

Summary	Installation of 2Ply and 3Ply Rilon Patch Kits				
Products Affected	All Roll Doors with 2ply and 3ply panels				
Key Word Tags	Rilon, 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					
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Please Read The Entire Bulletin Before Proceeding

This service bulletin provides instruction to install a Rilon 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. The patch kit is for tears approximately 30" or less. Tears cannot be in the side column area. For tears in the side column area Rytec recommends replacing the panel.

Step #1: Move the door to a workable height. All the tension must be removed from the panel. This can be done by loosening the blue tension straps on both sides. Refer to the owner's manual for how to remove tension. If the door is a breakaway style, breaking away the bottom bar will work.



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

Step #2: Rough up the surface to be patched. The area should only be as big as the patch material to be applied. The patch material must be applied to the front and back of the tear. To rough up the surface, use fine grit sandpaper. After sanding, wipe the area clean with a dry cloth making sure the area is free of grit, dirt, grease, or oil residue.

Step #3: Mix the Plastopang with the activator provided in the kit. Mixing ratio is 8oz of Plastopang to 7.5cc of activator. Only mix as much bonding as needed because once it is combined, the bond will harden in approximately 15-20 minutes.

Step #4: Apply mixed bond to the sanded area on the panel and to the patch material with the brush provided in the can. Let the bond dry to the touch and then apply a second coat. Before the second coat is dry apply the patch to the panel. Clamp the patch to the panel with clamps and wood backing plates. Remember to place the patch material on the front and back of the panel.

Step #5: The door must not be used and locked out of operation for at least 6 hours. After the 6 hour cure time has passed, remove all the clamps and backing plates. Tension can now be reapplied to the panel and the panel put back into the guides.

Step #6: Reapply power and test the operation of the door for panel tracking.

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