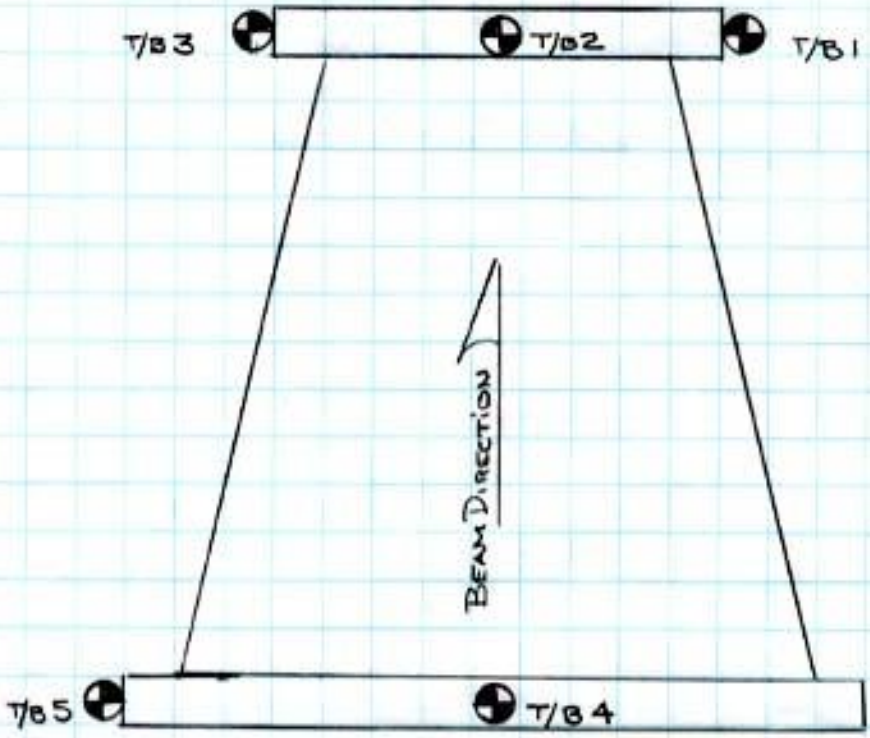
FIXED MASK
B/L 4

APERTURE USED TO SET X, Y = 0
D/S FLANGE USED TO SET Z = 0

KM
8/19/03



	X	Y	Z
1	-4.867	+0.007	-0.437
2	+0.011	+4.850	-0.403
3	+4.854	-0.038	-0.428
4	-0.038	6.473	-39.727
5	+6.474	-0.046	-39.729

B/L 4 – fixed mock

Note:
aperture used to
Set x,y = 0
d/s flange used to
set z = 0
aperture used to
Control roll.
1st tooling ball used.
ck:s 7-23-03

> BLOCK # 1
BORE ALIGNMENT

> BLOCK # 2
CIRCLE

	MEASURED
X	0.00000
Y	0.00011
D	6.73165

RANGE: 0.00002

> BLOCK # 3
CIRCLE

	MEASURED
X	0.00001
Y	-0.00015
D	9.96710

RANGE: 0.00006

> BLOCK # 4
SYMM:POINT/POINT SYMM_PT1:

	MEASURED
X	0.00638
Y	-0.00651
Z	-1.89868

> BLOCK # 5
SYMM:LINE/LINE SYMM_LI1:

	MEASURED
X	0.09175
Y	0.00329
D	0.09175

RANGE: 0.00044

> BLOCK # 6
TRANSLATE/ROTATE

> BLOCK # 7
SYMM:POINT/POINT

	MEASURED
X	0.00025
Y	-0.02161
Z	-1.89868

> BLOCK # 8
SYMM:POINT/POINT

```
   X      0.15877
   Y      0.00017
   Z     -1.89829

> BLOCK #  9
SPHERE                          TB1:

        MEASURED
   X     -4.86713
   Y      0.00653
   Z     -0.43684
   D      0.49826

                                        RANGE:        0.00058

> BLOCK # 10
SPHERE                          TB2:

        MEASURED
   X      0.01072
   Y      4.84979
   Z     -0.40297
   D      0.49880

                                        RANGE:        0.00097

> BLOCK # 11
SPHERE                          TB3:

        MEASURED
   X      4.85383
   Y     -0.03836
   Z     -0.42783
   D      0.49824

                                        RANGE:        0.00039

> BLOCK # 12
SYMM:POINT/POINT

        MEASURED
   X     -0.00009
   Y     -0.03661
   Z     -1.89955

   VERIFY X = 0

> BLOCK # 13
SYMM:POINT/POINT

        MEASURED
   X      0.09992
   Y     -0.00003
   Z     -1.89930

   VERIFY Y = 0

 BLOCK # 14
SPHERE                          TB4:

        MEASURED
   X     -0.03773
   Y      6.47308
   Z    -39.72714
   D      0.49837
```

RANGE: 0.00093

> BLOCK # 15
SPHERE TB5:

	MEASURED
X	6.47372
Y	-0.04558
Z	-39.72913
D	0.49915

RANGE: 0.00035

> BLOCK # 16
SYMM:POINT/POINT

	MEASURED
X	0.21253
Y	0.00013
Z	-1.90414

VERIFY Y = 0

> BLOCK # 17
SYMM:POINT/POINT

	MEASURED
X	-0.00010
Y	0.03579
Z	-1.90465

VERIFY X = 0

> BLOCK # 18
SYMM:POINT/POINT SYMM_PT2:

	MEASURED
X	2.95790
Y	-0.00190
Z	-39.39677

CHECK TWIST U/S

> BLOCK # 19
SYMM:POINT/POINT SYMM_PT3:

	MEASURED
X	-3.11869
Y	-0.00886
Z	-39.41100

CHECK TWIST

Note:

⊥ u/s flange is .007-.008

d/s flange < .002