

Excerpts of Axiall Corporation Tank and Hopper Railcar Maintenance Manual,
Version 7.0, August 2015

CHAPTER 3

SPECIFIC REQUIREMENTS FOR ALL Axial RAILCARS SHOPPED FOR SCHEDULED AND NON
SCHEDULED MAINTENANCE AND REPAIR

Requirements for All Axial Cars Leased or Owned:

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Requirements for Axial Owned Cars Only preferred for leased cars:

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19. ACF 200 Style Draft Sill Inspection Requirements:

- a. Cars with ACF 200 underframes shall be modified to include a head brace when the car is scheduled to be relined. Use Texana Tank Car drawing TNC T2151.
- b. Until a car with an ACF 200 stub sill has been modified the stub sill shall have an SS3 inspection performed every 5 years. All completed SS3 forms are to be submitted to MAC with the rest of the cars shopping repair inspection paperwork. Do not change the stub sill inspection due date on the cars stencil qualification marking area but be sure to update the inspected dates on the cars stencil.

CHAPTER 4

SPECIFIC REQUIREMENTS FOR 17500 GALLON CAPACITY CHLORINE TANK CARS

DOT Specification 105J500W for cars in chlorine service PIH service sometime before March 16
2009 and 105J6001 for cars in chlorine service PIN after March 16, 2009

Requirements for All Axial Cars Leased or Owned

1. Lease and owned Chlorine cars are on a 5-year cleaning inspection. During the 5-year cleaning inspection all service equipment is to be inspected and the cars qualification stencil reflect the inspection date. The 5 year cleaning inspection will be performed at the time of the qualification inspection as well as in between qualifications. Refer to CHAPTER 18 for specific instructions when performing the 5 year cleaning inspections.

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CHAPTER 17

SPECIFIC REPAIR PROCEDURES

Axial Chlorine Tank Car 5-Year Cleaning Inspection Procedure (also refer to Chapter 4 for additional details):

1. The car is to be inspected for corrosion and the condition of the components is to be evaluated and documented on the Axiall internal inspection form.
2. All of the work below is to be completed per the Axiall maintenance manual:
 - Clean car interior.
 - Perform tank thickness measurements to verify shell integrity.
 - Perform a service equipment qualification inspection which includes remove and replacing the dome housing and cover plate.
 - Remove the dome housing from the cover plate blast and coat before reapplying).
 - Replace all gaskets.
 - Replace all studs and nuts on the pressure plate prior to reapplying pressure head to car (excluding the studs and nuts holding the protective housing to the flange commonly referred to as bonnet studs and nuts).
 - Remove recondition Axiall approved supplier and reapply angle valves.
 - Apply 1 ¼" x 4" long schedule 80 nipple to the bottom coverplate under the check valve.
 - Remove inspect and reapply excess flow valves. Apply Midland A-120 high flow rated check vales if not so equipped.
 - Leak test eduction piping and fittings and repair or replace as necessary.
 - Recondition (Axiall approved supplier) and test safety valve.
 - Blast dome and coverplate inside and out.
 - Prime dome housing and coverplate inside and out.
 - Paint inside of dome and coverplate with aluminum paint.
 - Do not paint valve handles of bellows sealed angle valves (leave the valves the initial green color).
 - Inspect and repair (patch) any jacket corrosion. Careful detail should be given to inspect areas around existing patches for corrosion that would prevent the repainted areas from lasting approximately 5 years between the cars next shopping event. Replace and repaint areas as required, including applying primer to undersides of patches to prevent corrosion.
 - Evaluate external paint for five years additional service and repaint if necessary. Only the centerband may be repainted if rust or stains cannot be removed by washing.
 - Renew all markings and decals if required.

3. Complete an Axial 5-year cleaning inspection form and a service equipment inspection form as specified in Axial's Customer Specific Requirements document hosted on the AllTranstek DHS website.
4. When changing valves be sure to remark (stencil or decal) the service equipment and safety valve station stencil and the year tested date but not the "due date" in the cars qualification inspection stencil. Complete form after work has been completed.
5. Return a copy of the qualification and inspection forms to MAC The forms are specified in Axial's Customer Specific Requirements document hosted on the AllTranstek DHS website. A copy of the Axial 5 year cleaning inspection form shall also be sent to MAC.