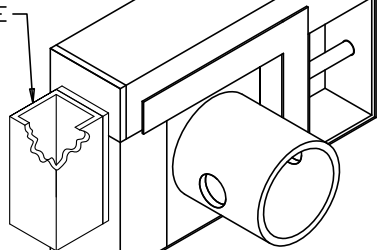


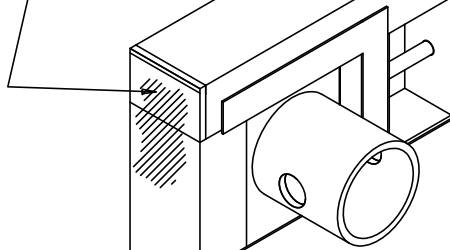
### STEP ONE

EXISTING STACKING HARDWARE



### STEP TWO

PREPAIR SURFACE TO BE WELDED



### GENERAL STACK TUBE 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 D1.1-90.
- A certified welder shall perform all welding.
- 70,000 psi welding rod or wire shall be used to complete the welds.

### 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 tube in required position. All stack tubes 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 (as shown in step three)
- B. End of the shield flush with inside face
- C. Inside face next to the recessed lift lug.

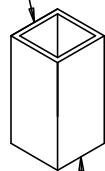
#### STEP FOUR

Weld stack tube to the shield using a continuous 3/16" fillet weld.

### STEP THREE

PLACE GME STACK TUBE AT THE SPECIFIED LOCATION

1/2"



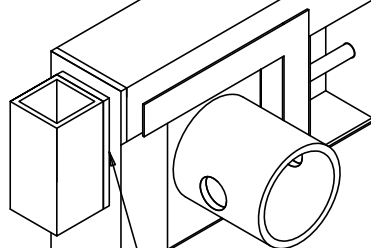
1/2 PLATE 4 X 8 (ASTM A36)

TS 4 X 4 X 3/8 X 8 (ASTM A500 GRD. B)

INSIDE WALL

END

### STEP FOUR



TUBE TO PLATE AND PLATE TO SHIELD

3/16"

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**GME**

**GRISWOLD**  
MACHINE AND ENGINEERING, INC.  
UNION CITY, MICHIGAN 49094

SCALE: AS SHOWN  
DWN: BPS

**2004 STACK TUBE ASSEMBLY**

DATE: 04/28/04

DRAWING NO. REPAIR 005

REV. NO. 0

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