



Assembly sequence:

Item 2 bonded to item 1

Items 5 & 5a bonded to item 4

Items 8 welded to item 7

Tops separated from all three tanks

Outer acrylic placed into stainless tank

Inner acrylic placed into outer acrylic

Item 3 bolted to inner acrylic top (note Item 3 must be self supporting)

Lower inner acrylic top into place & fasten to body

Lower outer acrylic top into place

Fasten item 3 to outer acrylic top

Fasten items 6 & 6a to outer acrylic top

lower stainless tank into place while inserting items 6 & 6a into holes in stainless top

slip O-ring over items 6 & 6a

Slide items 9 over items 6 & 6a then fasten it to items 8 (crushes 45 deg. O-ring)

Fasten calibration spools (items 10) to stainless tank top

Not yet considered:

a) attach items 6 & 6a to GDLS & LS overflow tanks

b) simultaneous sequence for filling/draining port penetrations (if any).