

Pallet / Base Repair – Sheet Patches

- One crack per 10.8 sq.ft (1 m²), up to 4" (100 mm) length
or
 one hole per 10.8 sq.ft (1 m²), up to 0.8" (20 mm) diameter
can be repaired as follows:

Drill stop holes and close the damages by welding, provided that the distance between the damages is not shorter than 13.7" (350 mm).

Grind welding flush on upper and lower side.

Stop holes must be visible after repair.

- Larger damages as indicated above **can be repaired as follows:**

Work-out the damaged area - min 0.4" (10 mm) radius in the corners, no sharp edges. A doubler, being on all sides min. 1.2" (30 mm) larger than the worked-out damage area has to be riveted to the sheet, distance between the rivets max. 1.2" (30 mm).

Edges or corners of the doubler shall be rounded off and/or sloped.

Rivets have to be the same as the original pallet/base rivets or better.

Doubler thickness min. 0.12" (3 mm) and material according to the original pallet/base sheet alloy.

A filling piece, which fits into the properly worked-out area, has to be riveted to the doubler.

Edges or corners of the doubler shall be rounded off.

Rivets have to be the same as the original pallet/base rivets or better.

Filling piece thickness and material according to the original pallet/base sheet alloy.

No protruding parts on the lower surface are allowed.

Section A-A

