

0/L 10 - fixed mask
K.S. 2-18 03

> BLOCK # 15
BORE ALIGNMENT

> BLOCK # 16
CIRCLE

CIRCLE1:

2-guns in the flange
Flanges used for X, Y zero
Aperture used to control roll
1" tooling ball used.

	MEASURED
X	0.00000
Y	0.00027
D	9.96811

VERIFY ZERO UPSTREAM

RANGE: 0.00036

> BLOCK # 17
CIRCLE

CIRCLE2:

	MEASURED
X	0.00023
Y	0.00016
D	6.73136

VERIFY ZERO DOWNSTREAM

RANGE: 0.00007

> BLOCK # 18
SYMM:LINE/LINE

SYMM_LI1:

	MEASURED
X	0.00411
Y	-2.31175
D	2.31176

APERTURE CENTER IN X

> BLOCK # 19
SYMM:LINE/LINE

SYMM_LI2:

	MEASURED
X	0.22768
Y	0.00553
D	0.22768

APERTURE CENTER IN Y

RANGE: 0.00038

> BLOCK # 20
SPHERE

TB1:

	MEASURED
X	-4.85552
Y	0.05505
Z	-0.42788
D	0.49839

RANGE: 0.00041

> BLOCK # 21
SPHERE

MEASURED
X -0.00711
Y 4.85944
Z -0.42035
D 0.49903

RANGE: 0.00025

> BLOCK # 22
SPHERE

TB3:

MEASURED
X 4.85739
Y -0.04528
Z -0.41248
D 0.49804

RANGE: 0.00020

> BLOCK # 23
SPHERE

TB4

MEASURED
X 0.03178
Y 6.24605
Z -39.73137
D 0.66244

> BLOCK # 24
SPHERE

TB5:

MEASURED
X 6.48531
Y -0.02035
Z -39.73474
D 0.49901

RANGE: 0.00023

> BLOCK # 25
POINT

POINT1:

MEASURED
X -0.15889
Y 4.68820
Z -40.32112

Z - UPSTREAM FLANGE @ TB4

> BLOCK # 26
POINT

POINT2:

MEASURED
X -0.21978
Y -4.77006
Z -40.31710

Z - UPSTREAM FLANGE

> BLOCK # 27
POINT

POINT3:

MEASURED
X 4.60060
Y 0.17280

40.31408
Z - UPSTREAM FLANGE @ TB5

> BLOCK # 28

POINT POINT4:

MEASURED
X -4.80127
Y 0.15531
Z -40.31439

Z - UPSTREAM FLANGE

> BLOCK # 29

POINT POINT5:

MEASURED
X -0.21435
Y 3.06975
Z 0.09351

> BLOCK # 30

POINT POINT6:

MEASURED
X -0.22433
Y -3.12815
Z 0.09748

Z - DOWNSTREAM FLANGE

> BLOCK # 31

POINT POINT7:

MEASURED
X -3.04313
Y -0.36019
Z 0.09674

Z - DOWNSTREAM FLANGE @ TB1

> BLOCK # 32

POINT POINT8:

MEASURED
X 3.13029
Y -0.21470
Z 0.09427

Z - DOWNSTREAM FLANGE @ TB3

> BLOCK # 33

PERP:BORE/PLANE PERP_BP1:

MEASURED
D 0.01005

PERP OF UPSTREAM FLANGE AND C/L

RANGE: 0.00502

> BLOCK # 34

PERP:BORE/PLANE PERP_BP2:

MEASURED
D/ 0.02941

PERP DOWNSTREAM FLANGE TO C/L

RANGE: 0.00117

> BLOCK # 35

PARA:PLANE/PLANE

PARA_PP1:

MEASURED

D 0.00142

FLANGE TO FLANGE

RANGE: 0.00825

> BLOCK # 36

CIRCLE

CIRCLE3:

MEASURED

X -0.00048

Y 0.00029

D 6.73135

VERIFY ZERO DOWNSTREAM

RANGE: 0.00032

> BLOCK # 37

CIRCLE

CIRCLE4:

MEASURED

X 0.00006

Y 0.00011

D 9.96841

VERIFY ZERO UPSTREAM

RANGE: 0.00047

3/L 10
1" tooling ball used
KS 7-17-02

BEAMLIVE 10

FIXED MASK

4/S OF MOVEABLE MASK

> BLOCK # 1
BORE ALIGNMENT

> BLOCK # 2
CIRCLE

CIRCLE1:

	MEASURED
X	0.00026
Y	0.00070
D	9.96927

VERIFY UPSTREAM ZERO RANGE: 0.00027

> BLOCK # 3
CIRCLE

CIRCLE2:

	MEASURED
X	0.00022
Y	0.00004
D	6.73112

VERIFY DOWNSTREAM ZERO RANGE: 0.00000

> BLOCK # 4
SYMM:LINE/LINE

SYMM_LI1:

	MEASURED
X	0.00959
Y	0.02382
D	0.02384

UPSTREAM WINDOW IN X RANGE: 0.00104

> BLOCK # 5
SYMM:LINE/LINE

SYMM_LI2:

	MEASURED
X	0.18625
Y	-0.00771
D	0.18625

UPSTREAM WINDOW IN Y RANGE: 0.00341

> BLOCK # 6
SYMM:LINE/LINE

SYMM_LI3:

	MEASURED
X	0.00917
Y	-0.01845
D	0.00917

DOWNSTREAM WINDOW IN X RANGE: 0.00015

> BLOCK # 7
SYMM:LINE/LINE

SYMM_LI4:

A 0.03207
Y 0.00693
D 0.05206

DOWNSTREAM WINDOW IN Y

RANGE: 0.00070

> BLOCK # 8

SPHERE TB1:

MEASURED
X -4.85459
Y 0.06239
Z -0.42985
D 0.49922

RANGE: 0.00067

> BLOCK # 9

SPHERE TB2:

MEASURED
X -0.00120
Y 4.85875
Z -0.42452
D 0.49979

RANGE: 0.00058

> BLOCK # 10

SPHERE TB3:

MEASURED
X 4.85897
Y -0.05354
Z -0.41454
D 0.49906

RANGE: 0.00047

> BLOCK # 11

SPHERE TB4:

MEASURED
X 0.03090
Y 6.47975
Z -39.74150
D 0.49754

RANGE: 0.00186

> BLOCK # 12

SPHERE TB5:

MEASURED
X 6.48230
Y -0.03013
Z -39.73800
D 0.49893

RANGE: 0.00022

> BLOCK # 13

CIRCLE

MEASURED

Y -0.00079
D 6.73275

VERIFY DOWNSTREAM ZERO

RANGE: 0.00014

> BLOCK # 14
CIRCLE

MEASURED
X -0.00041
Y 0.00035
D 9.96920

VERIFY UPSTREAM ZERO

RANGE: 0.00048