

General Requirements

- The damaged part has to be cut-out carefully with a radius of at least 5 mm (3/16") in the corners
 - Thereafter a patch with at least 20 mm (1") radius at the corners and a 20 mm (25/32") overlap on all sides has to be fixed by means of rivets.
 - The patch should be made of the same quality as the original sheet
 - $R_m = 315 \text{ N/mm}^2$
 - $R_{p0,2} = 255 \text{ N/mm}^2$
 - Minimum patch gauge = same thickness as original sheet
 - Maximum distance between rivets = 50 mm (2").
 - Minimum distance from the edge of the patch and from the cut-out = 9 mm (11/32").
 - Blind rivet GFB No. 315720, Alcan Singen P/N 927237,
Ø 4.8/0.8-3.2 mm grip
 - Tensile strength = 3100 N**
 - Yield strength = 2260 N**
- or other blind rivets with equal or better strength figures

Pls. note that patches do not require the OEM's approval as long as the before mentioned requirements are fulfilled.

According to our manuals (paragraph *Classification of Damage* and paragraph *Repairs*) there are **no limits** for the size, the quantity and the location of patches.

In paragraph *Classification of Damage* we define:

- what kind of damage to the container is allowed
 - ➔ the container is still airworthy **without** any repairs ➔ Class I, i.e. a repair of these damages will only be necessary if requested by the owner or user of the ULD in regards to preventive maintenance
- what kind of damage needs a 50% load reduction
 - ➔ the container is still airworthy without any repair, but in this case the max. load of the ULD has to be reduced by 50% ➔ Class II
- what kind of damage needs an immediate repair
 - ➔ the container will loose its airworthiness without being repaired ➔ Class III

