

Customer: ENERGY INDUSTRIES OF OHIO

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Part: SE141-116 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-116 Revision: 7
Links: I-Type:W: 65707/4.0 Sub: 1 Op: 35

Customer P.O.: S005242-F/Ln:4
Serial No./Qty: C4

Reported By: MIKE GRIFFITH
E-Mail: mGriffith@MajorTool.com

Telephone: 317-636-6433
Fax: 317-634-9420

Problem: TOOL GOUGE APPROXIMATELY 1.5" LONG X .5" WIDE AND .250" DEEP ON THE CORNER OF THE T.
GOUGE IS LOCATED ON THE DATUM -D- SIDE (SEE PICTURES).

Proposed Disposition:

RECOMMEND WELD REPAIR OF DEFECTIVE AREA PRIOR TO FINISH MACHINING.
ALSO RECOMMEND REPAIR TO BE INSPECTED USING PT AND MAG PERMEABILITY CHECK WITH
WAIVER OF THE X-RAY REQUIREMENT.

Number of additional pages: 2 attached pictures

Customer Disposition: Use As Is Rework Repair Scrap Replace

PPPL concurs with Major Tools recommended disposition.

Phil
Heitzenroeder

Digitally signed by Phil Heitzenroeder
DN: CN = Phil Heitzenroeder, C = US,
O = PPPL, OU = Mech. Eng. Division
Reason: I am approving this
document
Date: 2006.02.10 16:31:49 -05'00'

Technical Contact Approval: _____

Title: _____ Date: _____

Brad
Nelson

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US,
o=ORNL, ou=FED,
email=nelsonbe@ornl.gov
Date: 2006.02.10 17:50:02
-05'00'

