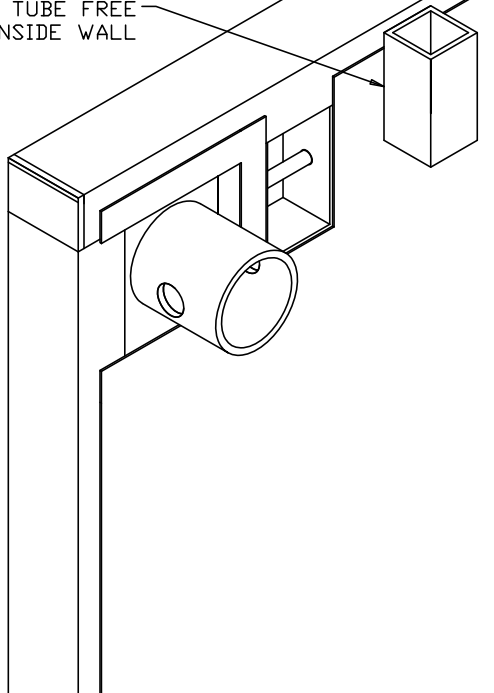


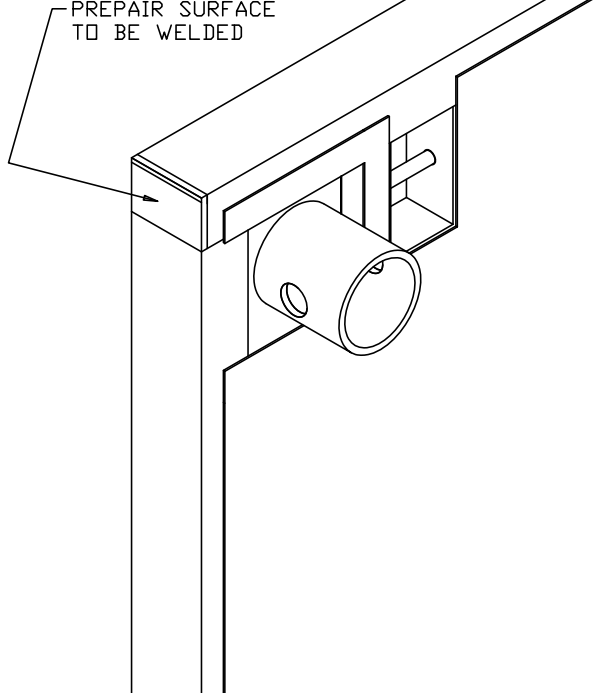
STEP ONE

CUT TUBE FREE FROM INSIDE WALL



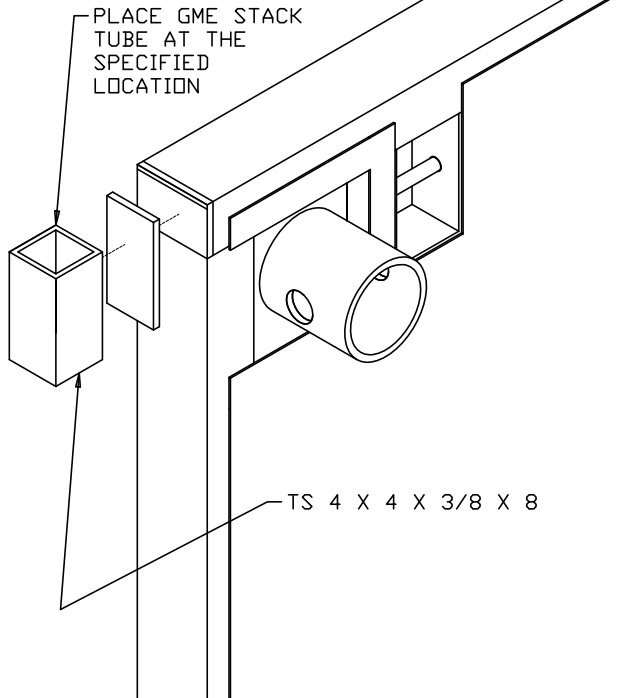
STEP TWO

PREPAIR SURFACE TO BE WELDED



STEP THREE

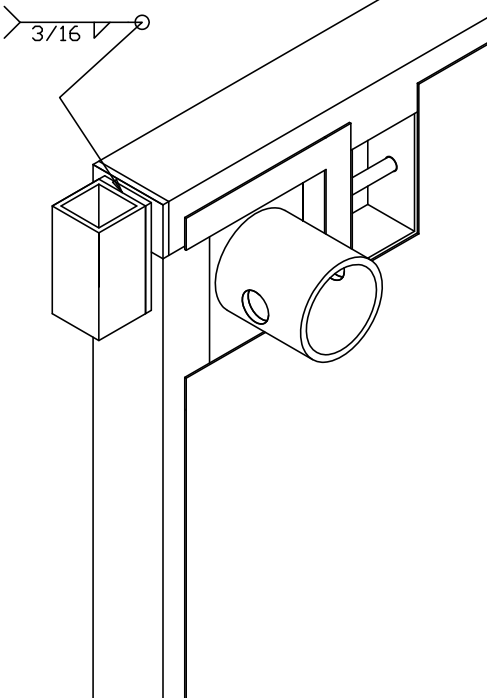
PLACE GME STACK TUBE AT THE SPECIFIED LOCATION



TS 4 X 4 X 3/8 X 8

STEP FOUR

STACK TUBE TO END OF SHIELD



3/16"

GENERAL STACK TUBE RELOCATION SPECIFICATION:

This specification applies to the following types of trench 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.
- 3/16" steel sheet with a 55,000 psi minimum yield strength shall be used to replace the skin plate cut away from the collars.
- The Stack tube shall be manufactured by GME.

PROCEDURE:

1. Cut off GME stack tube located on the inside skin of the shield.
2. Repair any holes on the skin that may have occurred during the cutting process. Once hole(s) are welded closed, clean the area thoroughly with a wire brush or grinding wheel.
3. Clean the area to be welded thoroughly with a wire brush or grinding wheel.
4. Weld the replacement stack tube to the end of the shield, using an all around 3/16" fillet weld.

NOTE:

In accordance with OSHA regulations, a Registered Professional Engineer must observe and provide written confirmation 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
DWN: BPS

**200 STACK TUBE
RELOCATION**

DATE: 12/10/03

DRAWING NO. REPAIR 002

REV. NO. 0

PAGE 1 OF 1