



Repair Standards

01-014 – Composite Van 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).
- Structural issues in the panel(s).
 - In the case of a cut in only the outer skin of the panel, place a patch over the area.

Restrictions:

- Patches should not be more than 144² inches in total if the panel is damaged one-foot or higher than the bottom of the panel.
 - If the damage is one foot or lower from the bottom of the panel, patches should be no wider than 12".
- Patches should not be less than 3" x 3" in total.
- Patches exceeding four feet (48") in length call for a panel section or even replacement.
- There should not be more than one patch within the lower two feet of an individual panel.
- Panel sections are not to be considered the same as 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.
 - 1) Remove interior scuff liner if making repairs to the lower 6"-12" of the panel.
3. Leaving 1" of excess on all four sides cut out the patch from, like-colored, .019 steel material.



4. Drill holes $\frac{1}{2}$ " inside the outside edge of the panel & patch cut-out, using a $\frac{3}{16}$ " or $\frac{1}{4}$ " drill bit and center on 2".
 - 1) Patches only covering cuts are able to be bonded without rivets.
5. Using a non-flammable solvent, clean the damaged area.
6. Spread on a reasonable amount of sealant around the damaged area, 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 $\frac{3}{16}$ " or $\frac{1}{4}$ " hard bucking 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.