



Repair Standards

01-006 – Sheet and Post Side/Front/Radius Panel 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:

- Acceptable repairs.
- Minor dents/scratches that are water tight

Requires repair upon return:

- Scratches that break through panel(s) skin.
- Holes in the panel(s).
- Panel(s) that have been torn.

Restrictions:

- Patches should not be more than 144² inches in total.
- Patches should not be less than 3" x 3" in total.
- Patches exceeding 144² inches call for a panel section or even replacement.
- There should not be more than two patches on an individual panel.
- Panel sections are not to be considered the same as panel patches.
- If buck rivets are not available, aluminum monobolts are acceptable for radius panel patches.
- Patch material and repairs should match the original rivet lines of the trailer.

Procedure:

1. Take out or repair the damaged area of the panel.
 - 1) Smooth all corners of the damaged area, after removal.
 - 2) If applicable, stop drill cracks to avoid any additional cracking of the panel.
2. Remove the interior liner and scuff liner cautiously, if necessary for repairs.
3. Leaving 1" of excess on all four sides cut out the patch from, like-colored, .050 panel material.
4. Drill holes ½" inside the outside edge of the panel & patch cut-out, using a 3/16" or ¼" drill bit and center on 2".
5. Using a non-flammable solvent, clean the damaged area.



6. Spread on a reasonable amount of sealant around the damaged area, on the interior, to create a water tight fit, before applying the patch.
 - 1) It is not necessary to apply sealant to the exterior of the patch, once in place.
7. Using 3/16" buck rivets, apply the patch over top of the damaged area and sealant.
8. If removed, re-attach the interior lining and interior scuff lining.
9. If any tape or decals were affected by the repairs, restore/replace them to original condition.

Finished Product

Exterior – Panel Patch

