



Repair Standards

01-015 – Composite Van 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 (that puncture the panel skin) larger than 144² inches in total.
- Bends in panels greater than three inches.
 - Panel replacement is dependent on severity of the bend.

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 be any less than 24" in height.
 - In the case that there is damage to 50% or more of the entire panel, the panel should be replaced.
- In the case that three, or more, panels (all next to each other) require sections, the seams should be offset by 24" on every third panel. **Ex. Panel 1: 24" section, panel 2: 24" section, panel 3: 48" section**
- A radius panel section should not exceed 30" in height.

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 scuff liner cautiously.
3. Cut out the patch from an appropriately thick and wide piece of composite panel material.
 - 1) The replacement material should be from the original trailer manufacturer.



- 2) Overlap is not necessary.
4. Prepare rivets on 1-1/2" centers by drilling 1/4" holes with a drill bit.
 - 1) Exterior cover and interior logistic plates can be used as guidelines for holes.
5. Using a non-flammable solvent, clean the lap 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 the suitable sized and length buck rivets, install the section.
 - 1) Buck rivets should be placed on 1-1/2" centers.
 - 2) Cover the horizontal butt joints with .090" aluminum inside and outside by placing 1/4" rivets on both panels.
 - i. Rivets should be spread out by 1-1/2".
7. Scuff liner should be put back on using the proper fasteners.
8. If any conspicuity tape or decals were affected by the repairs, restore/replace them to original condition.