



CRYO BOX ASSEMBLY PROCEDURE - STAGE #2

1. TAKE ITEM 7 (LN2 RESERVOIR ASSEMBLY) AND SLIDE OVER ITEM 8 (LHE RESERVOIR ASSEMBLY) TAKING CARE TO INSURE ADEQUATE CLEARANCE BETWEEN LHE RESERVOIR EXTERNAL TUBING AND LN2 RESERVOIR'S INNER CYLINDER.
2. WHILE INSTALLING ITEM 7, SLIDE TUBES FOR LIQUID LEVEL EXTENSION TUBE AND LN2 VENT PIPE THROUGH ITEMS 9 AND 2 AND INSURE ALIGNMENT IN ITEM 2.
3. SECURE ITEM 7 TO ITEM 2 USING THE SUPPORT STRAPS FROM ITEM 7.
4. WELD UPPER END OF LIQUID LEVEL EXTENSION TUBE AND LN2 VENT PIPE TO ITEM 2. THEN WELD FITTINGS ITEMS 19 AND 20 TO THE END OF TUBE/PIPE.
6. VERIFY INTERFACE OF LN2 RESERVOIR PIPING WITH LN2 RESERVOIR TOP PLATE AND WELD IN POSITION AS SHOWN IN SECTION H-H.
7. FABRICATION OPTION TO SILVER SOLDER LN2 COPPER SHIELD (67145-00206) IN POSITION REF LN2 RESERVOIR ASSEMBLY (67145-00200).
8. ALIGN AND WELD LN2 PIPING ASSY #3 (67145-00210) TO LN2 PIPING ASSY #5 (67145-00215) AND LH2 RESERVOIR BASE PLATE WELDMENT (67145-00203) AS SHOWN IN SECTION N-N.
9. ALIGN AND WELD LN2 PIPING ASSY #4 (67145-00211) AS SHOWN IN SECTION M-M.
10. SILVER SOLDER ITEMS 10 (LN2 CRYO INTERCEPT SHIELD RING) TO ITEMS 9 AND 7 AS SHOWN IN SECTIONS K-K AND L-L.
11. EXTREME CARE SHALL BE TAKEN TO PROTECT ALL INSTRUMENTATION WIRING DURING WELDING, SOLDERING AND ASSEMBLY.

SECTION J-J
SCALE: 1/2

