**STEP ONE**
- Cut tube free from inside wall

**STEP TWO**
- Repair surface to be welded

**STEP THREE**
- Place GME stack tube at the specified location

**STEP FOUR**
- Stack tube to end of shield 3/16" x 3/8" x 8

**GENERAL STACK TUBE RELOCATION SPECIFICATION:**
This specification applies to the following types of trench shields: 3M, 4L, 4M, 6M, 8M, T, E, N, K, and LD

**SPECIFICATIONS:**
- All welding shall be performed according to the Structural Welding Code for Steel - AWS D1.1-90.
- A certified welder shall perform all welding.
- 70,000 psi welding rod or wire shall be used to complete the welds.
- 3/16" steel sheet with a 55,000 psi minimum yield strength shall be used to replace the skin plate cut away from the collars.
- The Stack tube shall be manufactured by GME.

**PROCEDURE:**
1. Cut off GME stack tube located on the inside skin of the shield.
2. Repair any holes on the skin that may have occurred during the cutting process. Once hole(s) are welded closed, clean the area thoroughly with a wire brush or grinding wheel.
3. Clean the area to be welded thoroughly with a wire brush or grinding wheel.
4. Weld the replacement stack tube to the end of the shield, using a all around 3/16" fillet weld.

**NOTE:**
In accordance with OSHA regulations, a Registered Professional Engineer must observe and provide written confirmation that the above specification has been followed as authorized by the factory or the Tabulated Data will no longer be valid.