

Customer: ENERGY INDUSTRIES OF OHIO

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

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

Part: SE141-114 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-114 Revision: 6

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

Reported By: MIKE GRIFFITH
E-Mail: mGriffith@MajorTool.com

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

Problem: SEVERAL MISCELLANEOUS ITEMS WERE FOUND DURING THE FINAL VISUAL INSPECTION OF THE PART. SEE ATTACHMENT FOR DETAILS.

Proposed Disposition:

PROPOSE TO USE AS IS.

Number of additional pages: 10 page attachment

Customer Disposition: Use As Is Rework Repair Scrap Replace

The list was reviewed during a conference call attended by J. Chrzanowski, F. Malinowski, D. Williamson, L. Sutton, and P. Heitzenroeder. M. Griffith was added to the call to discuss the "short" G-10 insulators which are mostly due to the stocking on the casting. He agreed that all remaining insulators will be extended as required. The list of miscellaneous defects was dispositioned as indicated below:

#1-Accept as is; PPPL will install Gl/Ep in the gaps after VPI is completed. MTM agreed to make remaining insulators extend to the edge of the parts.

#2-Accept as is.

#3-Accept as is; PPPL will install Gl/Ep in the gaps after VPI is completed. MTM agreed to make remaining insulators extend to the edge of the parts.

#4-" "

#5-Accept as is. PPPL will verify that dye will not degrade G-10.

#6-Accept as is.

#7-Accept as is.

#8-Accept as is.

#9-Accept as is.

#10-Accept as is.

#11-Accept as is.

#12-Accept as is.

#13-Accept as is.

#14-Accept as is.

Approved by:

Tech. Rep.

RLM

Major Tool Implemented By: _____

Title: _____

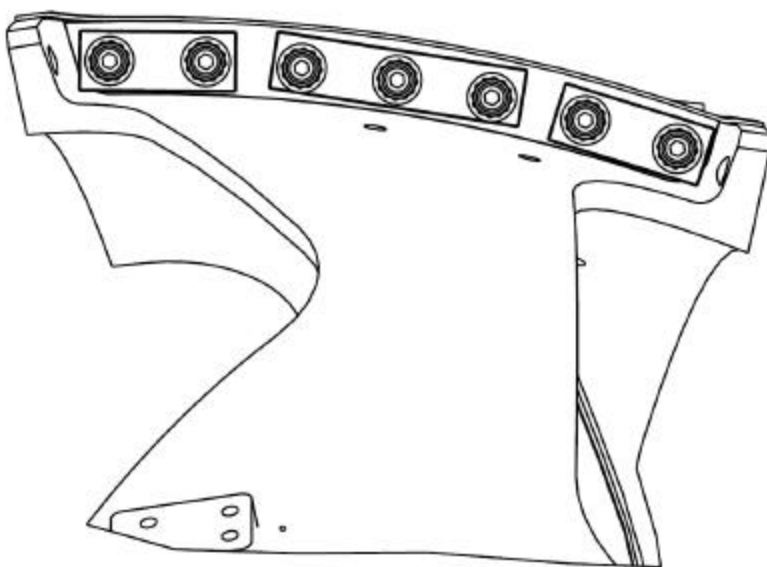
Date: _____

SE141-114 A1
NC19933 attachment

1. G11 shim between break flanges and bearing plates.



G11 shim has a full radius on both ends. The drawing shown below shows only the radius toward the inside cast wall.

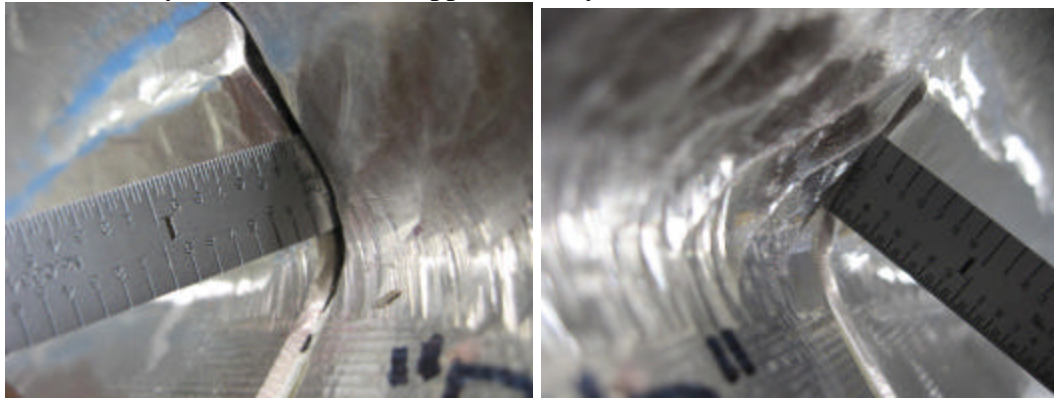


SE141-114 A1
NC19933 attachment

2. Photo below shows areas where counterbore clearances were cut heavy into the casting wall. These areas will not accept the 3" diameter clearance gage. These areas and others were identified and reported on RFD 14-020.

