

Steel Roof Replacement

May 2026

Introduction

The purpose of this training is to equip Container Repair Technicians (CRTs) with the knowledge, skills, and confidence to safely and correctly perform a complete steel roof replacement. Through a combination of guided observation and hands-on application, participants will learn the proper sequence of steps, correct tool usage, and required safety practices. The training emphasizes identifying critical steps, avoiding common failure points, and recognizing potential hazards to ensure repairs are completed consistently, efficiently, and in compliance with company standards. Ultimately, this training is designed to improve repair quality, reduce rework, and promote a strong culture of safety in the field.

- **The Tell – Show – Prove – Review Cycle:** The most critical component of this training program is the Tell, Show, Prove, Review cycle. The training for each task should start with you explaining **(tell)** and demonstrating the task **(show)** before the trainee attempts the task themselves **(prove)** and you provide feedback **(review).** This cycle ensures that a trainee has been given instructions for and observed a demonstration of a task before attempting it themselves, reducing the risk for injury or damage.

The training team believes in continuous improvement. If you have any ideas on how to make this program better in any way, please reach out to the Corp Ops Training Team at PODSU@PODS.com.

Steel Roof Replacement Certification Program

Only trained, certified and validated CRTs can perform steel roof replacements safely, consistently, and to brand standards.

Training

Tell | eLearning on PODS U

The purpose of the eLearning is to provide a single source of information for you. The training is available on PODS U under the title “Steel Roof Replacement Certification.” You will be assigned the course and it should be completed prior to in-person training.

Show | Training Leads a Full Roof Repair

During this exercise, participants will observe one complete steel roof replacement from start to finish. The trainer will actively guide the observation by calling out key elements throughout the process, including critical steps that must be executed correctly, common failure points where mistakes often occur, and safety risks that must be recognized and managed on the job. This real-time narration is intended to reinforce proper technique, increase awareness, and connect the procedure to real-world application.

Fill out the checklist as the repair is completed.

Preparation & Removal
☐ Observes removal of plastic roof using proper tools
☐ Observes safe use of forklift for roof removal
☐ Confirms all old roof tape is completely removed
☐ Observes removal of dome straps and springs

Surface Prep & Setup
☐ Observes caulking applied to header corners
☐ Observes safe placement of steel roof onto container
☐ Confirms roof is centered (side-to-side and front-to-back)

Compression & Alignment
☐ Observes application of ≥5,000 lbs. weight on container
☐ Confirms gasket compression is visually checked
☐ Notes use of spacers for alignment (and removal before drilling)

Drilling & Mounting
☐ Confirms use of 21/64” drill bit for frame holes
☐ Observes proper drilling technique (straight, clean holes)
☐ Identifies correct spacer selection (½” or ¾”)
☐ Observes application of Loctite to bolt threads
☐ Confirms bolts installed with spacers in place
☐ Notes torque requirement (25 ft-lbs)

Adjustment
☐ Observes use of mallet to close gaps at roof corners
☐ Confirms roof sits evenly with no visible gaps

Corner Bumper Installation
☐ Observes correct pilot hole drilling (roof only)
☐ Observes correct frame hole drilling (19/64”)
☐ Confirms spacer inserted before installation
☐ Observes Loctite applied to hardware
☐ Confirms bumpers installed on all four corners

Safety Awareness (Throughout)
☐ Identifies PPE being properly used at all times
☐ Recognizes safe tool handling during drilling and fastening
☐ Observes safe practices during lifting and weight placement
☐ Notes hazards (sharp edges, pinch points, falling objects)

Final Step
☐ Acknowledges completion of Steel Roof Addition Form process

Do | Assisted Execution

In this portion of the training, the CRT will perform the full roof replacement while the trainer observes and provides direct, hands-on support. The trainer will intervene as needed to guide, correct, or demonstrate proper techniques, ensuring the repair is completed correctly and safely. Emphasis will be placed on following the proper sequence of steps, using tools appropriately, and maintaining strict adherence to all safety requirements throughout the process.

***Best Practice:** The trainer may read the steps aloud during the repair to reinforce the correct sequence and help the CRT stay aligned with the procedure in real time.

Review | Evaluation

You will be evaluated on your adherence to the critical procedures and all safety guidelines.

