

**Major****Tool & Machine, Inc.**1458 E. 19th Street, Indianapolis, In 4621
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Nondestructive Test Certification for Liquid Penetrant Examination

Date of Inspection:12/12/2005**Type of Material:**CAST STAINLESS**NDT#:**14900**Stage of Inspection:**☐ Incoming Inspection
☐ In-Process Inspection
☒ After Repair
☐ Final Inspection**Manufacturing Process:**☐ Weldment ☒ Casting
☐ Bar Stock ☐ Plate
☐ Forging ☐ Other**Surface Condition:**☒ Machined
☐ Rough
☒ Other
CLEANED & DEBURRED**Test Being Run to:**☒ Router Instructions
☒ Drawing
☐ Test Plan
☐ Technique Card
SEE NOTES**Heat Treated:**☒ Yes
☐ No**Part Information:**MTM Job Number: 65707/2.0 -Sub:16 -Op:20
Resource ID: 810-LIQUID PENETRANT INSPECTI
Part ID: SE141-116
Part Name: MODULAR COIL WINDING FORM
Serial Number:
Customer P.O.: S005242-F
Customer Unit/Plant:**Test Results:**Quantity Inspected: 1
Quantity Accepted: 0
Quantity Rejected: 1**Run Hours:****Inspection Results:****Customer N/C #:**☐ Accepted
☒ Rejected
☐ N/C-Report
☐ Rework
MTM N/C #: 18715

Customer Inspection PI SEE NOTES

Test Step:

Revision:

Material Test Number:

Inspection Criteria:Customer Specification: ASTM A903/A903M
MTM Spec Number: PS582 (REF NDT-WI-09)
Acceptance Standard: ASTM A903 (SEE NOTES)**Inspection Materials Used:**Manufacturer: SHERWIN
Type of Penetrant: DP-51
Batch Number: 41-E47
Developer: D-100
Batch Number: 520-H6**Penetrant Examination Processes:**Type: II (Visible) / Dwell Time: 15 Minutes
Method: A (Water Wash)
Method of Drying: Normal Evaporation
Form: e (nonaqueous for Type II visible dye) / Dwell Time: 12 Min**Inspection Requirements:**% of all accessible surfaces ☐ Joint Preps ☐ Root Pass ☐ Back Gouge ☐ Cover Pass ☒ Other
SEE NOTES**Notes:**

PERFORM A LOCAL LPI CHECK OF THE 3 PREVIOUSLY REJECTED AREAS. THERE WAS 1 REJECTION ON THE MACHINED T AND 2 REJECTIONS IN 1 AS-CAST REGION.

Please reference MTM NC 18715 for additioanl information.

Specification: ASTM A903/A903M

Method: ASTM E165

Acceptance Criteria: ASTM A903/A903M Level II for as cast surfaces

Acceptance Criteria: ASTM A903/A903M Level I for machined surfaces including the entire "T" section (high stress areas)

2 indications remain after excavation, one on the finished machine area, and one in the as cast surface.

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

Inspector: 581-D.EDWARDS**Date:** 12/12/2005*Douglas D. Edwards* Level II