

Repair Specification: Liner Collar

GENERAL COLLAR REPAIR SPECIFICATION:

This specification applies to the following types of trench shield

3M, 4L, 4M, 6M, 8M, T, E, N, K, AND LD

- 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.
- 3/16" steel sheet with a 55,000 psi minimum yield strength cut away from the collar
- The Replacement Collar shall be manufactured by GME.

PROCEDURE:

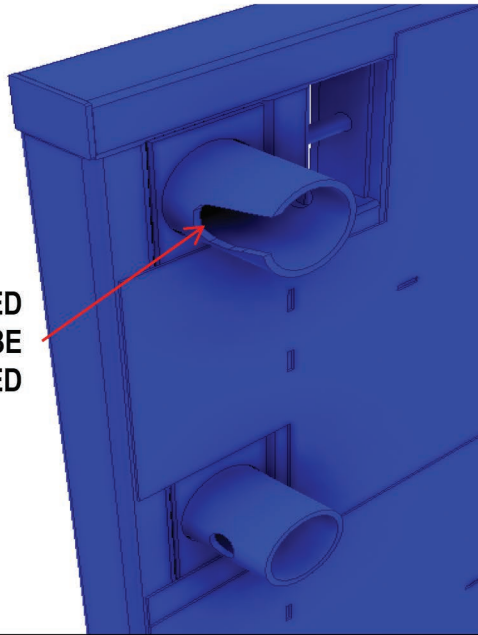
1. Identify collar that needs replacing.
2. Cut old collar out, being careful not to cut into the vertical tubes. Clean the area to be welded thoroughly with a wire brush or grinding wheel.
3. Insert assembly into collar opening in frame, making sure in leaving a gap between frame and outer pipe (collar) to insure full penetration weld.
4. See details in step four illustration for gap and welding details.



Drawing No: REPAIR-017

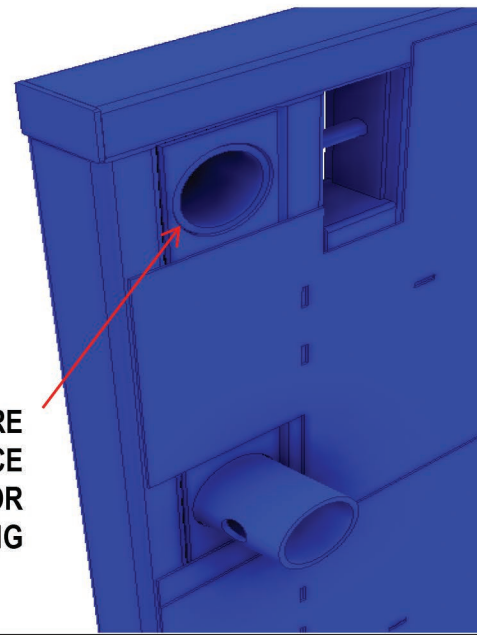
STEP ONE

DAMAGED COLLAR TO BE REPLACED



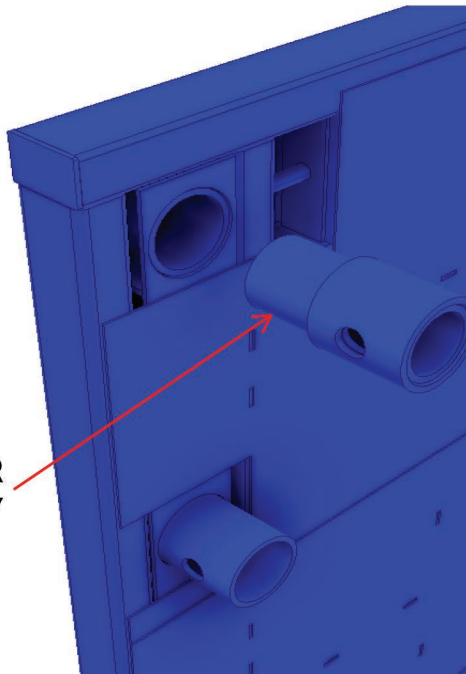
STEP TWO

PREPARE SURFACE FOR WELDING



STEP THREE

LINER COLLAR ASSEMBLY



STEP FOUR

FULL PIPE TO FRAME

1/2 INSIDE PIPE