Reference | PODS Steel Retro Roof Installation Instructions

Tools Needed	Materials Needed	Personal Protective Equipment (PPE)

• Drill
• 3/8” Impact Driver
• 19/64” Drill Bit (Heavy Duty, P/N RDB101)
• 21/64” Drill Bit (Heavy Duty, P/N RDB100)
• 9/16” Socket
• 3/4” Socket
• #3 Phillips Bit
• Torque Wrench (10–50 ft-lbs and 100–600 in-lbs range)
• Pry Bar
• Dead Blow Mallet
• Caulk Gun
• Scraper
	• 16’ Steel Roof – PPL116STL-1
	• 12’ Steel Roof – PPL112STL
	• 7’ Steel Roof – PPL108STL
	• Steel Corner Bumpers (4) – PFA119
	• Self-Tapping Screws 3/8” x 2” (8) – PFA113
	• Flat Head Screws (8) – PFA121 (Fastenal #1132511)
	• Plastic Spacers:
	  ○ ½” – PFA115
	  ○ ¾” – PFA116
	• Loctite 243 Thread Locker
		• Steel-toed shoes
		• Safety glasses
		• Bump cap
		• Cut-resistant gloves
		• Hearing protection
		• Full face shield
		•

Steel Roof Installation Procedure

1. Remove Existing Roof

- Remove roof bolts from the plastic roof using an impact driver and ¾" socket.
- Lift plastic roof off container using a forklift.

2. Clean Surface

- Scrape old roof tape off the container.

3. Remove Hardware

- Remove dome straps and springs from the top of the beams.

4. Seal Corners

- Apply caulk to gaps on the top two corners of the header.

5. Position Steel Roof

- Carefully place the steel roof onto the container.

6. Cor-Ten Steel Notes

- Cor-Ten steel forms a protective oxide layer that resists corrosion.
- No treatment is required before installation.

Optional Cosmetic Touch-Up (White Appearance):

- Clean surface with soap and water only
- Steps: Wash → Rinse → Wipe → Spray (Rustoleum Gloss White) → Dry
- Materials:
  - PODS cleaner
  - Rustoleum Gloss White spray paint
  - Rag

7. Center the Roof (CRITICAL)

- Roof must be centered on all sides.
- Use a crowbar and spacers to ensure equal spacing:
  - Side-to-side
  - Front-to-back
- Remove spacers before drilling.
- Note: Container widths vary—select correct spacer size.

8. Apply Weight (CRITICAL)

- Place a secondary container **(minimum 5,000 lbs.)** on top.
- Perform internal inspection to confirm gasket is fully compressed.

9. Drill Mounting Holes

- Drill **21/64" holes** into the container frame using roof pre-punched holes as guides.

Critical Requirements:

- MUST use 21/64" drill bit
- Holes must be perfectly round (not elongated)
- Keep drill straight
- Use water mist to ease drilling

Do NOT: Drill holes for corner bumpers at this step

10. Select Spacers

- Choose proper spacer length (½" or ¾") based on container width variation.

11. Apply Thread Locker

- Apply Loctite 243 to bolt threads before installation.

12. Install Roof Bolts

- Install bolts using an impact driver with correct spacers between roof and angle iron.

Torque Requirement:

- All hex bolts MUST be torqued to **25 ft-lbs**

Do NOT: Install corner bumpers during this step

13. Adjust Roof Fit

- Use a dead blow mallet to adjust corners and close any gaps between sides and ends.

Steel Corner Bumper Installation Procedure

14. Drill Pilot Hole (If Needed)

- If holes are not pre-punched:
- Hold bumper in place
- Drill **21/64” pilot hole through roof only**

Important: Do NOT drill into container frame in this step

15. Drill Frame Hole

- Drill **19/64” hole through container frame** for mounting screw

16. Insert Spacer

- Insert ½” spacer between roof and frame aligned with hole

17. Apply Thread Locker

- Apply Loctite to threads

18. Install Corner Bumpers

- Use impact driver with #3 Phillips bit
- Install bumpers on all four corners using pan head screws

19. Documentation

- Complete Shop Floor Tracker with secondary sign-off by Manager or Lead
- Complete the Steel Roof Addition Form
- Email to: **assetmanagement@pods.com**
- This ensures the container is recorded as having a steel roof