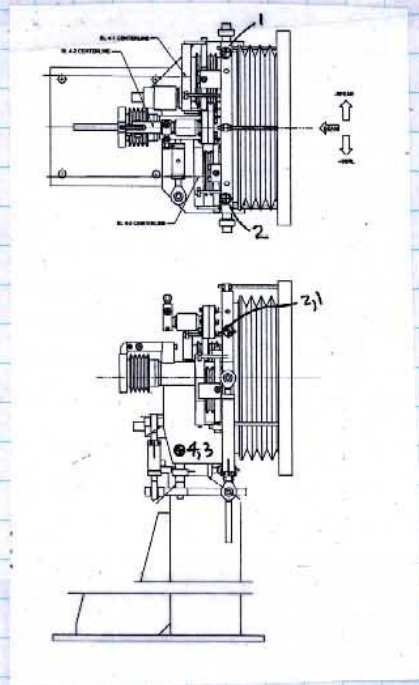


SSRL

BL 4 BREAK OUT



	X	Y	Z
1	-7.820	4.210	641.764
2	7.791	4.222	641.736
3	-1.861	-6.321	645.912
4	1.786	-6.327	645.977

SSRL

2-28-08

BL 4 BREAK OUT

J.M., L.G.

(X)

5.000
5.000
19.500
19.542
30.000
28.766

15.154
(+) .068

15.086 = ϕ

9.091

19.846 s/r
19.846 s/r

40.000

- 24.914 LOS

9.093

9.095

9.088

- 24.846 LOS

40.000 REF. BLADE

15.154 = ϕ

4-2 OPENING

(+) _____ (-)

15.154 15.154
+ .648 + .648

14.506 s/r 15.802 s/r
+ .070 + .066

$\bar{m} = +.068$

15.154

23.900
4-2 PIPE 2" ϕ

24.914
- 1.000 R

23.914 s/r
23.900

[-.014]

1) 16.094
1.000

17.094
24.914

[-7.820]

2) 15.086
17.619

32.705
24.914

[+7.791]

3) 22.053
1.000

23.053
24.914

[-1.861]

4) 9.081
17.619

26.700
24.914

[+1.786]

BL 4 BREAK OUT

① ϕ HZ +40" FROM BOTTOM OF STAND

$$\begin{array}{r} 4-1 \\ \hline -.285 \text{ S/R (BOT.)} \\ -.287 \end{array}$$

$$\boxed{-002}$$

$$\begin{array}{r} 4-2 \\ \hline +.157 \text{ S/R (BOT.)} \end{array}$$

$$\begin{array}{r} -.069 \text{ 4-1 Top} \\ +.086 \text{ 4-2 Bot} \end{array}$$

$$\boxed{+.155}$$

$$\begin{array}{r} 4-3 \\ \hline \phi \text{ S/R (TOP)} \end{array}$$

$$\boxed{-1.002}$$

.560 PIVOT HEAD

56.837 READ BOT. OF STAND
40.000 BL

$$\boxed{16.837 \text{ HI}}$$

PIVOT POINTS

$$\begin{array}{r} 4-2 \\ \hline 13.959 \\ +.250 \\ \hline 14.209 \\ \hline 16.837 \\ \hline \boxed{2.628} \end{array}$$

$$\begin{array}{r} 4-1 \\ \hline 15.862 \\ +.280 \\ \hline 16.142 \\ \hline 16.837 \\ \hline \boxed{+.695} \end{array}$$

$$\begin{array}{r} 4-3 \\ \hline 17.558 \\ +.280 \\ \hline 17.838 \\ \hline 16.837 \\ \hline \boxed{-1.001} \end{array}$$

$$\begin{array}{r} 1) 11.627 \\ +1.000 \\ \hline 12.627 \\ \hline 16.837 \end{array}$$

$$\boxed{+4.210}$$

$$\begin{array}{r} 2) 11.615 \\ +1.000 \\ \hline 12.615 \\ \hline 16.837 \end{array}$$

$$\boxed{+4.222}$$

$$\begin{array}{r} 3) 12.629 \\ +10.529 \\ \hline 23.158 \\ \hline 16.837 \end{array}$$

$$\boxed{-6.321}$$

$$\begin{array}{r} 4) 12.635 \\ +10.529 \\ \hline 23.164 \\ \hline 16.837 \end{array}$$

$$\boxed{-6.327}$$

BL 4 BREAKOUT

J.M., L.G.

(Z)

9.092 READ TO U/S FACE OF MOW PLATE
 640.456 Z OF MOW

631.364 LOS

7.035 REF. BLADE

624.329 = Ø ON BLADE

33.120

657.449 LOS

1) 14.685
 1.000

15.685

657.449

641.764

2) 14.713
 1.000

15.713

657.449

641.736

3) 10.537
 1.000

11.537

657.449

645.912

4) 10.472
 1.000

11.472

657.449

645.977

D/S FACE (+) SIDE 4-2

657.449 LOS

15.172

642.277

Alignment:

Alignment crew: John Mc, LEVIRT G.

Dimensions in { } are absolute dimensions.

MIR 2.623
CA 2.678

Reference point (P) / edge (E) / axis (A) / surface (S):

Based on drawings PF-451-082-69 (Moly Plate)

Mark and label reference alignment points

x:	{+0.648"}	SSRL side of the 04-2 opening (moly plate, center)
y:	{+0.197"} .157	bottom edge of the 04-2 opening (moly plate, center)
z:	{+640.456"}	moly plate face (center location)
roll:	0.000	bottom edge 04-1 opening to top edge 04-3 opening
pitch:	0.000	moly plate face
yaw:	0.000	moly plate face

Tolerance for installation:

x:	+/- 0.010"	measured: _____
y:	+/- 0.005"	measured: _____
z:	+/- 0.080"	measured: _____
roll:	+/- 0.001 rad	measured: _____
pitch:	+/- 0.002 rad	measured: _____
yaw:	+/- 0.002 rad	measured: _____

Items to fiducialize:

04 breakout plate center, ds center surface:

x:	{0.000"}	measured: <u>-1.014 2" PIPE</u>
y:	{0.000"}	measured: _____
z:	{+642.264"} 15.172	measured: <u>642.277</u>

04-1 pivot point:

y:	{+0.710"}	measured: <u>+1.695</u>
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04-2 pivot point:

y:	{+2.639"}	measured: <u>+2.628</u>
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04-3 pivot point:

y:	{-1.000"}	measured: <u>-1.001</u>
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