

**Customer: ENERGY INDUSTRIES OF OHIO**

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

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

**Part: /**

Drawing ID: SE141-116

Revision: 7

Customer P.O.: S005242-F/Ln:2  
Serial No./Qty: C2

Reported By: MIKE GRIFFITH

E-Mail: mGriffith@MajorTool.com

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

Problem: Workorder: 65707/2.0 Sub:1 Op:134

Inspection Test #: 140 rejected: P TO M: {g|.1|R|S|T}: REFERENCE IGES DATA

Inspection Test #: 180 rejected: M TO N: {g|.02|R|S|T}: REFERENCE IGES DATA

Inspection Test #: 190 rejected: 96X

Ø.375-16 UNC .188 DEEP

C'BORE Ø.625 AS SHOWN: {#.01|R|S|T}: .077 POSITION / ACCEPT THREAD / .624 CBORE

Inspection Test #: 210 rejected: 8X Ø1-8 UNC THRU: {#.01|A|B|C}: .038

Inspection Test #: 230 rejected: : {f|.01}: 0.020

Inspection Test #: 250 rejected: : {f|.01}: 0.016

Inspection Test #: 260 rejected: : R76.00: 75.750 - 75.925

Inspection Test #: 270 rejected: : R73.70: 73.723

Inspection Test #: 280 rejected: 8X

Ø1.13 THRU

BACK SPOT FACE Ø2.38

MIN DEPTH FOR C'UP: {#.01|A|B|C}: .027 / 1.12 - 1.13 / ACCEPT SPOT

Inspection Test #: 290 rejected: 3X Ø1.88 THRU

Ø3.00 BACK SPOTFACE

MIN TO CLEANUP: {#.010|D|A|N}: .027 / 1.87 - 1.88 / ACCEPT CLEAN UP

Inspection Test #: 295 rejected: 3 X SPHERICAL R.750 +.002 / -.003

TOLERANCE CHANGE PER

RFD 14-009 ITEM 5.

DATUM -D- FLANGE.: : .753 / .764 / .763

Inspection Test #: 300 rejected: 3X SPH R.75 TO .75 DEEP: {#|d.01|D|A|N}: TP .020 / .74 DEEP

Inspection Test #: 310 rejected: 17X Ø1.88 THRU

Ø3.00 BACK SPOTFACE

MIN TO CLEANUP: {#|d.01|D|A|N}: 0.102 / 1.87 - 1.88 / 3.00 CLEAN UP

Inspection Test #: 320 rejected: 3X Ø1.13

Ø2.38 BACK SPOTFACE

MIN TO CLEANUP: {#|d.01|D|A|N}: 0.041 / 1.12 - 1.13 / 3.2 CLEAN UP

Inspection Test #: 340 rejected: 3X Ø1.375-6 UNC THRU: {#|d.01|D|A|N}: .038 / ACCEPT THREADS

