



Repair Standards

02-006 – Reefer 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:

- Holes, breaks or cuts in the side/front panels.

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 to interior liners.
- 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. Cut out the panel that needs to be repaired $\frac{1}{2}$ " above the closest post rivet hole.
 - 1) Replenish any lost insulation with a Polyurethane spray foam.
2. Add a plentiful amount of caulking to the areas being sectioned.
3. Cut out a replacement for the damaged area from a like-colored .050 aluminum material.
 - 1) Be sure to leave one-inch of excess material in order to reach $\frac{1}{2}$ " beneath the rivet seam.
4. Secure the new panel into place using $\frac{3}{16}$ " x $\frac{7}{16}$ " aluminum monobolt rivets into the posts and panel joint. The rivets used in the top rail should be $\frac{1}{4}$ " aluminum monobolt rivets. The



rivets should be in line with the posthole rivet pattern in the panel seams and on 2" centers.

5. When sectioning a panel near the top rail, be sure to install the section behind the top rail and overlapping the outside of the original panel.
 - 1) Sides should be lapped just as the original is.
6. When sectioning a panel near the bottom rail be sure to install the section behind the original panel and on the outside of the bottom rail.
7. Sections should be secured with 3/16" x 7/16" aluminum monobolts into the post and panel seam and on two-inch centers.
 - 1) 1/4" and 5/16" monobolts should be used to secure the bottom rail to the panel.
8. On the back side of the section, spread on a plentiful amount of sealant.
 - 1) It is unnecessary to put sealant on the outside of the sections.