
Customer: ENERGY INDUSTRIES OF OHIO

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Part: SE141-114 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-114 Revision: 6
Links: 1-Type:W: 65709/1.0 Sub: 1 Op: 100

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: A1

Reported By: MIKE GRIFFITH
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Problem: PART IS REJECTED PER ASTM A903/A903M LEVEL 1.
SEE ATTACHMENT FOR SIZES AND LOCATIONS.

Rev. 1
5-31-06 Attachment revised to include additional photo of item 15.

Proposed Disposition:

Propose to Use As Is.

Number of additional pages: 12 page attachment

Customer Disposition: Use As Is Rework Repair Scrap Replace

The attached group of indications were reviewed during a conference call between F. Malinowski, R. Sheppard, M. Griffith, (who were all at MTM) and D. Williamson and P. Heitzenroeder on 5/24/06. After consideration of each, it was determined that all are accepted as is based on an assessment of the stress in these regions (which were acceptably low).

Accepted by:

Tech. Rep.

RLM

Major Tool Implemented By: _____ **Title:** _____ **Date:** _____

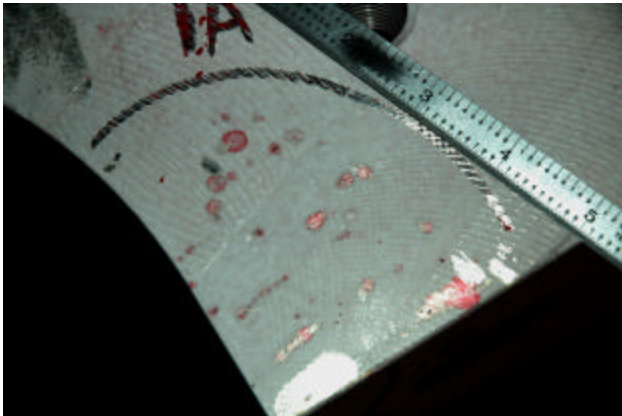
PT Inspection Results of A1 – NC19891

Rev. 1 – revised to include addition photo of item 15.

1. Cluster of linear indications – longest is 2". Reference dwg. Sheet 4, zone G6. The indications are on the edge of the large cutout. These indications were previously reported (see the picture to the left). The photo on the right is of the final PT inspection.



- 1a. Cluster of linear indications. Longest is .600". These indications are adjacent to the area shown in #1 but are on the face of the foot. See dwg. Sheet 3, zone F4.

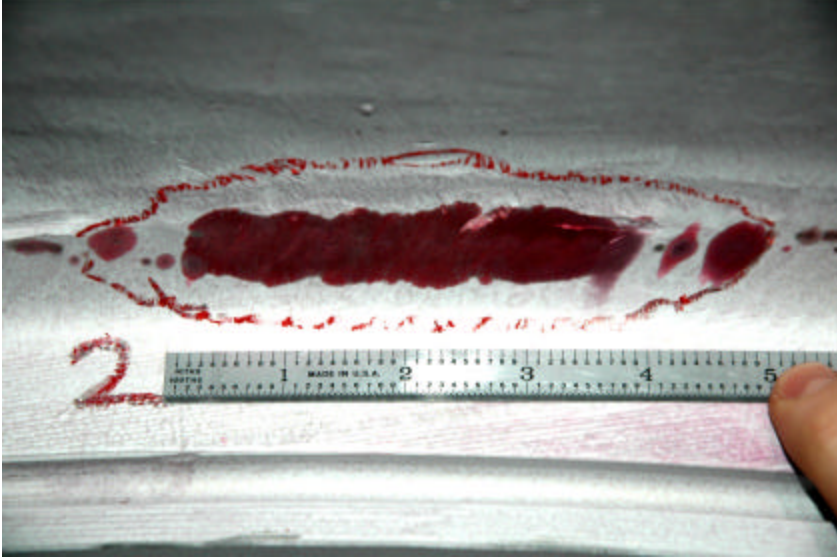


- 1b. Rounded and linear indications. Longest is .400". These indications are also adjacent to #1 but are on the Datum D flange face. The picture on the right is of the indication when previously noted prior to final machining.

