



Signature Plate

MAINTENANCE AND REPAIR MANUAL

SUPREME CORPORATION

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[SUPREME Preferred Service and Parts Centers](#)

[SUPREME Warranty and Customer Service](#)

This manual is intended to provide general instructions to the user on how to repair PW and Fiberpanel HC damage. There is no guarantee, no assumption of responsibility, or liability to the user for the methods or materials suggested in this manual. All information contained herein, and its implementation, is for use at the discretion of the manual user. The user assumes all responsibility and liability.



Always perform a Delamination Test prior to starting any repair on Signature Plate walls. Repairs applied to a wall where delamination has started, due to the damage, will result in an ineffective repair. Delamination, if not corrected, may weaken the walls structural integrity over time.

Contact Supreme Corporation Warranty Support and Service with any questions related to materials, repair process, and/or any other concerns if not covered within this manual.

Required Tool and Materials Needed (Use automotive grade materials wherever possible)

- | | |
|--------------------------|-------------------------------|
| 1. 7" High Speed Grinder | 2. Dual Action Air Sander |
| 3. Caulk Gun | 4. Phonetic Foam Paint Roller |
| 5. Deburring Router | 6. Rubber Mallet |
| 7. Flexible Putty Knife | 8. Solvent Mixing Sticks |
| 9. Metal/Tin Snips | 10. |

Materials

- | | |
|--|--|
| 1. Automotive Masking Tape | 2. Mylar Film |
| 3. Reinforced Body Filler (Short Strand) | 4. Isopropyl Alcohol |
| 5. 7" Grinding Discs | 6. 3000 to 5000 grit sanding discs |
| 7. Tack Cloths (Automotive Finish Grade) | 8. Clean Shop Rags |
| 9. Imron 5000 Primer | 10. Imron Finish Coat Paint in color matching wall |
| 11. Quickset Finish Coat Paint System (Only approved for minor scratch repair, Option 1) | |

Examples of Tools and Materials



Repairs completed using automotive grade materials will provide the best long-term results as well as reduce sanding and prep time.

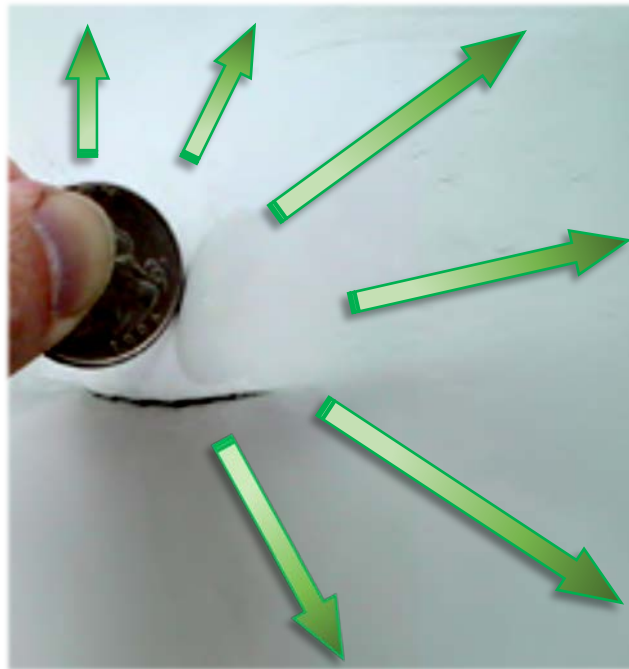
Delamination Test

Using a quarter lightly tap the exterior wall panel, right next to the damaged area, slowly moving outward. While tapping listen, for changes in the pitch produced by the tapping of the wall. Similar to the change in sound when locating a stud in a wall.

If while moving outward the sound of the tapping changes pitch, it is a good indication that delamination has occurred.

If there is no noticeable change in pitch, it is safe to continue with the intended repair.

In the event the delamination test results indicate delamination has occurred, contact Supreme Warranty/Customer Service/Customer Service/Customer Service and Customer Service for information regarding the appropriate repair that needs to take place.



Continuing with a repair, after the delamination test indicates delamination has occurred, may lead to further weakening of the walls structural integrity. Supreme recommends panel replacement if delamination is present to prevent any further structural deterioration.

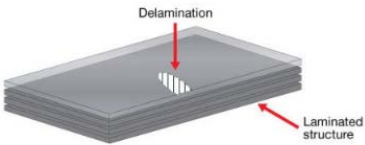





DO NOT attempt to hammer out a dent in the Signature Plate panel. Doing so will result in delamination of the panel, steel plate separating from the core material.

