Repair Standards

02-004 – Reefer 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.

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.
        - <u>Never</u> 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.

Note:
- Patches are to be less than 12 inches or 144² inches.
    - In the event that a repair is greater than 12 inches or 144² inches, the panel should be sectioned or replaced (dependent on the size of the repair needed)
- Filler should <u>never</u> be used to repair holes in the side panel, repairs need to be patched, sectioned or replaced.

Procedure:
1. Cut out the area that needs to be repaired.
    1) All corners must be rounded and smoothed to avoid cracking.
    2) Replenish any lost insulation with a Polyurethane spray foam.

2. Add a plentiful amount of caulking to the area that was removed before installing the patch over it.
3. Cut out a replacement for the damaged area from a like-colored .050 aluminum material.
4. Secure the patch into place using 3/16" x 7/16" aluminum monobolt rivets. The rivets should be ½" from the edges of the patch and on 2" centers.
5. On the back side of the patch, spread on a plentiful amount of sealant.