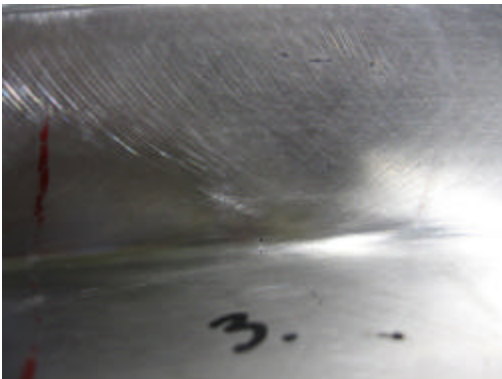
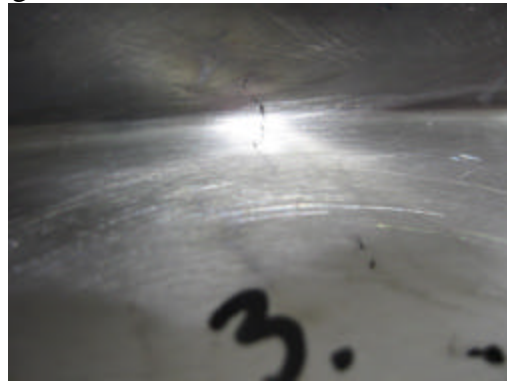
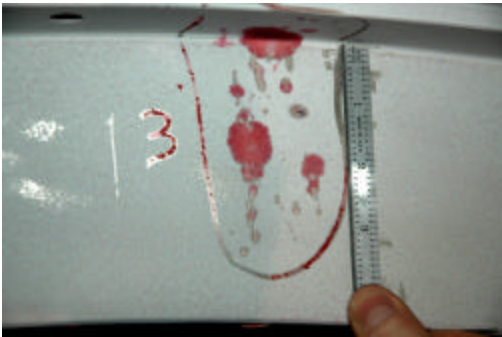


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2. Linear indication, 3.6" in length. Indication is beneath the VPI groove in the radius of the inner casting wall. (D flange side close to hole 30).

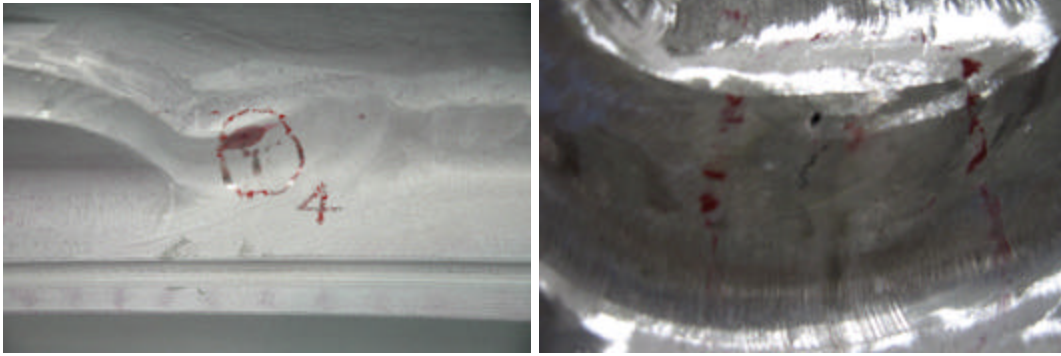


3. Linear and rounded cluster, longest is 2". Located on D flange side close to hole 30. Along both the long and short legs.

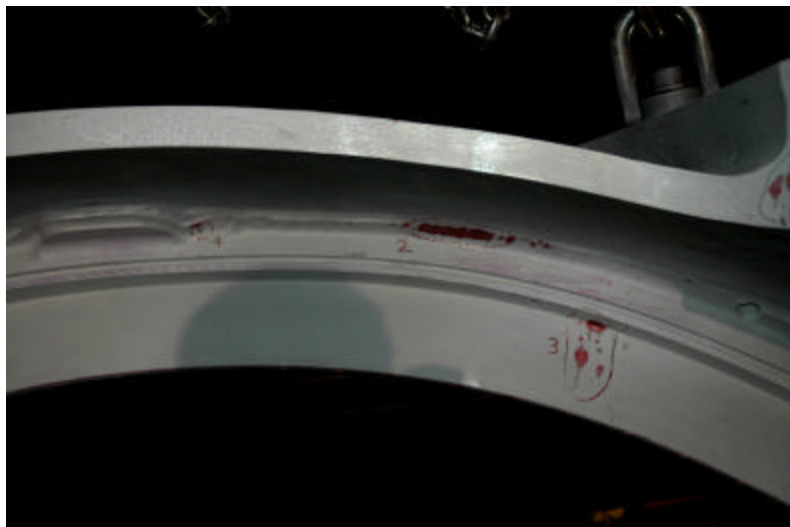


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4. Linear cluster, longest is .400". Located on D side close to hole 34. Beneath VPI.



