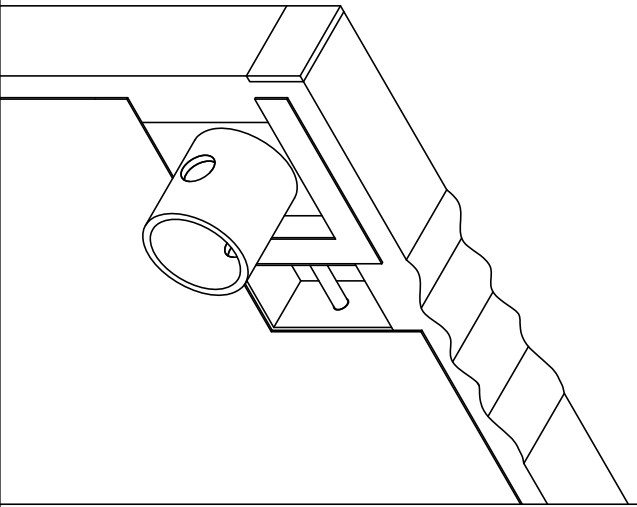
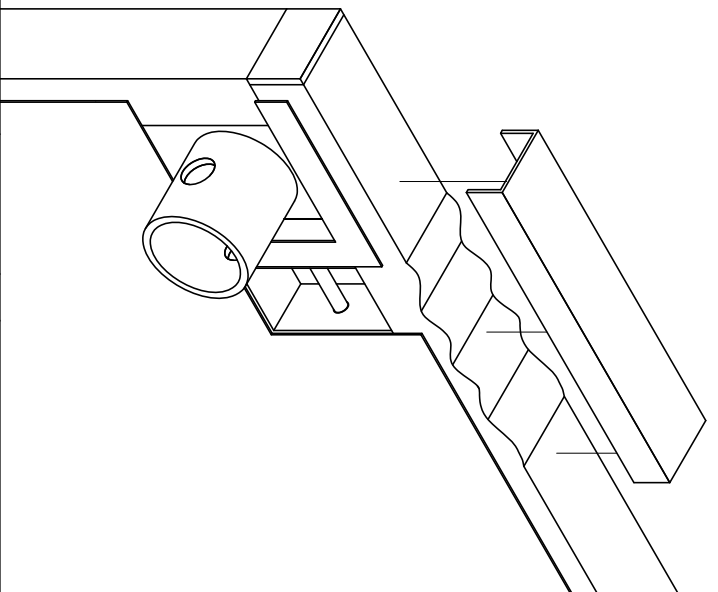


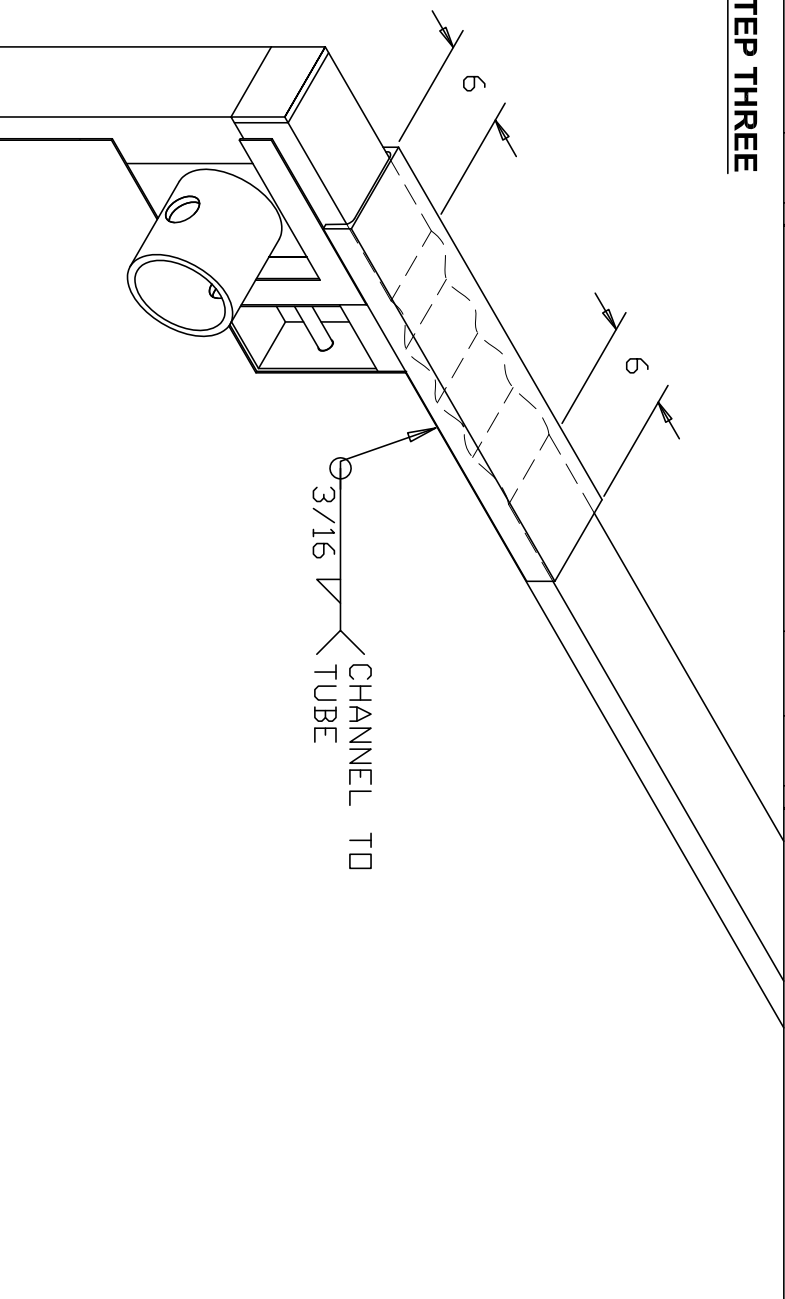
STEP ONE



STEP TWO



STEP THREE



GENERAL TUBE REPAIR SPECIFICATION:
This specification applies to the following types of trench shields shields:

- 4L, 4M, 6M, 6H, 8M, 8H, T, E, N, K, and LD

CHANNEL SIZE REQUIRED

4L, 4M, N, E	C5 X 9 CHANNEL
6M, 6H, K	C7 X 12.5 CHANNEL
8M, 8H, LD	C9 X 15 CHANNEL

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.
- C-Channel shall be Fy=50ksi material.

PROCEDURE:

1. Inspect tube make sure tube is can be capped or formed back in place. If skin plate is damaged, consult factory.
2. Determine length of the channel required. Overlap damaged area by a minimum of six inches on each end.
3. Weld channel to damaged tube using a continuous 3/16 fillet weld as shown.

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GRISWOLD MACHINE AND ENGINEERING, INC.
UNION CITY, MICHIGAN 48094

SCALE: AS SHOWN
DWN: BPS

DATE: 10/09/08

TOP TUBE REPAIR SPECIFICATION

DRAWING NO. REPAIR 006
REV. NO. 0
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