**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.
- 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.