Counterbore adjacent to Poloidal Break on E Flange.JPG

Counterbore is next to Poloidal Break on the E flange. Approximately 60% of counterbore cleaned up 100%. The area of non cleanup has tooling gouges and is approximately .050” in depth.
Noncleanup of foot on back side of D flange.jpg

This area is beneath the leg shown on sheet 4, zone C5. Instead of the 2.38” spot face on the back side, we typically machine this entire surface to a full clean up. The two holes in this view do not have a 100% cleanup. The photo below shows that the flange thickness in this area is approximately 1.100” in the thinnest cross section.

D flange foot thickness of 1.100.jpg
Tool Gouge short leg E37 wide view.JPG

This is a tooling gouge on the short leg of the “T” on the E flange side located close to hole 37. The gouge is approximately .590” in length by .200” wide and .005” in depth.

Tool Gouge short leg E side adjacent to hole 37.JPG
This is a tooling gouge on the short leg of the “T” on the E flange side located close to hole 83. The gouge is approximately 2.200” in length by .200” wide and .008” in depth.
This is a tooling gouge on the short leg of the “T” on the E flange side located close to hole 57. The gouge is approximately .800” in length by .200” wide and .010” in depth.
These pictures show the interference below the VPI groove located adjacent to poloidal break on the D side from hole 11 to 13. The interference to the gage is approximately .100” - .200” over a length of about 10”.
These pictures show the interference below the VPI groove located on the D side from hole 45 to 50. The interference to the gage is approximately .200” - .300” over a length of about 15”.
The above pictures show noncleanup after final machining on the large flange of the D side. The depths are approximately .02 - .04”.
This photo shows a tooling gouge in the cast wall located below the 6.5" opening shown on sheet 7 section view PT11. Gouge is approximately 1.470” x .800. The casting wall in this area measures 1.3”. The gouge is approximately .25” in depth.