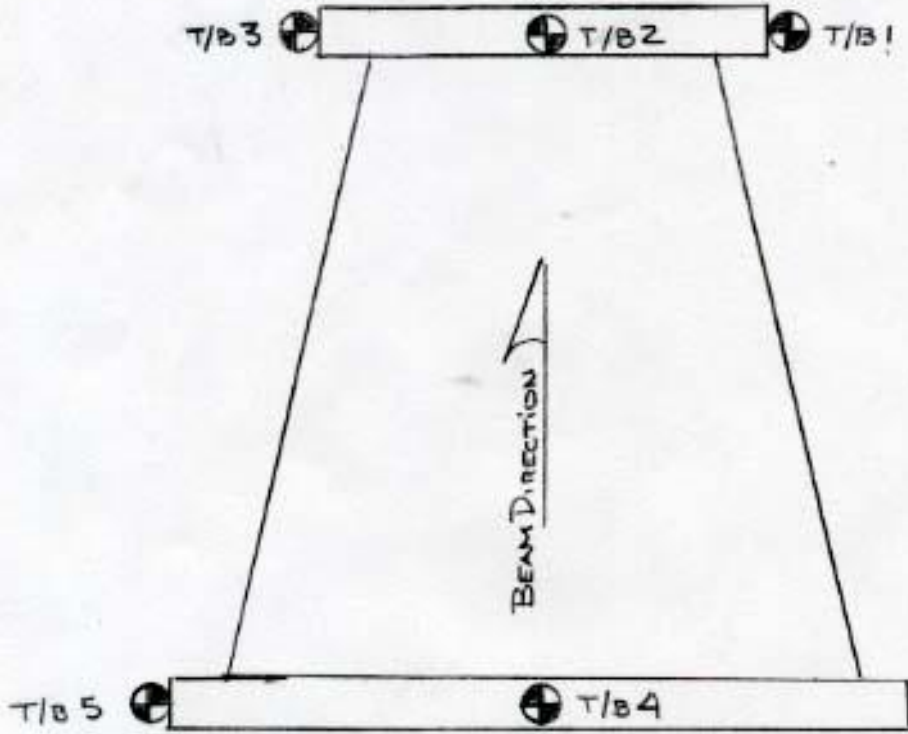


FIXED MASK B/L 60

FLANGES USED FOR X, Y & Z
VALUES DISPLAYED ON THIS
SHEET ARE THE CORRECTED
VALUES AND SHOULD BE USED

K1
8/19/03



D/S FLANGE FACE Z=0

	X	Y	Z
1	-4.854	-0.088	-0.441
2	-0.005	+4.863	-0.436
3	+4.868	-0.020	-0.458
4	-0.018	+6.481	-39.740
5	+6.484	-0.001	-39.760

B/L 6 - fixed mask

7/21/03

NOTE →

> BLOCK # 1
BORE ALIGNMENT

> BLOCK # 2
PLANE

	MEASURED
X	0.02471
Y	0.07539
Z	0.00001

VERIFY Z ZERO

RANGE: 0.00031

> BLOCK # 3
CIRCLE

	MEASURED
X	0.00004
Y	-0.00048
D	6.73296

VERIFY D/S ZERO

RANGE: 0.00027

BLOCK # 4
CIRCLE

	MEASURED
X	-0.00004
Y	0.00059
D	9.96653

VERIFY U/S ZERO

RANGE: 0.00014

> BLOCK # 5
SYMM:LINE/LINE

	MEASURED
X	0.00891
Y	-0.00365
D	0.00890

APERTURE CENTER IN Y

RANGE: 0.00095

> BLOCK # 6
SYMM:LINE/LINE

	MEASURED
X	-0.00652
Y	-0.01270
D	0.01268

APERTURE CENTER IN X

> BLOCK # 7
SPHERE

TB1:

2-3 is d/s flange
Flanges used for x,y zero
Aperture used to control roll
1" tooling ball used
KS 7-21-03

CIRCLE1:

VALUES WRITTEN IN
PENCIL ARE THE CORRECTED
OFFSET VALUES 0

CIRCLE2:

Y -0.09218
Z -0.44096
D 0.49976

X = -4.861
X = -4.854
Y = -0.088

BL 6

RANGE: 0.00030

> BLOCK # 8
SPHERE

TB2:

MEASURED
X -0.01197
Y 4.85886
Z -0.43644
D 0.49894

X = -0.005
Y = 4.863

RANGE: 0.00067

> BLOCK # 9
SPHERE

TB3:

MEASURED
X 4.86129
Y -0.02394
Z -0.45791
D 0.49860

X = +4.868
Y = -0.020

RANGE: 0.00007

> BLOCK # 10
SPHERE

TB4:

MEASURED
X -0.02543
Y 6.47690
Z -39.74001
D 0.49866

X = -0.018
Y = 6.481

RANGE: 0.00156

> BLOCK # 11
SPHERE

TB5:

MEASURED
X 6.47714
Y -0.00471
Z -39.75957
D 0.49826

X = 6.484
Y = -0.001

22
7/03

RANGE: 0.00061

> BLOCK # 12
CIRCLE

CIRCLE3:

MEASURED
X -0.00021
Y -0.00033
D 9.96826

RANGE: 0.00037

VERIFY U/S ZERO

> BLOCK # 13
CIRCLE

MEASURED

X 0.00246
Y -0.00026
D 6.73363

BL 6

VERIFY D/S ZERO

RANGE: 0.00014

> BLOCK # 14
ANE

MEASURED
X 0.00744
Y 0.56205
Z -0.00004

RANGE: 0.00042

> BLOCK # 15
POINT

POINT1:

MEASURED
X -0.18890
Y 3.11194
Z 0.09519

Z @ TB1

> BLOCK # 16
POINT

POINT2:

MEASURED
X 0.27251
Y -3.10224
Z 0.09528

> BLOCK # 17
POINT

POINT3:

MEASURED
X -3.04139
Y 0.39219
Z 0.09414

Z @ TB1

> BLOCK # 18
POINT

POINT4:

MEASURED
X 3.02498
Y 0.39339
Z 0.09696

Z @ TB3

> BLOCK # 19
POINT

POINT5:

MEASURED
X 0.38899
Y 4.71406
Z -40.32527

Z - U/S FLANGE @ TB4

> BLOCK # 20
POINT

POINT6:

BL 6

MEASURED
X -0.39744
Y -4.68848
Z -40.32277

Z - U/S FLANGE

> BLOCK # 21
POINT

POINT7:

MEASURED
X 4.69363
Y 0.45115
Z -40.32384

Z - U/S FLANGE @ TB5

> BLOCK # 22
POINT

POINT8:

MEASURED
X -4.59387
Y 0.47802
Z -40.32421

Z - U/S FLANGE

> BLOCK # 23
PARA:PLANE/PLANE

MEASURED
D 0.00204

FLANGE TO FLANGE

RANGE: 0.00104