RLM: _____

Title: _____ Date: _____

Major Tool Implemented By: Mike Griffith Title: QFT. ENGINEER Date: 2-10-06

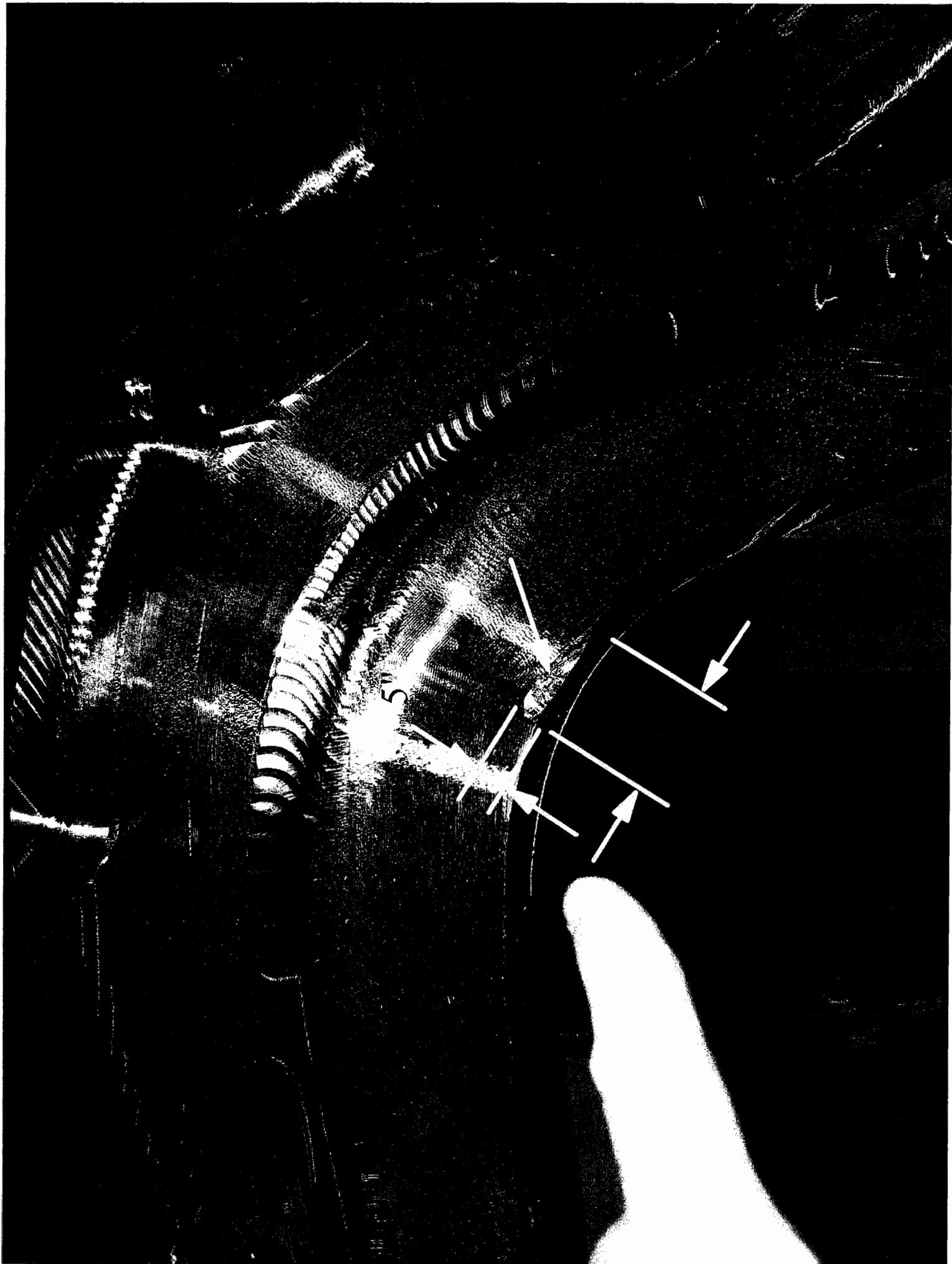
Root Cause1: 803-INEFFECTIVE TRAINING

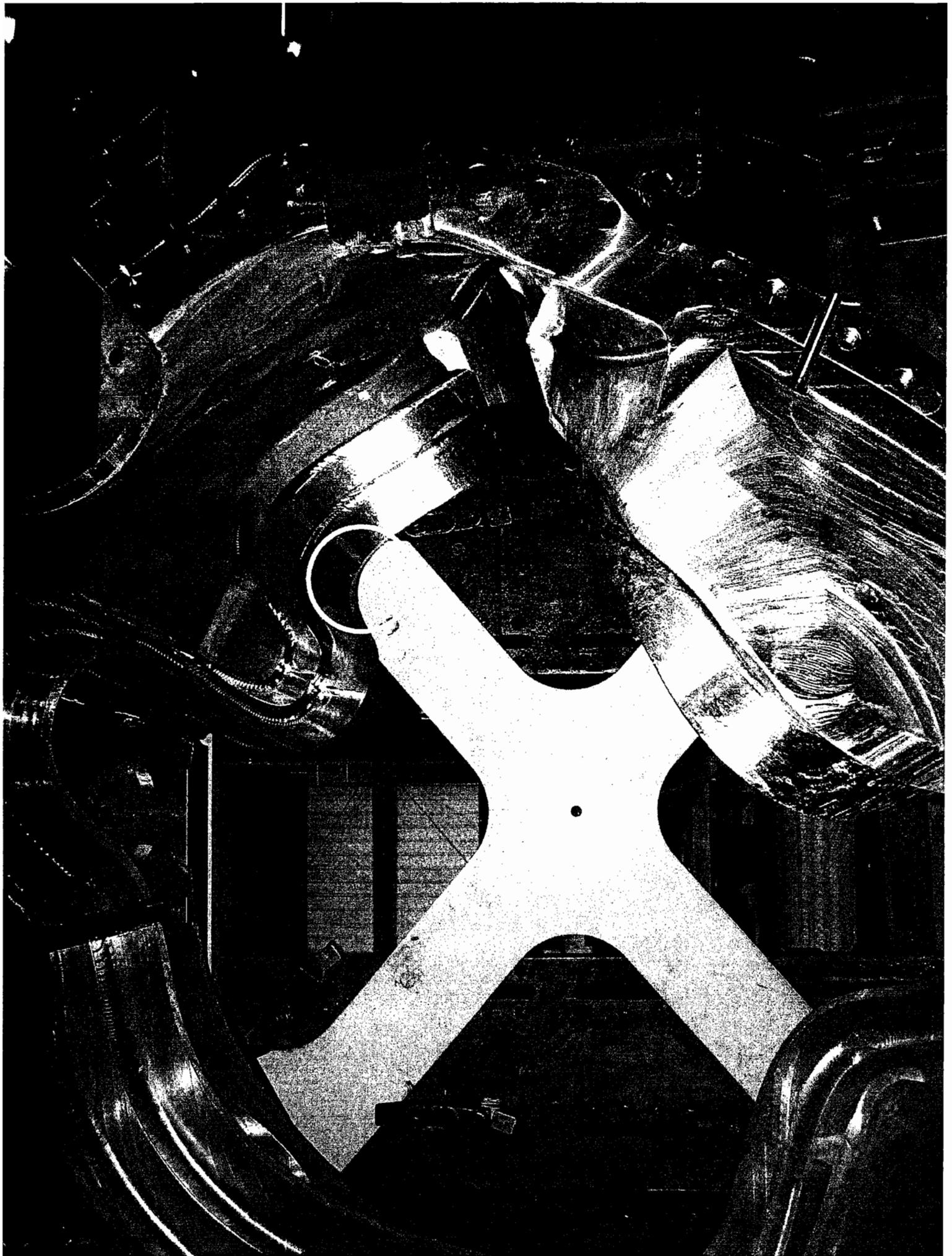
Resource: CAD/CAM - LARGE MILLING Equipment:
Description: THE TOOL-GOUGE OCCURRED AS A RESULT OF A PROGRAMMING ERROR. PROGRAMS HAD BEEN MODIFIED TO HELP REDUCE MACHINING CYCLE. THE NEW PROGRAM WAS VERIFIED USING VERICUT PRIOR TO RELEASING TO THE MACHINE. THE PROGRAMMER AGAIN VERIFIED THE PROGRAM AFTER THE GOUGE OCCURRED AND DISCOVERED THAT THE ERROR HAD BEEN DETECTED BY VERICUT. THE PROGRAMMER WAS NOT CORRECTLY INTERPRETING THE RESULTS FROM THE VERIFICATION PROCESS.

