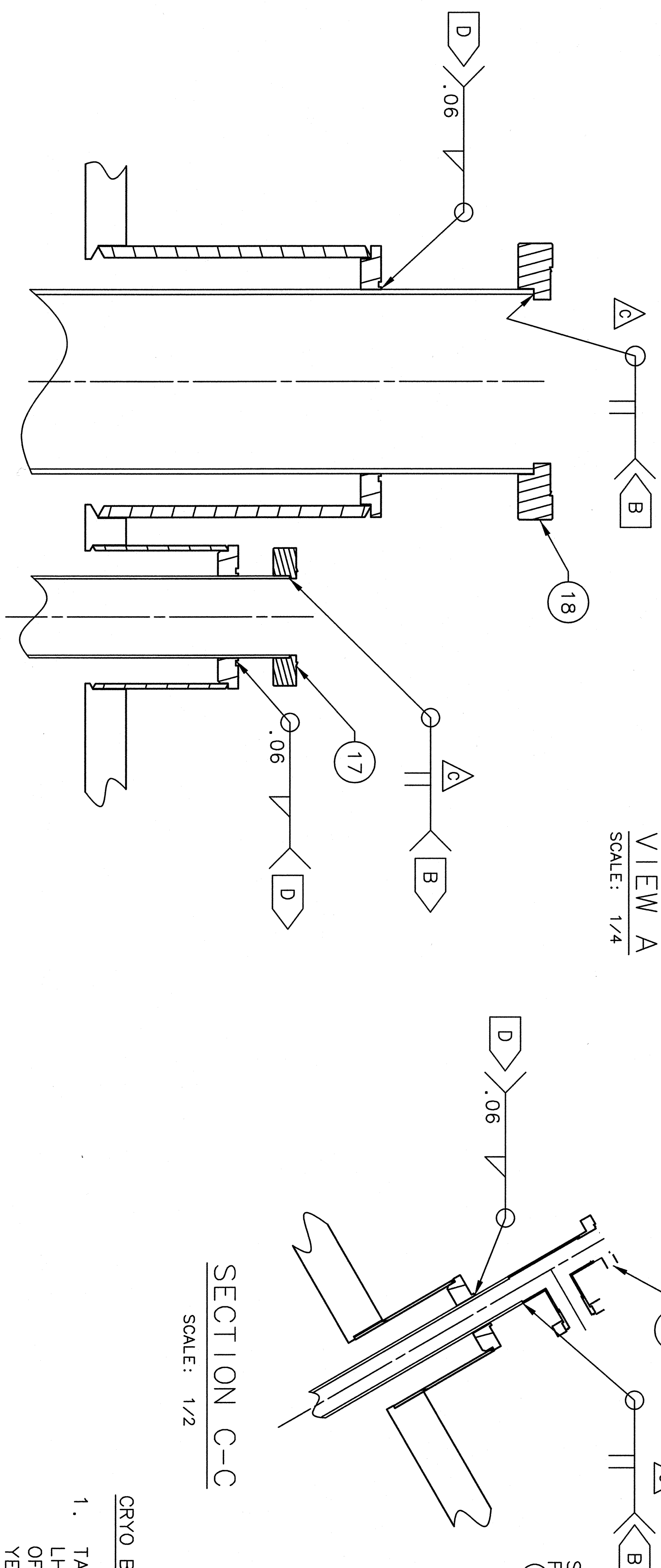
