

Major Tool & Machine, Inc.
1458 East 19th Street
Indianapolis, IN 46218-4289

MTM N/C: 18236

Page: 1
Date: 09/21/05
User ID: BOWLINK

Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
E-Mail: NKHFlowen@aol.com

Telephone: 216-496-2314
Fax: 216-328-2001

Part: SE141-116 / MODULAR COIL WINDING FORM TYPE
Drawing ID: SE141-116 Revision: 6

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: C1

Reported By: KEVIN BOWLING
E-Mail: kBowling@MajorTool.com

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

Problem: AFTER MACHINING SEVERAL MACHINING DEFECTS WERE DETECTED UPON VISUAL EXAMINATION. SEE ADDITIONAL DOCUMENTS FOR MAPS AND LISTS OF (16) SEPARATE NON-CONFORMING FEATURES.

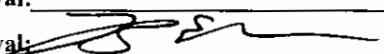
Proposed Disposition:

SUBMIT TO CUSTOMER CONTINUE PROCESSING THE PART.

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

PAPL WILL PATCH IMPERFECTIONS WITH
FILLED EPOXY MIXTURE

Technical Contact Approval: _____

RLM ~~Buyer~~ Approval: 

Title: _____

Title: RLM

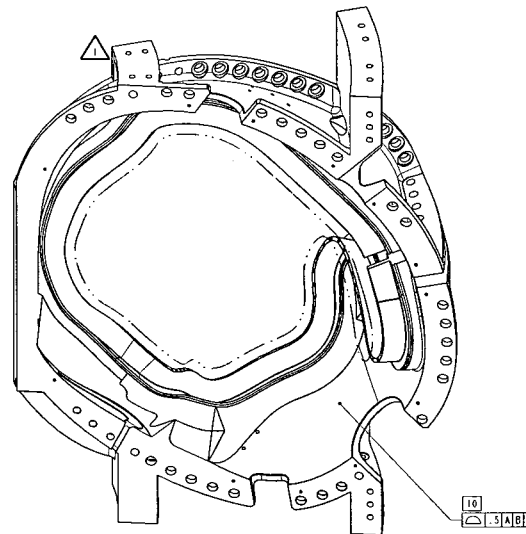
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Date: 9/22/05

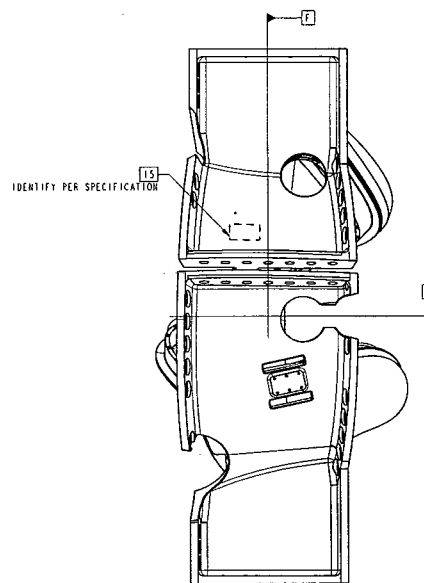
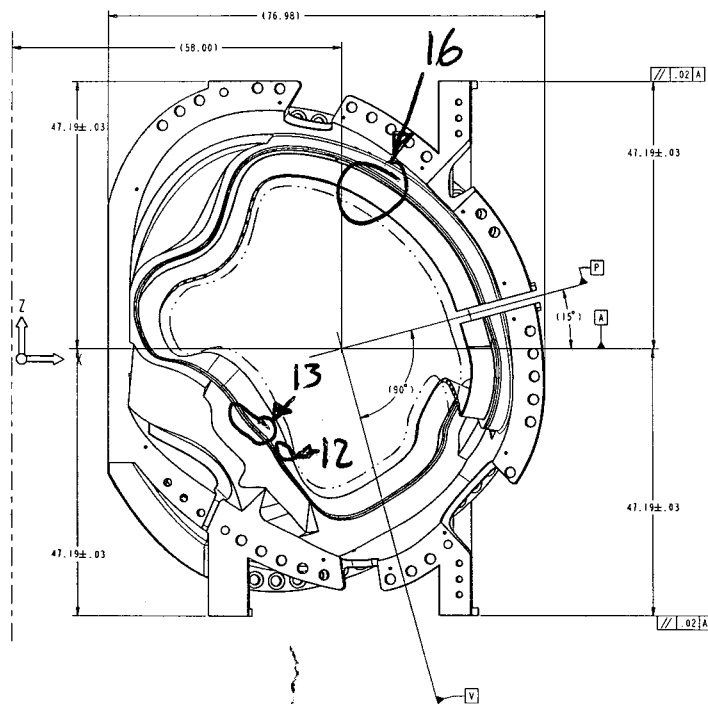
Major Tool Implemented By: _____

