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.

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.