



## Repair Standards

### 01-007 – Sheet and Post Side/Front/Radius Panel Section

#### 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.

#### Requires repair upon return:

- Unacceptable repairs.
- Holes/dents/scratches larger than 144<sup>2</sup> inches in total.

#### Restrictions:

- Sections can ONLY be made at the top OR bottom of a panel.
- There should not be more than two sections on an individual panel (including radius panels).
  - After two sections, the panel should be replaced.
- A panel section (not including radius panel) should not exceed 24" in height.
- The height of a panel section should not be less than the first rivet above the bottom rail or below the first rivet of the top rail.
- A radius panel section should not exceed 30" in height.
  - ¼" monbolts should be used to secure a radius panel section.

#### Procedure:

1. Take out the damaged area by removing the full width, and appropriate height, of that panel.
  - 1) This should be ½" beneath the closest top rivet hole at the bottom of the panel and ½" above the closest top rivet hole are the top of the panel.
2. Remove the interior liner and scuff liner cautiously.
3. Leaving 1" of excess material on all four sides cut out the patch from, like-colored, .050 panel material. The extra 1" of material will allow for ½" above or below the rivet seam.
  - 1) Overlap should be over at the top, and under at the bottom.
4. Drill holes at the overlap of the panel, between posts, and in previous holes in posts and rails.
  - 1) Holes should be drilled using a 3/16" or ¼" drill.



5. Using a non-flammable solvent, clean the overlap areas and add sealant prior to applying the section.
  - 1) It is not necessary to apply sealant to the exterior of the section, once in place.
6. Using 3/16" or 1/4" buck rivets, rivet the section into the posts, panel joints, and rails on 2" centers and equivalent to the posthole rivet pattern originally in place.
7. If any tape or decals were affected by the repairs, restore/replace them to original condition.