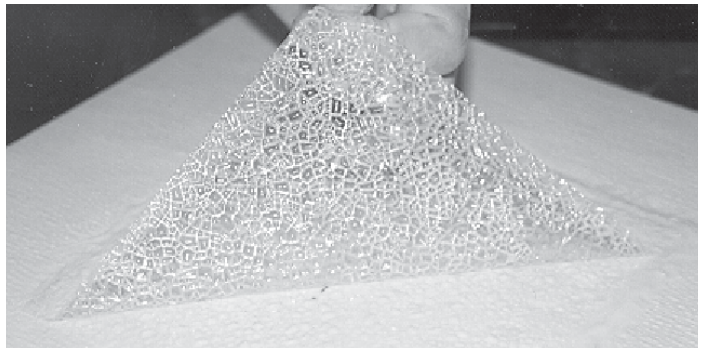
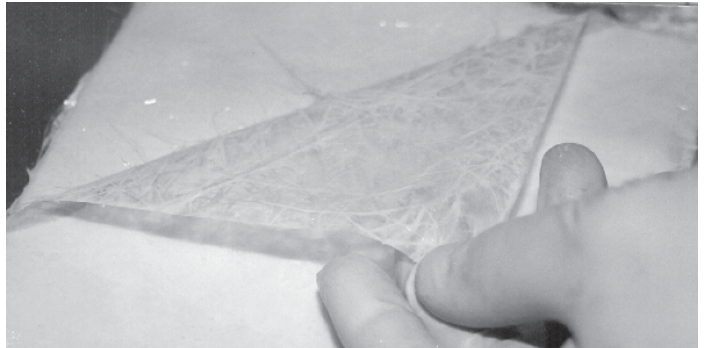


REPAIR GUIDE for small roof repairs with SunPatch® Roof Kit



for use with repair kit #R50SNPTCHKIT2

SUNPATCH ROOF REPAIR KIT FOR SMALL REPAIRS

FOR USE WITH REPAIR KIT #R50SNPTCHKIT2 | ROOF REPAIR KIT (R50TFIX)

ALSO AVAILABLE FOR LARGE REPAIRS

The SunPatch fiberglass repair kit is a technique specifically designed for repairing damage to Crane Composites' roof panels. The patch is a pre-impregnated fiberglass mat packaged individually in a foil pouch and is easily applied.

THE SUNPATCH CAN BE USED AS FOLLOWS:

- Cures in as little as 4 to 6 minutes
- Works in hot or cold climates (0-100° F)
- No mixing of resin required
- Kit comes ready to use with a squeegee

DISCLAIMER

PLEASE READ ALL INSTRUCTIONS BEFORE BEGINNING INSTALLATION

These guidelines are provided in good faith, but without guarantee. The manufacturer and distributor of the product bear no responsibility for actions taken or not taken. There are many nuances of repair techniques that are assumed to be general knowledge; such nuances are not included in these instructions. Rather, these guidelines are strictly recommendations and are not intended to serve as a step-by-step, foolproof repair checklist. Selection of an experienced repair facility is the sole responsibility of the owner.

Since conditions of use are beyond Crane Composites' control, all risks are assumed by the user. Nothing herein shall be construed as a recommendation for uses which infringe on valid patents or as extending a license under valid patents.

If you have any questions about repair techniques for your particular project, please call 1.800.435.0080 or 1.815.467.8600 and ask for Customer Care or e-mail sales@cranecomposites.com.

SEE OUR MOST CURRENT SDS AT CRANECOMPOSITES.COM/SDS.HTML PRIOR TO WORKING WITH OUR PRODUCTS

CAUTION: Wearing disposable latex gloves, goggles, and use of a mask as per the SDS are recommended. Read and follow all manufacturer safety recommendations on labels of materials used for repair. Some materials may be flammable and should be used with caution. SEE OUR MOST CURRENT SDS AT CRANECOMPOSITES.COM/SDS.HTML PRIOR TO WORKING WITH OUR PRODUCTS.

GENERAL INFORMATION

In the pages to follow, you will find instructions for this easy-to-apply patch to be used with Crane Composites roof products (reefer roof and translucent roof). Our SunPatch may cure in as little as 4 minutes on a sunny and hot day and will fully cure in 10 to 20 minutes. The patch will begin curing immediately after exposure to UV light. Do not open the patch until instructed to do so. It is recommended that protective gloves and mask be used as per the SDS.

Supplies and Equipment

SUNPATCH KIT CONTENTS INCLUDE

- SunPatch (size 12"x12")
- Squeegee
- SunPatch Instructions

RECOMMENDED TOOLS NEEDED (NOT INCLUDED)

- | | |
|--|--|
| • Protective Gloves | • Wipe Cloths |
| • 80 Grid Sandpaper | • Masking/Packing Tape |
| • Acetone | • Silicone |
| • Spray Foam Filler | • Paint |
| (for reefer trailers and truck bodies) | (for reefer trailers and truck bodies) |

FOR TRANSLUCENT ROOF ONLY:

1. Identify the damaged area (Figure 1). Proceed to step two for translucent roof with no underlying foam.
2. Using 80 grit sandpaper, sand an area at least 4" wider than the damage on all sides. Cut the patch to fit the sanded area. Sand until the embossment is no longer visible and the area has a uniformly dull appearance (Figure 2). A disc or belt sander can be used. Remove the sanding dust from the patch area with a dry cloth or shop vac (Figure 3). Wipe clean with acetone.

