1. Use riveted copper pipe straps to hold pipe to heat sink. Apply Dow Corning SE 4486 conductive RTV along edge of interface between pipe and aluminum sheet.

2. Use 3M Scotch-Weld 2216 two part epoxy to cement all metal sheets and styrofoam together.

3. Use contact adhesive to cement formica to Styrofoam.

4. Dry fit all parts before using adhesive.

5. Rivets and pipe straps not shown.

6. To ensure proper alignment, place central four Handle Attachment Plates while attached to Lifting Frame Assembly PFS00034 and rivet in place.