Duco". The paste should first be mixed with a small quantity of the 259 Gray enamel, unthinned, and when thoroughly mixed, added to the remainder of the enamel. The final mixture should then be thoroughly mixed before reduction with the thinner and before application.

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Caution should be exercised against the possibility of color variations from can to can if the aluminum paste is not weighed and added very carefully to the gray enamel. This precaution is essential in final coat application.

It should be noted that "Duco" Metallic Enamels are sprayed slightly different from the solid color "Duco" enamels. Best results are obtained by spraying fairly dry. If sprayed too wet, the aluminum content may give a mottled appearance to the film.

EIGHTH DAY - NINTH OPERATION:-

Apply three coats of "Duco" aluminum lettering material, 289-5935. If reduction for brush application seems desirable for ease of application, use "Duco" Thinner, 3681.

Dec 10 1954

SPECIFICATIONS
ATLANTIC COAST LINE RAILROAD

LOCOMOTIVE EQUIPMENT - WHEELS, PILOT, ETC.

FIRST DAY - FIRST OPERATION:-

Apply by brush or spray one coat of "Dulux" Metal Primer, 68-008, allowing overnight dry.

SECOND DAY - SECOND OPERATION:-

Apply by brush or spray one or two coats of "Dulux" Surfacer Dark, 68-011, allowing four hours between each coat, when applied by spray, and overnight if applied by brush.

THIRD DAY - THIRD OPERATION:-

Putty all major imperfections of surface with Hard Putty Dark, 21-504. Do not use an excess of putty around rivets or joints and allow to dry four hours before recoating.

THIRD DAY - FOURTH OPERATION:-

Knife in entire surface with "Dulux" Glazing Dark, 21-505. This material sets up quickly and therefore should not be recoated until it has dried hard. If necessary to secure a smooth surface, apply second coat of Glaze after four hours.

FOURTH DAY - FIFTH OPERATION:-

Sand out entire surface with suitable wet-or-dry sandpaper. Let surface dry overnight before recoating.

FIFTH DAY - SIXTH OPERATION:-

Dust off surface. Apply by brush or spray one coat of "Dulux" Locomotive Black, 88-752, and allow to dry overnight.

SIXTH DAY - SEVENTH OPERATION:-

Apply second coat of "Dulux" Locomotive Black, 88-752.

SEVENTH DAY - EIGHTH OPERATION:-

Apply two coats of "Dulux" Aluminum Lettering material, No. 95-081 as per drawings. If reduction for ease of application is desired, reduce with "Dulux" Thinner, No. 3819.

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SPECIFICATIONS COVERING COMPLETE
"DUCO" SYSTEM FOR
ATLANTIC COAST LINE RAILROAD

CAB ROOF, INTERIOR AND SASH

BALDWIN LOCOMOTIVE WORKS

TO BE PAINTED BLUE TO MATCH BLUE PICKLED FINISH OF HARKET.

Cab roof should be given two coats of "Ducol" Metal Primer, 63-008, allowing overnight dry between coats and Metal Protective Enamel, allowing overnight dry between coats.

Cab interior and sash should be given one coat of "Ducol" Metal Primer, 63-008, allowing overnight dry, one coat of "Ducol" Enamel, allowing overnight dry and two coats of "Ducol" Cab Green, allowing overnight dry between coats.

If sash is to be in separate color, follow the same instructions using the selected sash color.