Types of Damage Covered in this Manual and the Repair Options

DAMAGE	REPAIR OPTION	DAMAGE DESCRIPTION
Surface Scratches	1	Scratches in the panel that are only through the painted surface. They do not gouge the steel plate
Scratches, Dents, and Gouges (2.0" or wider)	2	Scratches and gouges that penetrate the paint and the steel plate exposing the panel core.
Deep Gouges	2	Gouges in the panel that penetrate the steel plate and core material.
Through Hole (not exceeding 3.0")	3	A hole, 3.0" wide or smaller, which completely penetrates the panel making the interior of the cargo body visible through it.
Through Hole Larger than 3.0" Wide	4	A hole, larger than 3.0", which completely penetrates the walls making the interior or the cargo body visible.

Definitions

Delamination	<p>The separation of the outer layer from the core. Delamination will not stop after a repair is made if the delamination occurring was not repaired as well. Over time the delamination of the panel will negatively impact the panel's structural integrity.</p> 
Mylar Film	<p>A thin but strong polyester film used in many industries.</p> 
Signature Plate	<p>Supreme manufactured wall composed of a high-density polyethylene core bonded between two sheets of high-strength steel.</p> 
Tack Cloth	<p>A wiping cloth designed specifically to remove fine particles from painted, sanded, primed, surfaces with its sticky/tacky coating.</p> 

Cleaning and Prepping Damaged Area for Repair:

1. Protect hands with disposable gloves.
2. Using the deburring tool or metal file, knock off any sharp edges or metal shards.
 - * If needed, sand or grind the damaged area to a smooth surface with an air sander or high speed grinder.
 - * When sanding for application of paint, sand a minimum of 3 inches around perimeter of the area to be repaired. Failure to do so can result in a lack of adhesion and failure of repair.
3. Using Isopropyl Alcohol and a clean rag, clean the damaged area thoroughly to remove any dust, dirt, metal shavings, etc.
4. Allow the alcohol to evaporate from the surface until it is completely dry.
5. When the damaged area is thoroughly cleaned, determine the type of repair that is needed, based on the repair types listed in the chart on page 5, to ensure the best possible results.

CLEAN-UP PROCEDURE: (after repairs are complete)

Immediately remove filler from skin, clothing, tools and other objects with acetone.

After sanding Signature Plate, dust off clothing and equipment to remove skin-irritating particles.

Safely dispose of used mixing buckets, mixing sticks, sanding materials, unused quantities of filler and paint materials after they have fully cured.



If welding or cutting near a Signature Plate panel, be very careful to not overheat the panel material. Excessive heat could melt the core material and cause the panel to delaminate.



Always wear the proper protective gear for the process being carried out. Manufacturer instructions for application and safety precautions to be followed when using their products should always supersede SUPREME provided information.



DO NOT attempt to hammer out a dent in the Signature Plate panel. Doing so will result in delamination of the panel, steel plate separating from the core material.

SURFACE SCRATCHES-REPAIR OPTION 1

Description:

Only outer surface of panel is affected, no exposure of core. Panel performance not impaired. Repair is for cosmetic reasons.

How to Repair:

1. Conduct a Delamination Test prior to starting repair process, see page 4.
2. Clean affected area per Cleaning and Prep process on page 6.
3. Following body filler manufacturer's instructions prepare and apply filler material.



4. After the body filler has cured, per manufacturer's instruction, sand the filler area to a smooth surface using a fine grit sandpaper.
5. Clean surface per filler manufacturer's instructions to prep the area for paint.
6. Paint over the repaired area, following the paint manufacturer's prep and application instructions and using the appropriate matching paint. Contact Supreme Warranty/ Customer Service/ Customer Service/ Customer Service if information is needed on paint codes.

* In this type of repair the Fast Top Coat Paint System can be used. It is applied with a phonetic roller without the use of primer and base coats.



* It may be necessary to apply a primer base, paint, and then top coat to achieve the best possible color match and blend.

* Painting processes should be carried out by qualified personnel to ensure the best possible results.

7. After the paint process is completed, thoroughly clean the repair area to ensure the repair is acceptable.

Note:

When sanding for application of paint, sand a minimum of 3 inches around perimeter of the area to be repaired. Failure to do so can result in a lack of adhesion and failure of repair.

SCRATCHES, DENTS, AND GOUGES-REPAIR OPTION 2

Description:

Scratches and gouges (2.0" or wider) that penetrate the paint and gouge the steel plate and/or expose the panel's core material.