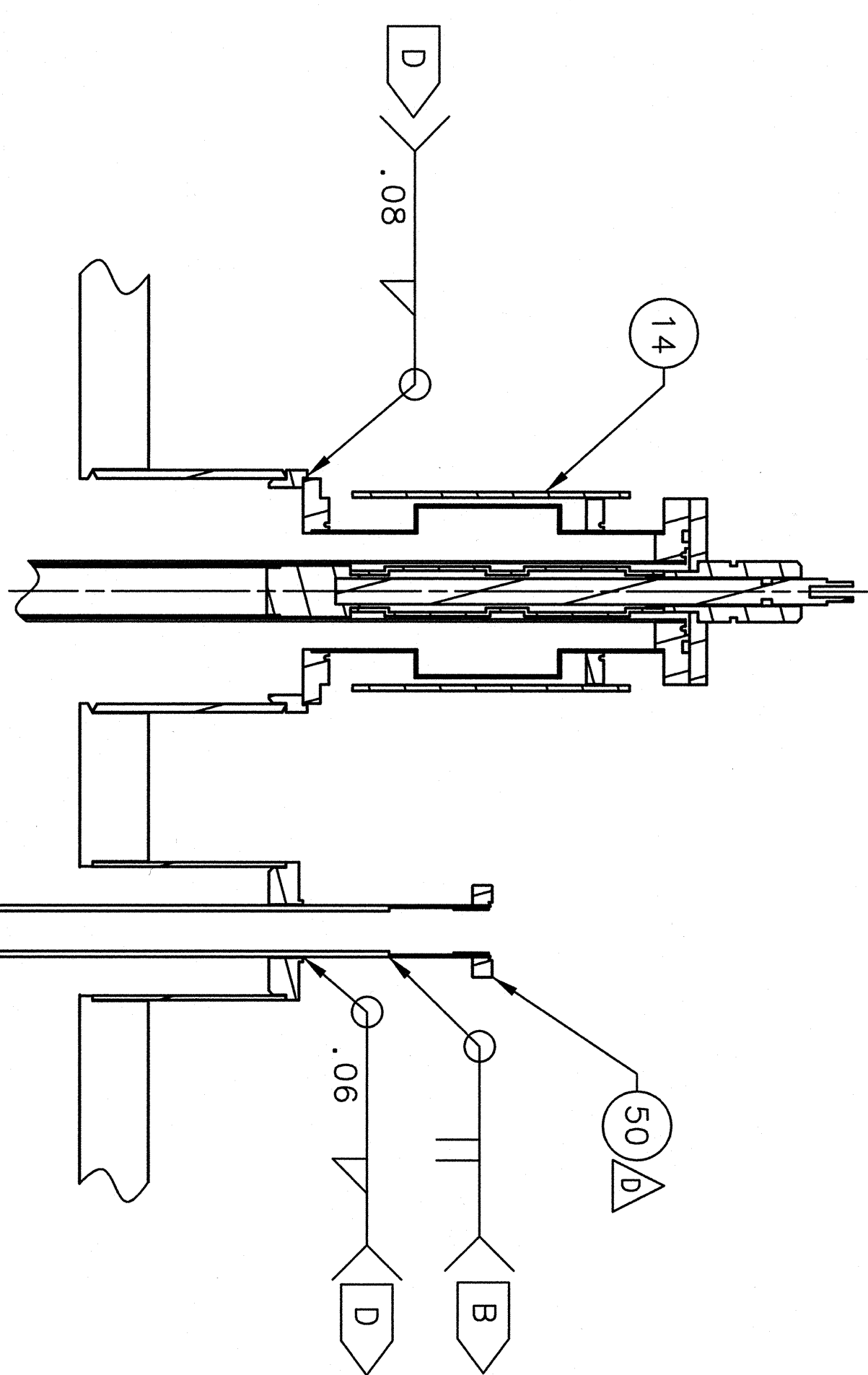


