Repair Specification: Liner Collar

**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**

**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.

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TRENCH PROTECTION SPECIALISTS
A DIVISION OF TRINITY SHORING PRODUCTS, INC.

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