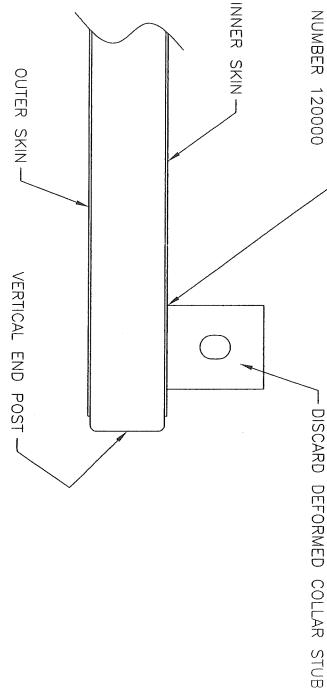


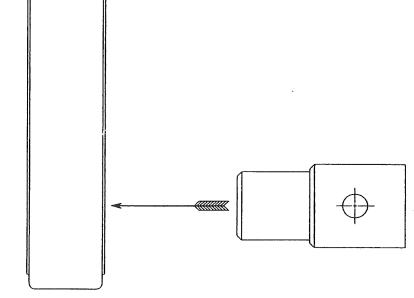
CUT COLLAR OFF FLUSH WITH INNER SKIN
ON SHIELDS AFTER SERIAL NUMBER 120000
AND FLUSH WITH FRAMING TUBES ON
SHIELDS BEFORE SERIAL NUMBER 120000



STEP 1: CUT OFF AND DISCARD DAMAGED COLLAR

S.O.# N/A PAGE:	PSF=N/A TYPE "C-60" SOIL	DRAWN BY Bruce Cates	DWG. # WELDINST	DATE 2-1-01	685 HULL RD. MASON MI. 48854	EFFICIENCY
COLLAR REPAIR KITS	INSTRUCTIONS FOR	STANDARD WELDING	הווכוכווכץ טועוועעועט	Efficiency Standards	685 HULL RD. WASON MI. 48854 Ph. (517)-676-8800 Fax (517) 676-0373	PRODUCTION INC.



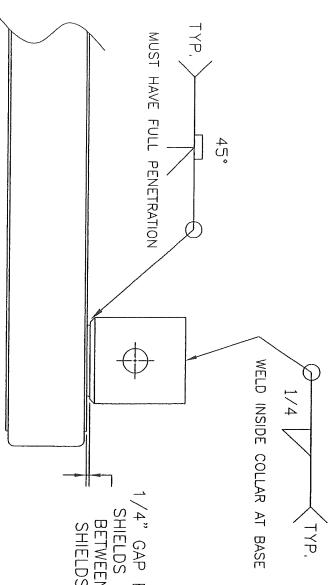


STEP 2: INSERT COLLAR REPAIR KIT INTO EXISTING COLLAR AND ALIGN HOLES OF COLLARS WITH EACH OTHER

685 HULL RD. MASON MI. 48854	EFFICIENCY
-	PRODUCTION
676-0373	NC.

DATE 2-1-01	
DWG # WEI DINST	בווכוסווכי טועוועעועט
F	
DRAWN BY Bruce Cates	WIANDARD WELDING
PSF=N/A TYPE "C-60" SOIL	INSTRUCTIONS FOR
S.O.# N/A PAGE:	COLLAR REPAIR KITS





74" GAP BETWEEN COLLAR AND INNER SKIN ON SHIELDS AFTER SERIAL NUMBER 120000 AND BETWEEN COLLAR AND FRAMING TUBES ON SHIELDS BEFORE SERIAL NUMBER 120000

STEP 3: WELD INSIDE AND OUTSIDE OF COLLAR REPAIR KIT

COLLAR REPAIR KITS	S.O.# N/A PAGE:
NSTRUCTIONS FOR	PSF=N/A TYPE "C-60" SOIL
GIANDARD WELDING	DRAWN BY Bruce Cates
רוומכוני) טומוממומט	DWG. # WELDINST
Efficiency Standards	DATE 2-1-01
Ph. (517)-676-8800 Fax (517) 676-0373	685 HULL RD. MASON MI. 48854 F
TICECCIICIA LINC.	
	LANCIPICA D