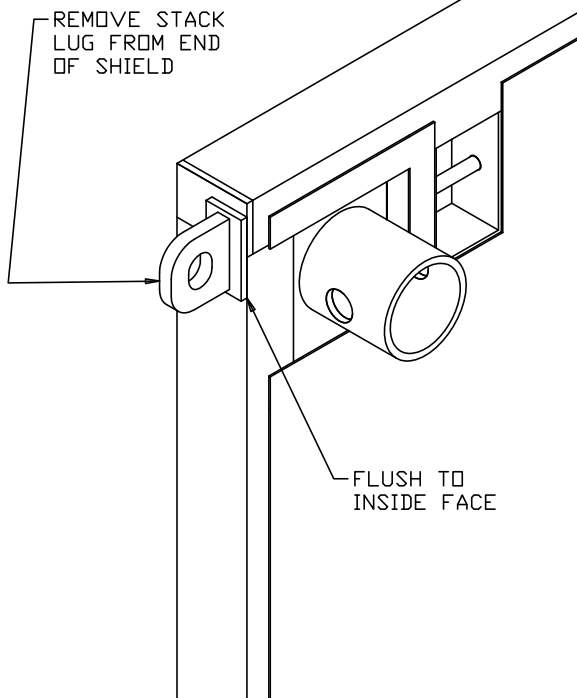
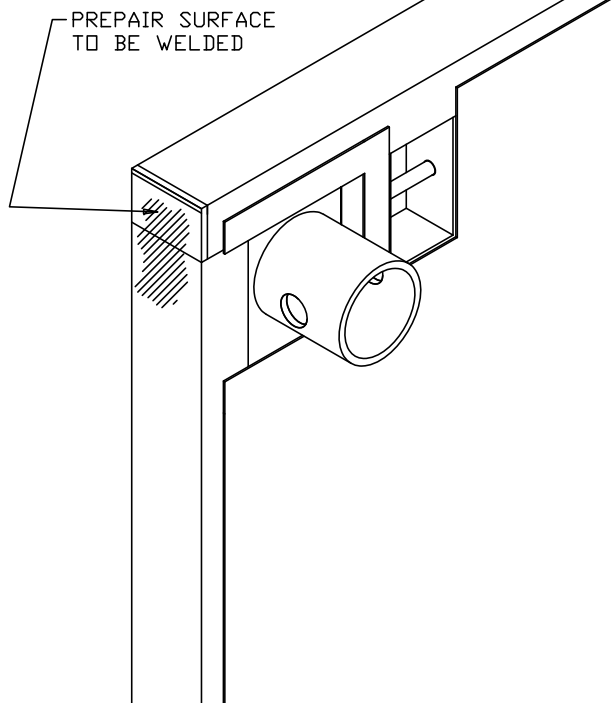


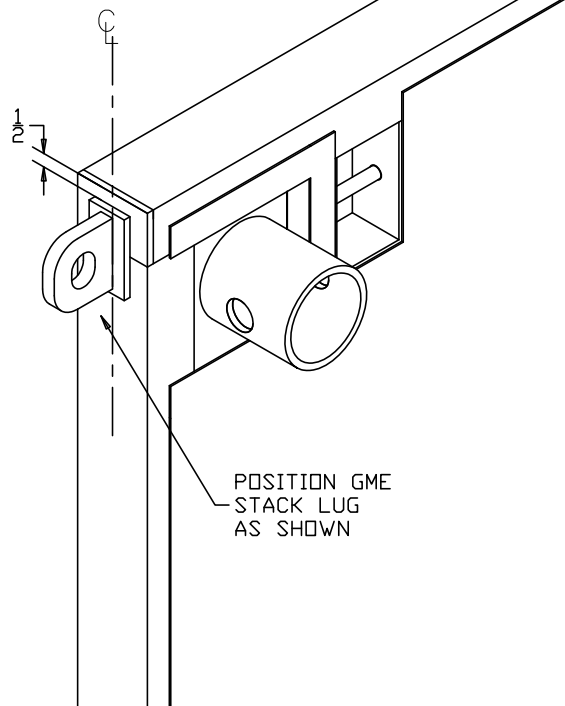
STEP ONE



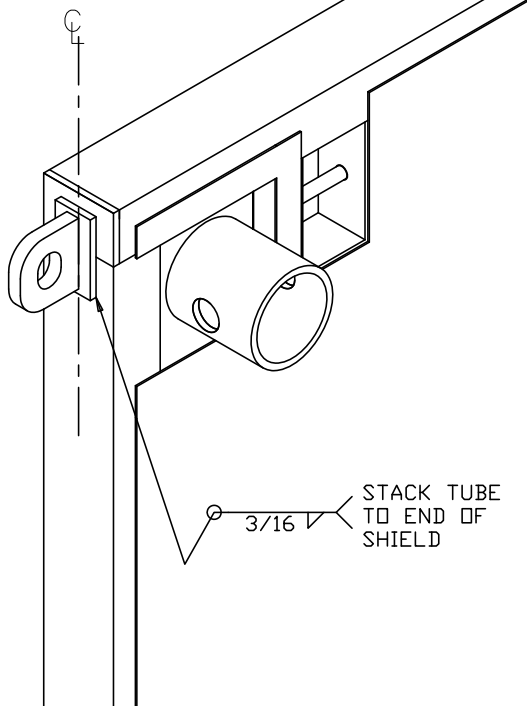
STEP TWO



STEP THREE



STEP FOUR



GENERAL STACK LUG RELOCATION 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.
- The Stack Lug shall be manufactured by GME.

PROCEDURE:

1. Carefully remove GME stack lug located on the outside vertical, flush to inside face of Trench shield. If the vertical member is damaged during the removal process, contact the factory.
2. Clean the area to be welded thoroughly with a wire brush or grinding wheel.
3. Weld the GME stack lug to the end of the shield centered on outside vertical end member, as shown, using a all around 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.

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

SCALE: AS SHOWN	2003 STACK LUG RELOCATION		
DWN: BPS	DATE: 12/10/03	DRAWING NO. REPAIR 003	REV. NO. 0
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