Subsystem Component Feature Relation	+/- Tol's		Comments
	X/Y (mm)	Z (mm)	
TKR			
Raw tolerances from drawings and IDD's			
Module tilt/bookshelfing wrt Flexure hole datums	0.000		Static deflec outside 372 mm stayclear
Dynamic motion wrt nominal position			
Module dynamic motion wrt nominal position (top of module)	0.755		3-sigma TKR random vibe for 100 Hz
Module dynamic motion wrt nominal position (bot of module)	0.220		
Grid			
Raw tolerances from drawings and IDD's			
Bay datum pins wrt neighboring bay	0.075		True position to 0.15 from CAL IDD
TKR flexure hole position wrt bay datum pins (all 12 holes)	0.075	0.025	Mach errors in Grid hole machining
Top flange profile tol (one-sided outward) wrt bay datum pins	0.150		
Dynamic motion wrt nominal position			
Max sag of Grid due to MECO launch accel		0.500	
Bay CL motion wrt neighbor due to 5 degC temp diff. at launch	0.019		PPG guarantees +/- 2.5 degC
Derived tolerances for TKR wrt nominal location on the Grid			
TKR module top swing due to tip from 500 micron sag of Grid	0.205		Imparted by Grid sag
TKR module swing at top due to Grid hole angle wrt Grid	0.121		Due to Grid corner datum hole Z-tol
TKR module corner twist due to rotation of Grid holes around Z	0.053		
TKR module centerline position total tolerance			
At top of TKR stay-clear	1.303		Half-gap = 1.250 mm
Near bottom of TKR stay-clear	0.442		Half-gap = 1.250 mm
In thickened bottom region of TKR stay-clear	0.442		Half-gap = .5 mm