3. On the backside of the damaged area, apply masking tape or packing tape to seal the repair area (Figure 4). This will prevent air from entering the patch from the backside.

NOTE: Do not perform the repair if it is raining. Excessive moisture, will inhibit the cure.

Remember that the patch will begin to cure as soon as it is exposed to sunlight. Do not open the pouch until you are ready to use it.

4. Remove the smooth film from the backside of the patch (Figure 5). Be sure the abraded area is dry.

Lay the smooth side of the patch over the abraded area, so that the embossed side of the patch is facing up (Figure 6).

5. Use a squeegee to work the resin from the center to the edges (Figure 7). Continue this until a small amount of resin is squeezed out around the perimeter of the patch. After the patch has been exposed to sunlight, the patch will be cured in 10 to 20 minutes.
6. Check the patch to see if it is cured. It will be hard to the touch. Resin that is not covered by the film, will feel tacky, but if the patch feels hard, it is cured. Remove the embossed film (Figure 8). The film can be left in place, but may release from the patch on its own. Remove any tape from the bottom side of the panel. Cover backside with silicone. Expose the resin side of the foil pouch to sunlight until cured for proper disposal.



Figure 1



Figure 2

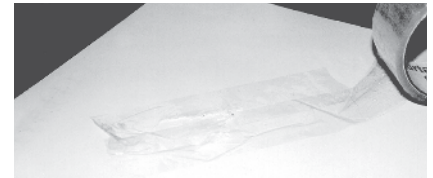


Figure 3



Figure 4



Figure 5

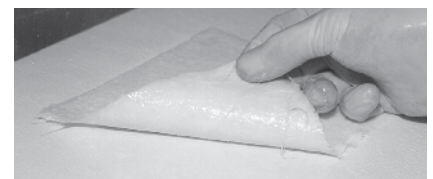


Figure 6



Figure 7

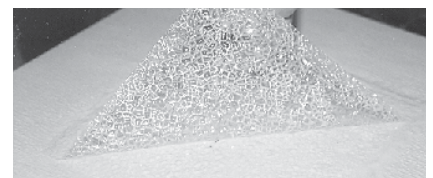


Figure 8

FOR REFRIGERATED ROOF ONLY:

1. Identify the damaged area (Figure 1). Proceed to step two for reefer roof with no underlying foam damage. If the foam has been damaged, fill the hole or void with body filler or a spray foam product (e.g., Great Stuff® or other similar product).
2. Using 80 grit sandpaper, sand an area at least 4" wider than the damage on all sides. Cut the patch to fit the sanded area. Sand until the embossment is no longer visible and the area has a uniformly dull appearance (Figure 2). A disc or belt sander can be used. Remove the sanding dust from the patch area with a dry cloth or shop vac (Figure 3). Wipe clean with acetone.

NOTE: Do not perform the repair if it is raining. Excessive moisture, will inhibit the cure.

Remember that the patch will begin to cure as soon as it is exposed to sunlight. Do not open the pouch until you are ready to use it.

3. Remove the smooth film from the backside of the patch (Figure 4). Be sure the abraded area is dry.

Lay the smooth side of the patch over the abraded area, so that the embossed side of the patch is facing up (Figure 5).

4. Use a squeegee to work the resin from the center to the edges (Figure 6). Continue this until a small amount of resin is squeezed out around the perimeter of the patch. After the patch has been exposed to sunlight, the patch will be cured in 10 to 20 minutes.
5. Check the patch to see if it is cured. It will be hard to the touch. Resin that is not covered by the film, will feel tacky, but if the patch feels hard, it is cured. Remove the embossed film (Figure 7). The film can be left in place, but may release from the patch on its own. Remove any tape from the bottom side of the panel. Cover backside with silicone. Expose the resin side of the foil pouch to sunlight until cured for proper disposal.
6. After the patch is fully cured, you may want to spray paint the repaired area with a white exterior paint (acrylic urethanes or acrylic enamels work well) to blend in the repaired area with the rest of the roof. Wear appropriate respiratory protection when spraying paint.



Figure 1



Figure 2



Figure 3

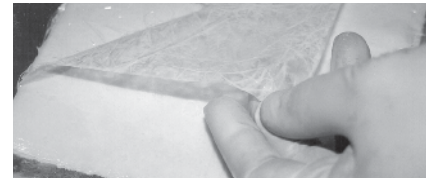


Figure 4

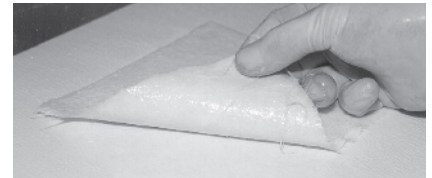


Figure 5



Figure 6

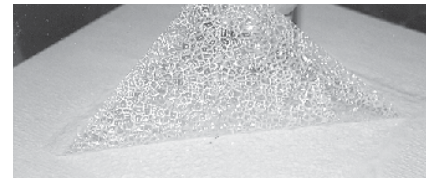


Figure 7

A global leading provider of resilient wall and ceiling coverings. Kemlite® was established in 1954 and the company changed names to Crane Composites in 2007. Crane Composites is headquartered in Channahon, IL and all our products are manufactured in the United States. We work with hundreds of distributors, ensuring our products are easily accessible and readily available to our customers.

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