



## Repair Standards

### 02-005 – Reefer Panel Replacement

#### 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:

- Holes, breaks or cuts in the side/front panels greater than 12" or 144<sup>2</sup>".
- Panels with more than two sections.

#### Safety Measures:

- Take appropriate safety precautions when working with fiberglass, polyester, epoxy or acetone.
  - Eyes should be covered with goggles.
  - Face should be protected by an OSHA approved respirator mask.
  - Hands should be protected by gloves.
- Take appropriate safety precautions when working with resins and solvents.
  - Read caution labels on each product used, in every use.
    - Never smoke or use tools that create sparks while making repairs with resins or solvents.
- Be sure that there is enough air circulation while working inside the trailer, without proper ventilation fumes could build up and cause harm.

#### Procedure

1. In the case that the repairable zone is on the first through the third panel (from either the front or rear of the trailer) begin repairs by taking away the "cove molding" and then remove the inner liner.
  - 1) In the case that the repairable zone is in the middle of the trailer, cut vertically through the repairable zone to uncover the panel that will be replaced. Once these repairs are made, replace the seam and sand it smooth.
  - 2) Once everything is dry, paint the repaired zone to match original color.



2. Without cutting, take out the scuff line fasteners and pull back the scuff to reveal the panel insulation and bottom rivet line.
3. Discard the damaged panel and replenish any lost insulation with Polyurethane spray foam.
4. Using 3/16" x 7/16" hard bucking rivets, mount the new panel into place.
  - 1) Rivets should be fastened in the posts and panel joints.
  - 2) ¼" hard bucking rivets should be used in top rail areas.
  - 3) ALL rivets should be placed on two-inch centers and aligned with the original posthole rivet pattern in the seam.
5. Sealant should always be placed on the back side of the seams.
  - 1) It is unnecessary to apply sealant to the outside of the seams.