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	Work Instructions: Drip Rail Modification		
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1.0 Product Affected

All 12' wide Blast Resistant buildings

2.0 Serial Numbers

BR4012XXXXX
BRF4012XXXXX
BRMS4012XXXXX
BRMSF4012XXXXX

3.0 Reason for Procedure

With the current configuration of the drip rail and exterior lighting on all 12' wide buildings (with the exception of 12' wide center sections), the units are over 12' wide. The drip rail and the exterior lighting are being modified to keep the building within 12'.

This will eliminate the additional costs associated with transporting these units.

4.0 Description

These work instructions will cover the process of modifying the permanent welded drip rails to detachable drip rails and modifying the exterior lighting fixtures and mounts.

5.0 Forms


Drip Rail Installation Instructions

6.0 Time on Task (Total Hours)

4 hours

7.0 PPE - Personal Protective Equipment

- Hard Hat
- Safety Glasses
- Steel Toe Boots
- Leather Gloves
- Face Shield
- Welders Jacket with Leather Sleeves
- Leather Welders Apron
- Hearing Protection

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8.0 Tools Needed

- Ladder/Work Platform
- Metabo 6" angle grinder
- Drill
- Impact Driver
- 5/16" Bit for Impact Driver
- Wire Cutters/Strippers
- Multi-meter
- # 2 Phillips Screwdriver
- Marson 325-RN Hand Rivet Nut Tool
- 7/16" Wrench or Socket


9.0 Supplies & Parts Needed

9.1 Supplies

- Drip Rail Drilling Jig
- Walter A-60-ZIP 6" Cutoff Wheel
- Walter 08-B-600 36 Grit 6" Grinding Stone
- Norton Neon R766 - 6" 36 Grit Flap Disc
- 25/64" Drill Bit
- Wilco 497.35 Quick Dry Red Primer
- Wilco 144.146 Cherry Red Spray Paint
- Marson M95637 ¼" - 20 Threaded Mandrel
- Denatured Alcohol
- Terry Towels
- Cutting Fluid

9.2 Parts

- 01-5201 – qty. 2, Drip Rail (Finished Part)
- 16-6765 – qty. 4, LED Drip Edge Light
- 17-7258 – qty. 8, Rivet Nut
- 17-7262 – qty. 8, ¼" - 20 X 1" Hex Cap Stainless Steel Bolt
- 17-7279 – qty. 8, ¼" Large O.D. Stainless Steel Washer
- XX-XXXX – qty. 1, Drip Rail Installation Instructions.
- Qty. 1, 4" Zip Tie

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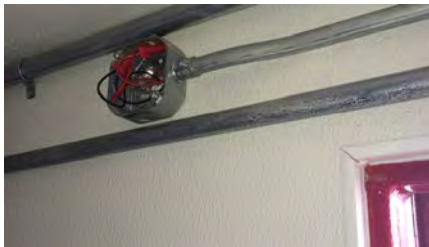
10.0 Procedure

10.1 Turn off power and lockout exterior lighting circuit.

10.2 Remove existing LED lights and wiring.




10.3 Remove old wiring from the junction box in interior of unit.



10.4 Drill 25/64" hole 1 1/2" centered below the tab all the way through the junction box inside.



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10.5 Cut off and grind down old lighting support tabs so they are at least 1/8" to 1/4" shorter than the widest point of the building.