Title: _____

Date: _____



ISOMETRIC VIEW



NOTES:

1. DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1994.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994.
3. DIMENSIONS ARE IN INCHES.
4. DRAWING DEPICTS FINAL MACHINED STATE OF PART
DEFINED BY PRO/ENGINEER FILE SET41-116.PRT.
5. UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE RELATED TO
DATA A - (PRIMARY X-Y PLANE, TOP)
DATA B - (SECONDARY Y-Z PLANE, SIDE)
DATA C - (TERTIARY X-Z PLANE, FRONT)
6. DIMENSIONS APPLY AT TEMPERATURE OF 70-30°C (168-66°F)
7. DIMENSIONS AND TOLERANCES EXCLUDE PROCESS MATERIAL
ALLOWANCES WHICH MAY ADD UP TO .015 IN.
8. APPROXIMATE WEIGHT : 4556 LBS.
WEIGHT OF FINISHED PART NOT TO EXCEED 6000 LBS.
9. UNLESS OTHERWISE SPECIFIED, AS-CAST SURFACE PROFILE
TOLERANCE: $\pm .25$ - INCHES. WITH EXEMPTION FOR INTERSECTING SURFACES
WHERE FILLETS ARE EXPECTED. MIN FILLET AND CORNER RADI: $0.5 \sqrt{.4} \sim 0.1$ - IN.
10. DESIGNATED SURFACE REGIONS HAVE PROFILE TOLERANCE: ± 0.125 - IN.
11. MIN THICKNESS PER CAD GEOMETRY. TOLERANCE: ± 0.25 - IN / ± 0.1 - IN.
12. PARTING LINE EDGES, FLASH, GATES, RUNNER, AND RISER EXTENSIONS 0.25 - IN MAX
13. UNLESS OTHERWISE SPECIFIED, MACHINED SURFACE PROFILE TOLERANCE: ± 0.01 - IN
14. BACK SPOTFACE ALL THRU HOLES MINIMUM TO CLEAN UP.
15. SEE LATEST REVISION OF SPECIFICATION MCS5-CSPCE-141-03
FOR ADDITIONAL REQUIREMENTS.

RELEASED FOR
FABRICATION / INSTALLATION
JERRY SIEGEL

AR	X		SE141-116	WINDING FORM TYPE-C	CAST SS	SEE NOTE #15	I
KIT		CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIN
1.			← NEXT ASSEMBLY	PARTS LIST			

NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS
MADE AS TO THE ACCURACY, COMPLETENESS OR RELIABILITY OF THE
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FORFEITING CONTRACTOR.

P THIS DRAWING PRODUCED
ON PRO-ENGINEER

[illegible]



