



## Repair Standards

### 01-012 - Aluminum Roof 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:

- Unacceptable repairs.
- Roof damage exceeding 576 square inches.
- More than two sections in the roof sheet.

#### Procedure:

1. It is imperative that repairs are made on level ground before beginning a roof replacement. Level the trailer in numerous places to confirm that the trailer is level. Not completing repairs on a level surface could result in a loose roof.
2. Take off the original roof sheet by heating up the areas where the adhesive joins the roof and the roof bows.
3. Be sure to take away all remaining adhesive from roof bows and rail flanges to leave a clean surface for the new roof sheet to be applied.
  - a. Roof bows don't need to be taken out if there is no damage to them.
4. Check the trailer for proper alignment and, confirm that the rear frame is square.
5. In the case that black foam tape was added to the original roof bows, replace this tape with the paper overhanging the side of the roof bow.
6. While maintaining the straightness of the rails, apply the new sheet, making sure that it is perfectly centered.
7. Secure the replacement sheet to the rear header of the trailer and tighten it from the front of the trailer.
  - a. Consider the roof sheet to be tight when the edges start to curl up.
8. In order to keep the new roof sheet tight, rivet it to the front corners of the trailer.
  - a. Rivets should be placed, at least, ten inches from the corner of the front and side rails.
9. While maintaining the rails stay straight, rivet the roof sheet at each roof bow on one side.
  - a. Complete the same process on the other side after pulling the sheet to that side.



10. Go back, on each side, and rivet all other locations in between the roof bows.
11. With the rivets in place, and the roof sheet tight, lessen the tension of the roof to trim and rivet the remaining areas from the middle out.
  - a. In areas where necessary, fold the new roof underneath the rail.
12. Apply an adhesive to the roof bows to bond the roof and bows together.
  - a. Take the paper backing off of any foam-back tape used.
  - b. Apply pressure to the roof bows for any other adhesive used.
    - i. The use of load jacks is suggested.