**GENERAL PIT KIT 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 pit kit 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 pit kit tube in required position. Refer to Subkeit manual for any and all pit kit locations for model of shield in repair.

**STEP FOUR**
Weld pit kit tube to the shield using a continuous 3/16" fillet weld.

**STEP THREE**
PLACE GME PIT KT TUBE AT THE SPECIFIED LOCATION

**STEP FOUR**
3/16" TUBE TO FRAME

**PREPAIR SURFACE TO BE WELDED**

**STEP ONE**
EXISTING PIT KIT HARDWARE

**STEP TWO**
TS 4 X 4 X 3/8 X LENGTH (ASTM A500 GRD. B)

**STEP FOUR**
INSIDE WALL