04-15



BOTTOM VIEW
SCALE 0.25

PPPL Drafting: Jerry Siegel

UT-BATTELLE

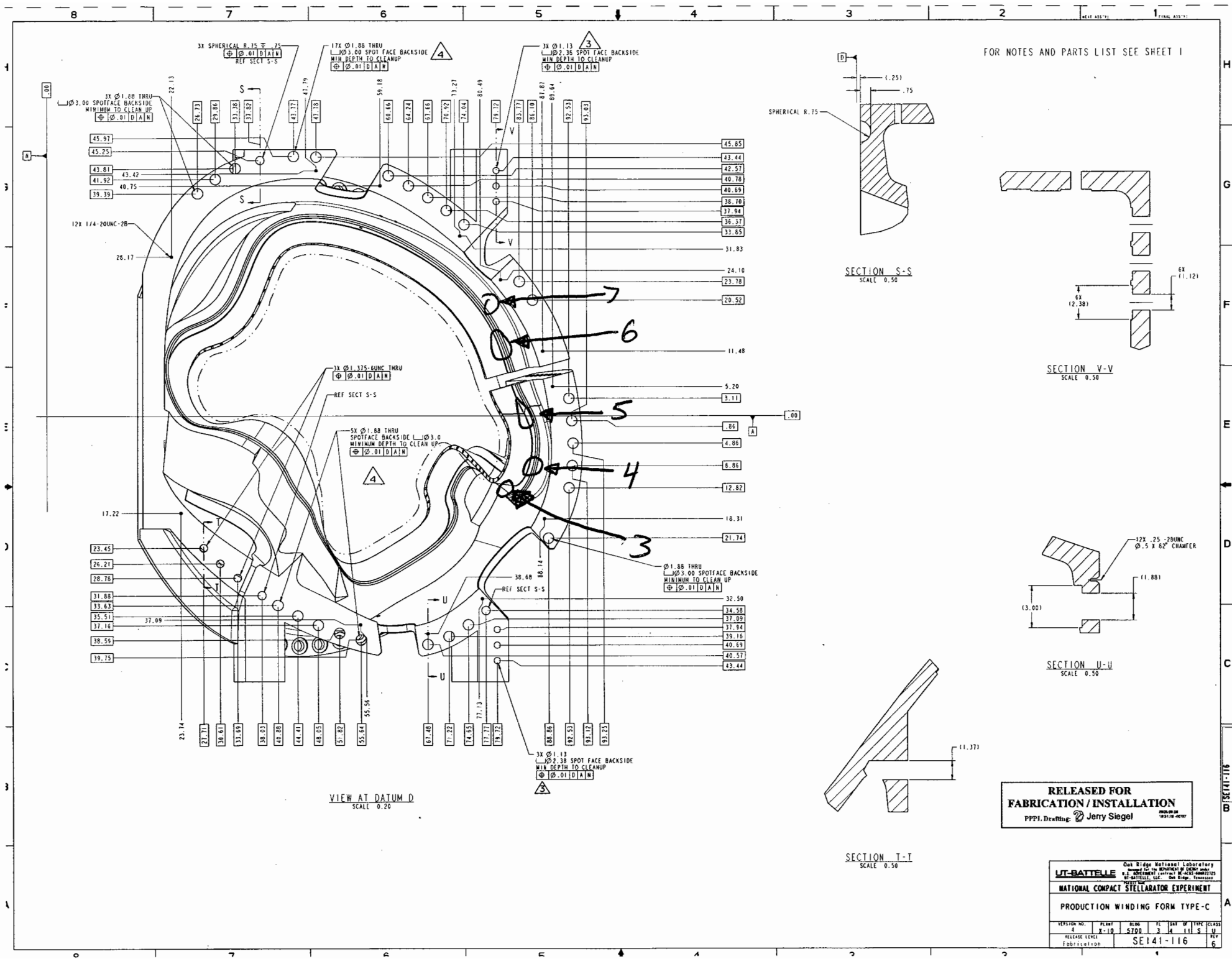
Oak Ridge National Laboratory
Managed for the DEPARTMENT OF ENERGY
U.S. GOVERNMENT CONTRACT NO. W-401-58-ENG-27-225
UT-BATTELLE, LLC Oak Ridge, Tennessee
MEMPHIS 24

NATIONAL COMPACT STELLATORATOR EXPERIMENT

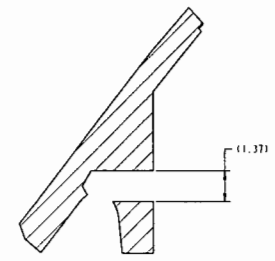
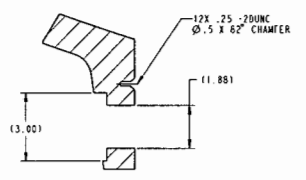
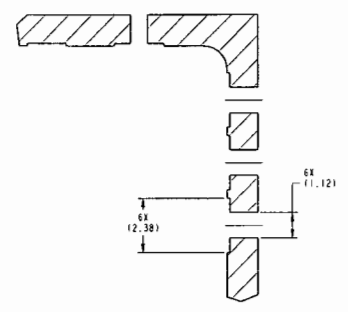
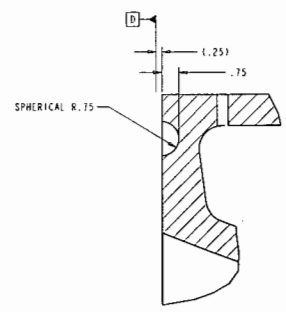
PRODUCTION WINDING FORM TYPE-C

