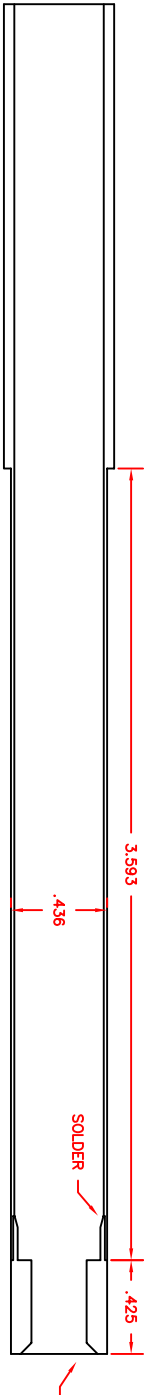
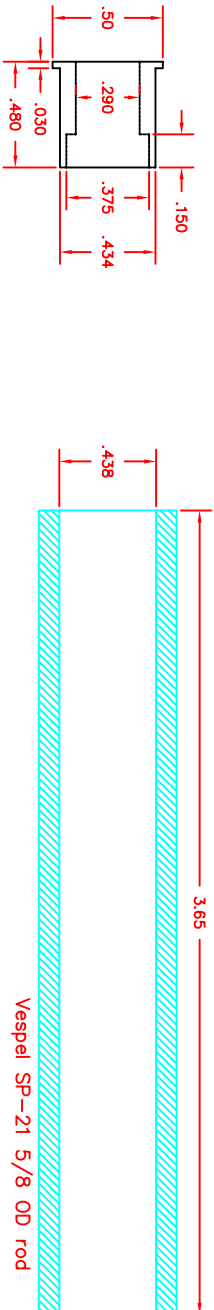


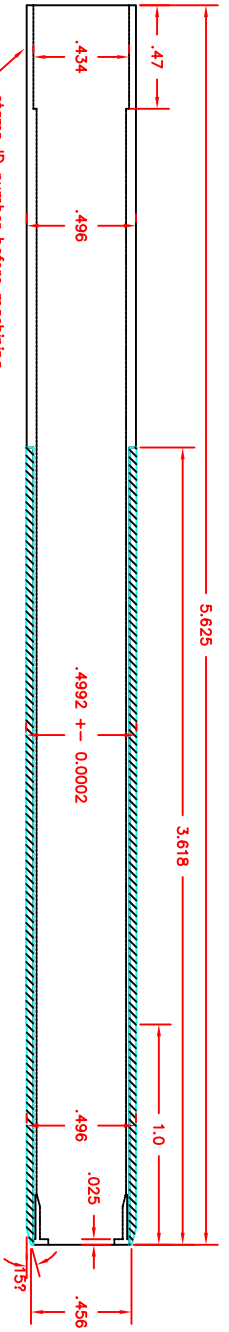
step 1: bore or ream tubing, machine end plug, tin with SS flux and soldering iron, solder together on hot plate



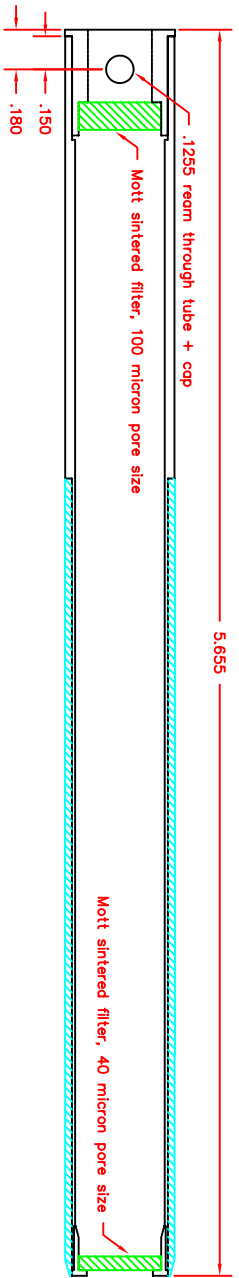
step 2: chamfer end to support with live center, machine OD to 0.436 as shown; rough finish OK



step 3: machine Vespel sleep, epoxy to tube with Eccobond 27; machine end plug



step 4: stamp ID number, then machine OD to correct size while supporting with live center; trim ends to correct length, bore out worn end to fit plug



step 5: insert end plug, drill and ream dowel pin hole