Inspection Test #: 350 rejected: 5X Ø1.88 THRU

Ø3.00 BACK SPOTFACE

MIN TO CLEANUP: {#|d.01|D|A|N}: .0182 / 1.87 - 1.88 / 2.98 - 2.99

Inspection Test #: 360 rejected: Ø1.88 THRU

Ø3.00 BACK SPOTFACE

MIN TO CLEANUP: {#|d.01|D|A|N}: .0184 / 1.88 / 2.99

Inspection Test #: 370 rejected: 3X Ø1.13

Ø2.38 BACK SPOTFACE

MIN TO CLEANUP: {#|d.01|D|A|N}: .028 / 1.13 - 1.27 / 3.2 CLEAN UP

Inspection Test #: 380 rejected: Ø1.88 THRU

Ø3.00 BACK SPOTFACE

MIN TO CLEANUP: {#|d.01|E|A|J}: .015

Inspection Test #: 410 rejected: 3X SPH R.75 TO .75 DEEP

: {#|d.01|E|A|J}: TP .0172

Inspection Test #: 430 rejected: 24X Ø1.88 THRU

Ø3.00 BACK SPOTFACE

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MIN TO CLEANUP: {#d.01|E|A|J}: .070 / 3.00 CLEANUP  
Inspection Test #: 440 rejected: 3X Ø1.5 TO 2.00 DEEP  
Ø3.00 TO 1.00 DEEP: {#d.01|E|A|J}: .051 / 2.99 / 1.00 DEEP  
Inspection Test #: 630 rejected: : R4.00 ~ .010: 3.90  
Inspection Test #: 650 rejected: : 4.00 ~ .010: 3.97  
Inspection Test #: 670 rejected: : R4.00 ~ .010: 3.98  
Inspection Test #: 710 rejected: : d8.00 ~ .010: 7.990-8.265 (0.275 OOR)  
Inspection Test #: 760 rejected: : 13.6 ~ 13.20  
Inspection Test #: 770 rejected: : 5.88 ~ .010: PAD BLENDS INTO CAST SUFACE  
Inspection Test #: 780 rejected: : 2.19 ~ .010: 2.1  
Inspection Test #: 790 rejected: : 2.19 ~ .010: 2.17  
Inspection Test #: 800 rejected: : 4X R.50: BOTTOM RADII BLEND INTO CAST SURFACE  
Inspection Test #: 880 rejected: : d8.00 ~ .010: 7.980-8.265 0.075 OOR  
Inspection Test #: 990 rejected: : {g|.5|A|B|C}: REFERENCE IGES DATA  
Inspection Test #: 1000 rejected: : {g|.02|R|T|S}: REFERENCE IGES DATA  
Inspection Test #: 1020 rejected: : {g|.02|R|T|S}: REFERENCE IGES DATA  
Inspection Test #: 1030 rejected: : {g|.5|A|B|C}: REFERENCE IGES DATA  
Inspection Test #: 1070 rejected: : 47.79 ~ .010: 47.776  
Inspection Test #: 1100 rejected: : 80.49: 80.469  
Inspection Test #: 1110 rejected: : 87.87 ~ .010: 87.838  
Inspection Test #: 1120 rejected: : 89.64 ~ .010: 89.584  
Inspection Test #: 1150 rejected: : 11.48 ~ .010: 11.463  
Inspection Test #: 1290 rejected: : 88.39 ~ .010: 88.371  
Inspection Test #: 1320 rejected: : 28.71 ~ .010: 28.721  
Inspection Test #: 1340 rejected: : 22.117 ~ .005: 22.109  
Inspection Test #: 1350 rejected: : 38.14 ~ .010: 38.152  
Inspection Test #: 1380 rejected: : 7.53 ~ .010: 7.555  
Inspection Test #: 1390 rejected: : 4.91 ~ .010: 4.879

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**Proposed Disposition:**

CUSTOMER TO ADVISE ON ACCEPTABILITY OF DIMENSIONAL INSPECTION.

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Number of additional pages: \_\_\_\_\_

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**Customer Disposition:**     Use As Is     Rework     Repair     Scrap     Replace

Dimensional discrepancies were evaluated per attached list and found to be acceptable.

**Technical Rep. Approval:**

**RLM Approval:**

**Major Tool Implemented By:** \_\_\_\_\_

**Title:** \_\_\_\_\_

**Date:** \_\_\_\_\_

Inspection Test #: 140 rejected: P TO M: {g|.1|R|S|T}: REFERENCE IGES DATA  
**OK PER EVALUATION BY T. BROWN / S. RAFTOPOLOUS**

Inspection Test #: 180 rejected: M TO N: {g|.02|R|S|T}: REFERENCE IGES DATA  
**OK PER EVALUATION BY T. BROWN / S. RAFTOPOLOUS**

Inspection Test #: 190 rejected: 96X Ø.375-16 UNC .188 DEEP C'BORE Ø.625 AS SHOWN: {#|.01|R|S|T}: .077 POSITION / ACCEPT THREAD / .624 CBORE  
**OK, C2 TEE HOLE POSITION IS OUT .077 MAX , BETTER THAN C1 (.165 MAX)**

Inspection Test #: 210 rejected: 8X Ø1-8 UNC THRU: {#|.01|A|B|C}: .038  
**OK, POSITION TOLERANCE SIMILAR TO C1, THIS IS A CLEARANCE HOLE W/ BUSHING**

Inspection Test #: 230 rejected: : {f|.01}: 0.020  
**OK, FLATNESS TOL FOR FLANGE DATUM-E SIMILAR TO C1**

Inspection Test #: 250 rejected: : {f|.01}: 0.016  
**OK, FLATNESS TOL FOR FLANGE DATUM-D SIMILAR TO C1**

