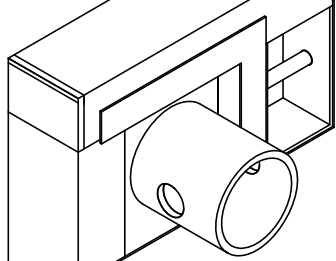


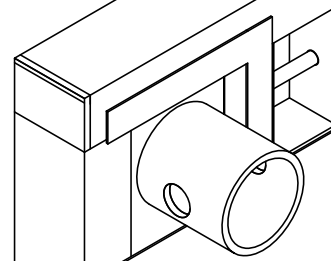
STEP ONE

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:

- End of the shield and centered (as shown in step three)
- End of the shield flush with inside face
- Inside face next to the recessed lift lug.

STEP FOUR

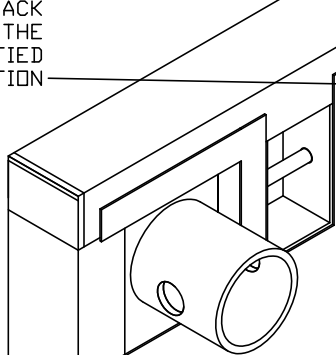
Weld stack tube to the shield using a continuous 3/16" fillet weld.

NOTE:

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

STEP THREE

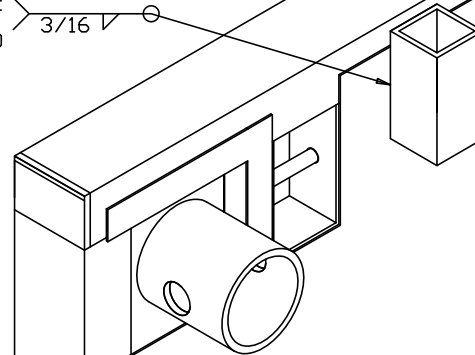
PLACE STACK TUBE AT THE SPECIFIED LOCATION



TS 4 X 4 X 3/8 X 8

STEP FOUR

STACK TUBE TO END OF SHIELD



THIS PRINT ISSUED BY GRISWOLD MACHINE AND ENGINEERING, INC. UPON REPRESENTATION THAT IT WILL BE RETAINED IN CONFIDENCE NEITHER TO BE DUPLICATED NOR EXHIBITED EXCEPT TO FACILITATE USE OR MANUFACTURE OF GRISWOLD PRODUCTS.

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

SCALE: AS SHOWN
DWN: BPS

SB STACK TUBE REPAIR

DATE: 04/12/07

DRAWING NO. REPAIR 015 REV. NO. 0 PAGE 1 of 1