SECTION C-C
SCALE: 1/2



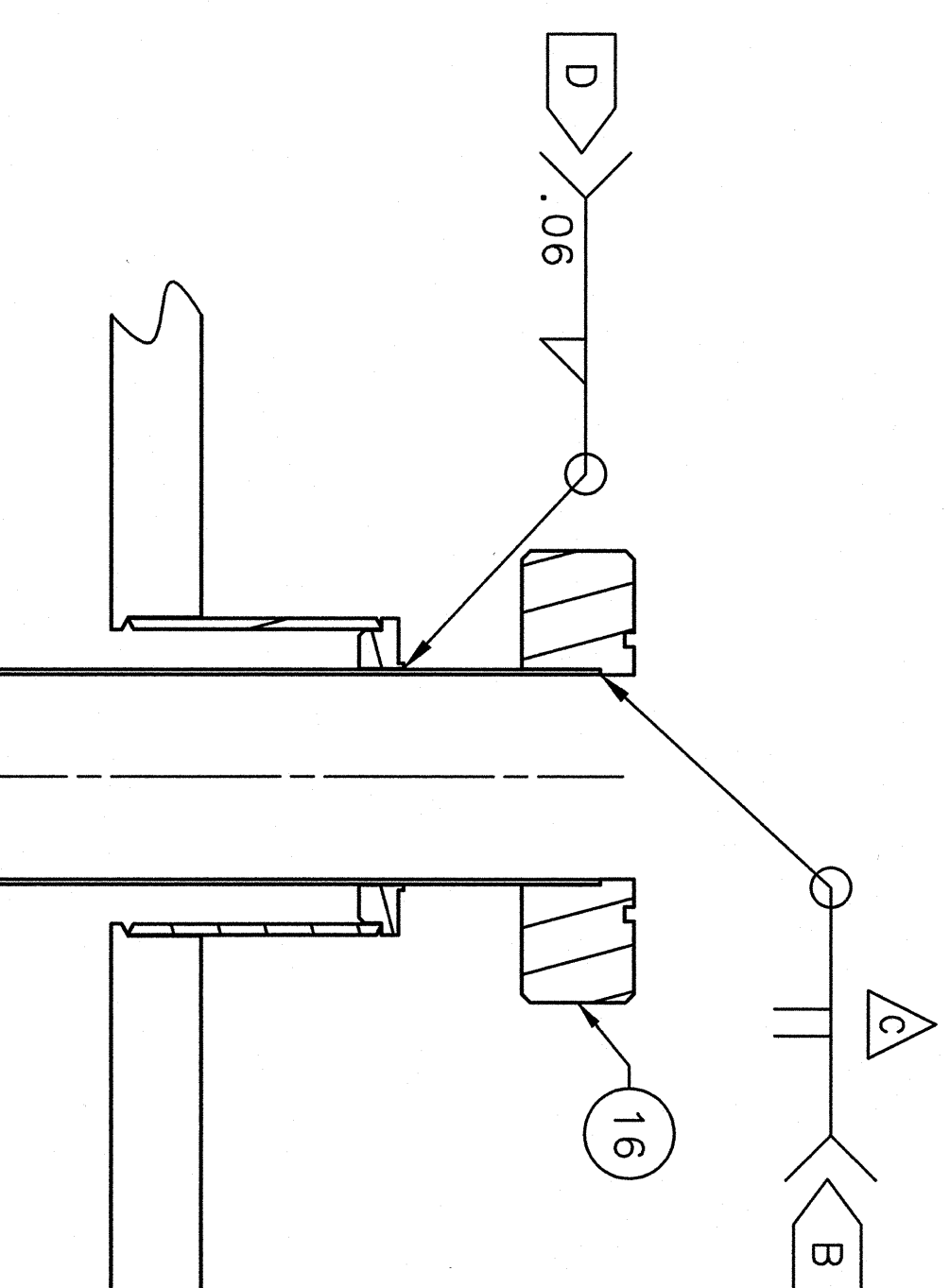
VIEW A
SCALE: 1/4

SECTION B-B
SCALE: 1/2



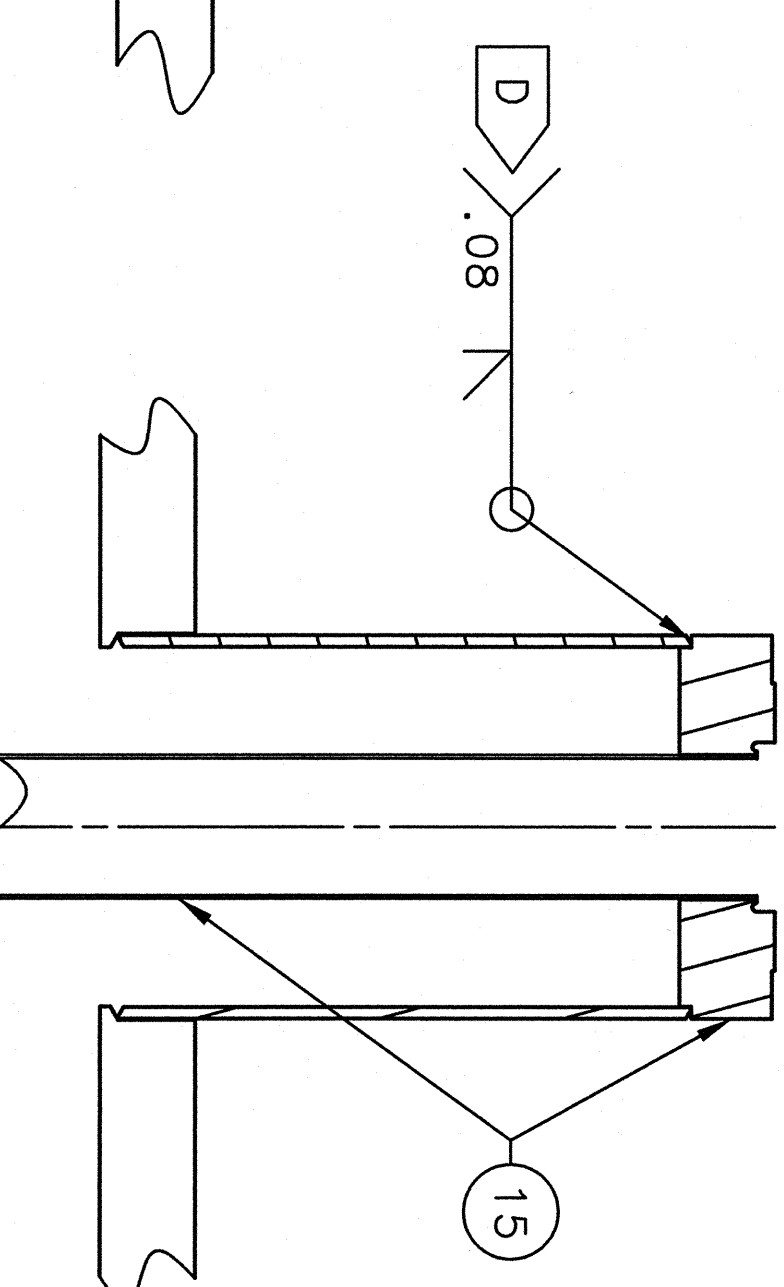
SECTION D-D
SCALE: 1/2

TYPICAL 6 PLACES



SECTION E-E
SCALE: 1/2

TYPICAL 2 PLACES



SECTION F-F
SCALE: 1/2

TYPICAL 4 PLACES

- CRYO BOX ASSEMBLY PROCEDURE - STAGE #1**
1. TAKE ITEM 9 (LN2 GRYO INTERCEPT SHIELD RING) AND SLIDE OVER THE LHe RESERVOIR TOP PLATE NIPPLES AND LHe LIQUID LEVEL GUIDE TUBE OF ITEM 8 (LHe RESERVOIR ASSEMBLY). NIPPLES AND GUIDE TUBE ARE NOT YET WELDED TO ITEM 8 PER DRAWING 67145-00302 (LHe RESERVOIR TOP PLATE WELDMENT)
 2. INSTALL ITEM 2 (CRYO BOX TOP PLATE WELDMENT) OVER THE LHe RESERVOIR TOP PLATE NIPPLES AND LHe LIQUID LEVEL GUIDE TUBE AS SHOWN IN SECTIONS B-B, C-C AND E-E.
 3. INSURE ALIGNMENT OF RESERVOIR NIPPLES AND LHe RESERVOIR LIQUID LEVEL GUIDE TUBE FROM ITEM 8, THRU ITEMS 9 AND 2. WELD NIPPLES AND GUIDE TUBE TO ITEM 2 PER DRAWING 67145-00302.
 4. WELD FLANGES AND FITTING, ITEMS 16, 17, 18 AND 19, TO END OF PIPE NIPPLES AND LHe RESERVOIR LIQUID LEVEL GUIDE TUBE.
