



## Repair Standards

### 02-011 – Reefer Floor Duct Riser Welds

#### 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 or breaks in the floor board.
- Rotten aluminum due to corrosion.

#### 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, solvents and insulation.
  - Read caution labels on each product used, in every use.
  - To reduce heat from welding, place a one-inch wide .063 aluminum bar beneath the seam before welding begins.
    - Be sure to have an abundance of water nearby to cool the welded area.
- Be sure that there is enough ventilation while working inside the trailer, without proper ventilation fumes could build up and cause harm.

#### Note:

- Damages greater than 12" in length need to be sectioned, not welded.

#### Procedure:

1. Be sure that the area, to be repaired, is clean and ready for welding.
  - 1) The damaged area can be cleaned with a wire brush after it has been straightened back to its original shape.
    - i. If the area is not cleaned a deep, non-porous, weld cannot be guaranteed.



2. If a tear is being repaired in the floor, use a hard disc grinder to v-groove the tear or grind the edges of a tear at 45-degrees.
3. Replace the missing floor area, or cut, with an aluminum flat stock of the same thickness. Once the replacement is in the proper location, weld it into place.
4. Use a hard disc grinder to grind and smooth out the repaired area.
  - 1) Clean up the grinded area with a soft disc grinder to get rid of any grinding marks left behind by the hard disc grinder.