STEP ONE

EXISTING STACKING HARDWARE

STEP TWO

PREPAIR SURFACE TO BE WELDED

GENERAL STACK LUG ASSEMBLY SPECIFICATION
This specification applies to the following types of trench shields 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 D11-90.
- A certified welder shall perform all welding.
- 70,000 psi welding rod or wire shall be used to complete the welds.
- The Stack Lug shall be manufactured by GME.

PROCEDURE:
STEP ONE
Remove existing stacking hardware if required. Contact factory if shield is damaged during this procedure.

STEP TWO
Clean the area to be welded thoroughly with a wire brush or grinding wheel.

STEP THREE
Locate stack lug in required position. All lugs shall be located 1/2" from the top of the shield and may be placed in the following position:
A. End of the shield and centered.
B. End of the shield flush with inside face (as shown in step three)
C. Inside face next to the recessed lift lug.

STEP FOUR
Weld stack lug to the shield using a continuous 3/16" fillet weld.

STEP THREE
INSIDE WALL

END

STACK LUG TO SHEILD

3/16"