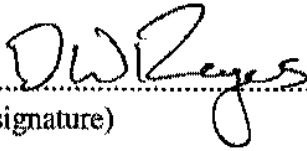
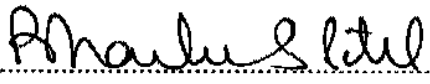




SUPPLY SPECIFICATION SURFACE FINISH REQUIREMENTS FOR TRANSPORT CONTAINERS	
Design Approval	D Rogers  (signature) date: 03/07/2008
Quality System Approval	B Patel  (signature) date: 03 July 2008
Date implemented	31 JUL 2008
Controlled file number	

1.0 PURPOSE AND SCOPE

This document specifies the surface coating or finish requirements (painting, galvanising, electroplating, clean and matt) of components for transport containers for radioactive materials. It is not necessarily restricted to this application.

2.0 REFERENCES

- BS 1706: Method for specifying electroplated coatings of zinc and cadmium onto iron and steel.
- BS 4800: Schedule of paint colours for building purposes.
- BS EN ISO 1461: Hot dip galvanized coatings on fabricated iron and steel articles.

3.0 DEFINITIONS

- Purchaser : REVISS Services (UK) Ltd.
- Supplier : Organisation named in the purchase order

4.0 QUALITY ASSURANCE

See purchase order and any specifications referenced therein for any supplementary requirements.

5.0 GENERAL

- The purchase order takes precedence over the manufacturing drawing.
- The manufacturing drawing takes precedence over this specification.
- The manufacturing drawing will specify the treatment, the applicable area and any special instructions.

6.0 PROTECTIVE COATINGS

6.1 CARBON STEEL (GENERAL)

- Paint: Zinga (obtainable from Zinga UK Ltd, 3 Arkwright Way, North Newmoor, Irvine).
 - Preparation: Ensure all surfaces are free from rust, moisture, oil or other surface contamination and blast clean to 60-80 μ m profile.
 - Application: Apply in accordance with manufacturer's instructions.
 - Thickness: Nominal 120 μ m dry film thickness.

6.2 CARBON STEEL (FLATRACKS AND ASSOCIATED COMPONENTS)

- Undercoat: Quick drying zinc phosphate high build primer (e.g. Product 51L25, Fiesta Industrial Paints Ltd, Burnley Road, Hapton, Lancs BB11 5QR).
 - Colour: Light grey.
 - Preparation: Ensure all surfaces are free from rust, moisture, oil or other surface contamination and blast clean to 60-80 μ m profile.
 - Application: Apply in accordance with manufacturer's instructions.
 - Thickness: Nominal 75 μ m dry film thickness.
- Top coat: Modified chlorinated rubber paint (e.g. Product 58L300, Fiesta Paints).
 - Colour: Light grey (e.g. BS 4800, 18B17).
 - Application: Apply in accordance with manufacturer's instructions.
 - Thickness: Nominal 75 μ m dry film thickness.



6.3 GALVANISING

- Prepare surface and hot dip galvanise in accordance with BS EN ISO 1461. Nominal thickness 0.1 mm.
- No drips or spikes permitted.

6.4 ZINC PLATING

Prepare surface, zinc electroplate and passivate in accordance with BS 1706, Zn-3.

7.0 STANDARD SURFACE FINISHES

Applies to corrosion resistant materials such as stainless steel, brass and lead:

7.1 CLEAN

Surfaces are to be wiped clean of all visible traces of lubricants, machining fluids, swarf, loose particles and dirt.

7.2 MATT

- Often used on stainless steel surfaces for glare control it may be achieved using bead blasting. Clean glass or plastic beads are necessary to avoid iron contamination and will avoid the surface becoming too rough.
- A matt finish may be achieved by mechanical or chemical means if not otherwise specified. Chemical techniques must include an appropriate cleansing procedure.
- The procedure and a sample of the finish must be submitted for approval by the Purchaser before application.