Pictures of Indications 1 – 4.

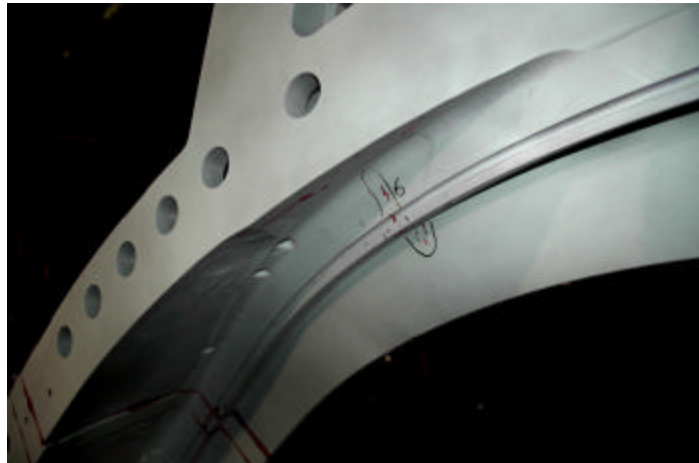


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5. Rounded and linear cluster, longest is .400". Located on D side close to hole 77.



6. Rounded and linear cluster, longest is .750". Located on E side close to hole 28.



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7. Rounded and linear cluster, longest is .500". Located on E flange side close to hole 43.



8. Rounded and linear cluster, longest is .300". Located on E flange side close to hole 76.



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9. Single linear, .350" in length. Located on E side close to hole 80.



10. Linear cluster, longest is 1". Located on E side close to hole 80.

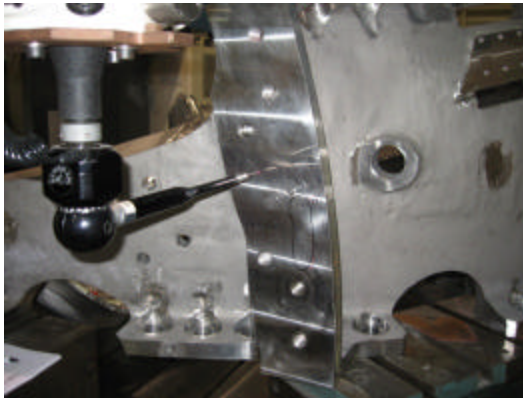


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Pictures of Indications 8-10.

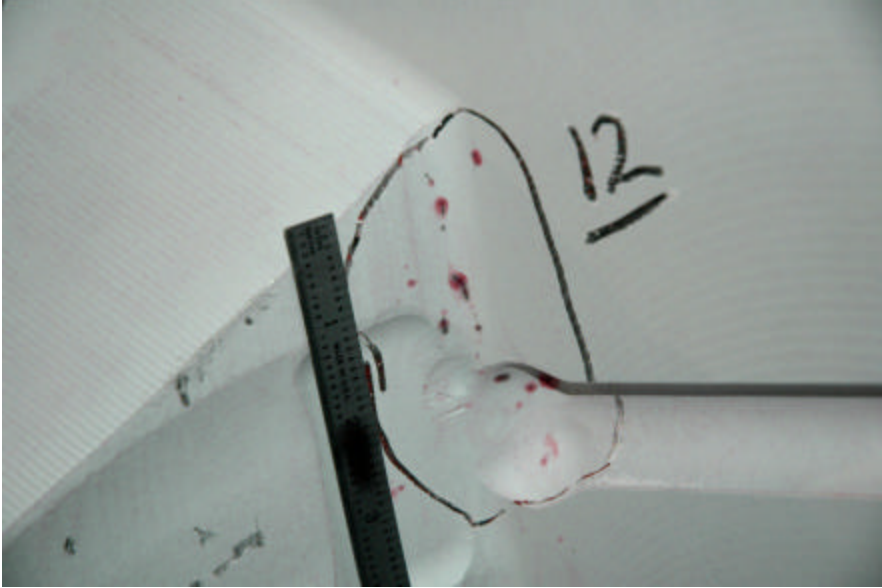


11. Linear cluster, longest is 1.9". See sheet 3, zone C4. On face of foot, located closest to datum D flange.



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12. Linear and rounded cluster, longest is .300". See sheet 5, zone D5.