VERSION NO.	PLANT	BLOG	FI	SPT	TYPE	CLASS
4	K-10	5700	3	3	11 S	U NEW
RELEASE LEVEL						
FORM NO.						

SEI-116



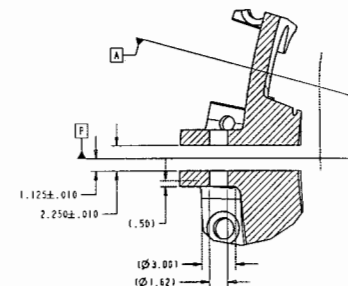
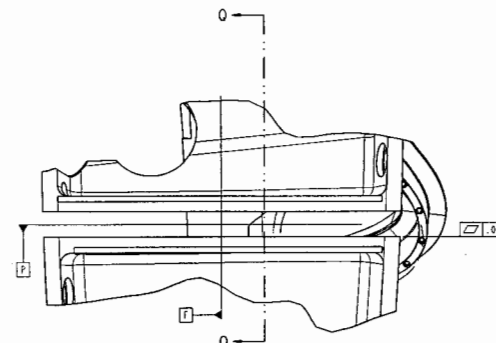
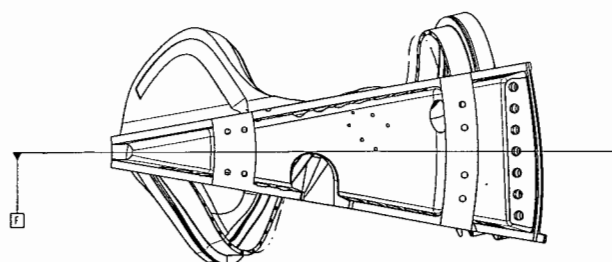
FOR NOTES AND PARTS LIST SEE SHEET 1



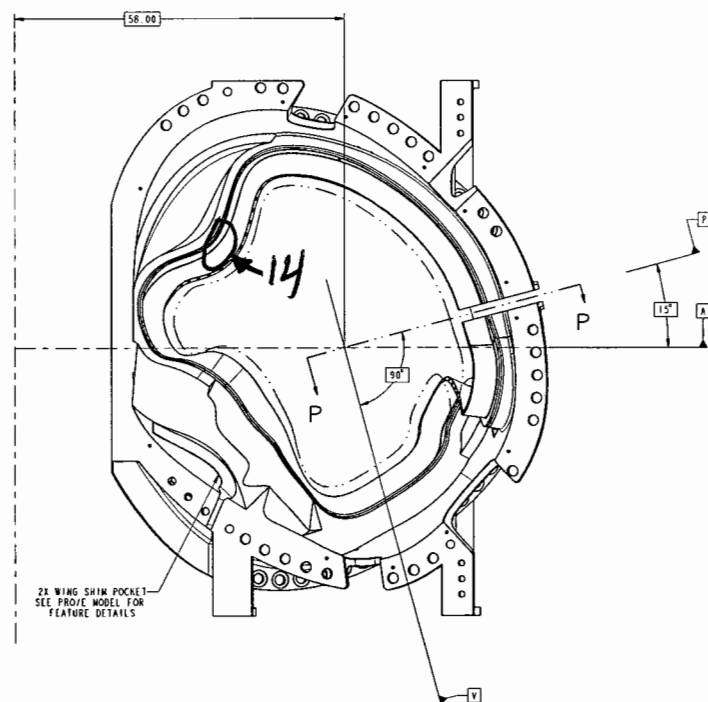
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PPPI Drafting Jerry Siegel