How to Repair:

1. Conduct a Delamination Test prior to starting repair process, see page 4.
2. Clean affected area per Cleaning and Prep process on page 6.
3. Following body filler manufacturer's instructions prepare and apply filler material.
4. Use putty knife to fill gouge completely. Ensure there are no air pockets in the filler material as it is applied.
5. Cover repair area with Mylar film, tape one end, then smooth with putty knife to remove air bubbles and push excess filler away from repair area. This method requires less sanding after the filler has cured.



6. Allow the filler to fully cure, per filler manufacturer's instructions. When the Mylar film starts to lift away from the filler material it is an indicator that the curing process is complete.
7. Carefully remove the Mylar film.
8. Lightly sand, with fine grit sandpaper to feather edges and to promote adhesion of paint.
9. Wipe down the repair surface with a tack cloth to prep the surface for paint.
10. Apply paint per paint manufacturer's instructions with appropriate matching color paint.

* It may be necessary to apply a primer base, paint, and then top coat to achieve the best possible color match and blend.

* Painting processes should be carried out by qualified personnel to ensure the best possible results.

Note:

When sanding for application of paint, sand a minimum of 3 inches around perimeter of the area to be repaired. Failure to do so can result in a lack of adhesion and failure of repair.



Always perform a Delamination Test prior to starting any repair on Signature Plate walls. Repairs applied to a wall where delamination has started, due to the damage, will result in an ineffective repair. Delamination, if not corrected, may weaken the walls structural integrity over time.

HOLE THROUGH PANEL NOT EXCEEDING 3.0" in DIA.-
REPAIR OPTION 3

Description:

A hole completely through the panel, allowing weather and debris to enter the cargo area, that is not larger than 3.0" in diameter.

How to Repair:

- 1 Conduct a Delamination Test prior to starting repair process, see page 4.
- 2 Clean affected area per Cleaning and Prep process on page 6.
- 3 Using body filler manufacturer's instruction prep and apply filler to both the exterior side and interior side of the hole.
- 4 Using a putty knife carefully fill the hole from the interior first. It may be necessary to fill the hole in several stages, unsupported filler sags. Mix a small quantity. Fill edge of hole, pushing filler firmly into edges.
- 5 Cover repair area with Mylar film, tape one end, then smooth with putty knife to remove air bubbles and push excess filler away from repair area. This method requires less sanding after the filler has cured.
- 6 Allow fully cure per the body filler manufacturer's instructions.
- 7 After the interior applied filler has cured, apply filler to the exterior portion of the hole making sure that the filler is completely filling the space.
- 8 Repeat Step 5.
- 9 Allow the filler to cure per the manufacturer's instructions. Then carefully remove the Mylar film.
- 10 Verify that the filler is completely cured by trying to make an impression in the filler with a fingernail. If the filler is completely cured you will not be able to make an impression in the filler with a fingernail.
 - * Some fillers will cure faster with the use of hot air. If acceptable the filler manufacturer will note what temperature and time to be used.
- 11 After all the filler is completely cured, lightly sand the repair surface to feather out the filler. Use a high grit sandpaper to limit any over sanding to the filler.
- 12 Remove debris from sanding from the repair surface then wipe the surface down with a tack cloth. This preps the surface for paint and improves the adhesion of the paint to the filler material and panel.
- 13 Mask off the repair area to prep for paint.
- 14 Apply paint following the paint manufacturer's instructions and Supremes' paint color requirement.
 - * Painting processes should be carried out by qualified personnel to ensure the best possible results.
- 15 After the paint process is complete, clean the repair surface thoroughly to ensure the repair is acceptable.

Note:

Painting is recommended on exterior surfaces. Painting not required on interior surfaces.

Note:

When sanding for application of paint, sand a minimum of 3 inches

around perimeter of the area to be repaired. Failure to do so can result in a lack of adhesion and failure of repair.



WARNING:
DO NOT ATTEMPT TO REPLACE/REPAIR A SIGNATURE PLATE PANEL WITHOUT SUPPORT FROM SUPREME WARRANTY/CUSTOMER SERVICE DEPARTMENTS.
UNAUTHORIZED PANEL REPLACEMENTS MAY RESULT IN IMPROPER MATERIALS AD PROCESSES USED THAT COULD HAVE A NEGATIVE IMPACT ON THE OVERALL STRUCTURAL INTEGRITY OF THE WALL.

HOLE THROUGH PANEL EXCEEDING 3.0" in DIA –REPAIR
OPTION 4

Description:

A hole completely through the panel, allowing weather and debris to enter the cargo area, that is not larger than 3.0" in diameter.

It is highly recommended that repairs of this nature are completed through a qualified/Supreme designated Service Center.

How to Repair:

- 1 Contact Supreme Warranty/Customer Service for information on Supreme qualified Service Centers near you.