
Customer: ENERGY INDUSTRIES OF OHIO

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Part: SE141-115 / MODULAR COIL, TYPE B

Drawing ID: SE141-115 Revision: 8

Customer P.O.: S005242-F/Ln:2
Serial No./Qty: B2

Reported By: MIKE GRIFFITH
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Problem: Sheet 5, zone D4.
8 of the 1.375 threaded holes on datum -E- are out of position by a 1/2 inch (holes 19 thru 26).

Proposed Disposition:

MTM RECOMMENDS REPAIRING HOLES PER ATTACHED REWORK PROPOSAL.

Number of additional pages: 2 Page Rework Proposal

Customer Disposition: ☐ Use As Is ☒ Rework ☐ Repair ☐ Scrap ☐ Replace

MTM's re-work proposal (attached) is accepted, with the understanding that the insert will be made of Stelalloy (to assure that magnetic permeability and strength requirements will be met). The strength of this repair is not an issue since the insert is threaded into the flange with 2.5-6 UNC threads and then tack welded in place.

Accepted by:

Tech. Rep.

RLM



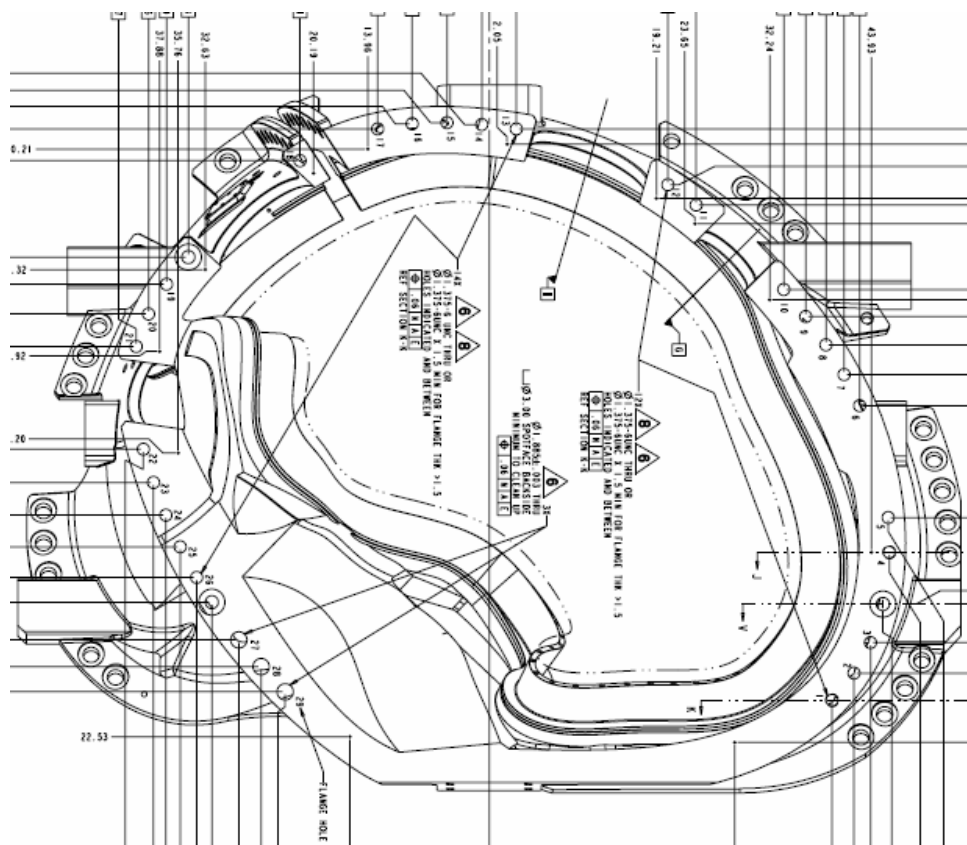
Major Tool Implemented By: _____ **Title:** _____ **Date:** _____



SE141-115 Type B2 Flange Hole Rework Proposal

Rework Proposal for Holes 19 thru 26:

- Oversize holes for a Ø2.50-6 UN insert.
- Inserts will be manufactured complete with the Ø1.375-6 ID thread.
- For 5 Blind Holes: bottom out insert in hole (approx. 1.6' deep) and tack weld in 4 places on flange.
- For 3 Thru Holes: install insert and tack weld in 4 places on flange face and 4 places on back side of flange.
- All inserts will be faced off flush with Datum -E- flange.



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MTM REVISIONS

SYMBOL	ZONE	DESCRIPTION	DATE	BY
-		INITIAL RELEASE	8/13/08	MJB

Ø 1.375-6 UNC2B

Ø2.50-6 UN-2B

1.625

.06" CHAMFER

			8
			7
			6
			5
			4
			3
			2
			1
QTY	PART NUMBER/MATERIAL	DESCRIPTION	ITEM

LIST OF MATERIAL

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

.X Ø6	.XX Ø20	.XXX Ø10
FRACTIONS	ANGLES	

MATERIAL

STELLALLOY

**Major**
TOOL & MACHINE DESIGNERS
DELAWARE, PENN.

MCWF FLANGE INSERT

SIZE A NUMBER SE141-INSERT-MTM

SCALE, ANVIL, SHEET 1 OF 1

DRWN BY: MIKE GRIFFITH

CHKD BY: NATHAN HIRSCHY

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D

D

C

C

B

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A