UT-BATTELLE					
Oak Ridge National Laboratory managed by Lockheed Martin Research Corp. for the U.S. Department of Energy under contract number DE-AC02-84OR21400 BATTELLE, LLC, One Bridge, Tennessee					
NATIONAL COMPACT STELLATOR EXPERIMENT					
PRODUCTION WINDING FORM TYPE-C					
VERSION NO.	4	PLANT	R-10	BLDG	314
RELEASE LEVEL	SE141-116				
Fabrication					

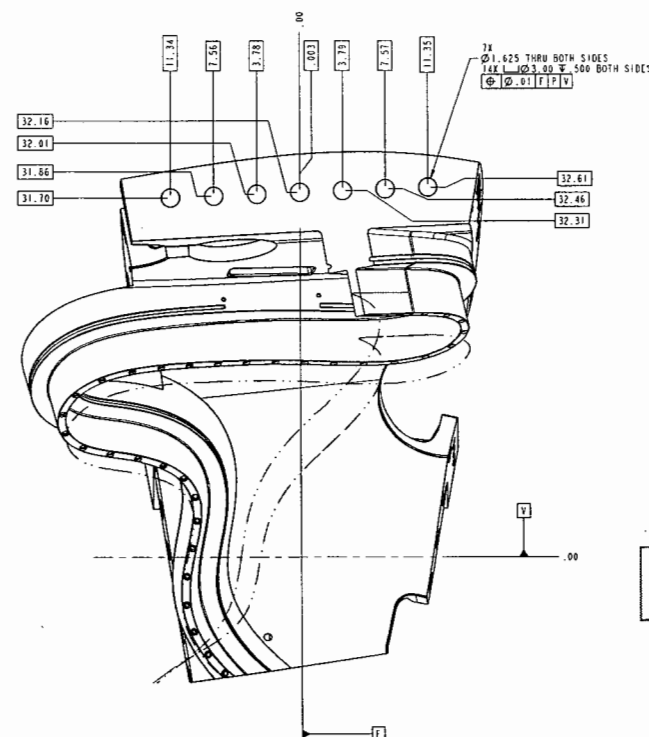
FOR NOTES AND PARTS LIST SEE SHEET 1



SECTION Q-Q



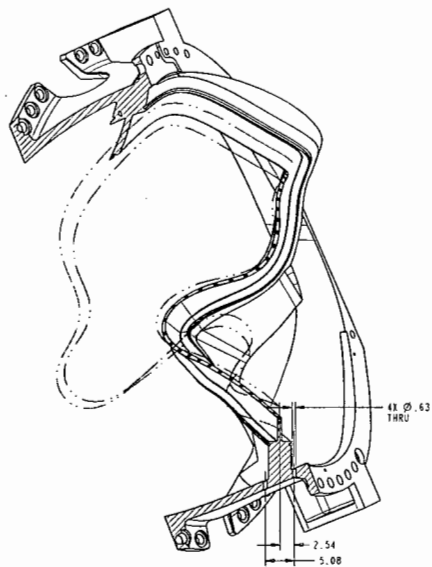
POLOIDAL BREAK DETAIL



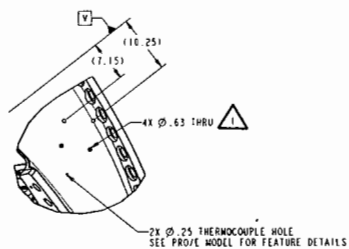
SECTION P-P
SCALE 0.75

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2001.08.08
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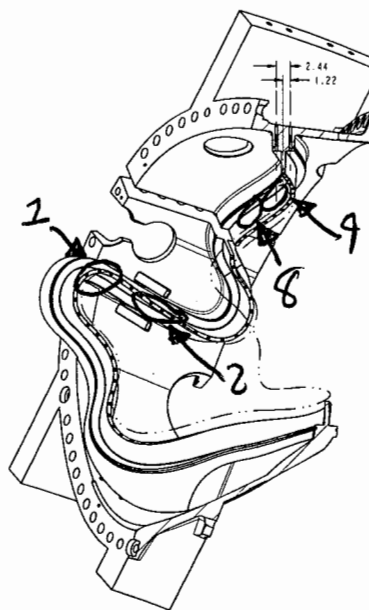
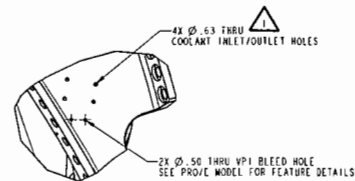
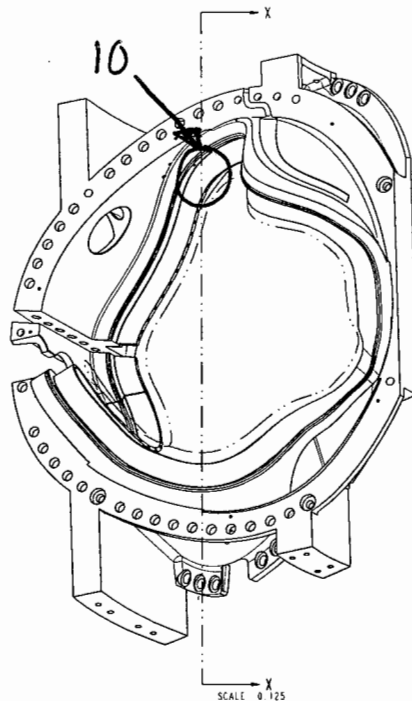
UT-BATTELLE					
Oak Ridge National Laboratory managed by the UNIVERSITY OF TENNESSEE for the U.S. DEPARTMENT OF ENERGY BETHEVA, TENNESSEE					