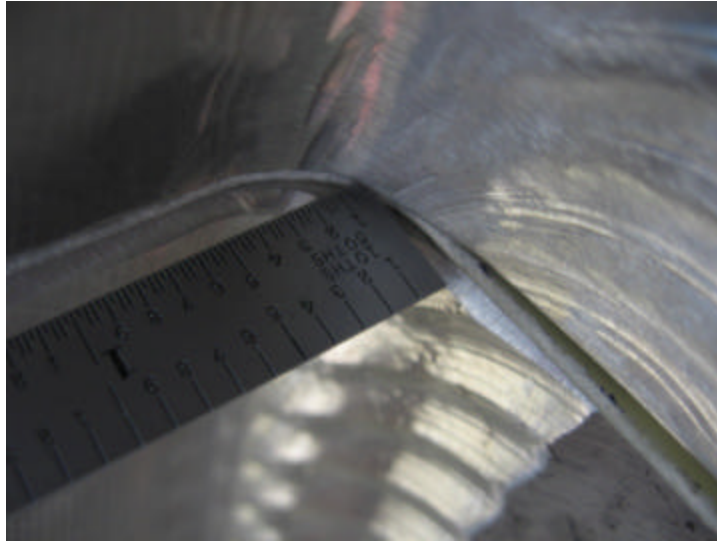


3. Poloidal Break, Datum D side. Casting radius between T section and inner wall extends beyond the G11 shim approximately .300" on each side.

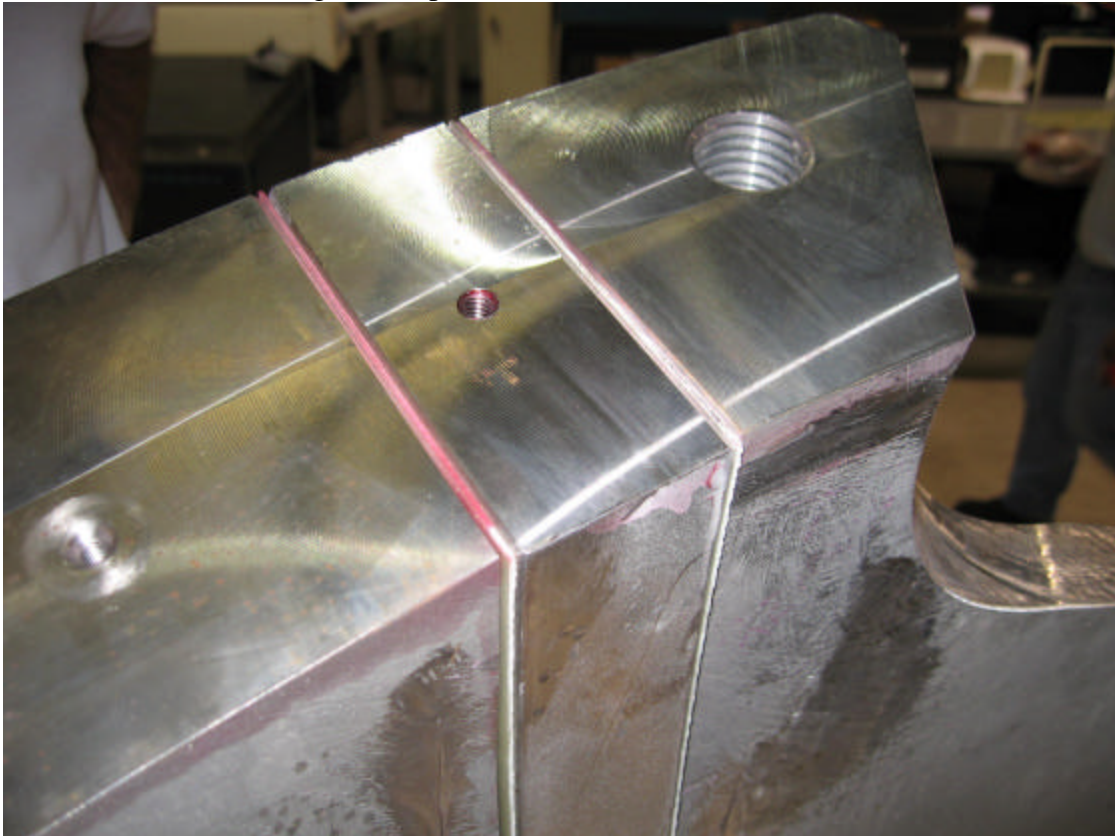


SE141-114 A1
NC19933 attachment

4. Poloidal Break, Datum E side. Casting radius between T section and inner wall extends beyond the G11 shim .050" on each side.