13. Linear cluster in wall of counterbore relief. Longest is .500". Located on sheet 5, zone C6, 44.87" from Datum A.

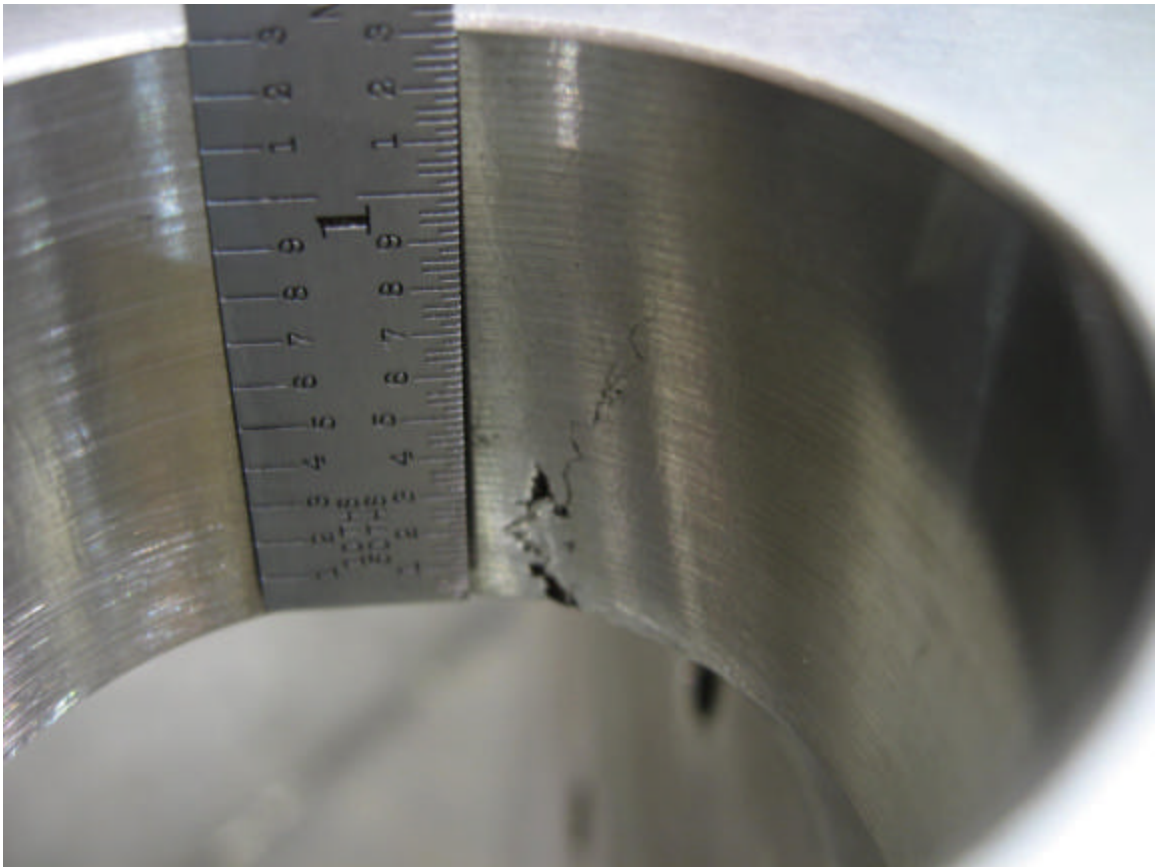


14. .700" long linear in counterbore relief. Located on sheet 5, zone G6, 40.28" from Datum A.



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15. Indication with a total length of approx. 1.700". Indication starts at edge of relief, travels down the side approx. .700", along the face approx. .5" and down the wall of the hole approx. .500". Located on sheet 5, zone G6, 43.40" from Datum A.