NATIONAL COMPACT STELLARATOR EXPERIMENT					
PRODUCTION WINDING FORM TYPE-C					
VERSION NO.	4	REV	1	DATE	11/15/94
REVISION LEVEL	SE141-116				
FABRICATION					



SECTION X-X
USE PROVE MODEL GEOMETRY TO
DETERMINE SECTION ORIENTATION

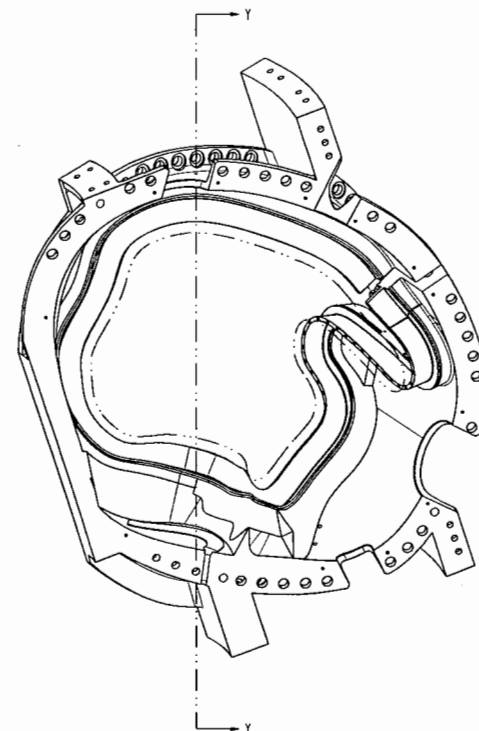


COOLING INLET / OUTLET HOLES -
TYPICAL 2 PLACES



SECTION Y-Y
SCALE 0.125

USE PROVE MODEL GEOMETRY TO
DETERMINE SECTION ORIENTATION



FOR NOTES AND PARTS LIST SEE SHEET 1

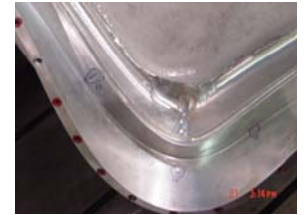
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PPPL Drafting: Jerry Siegel

UT-BATTELLE Oak Ridge National Laboratory managed by the Department of Energy under contract number DE-AC05-84OR21400 UT-BATTELLE, LLC, One Bridge, Tennessee					
NATIONAL COMPACT STELLARATOR EXPERIMENT					
PRODUCTION WINDING FORM TYPE-C					
VERSION NO.	PLANT	BLDG	FL	FRONT OF TYPE	RELEASE
4	R-10	5200	3	19	10
RELEASE LEVEL Fabrication					
SE141-116					



C1 MCWF

Photos for NC18236



K. Bowling 21-Sep-05