10.5.1 Make sure to round the corners and edges of the tabs.




10.6 Remove existing drip rail with 6" cut off wheel.



10.7 Use 36 grit grinding stone to even out the cut.

10.8 Use 36 grit flap disc to smooth surface before painting.

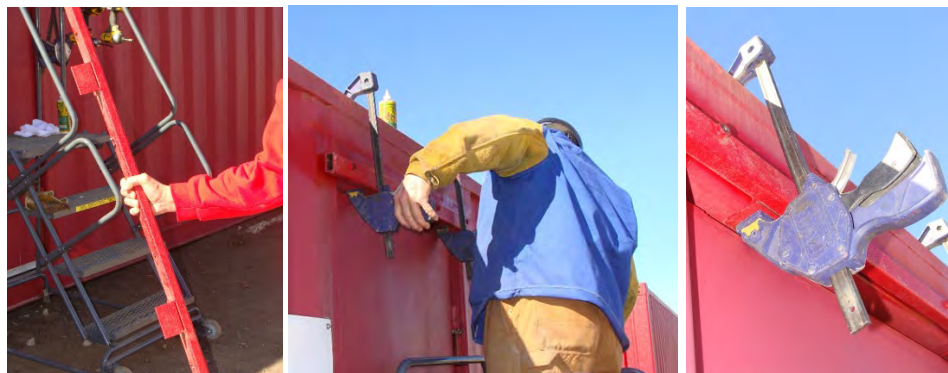



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- 10.9 Remove all debris and slag from the cut edges and surrounding area.
- 10.10 Prep area to be painted with denatured alcohol and allow to dry.
- 10.11 Spray all bare metal with Wilko 497.35 quick dry red primer and allow to dry.
- 10.12 Once primer is dry spray area with Wilko 144.146 cherry red paint and allow to dry.



- 10.13 Once paint is dry, center drilling jig on the top frame above the door and hold in place with two clamps.



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10.14 Drill four (4) 25/64" holes into top of door frame.

10.14.1 Make sure to use cutting fluid to extend the life of the drill bit.



10.15 Remove jig and wipe down holes to remove debris and oil.

10.16 Attach rivet nut to stud setting tool.




10.17 Use caution when tightening rivet nuts, do not over tighten or under tighten.

10.18 Adjust tool each time you insert a rivet nut to make sure it is tightened accordingly.

10.18.1 If tool is held at an angle or not set correct when setting the rivet nut, the mandrel will break.



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10.19 Install weather stripping on drip rail.

10.20 Once all rivet nuts are set, attach the drip rail to ensure fit and function.

10.20.1 Use caution when tightening bolts, do not over tighten and strip out the bolts or rivet nuts.


10.20.2 If rivet nut is stripped or galled, replace with new one.



10.21 Remove drip rails and reinstall bolts and washers. Make sure they are snug.



10.22 Attach drip rail installation instructions with zip tie and place in building.

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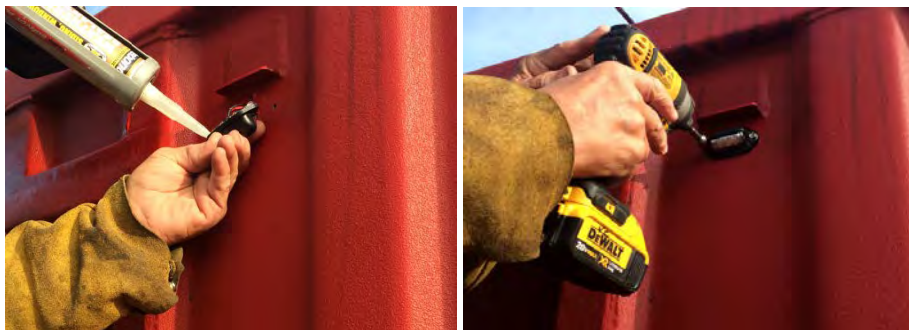
10.23 Use a fish rod to pull wiring for new exterior light into junction box in unit.



10.24 Mount new exterior light.


10.24.1 Use silicone to seal penetration and all holes.

10.24.2 Make sure light is level, centered and square.



10.25 Trim off excess wire and make connections to 12V supply side of transformer, red wire to red wire – black wire to black wire.



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10.26 Ensure lighting is operational. Refer to section 11.0 for testing procedure.




10.27 Close all junction boxes.



10.28 Finished Modification



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11.0 Testing Procedure- Exterior Lighting

- 11.1 Apply power to unit.
- 11.2 Remove lockout from exterior lighting circuit and turn on.
- 11.3 Check function of both exterior lights and that all lights on LED module are lit.
- 11.4 If exterior light module does not have all LEDs lit, replace module.
- 11.5 If light not functioning at all.
 - 11.5.1 Check all connections and breakers (wire nuts etc....).
 - 11.5.2 Check output voltage of transformer. Should be 12VDC.
 - 11.5.3 Check input voltage of transformer. Should be 110VAC.
 - 11.5.4 If input voltage of transformer does not measure 110VAC, check wiring and connections.
 - 11.5.5 If input voltage of transformer measures 110VAC and you are not getting an output voltage of 12VDC, the transformer is bad and will need to be replaced.

12.0 Additional Information

N/A

13.0 Revision History

Revision	Description of Change	Revision Date	Approved by
NC-New	Drip Rail Modification Work Instructions	5.10.2016	Paul New