AMENDMENT

IN THE CLAIMS:

Please amend the claims as follows:

1-23. (CANCELLED)

24. (CURRENTLY AMENDED) A method of attaching a plastic tube to a plastic tube plate comprising the steps of:

a) inserting an end of a tube into an opening of the tube plate;

b) pressing on the end of the tube with a spherically shaped form to ~~generate~~ create a flange pressed against a surface of the tube plate, wherein the spherical form is laser transparent; and

c) laser welding the flange to the tube plate by moving a laser beam within the spherically shaped form to generate a continuous weld between the flange and the tube plate.

25. (CURRENTLY AMENDED) The method as recited in claim 24, wherein the ~~form includes a spherical~~ spherically shaped form ~~surface that forms~~ forms a flange less than 90 degrees from a centerline of the tube.

26. (CANCELLED)

27. (ORIGINAL) The method as recited in claim 25, wherein laser energy is directed through the from to weld the flange to the tube plate while the form is pressing the flange against the tube plate.

28. (ORIGINAL) The method as recited in claim 27, including a biasing member for biasing the form into the tube and against the surface of the tube plate.

29. (CURRENTLY AMENDED) The method as recited in claim 24, wherein the spherically shaped form comprises a glass ball.

30. (ORIGINAL) The method as recited in claim 24, wherein the form comprises a spherical surface formed on a surface of a glass plate.

31. (NEW)The method as recited in claim 24, including the step of rotating the laser beam about a central axis of the tube to generate the continuous weld between the flange and the tube plate.

32. (NEW)The method as recited in claim 31, wherein the laser beam is directed through the spherically shaped form at an angle relative to the axis.

33. (NEW)The method as recited in claim 24, wherein the opening in the tube plate includes a beveled open end within which the tube is received.

34. (NEW)The method as recited in claim 33, wherein the tube comprises at least a partially formed flanged end, the flanged end disposed at angle relative to a top surface of the tube plate.