POST OFFICE ENGINEERING DEPARTMENT

SPECIFICATION

FOR

WALL BOARDS D1/60577, D2/60577, D3/60577 AND D4/60577 E-in-C DRAWING 60577
AND WALLBOARDS D1/63747 AND D2/63747 E-in-C DRAWING 63747
AND PARTITION D60967 E-in-C DRAWING 60967

*1. GENERAL

1.1 Specification D 1000 shall be taken as forming part of this specification.

1.2 Each wallboard comprises the details and components shown on the main assembly drawings. (Drgs. 60577 or 63747).

1.3 Whenever the colour grey is mentioned in this specification, colour 9/100 G(E) Specification BS 2660 shall be used.

*2. MATERIALS

2.1 Plywood

(i) The thickness of the plywood shall be

(a) 18 mm in the D2/ ....., D3/ ..... and D4/ ..... wallboards and bottom of containers No. 1-4.
(b) 9 mm in the Partition D60967.
(c) 18 mm including the S.R.B.P. facing in the D1/ ..... wallboards.
(d) 12 mm including the S.R.B.P. facing in the Shelf No. 9.
(e) 18 mm including the S.R.B.P. facing in top of containers No. 1-4

(ii) The plywood shall comply with BS 1455, Grade 3, WBP bonding.

(iii) All cut edges and surfaces not faced by SRBP shall be given one brush coat of a 5% solution of copper napthenate in a volatile solvent, or other approved preservative.

2.2 S.R.B.P.

(i) The S.R.B.P. sheet used on the front face of the D1/ ..... wallboards and shelf surfaces of the D2/ ..... and D3/ ..... wallboards shall conform to B.S. 1323 type 1. The sheet shall be 3/64" thick and shall have a black high gloss surface.

(ii) The S.R.B.P. sheet used on the back surface of the D1/ ..... wallboards shall conform to B.S. 1137 type 1. The sheet shall be 3/64" thick and may be neutral in colour and have a non glossy surface.

(iii) The S.R.B.P. shall be firmly bonded by means of suitable adhesives and shall show no bulges, waviness or signs of parting around the edges.

(iv) Where the sheet is bonded to plywood it shall pass the following tests:-

(a) Two saw cuts shall be made at right angles by means of a circular or band saw. After this treatment there shall be no separation of the plywood and S.R.B.P. sheet at the intersection of the cuts or elsewhere.

(b) There shall be no separation of the plywood and the S.R.B.P. sheet after immersion of a piece of the faced plywood in boiling water for 30 minutes.

(v) All S.R.B.P. veneers shall be cut clean and have no sharp or rough edges; a radius or chamfer on the edges not exceeding 1/32" is permissible.

*3. WALLBOARD D1/60577 AND WALLBOARD D 1/63747

3.1 The wallboard shall be constructed of plywood (Par. 2.1) and faced both back and front with SRBP (Para. 2.2)

3.2 The Frames Notice and Frame Mirror shall be made from 20 SWG rust resistant steel to P.O. Specification No. M1., Composition No.1, condition (b). They shall be made in one piece; jointed corners are not acceptable. Items 5,6 and 7 shall be fitted with a sheet of White International Pasteboard (12 sheet) and cut to the same size as the corresponding glass. The pasteboard shall be fitted underneath the glass.

Items 5, 6 and 7 shall be capable of being easily removed and replaced by means of a Key Frame Notice No. 29 (Drawing No. 60881). The mounting brackets for the notice frames shall be securely fixed to the backboard and be free from bends or burrs. The location pins shall be securely rivetted.

4. WALLBOARDS D2, D3 and D4/60577 and D2/63747

4.1 The backboard shall be constructed of plywood (par. 2.1)

4.2 The wood shall be smooth and well filled and one or more coats of black stain shall be applied to ensure a uniform finish. It shall then be finished with a hard, tough, black lacquer which shall have a smooth high gloss surface, with good resistance to abrasion and not liable to chip or crack.

4.3 The tapped metal securing strips shall be fixed firmly and be flush with the back of the wallboard.

* 4.4 Containers Nos. 1-4

(i) The sides shall be constructed of Grade 1 Honduras Mahogany. The top and bottom of plywood (Para. 2.1)

(ii) The facing strips shall be made of 18 SWG rust resistant steel to P.O. Specification M1., Composition No. 1, condition (b) and the edges shall be rounded and smoothed (this is most important). The fixing screws and brads shall be sunk slightly below the surface. Strip No. 1 on Wallboard D2/60577 includes an ash-tray, as does Strip No. 6 on Wallboard D2/63747.

(iii) The rust resistant steel for the shelf Nos. 1,2,3 and 4 shall be 26 SWG to P.O. Specification M1., Composition No. 1 or 2, condition (a).

