

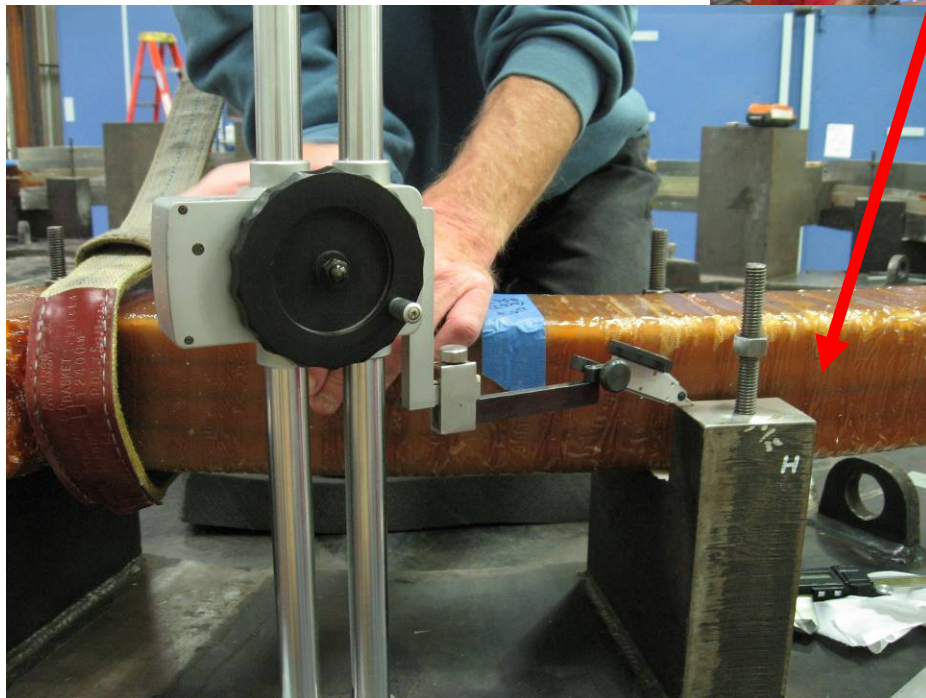
X-Y Geometry Check

- Solid steel fixture used as template
- Saddles in fixture are precisely machined to within $\pm .005$ in one setup in a large CNC machine and inspected
- Coil inserted into fixture and gaps measured in saddles to determine location of coil with respect to nominal requirement
- Inspection report provided referencing dimensional requirements from drawing and associated as built tolerance

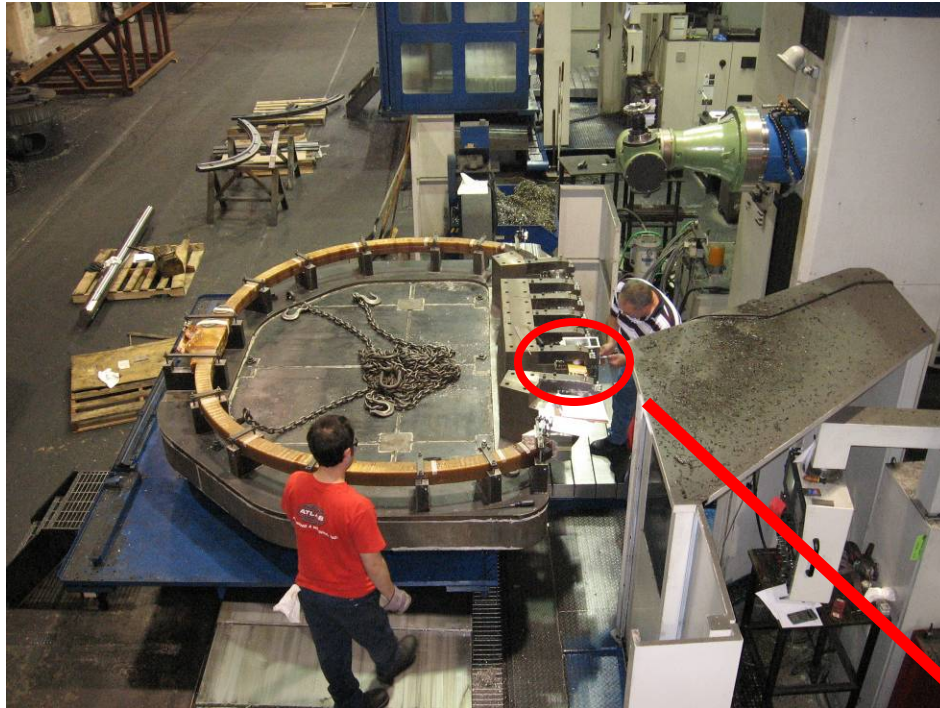


Planarity Geometry Check

- Height of center line of coil checked against the center plane of the coil and deviations are recorded.



