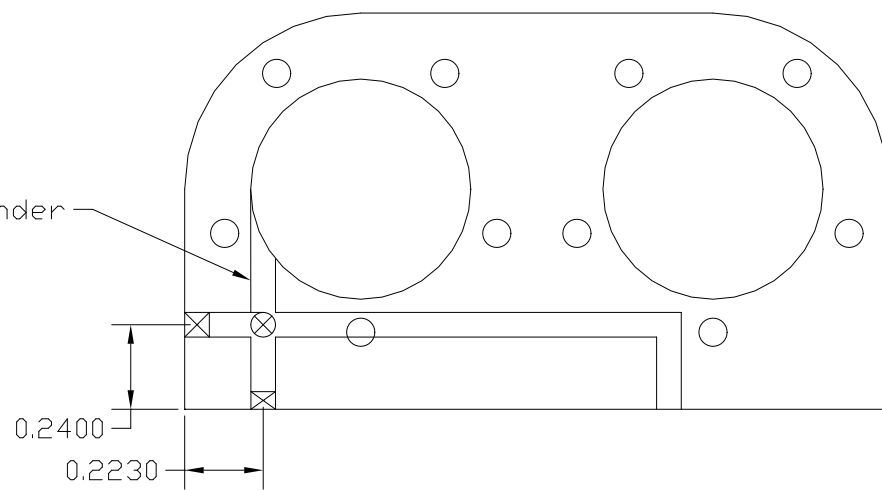
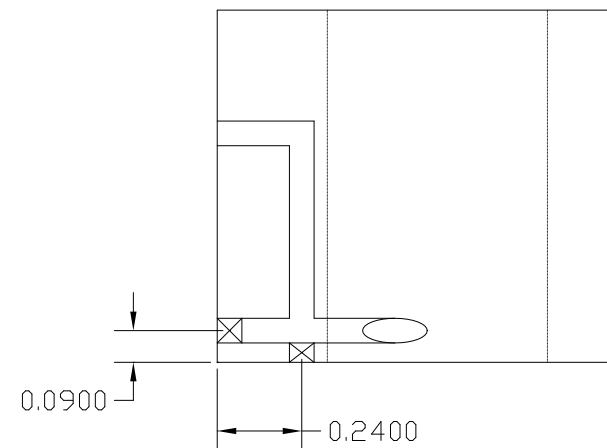
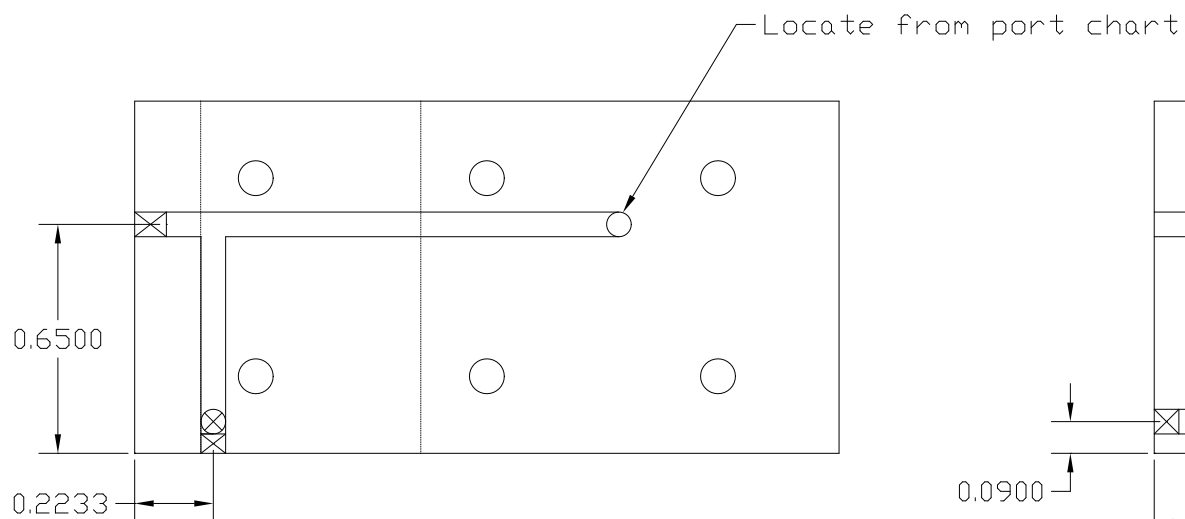


Drill port before boring cylinder



Port 3



Drill all ports #50
Plug where shown
with X