Corrective Action 1:

Action: 02/09/06 By: 242-M.GRIFFITH

Description: THE PROGRAMMER HAS BEEN GIVEN ADDITIONAL TRAINING ON THE USE OF VERICUT AND FULLY UNDERSTANDS HOW THE ERROR WAS MISSED.







Major

Tool & Machine, Inc.

Nondestructive Test Certification for Liquid Penetrant Examination

1458 E. 19th Street, Indianapolis, In 4621
TEL:(317)636-6433 FAX:(317)634-9420

Date of Inspection:02/10/2006

Type of Material:316_17

NDT#:15604

Stage of Inspection: <input type="checkbox"/> Incoming Inspection <input checked="" type="checkbox"/> In-Process Inspection <input type="checkbox"/> After Repair <input type="checkbox"/> Final Inspection	Manufacturing Process: <input checked="" type="checkbox"/> Weldment <input type="checkbox"/> Casting <input type="checkbox"/> Bar Stock <input type="checkbox"/> Plate <input type="checkbox"/> Forging <input type="checkbox"/> Other	Surface Condition: <input type="checkbox"/> Machined <input checked="" type="checkbox"/> Rough <input type="checkbox"/> Other	Test Being Run to: <input checked="" type="checkbox"/> Router Instructions <input type="checkbox"/> Drawing <input type="checkbox"/> Test Plan <input type="checkbox"/> Technique Card	Heat Treated: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No
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Part Information: MTM Job Number: 65707/4.0 -Sub:11 -Op:20 Resource ID: 810-LIQUID PENETRANT INSPECTI Part ID: SE141-103-1 Part Name: MOD COIL WINDING FORM ASSE Serial Number: Customer P.O.: S005242-F Customer Unit/Plant:	Test Results: Quantity Inspected: 1 Quantity Accepted: 1 Quantity Rejected: 0 Run Hours:
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Customer Inspection PI Test Step: Revision: Material Test Number:	Inspection Criteria: Customer Specification: ASTM A903/903M LEVEL 1 MTM Spec Number: NDT-WI-009 Acceptance Standard: NO DEFECTS
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Inspection Materials Used: Manufacturer: SHERWIN CORP. Type of Penetrant: DP-51 Batch Number: 41-E47 Developer: D-100 Batch Number: 520-H6	Penetrant Examination Processes: Type: II (Visible) / Dwell Time: 30 Minutes Method: A (Water Wash) Method of Drying: Normal Evaporation Form: e (nonaqueous for Type II visible dye) / Dwell Time: 30 Min
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Inspection Requirements:

% of all accessible surfaces Joint Preps Root Pass Back Gouge Cover Pass Other

Notes:
INSPECT WELD REPAIR.

NO REJECTABLE INDICATIONS AT TIME OF INSPECTION.

This is a LPI check in reference to NC 19209.

This is to certify that the pieces specified have been inspected in accordance with the specifications shown.

Inspector: 674-S.WILLIAMS

Date: 02/10/2006

Sylvester Williams Level II



INSPECTION DATA CHECKLIST

Workorder: 65707/4-0 Sub:11 Op:30

Revision: 03/06/06 7:44

Part: REWORK - REWORK / REPAIR PER N/C - N/C # _____

Drawing ID: SE141-116 Rev: 8		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
(10)		N C 19209 RECORD PERMEABILITY READINGS OF THE REPAIRED AREA. MAG PERMEABILITY TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1165	<1.02	854-R.UP 03-08-06		

A

Employees: 854-R.Upchurch

* To Far Right Indicates Data Package Requirement

NOTE: the recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, title 18, chapter 47.