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|-------------------------------|------------------------------------------------------------------------------------|------------|--------|--------|--------|
| Summary                       | Installation of Vinyl Patch Kit for Roll Doors                                     |            |        |        |        |
| Products Affected             | All Fabric Roll Doors With Vinyl Material                                          |            |        |        |        |
| Key Word Tags                 | Vinyl, Repair, Patch, Kit                                                          |            |        |        |        |
| Tools/Equipment (If Required) | Clamps, Fine Grit Sand Paper, Dry and Clean Cotton Cloth, Rubber Gloves            |            |        |        |        |
| Parts/Materials (If Required) | RILON/PVC PANEL REPAIR KIT, X COLOR R0099008-0X00 (PART NUMBER WILL VARY BY COLOR) |            |        |        |        |
| Related Media                 |                                                                                    |            |        |        |        |
| Author                        | Paul Chichlowski, RevA M. Burzlaff                                                 | Issue Date | 5/2/94 | Status | Active |

## Please Read The Entire Bulletin Before Proceeding

This service bulletin provides instruction to install a vinyl patch kit on Rytec roll doors in the event the panel material is torn. The location and extent of the tear will determine if a patch kit can be applied successfully. Please contact Rytec Customer Support for any questions.

### Installation procedure

*Note: If the tear is located more than two feet above the bottom bar, the added patch will affect the alignment of the panel material as it rolls up on the drum when the door opens. It may be necessary to add a second patch, opposite the tear, to maintain an even panel thickness.*

1. Move the door to a workable height. Depending on the location of the tear, it may be easier to apply the vinyl patch with the door panel lying flat on a horizontal surface. If so, break the door away, or remove the front windbar guides if non-breakaway, and support the bottom bar and panel. Saw horses and a plywood sheet generally work well.



The disconnect must be in the OFF position and properly locked and tagged before performing the next step of the procedure.

2. To prevent the tear from growing, a radius must be added at each end of the tear. This can be done by heating a 1/4" dia bolt and "burning" in a radius.
3. Cut the vinyl patch material to cover the tear, there should be a 2-4" overlap of the vinyl patch surrounding the tear. Cut two patches, one for each side of the panel to sandwich the tear. If you will be applying a patch to the opposite side, reference the above note, you will need to cut four identical patches.
4. Clean and dry the panel area and the vinyl patch.

5. Apply the Loctite adhesive to the vinyl patch, using a crisscross pattern. Apply the patch to the panel material being sure the edges of the patch adhere to the panel material. Wipe clean any adhesive that weeps out from the patch. Apply pressure to the patch for approximately five minutes. In the same manner, apply the second patch to the opposite side of the panel.  
CAUTION: The Loctite adhesive will bond most materials and skin instantly. Wear gloves to avoid contact.
6. Check to ensure the Loctite adhesive is dry. Reassemble the bottom bar and cycle the door several times, checking for adequate adhesion of the patch. If additional Loctite is required, be sure it is dry prior to cycling the door. If not, damage to the door material can occur.

If you have any questions please contact Rytec Customer Support at 1-800-628-1909.