(iv) The jointing of the sides, top and bottom of the containers shall be by the tongue and mitre method as detailed on the drawing. The left vertical member may be framed with mortice and tenon joints or cut from a solid piece. If the latter, the internal corners of the opening may have a radius not exceeding $\frac{1}{2}$in. In either case the edges shall be rounded.

4.5 Container No. 5

(i) The item shall be constructed of aluminium alloy to B.S. 1470 NS3, $\frac{1}{2}$H and in accordance with Drgs. 91091 and 91104.

(ii) The finish shall be grey stove enamel to P.O. Specification M 288 (see also 1.3).

(iii) The slotted plate of the cigarette rest shall be rust resistant steel to P.O. Specification M1., Composition No. 1, condition (b). The body shall be mild steel, finished in black stove enamel to P.O. Specification M 288.

4.6 Holder Directory No. 5

(i) The holder shall be constructed in accordance with P.O. drawing 91297 which includes details of material amd finishes.

(ii) The adjustable brake included in each Directory Carrier is to prevent fast restoration with possible injury to users. Initial tightening of the brake should be such that with a London Postal Authority Directory fitted (weight approx. $2\frac{1}{2}$ lbs) the holder will not restore to its at res' position by gravity but will require assisting. The two adjusting screws should be set up to ensure a constant effort over the whole braking area.

(iii) The holder must slide over the supporting studs without undue force being required to place it in position or to remove it.

(iv) No locks will be supplied with the Holders but when a Lock No.31 or 39 ... is fitted it must operate smoothly and securely lock the Holder to the Wallboard without requiring excessive pressure on the key.

4.7 Bracket Mounting D 91092

(i) The item shall be constructed of mild steel in accordance with Drawing 91092.

(ii) The finish shall be grey stove enamel to P.O. Specification M 288. (see also 1.3)

4.8 Shelf No. 9

(i) The item shall be constructed in accordance with P.O. Drawing 91326.

4.9 Partition D 60967

(i) The partition shall be constructed of plywood (par. 2.1) in accordance with P.O. Drawing 60967.

(ii) The wood shall be well filled and smooth and finished with a hard tough black lacquer.

5. MARKINGS

Each part of the wallboard shall be marked in accordance with Specification D 1000 and in the position shown on the drawing with the P.O. Stock List No. and the approved code letters identifying the manufacturer, e.g.

D1/60577 FH	for Wallboard	D1/60577
D2/60577 FH	for "	D2/60577
D3/60577 FH	for "	D3/60577
D4/60577 FH	for "	D4/60577

In addition a white patch $\frac{3}{4}$" x $\frac{1}{2}$" shall be provided immediately under the marking.

Partitions D 60967 shall be marked D 60967 as shown on Drawing 60967.

Containers No. 1-4 shall be marked as shown on Drawings 90077-8 with the P.O. Stock List No. e.g. 1.

Containers No. 5 shall be marked as shown on Drawing 91091 with the P.O. Stock List No. e.g. 5.

Holders Directory No. 5 shall be marked as shown on Drawing 91297 with the P.O. Stock List, e.g. No. 5.

Brackets Mounting D 91092 shall be marked as shown on Drawing 91092, e.g. D 91092 FH.

Shelves No. 1-4 and 9, Strips No. 1-7 and Cigarette Rest No. 1 shall be marked with that P.O. Stock List No. as shown on Drawing 90072-3, 90075-6, 91236 and 91107 e.g. 1.

The code letter FH are typical and shall be substituted by the approved code allocated to the manufacturer.

6. TESTS

Before manufacture commences, a sample of the plywood shall be submitted for test to the London Materials Sections, P.O. Eng. Dept., Studd Street, London, N.1.

One of each wallboard D1/ ...., D2/ ...., D3/ .... and D4/ .... or part thereof, as required, shall be submitted for approval before manufacture of the bulk of the order is proceeded with. At any time samples of materials may be taken for test at the discretion of the P.O. inspecting officer.

7. SCHEDULE OF DRAWINGS, AND SPECIFICATIONS REFERRED TO IN, OR COVERED BY THIS SPECIFICATION:-

Drawing No.	Specification No.	
D 60577	P.O. M1	B.S. 1137
63747	M 288	1323
60592	D 1000	1455
60593		2660
60594		
60595		
60881		
60967		
63703		
90071		
90072		
90073		
90075		
90076		
90077		
90078		
91091		
91092		
91104		
91107		
91297		
91326		

END OF SPECIFICATION

May, 1962

Subscriber's Apparatus & Miscellaneous Services Branch, (S 1/2)
Engineering Dept., G.P.O.,
London, E.C.2.