Wedge Geometry Check



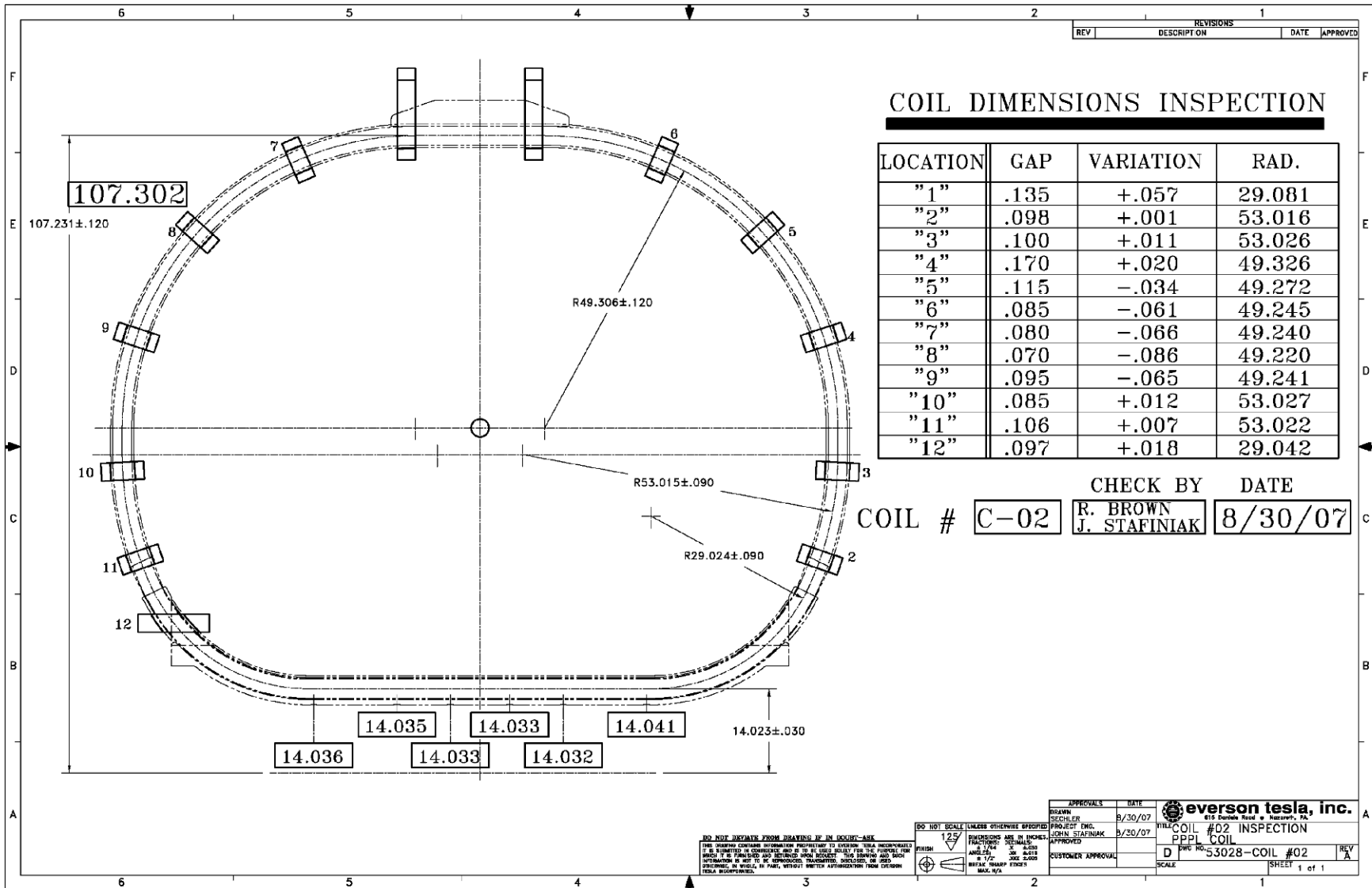
- A precisely machined wedge template is used to inspect the wedge angle as well as the location of coil with respect to the intersecting axis formed by the angle



- The remaining coil geometry is located with respect to the axis described by the intersecting wedge planes by referencing back to an inspected point on the fixture
- The true position tolerance with respect to flatness and planarity of the wedge cut is inspected using a probe on the CNC machine



Dimensional Inspection Report Example TF#2



DO NOT DEPART FROM DRAWING OR IN HOUSE-MAKE
 THIS DRAWING CONTAINS INFORMATION PROPRIETARY TO EVERSON-TESLA INCORPORATED
 IT IS HEREBY TO BE CONFIDENTIAL AND NOT TO BE LOANED, REPRODUCED, COPIED, REPRODUCED, OR
 DISCLOSED IN ANY MANNER WITHOUT WRITTEN AUTHORIZATION FROM EVERSON-
 TESLA INCORPORATED.

DO NOT SCALE UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES
 FINISH: 125
 ANGLE: 1/4
 BEVEL: 1/4
 MAX. V.A.

APPROVALS: DATE: 8/30/07
 DRAWN: RECHLER
 PROJECT ENG: STAFINIAK
 APPROVED: 8/30/07
 CUSTOMER APPROVAL:

everson tesla, inc.
 815 Dunbar Road • Nazareth, PA
 TITLE: COIL #02 INSPECTION
 PPL COIL
 D PWT: S3028-COIL #02
 SCALE: SHEET 1 of 1

Verification for Coil #1



- PPPL verified Everson tooling and measurement techniques on TF Coil#1 on location at Everson