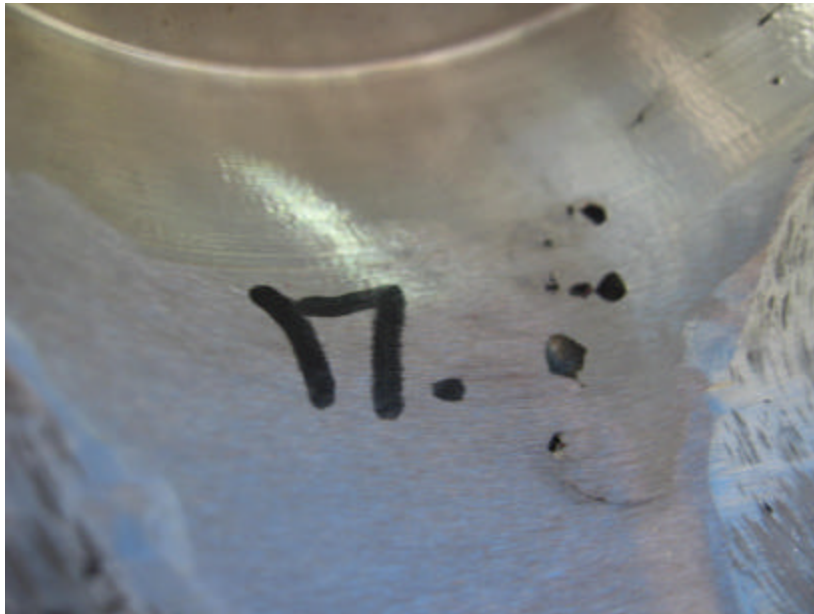


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16. Linear cluster on 4.0" diameter boss, longest is .600". Located on Sheet 3, zone F4.



17. Rounded cluster, largest is .130". Located on sheet 4, zone D5, 32.35 from datum A.

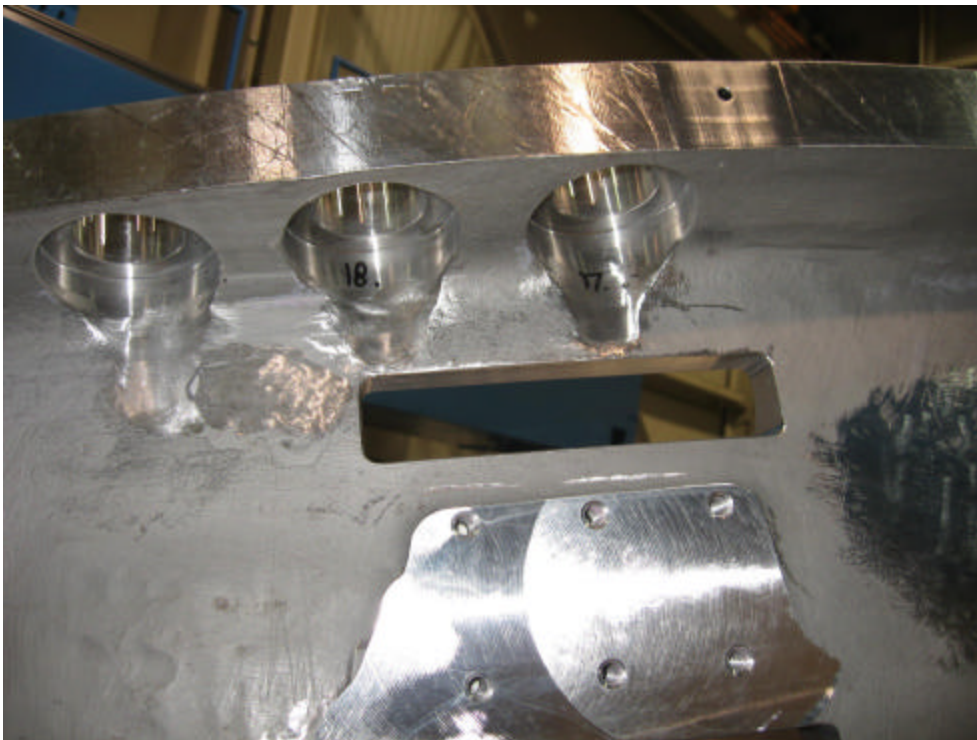


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18. .200" rounded indication. Located on sheet 4, zone C5, 35.37 from datum A.



Pictures of Indications 17-18.



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19. .750" long linear located on sheet 3, zone C6.



