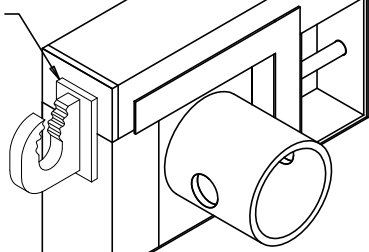


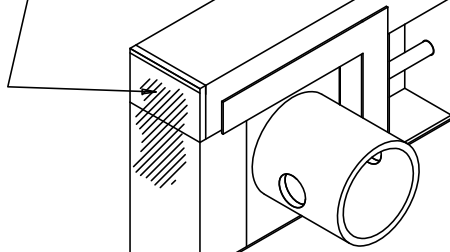
STEP ONE

EXISTING STACKING HARDWARE



STEP TWO

PREPAIR SURFACE TO BE WELDED



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

PROCEDURE:

STEP ONE

Remove existing stacking 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 stack lug in required position. All lugs shall be located 1/2" from the top of the shield and may be placed in the following position:

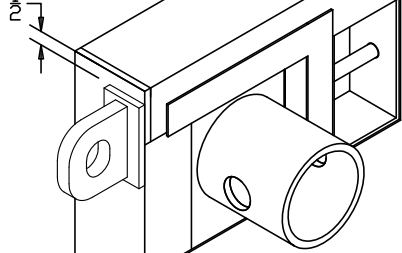
- A. End of the shield and centered.
- B. End of the shield flush with inside face (as shown in step three)
- C. Inside face next to the recessed lift lug.

STEP FOUR

Weld stack lug to the shield using a continuous 3/16" fillet weld.

STEP THREE

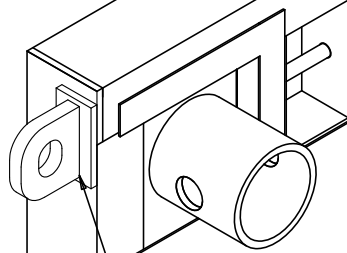
1/2"



INSIDE WALL

END

STEP FOUR



3/16" STACK LUG TO SHIELD

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

SCALE: AS SHOWN
DWN: BPS

2004 STACK LUG ASSEMBLY

DATE: 04/28/04

DRAWING NO. REPAIR 004

REV. NO. 0

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