 5. ORIENTATION OF ITEM 16 (LHe VOL INTERCONNECT FLANGE) IS CRITICAL AND SHOULD BE POSITIONED AS SHOWN IN VIEW "A". WELD ITEM 16 IN PLACE AS SHOWN IN SECTION E-E.
 6. REMOVE BALL VALVE ASSEMBLY FROM ITEM 15 (1 1/2 FEMALE BAYONET ASSEMBLY) INSTALL VALVE FLANGE (67145-E-00637) AND TUBE (67145-E-00630-8) INTO ITEM 2. ALIGN AND FIT LOWER END OF ITEM 15 TO APPROPRIATE TUBE ASSEMBLIES AROUND ITEM 8 AND WELD IN PLACE. ORIENTATION OF VALVE FLANGE IS CRITICAL AND SHOULD BE POSITIONED AS SHOWN IN VIEW "A". WELD ITEM 15 IN PLACE AS SHOWN IN SECTION F-F.
 7. INSTALL ITEM 14 THROUGH ITEMS 2 AND 9 TO ALIGN AND FIT UP WITH EXTERNAL TUBING AROUND ITEM 8. WELD ADAPTER RING OF ITEM 14 TO ITEM 2 AS SHOWN IN SECTION D-D ALIGN AND FIT LOWER END OF ITEM 14 TO APPROPRIATE TUBE ASSEMBLIES AROUND ITEM 8 AND WELD IN PLACE.
 8. SILVER SOLDER HEAT INTERCEPT RING/TAB OF ITEMS 14 AND 15 TO ITEM 9.
 9. SILVER SOLDER COPPER BRAIDING FROM TWO PIPES OF ITEM 8 TO ITEM 9
 10. EXTREME CARE SHALL BE TAKEN TO PROTECT ALL INSTRUMENTATION WIRING DURING WELDING, SOLDERING AND ASSEMBLY.