



Repair Standards

01-001 - Aluminum Roof Patch

Disclaimer:

Only a certified and experienced person using suitable tools should complete the repairs described below. Repairs should meet or exceed manufacturer's minimum specifications and should be in agreement with all safety and ecological regulations.

Permissible upon return and does not require repair:

- Negligible dents and scratches that are water tight.

Requires repair upon return:

- Any cuts, tears or holes to the roof sheet.

Restrictions:

- Patches must not exceed 576 square inches.
- Any damage that surpasses this size will require a roof section from the front or rear of the trailer or even a replacement of the roof.
- Patches cannot be smaller than nine square inches.
- Do not surpass seven patches on one roof.
- A roof section is not considered a patch.

Procedure:

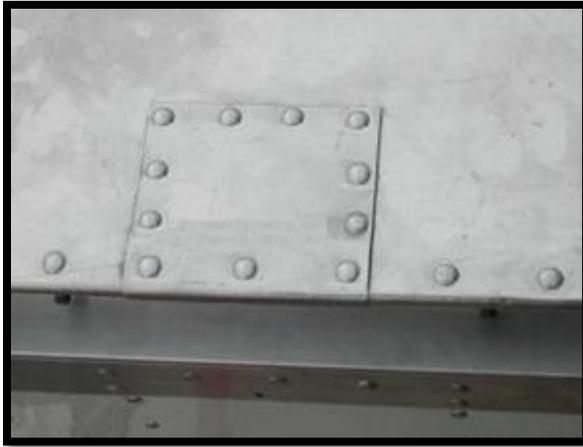
1. Remove and/or straighten the damaged area of the roof and round the corners after the damaged area is removed.
2. If necessary, remove interior roof lining and/or roof scuff lining.
3. Cut a piece of industry standard aluminum roof material at least one inch larger than the damaged area in every direction.
4. Using a 3/16" drill bit as required, drill 1/2" from the outer perimeter of the patch material and roof on 1 1/2" centers.
5. Clean the damaged area with a non-flammable solvent and apply a considerate amount of Seal-Gap AH-55 around the damaged area before the patch is installed.
6. Place the patch over the damaged area. To install patch, use 3/16" x 3/8" soft or hard bucking-type rivets.
 - a. If patch is along edge of the roof, install rivets so that they are spaced similarly to existing rivets.
7. After all rivets are installed, seal the top of the rivets and the border of the patch with Seal-Gap AH-55.
8. If necessary, reinstall interior roof lining and/or scuff lining.



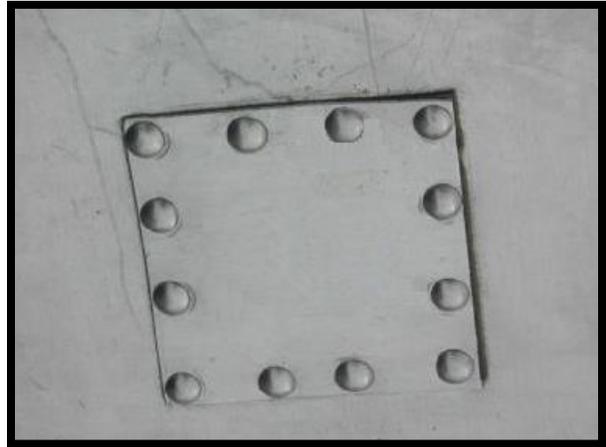
Finished Product

Exterior

Edge of Roof



Middle of Roof



Interior

Edge of Roof



Middle of Roof

