1. Check spline tube fit inside coil segment #1 prior to any welding.
   Do dimensional check after welding head and back plate.

2. Reverse mounting on weld table, slide on coils.

3. Fit shroud, make longitudinal weld and weld to back plate.

4. Weld Table

5. Adjustable Shroud Weld
   - Locate weld "end-nib"
   - After weld, assembly can be lifted from here
   - Make this weld with cover bolted to inner and outer flanges
   - After weld remove cover and add support straps

6. Slide on vacuum jacket
   - Add G-10 'button' stand-offs to aid vacuum bore tube alignment
   - Floor fixture or modify weld table to attach to flange bolting through blocks
   - Weld vacuum jacket bellows, bolt support feet to cryostat pads through openings in vacuum jacket
   - Weld support feet bellows flanges to vacuum jacket