Inspection Test #: 260 rejected: : R76.00: 75.750 - 75.925  
**OK, INNER RADIUS OF OUTER TF SHELF, INTERFACE NOT CRITICAL**

Inspection Test #: 270 rejected: : R73.70: 73.723  
**OK, OUTER RADIUS OF OUTER TF SHELF, INTERFACE NOT CRITICAL**

Inspection Test #: 280 rejected: 8X Ø1.13 THRU BACK SPOT FACE Ø2.38 MIN DEPTH FOR C'UP: {#|.01|A|B|C}: .027 / 1.12 - 1.13 / ACCEPT SPOT  
**OK, C2 HOLE POSITION IS OUT .027 MAX, BETTER THAN C1 (.054 MAX)**

Inspection Test #: 290 rejected: 3X Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP: {#|.010|D|A|N}: .027 / 1.87 - 1.88 / ACCEPT CLEAN UP  
**OK, THIS IS A CLEARANCE HOLE W/ BUSHING**

**Inspection Test #: 295 rejected: 3 X SPHERICAL R.750 +.002 / -.003 TOLERANCE CHANGE PER RFD 14-009 ITEM 5. DATUM -D- FLANGE.: : .753 / .764 / .763**  
**DISCUSS WITH PPPL, NUMBERS ARE DIFFERENT ON CHECKLIST (.758/.752/.750)**

Inspection Test #: 300 rejected: 3X SPH R.75 TO .75 DEEP: {#|d.01|D|A|N}: TP .020 / .74 DEEP  
**DISCUSS WITH PPPL**

**Inspection Test #: 310 rejected: 17X Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP: {#|d.01|D|A|N}: 0.102 / 1.87 - 1.88 / 3.00 CLEAN UP**  
**LARGEST POSITIONAL ERROR, CHECK IGES DATA FOR LOCATION, NUMBER, DISCUSS**

Inspection Test #: 320 rejected: 3X Ø1.13 Ø2.38 BACK SPOTFACE MIN TO CLEANUP: {#|d.01|D|A|N}: 0.041 / 1.12 - 1.13 / 3.2 CLEAN UP  
**OK, C2 HOLE POSITION IS OUT .041 MAX, BETTER THAN C1 (.054 MAX)**

Inspection Test #: 340 rejected: 3X Ø1.375-6 UNC THRU: {#|d.01|D|A|N}: .038 / ACCEPT THREADS  
**OK, SAME POSITION ERROR AS THRU HOLES, MATES CLEARANCE HOLE W/ BUSHING**

Inspection Test #: 350 rejected: 5X Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP: {#|d.01|D|A|N}: .0182 / 1.87 - 1.88 / 2.98 - 2.99  
**OK, THIS IS A CLEARANCE HOLE W/ BUSHING**

Inspection Test #: 360 rejected: Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP: {#|d.01|D|A|N}: .0184 / 1.88 / 2.99  
**OK, THIS IS A CLEARANCE HOLE W/ BUSHING**

Inspection Test #: 370 rejected: 3X Ø1.13 Ø2.38 BACK SPOTFACE MIN TO CLEANUP: {#|d.01|D|A|N}: .028 / 1.13 - 1.27 / 3.2 CLEAN UP  
**OK, C2 HOLE POSITION IS OUT .028 MAX, BETTER THAN C1 (.054 MAX)**

Inspection Test #: 380 rejected: Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP: {#|d.01|E|A|J}: .015 (positional error)  
**OK, THIS IS A CLEARANCE HOLE W/ BUSHING**

Inspection Test #: 410 rejected: 3X SPH R.75 TO .75 DEEP : {#|d.01|E|A|J}: TP .0172  
**OK, FEATURE LOCATION ESTABLISHED BY ROMER PRIOR TO ASSEMBLY**

Inspection Test #: 430 rejected: 24X Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP: {#|d.01|E|A|J}: .070 / 3.00 CLEANUP  
**OK, THIS IS A CLEARANCE HOLE W/ BUSHING**

Inspection Test #: 440 rejected: 3X Ø1.5 TO 2.00 DEEP Ø3.00 TO 1.00 DEEP: {#|d.01|E|A|J}: .051 / 2.99 / 1.00 DEEP  
**OK, FEATURE LOCATION ESTABLISHED BY ROMER PRIOR TO ASSEMBLY**

Inspection Test #: 630 rejected: : R4.00 ~ .010: 3.90  
**OK, DIM REFERENCES PORT OPENING, LARGE CLEARANCE**

Inspection Test #: 650 rejected: : 4.00 ~ .010: 3.97  
**OK, DIM REFERENCES PORT OPENING, LARGE CLEARANCE**

Inspection Test #: 670 rejected: : R4.00 ~ .010: 3.98  
**OK, DIM REFERENCES PORT OPENING, LARGE CLEARANCE**

Inspection Test #: 710 rejected: : d8.00 ~ .010: 7.990-8.265 (0.275 OOR)  
**OK, DIM REFERENCES PORT OPENING, LARGE CLEARANCE**

Consider changing tolerance

Inspection Test #: 760 rejected: : 13.6 ~ 13.20  
OK, DIM REFERENCES LEADS AREA

Inspection Test #: 770 rejected: : 5.88 ~ .010: PAD BLENDS INTO CAST SUFACE  
OK, DIM REFERENCES LEADS AREA

Inspection Test #: 780 rejected: : 2.19 ~ .010: 2.1  
OK, DIM REFERENCES LEADS AREA

Inspection Test #: 790 rejected: : 2.19 ~ .010: 2.17  
OK, DIM REFERENCES LEADS AREA

Inspection Test #: 800 rejected: : 4X R.50: BOTTOM RADII BLEND INTO CAST SURFACE  
OK, DIM REFERENCES LEADS AREA

Inspection Test #: 880 rejected: : d8.00 ~ .010: 7.980-8.265 0.075 OOR  
OK, DIM REFERENCES PORT OPENING, LARGE CLEARANCE

Inspection Test #: 990 rejected: : {g|.5|A|B|C}: REFERENCE IGES DATA  
OK PER EVALUATION BY T. BROWN / S. RAFTOPOLOUS

Inspection Test #: 1000 rejected: : {g|.02|R|T|S}: REFERENCE IGES DATA  
OK PER EVALUATION BY T. BROWN / S. RAFTOPOLOUS

Inspection Test #: 1020 rejected: : {g|.02|R|T|S}: REFERENCE IGES DATA  
OK PER EVALUATION BY T. BROWN / S. RAFTOPOLOUS

Inspection Test #: 1030 rejected: : {g|.5|A|B|C}: REFERENCE IGES DATA  
OK PER EVALUATION BY T. BROWN / S. RAFTOPOLOUS

Inspection Test #: 1070 rejected: : 47.79 ~ .010: 47.776  
OK, DIM REFERENCES ¼-20 HOLES FOR SHIM ATTACH

Inspection Test #: 1100 rejected: : 80.49: 80.469  
OK, DIM REFERENCES ¼-20 HOLES FOR SHIM ATTACH

Inspection Test #: 1110 rejected: : 87.87 ~ .010: 87.838  
OK, DIM REFERENCES ¼-20 HOLES FOR SHIM ATTACH

Inspection Test #: 1120 rejected: : 89.64 ~ .010: 89.584  
OK, DIM REFERENCES ¼-20 HOLES FOR SHIM ATTACH

Inspection Test #: 1150 rejected: : 11.48 ~ .010: 11.463  
OK, DIM REFERENCES ¼-20 HOLES FOR SHIM ATTACH

Inspection Test #: 1290 rejected: : 88.39 ~ .010: 88.371  
OK, DIM REFERENCES ¼-20 HOLES FOR SHIM ATTACH

Inspection Test #: 1320 rejected: : 28.71 ~ .010: 28.721  
OK, DIM REFERENCES ¼-20 HOLES FOR SHIM ATTACH

Inspection Test #: 1340 rejected: : 22.117 ~ .005: 22.109  
OK, DIM REFERENCES ¼-20 HOLES FOR SHIM ATTACH

Inspection Test #: 1350 rejected: : 38.14 ~ .010: 38.152  
OK, DIM REFERENCES ¼-20 HOLES FOR SHIM ATTACH

Inspection Test #: 1380 rejected: : 7.53 ~ .010: 7.555  
OK, DIM REFERENCES ¼-20 HOLES FOR SHIM ATTACH

Inspection Test #: 1390 rejected: : 4.91 ~ .010: 4.879  
OK, DIM REFERENCES ¼-20 HOLES FOR SHIM ATTACH

MTM is requested to add Visual Manufacturing references on data lists.