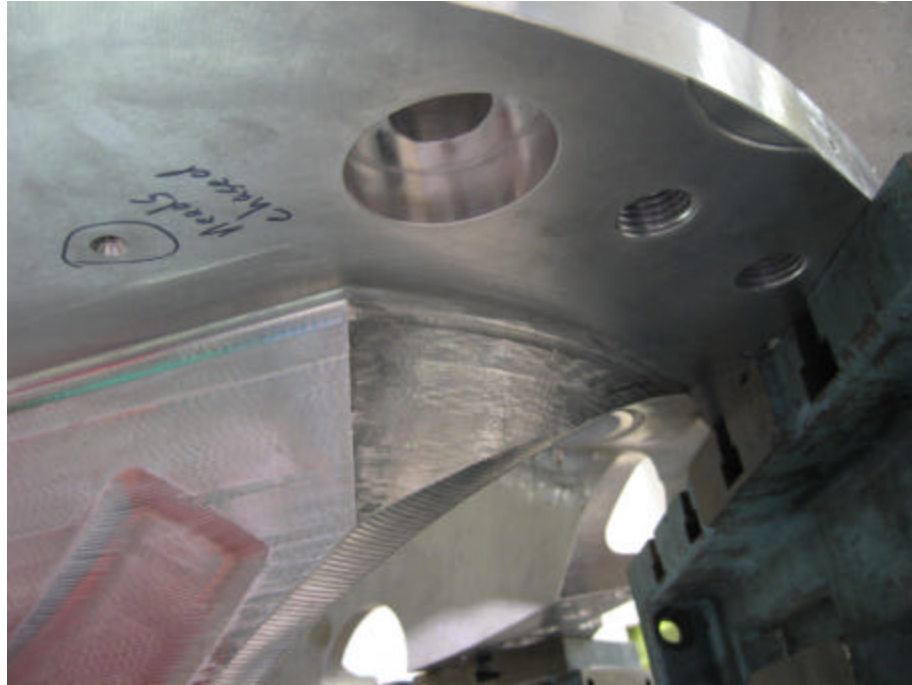


5. One of the G11 shims from the Datum D view is contaminated with the Liquid Penetrant used during the PT process.

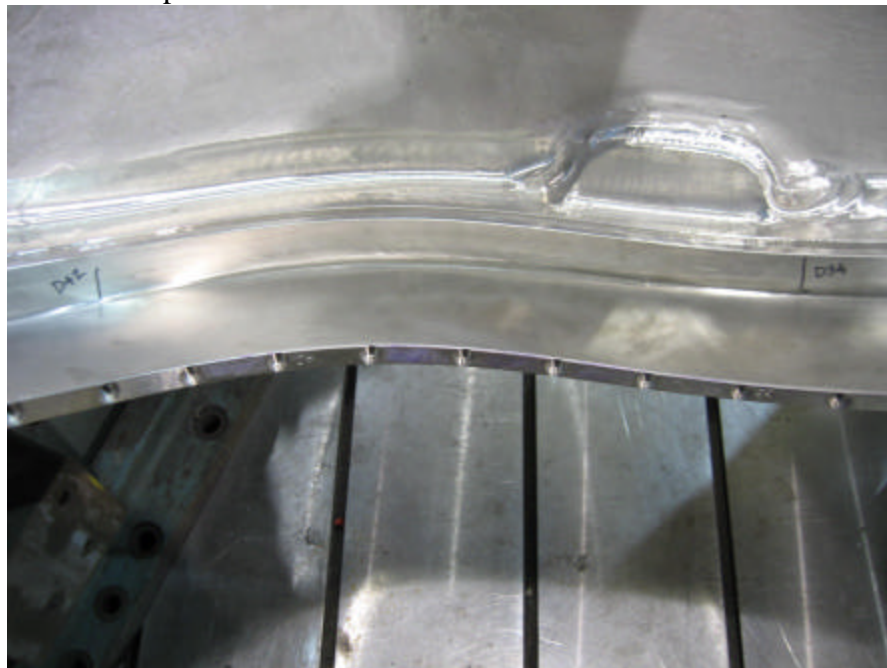


SE141-114 A1
NC19933 attachment

6. Tool gouge on datum E flange. Gouge measures .038" deep by 3.25" long by .50" at its widest point. Radial gouge from 6" face. The gouge is located on the datum E flange in section C5 on sheet 5 of the drawing.



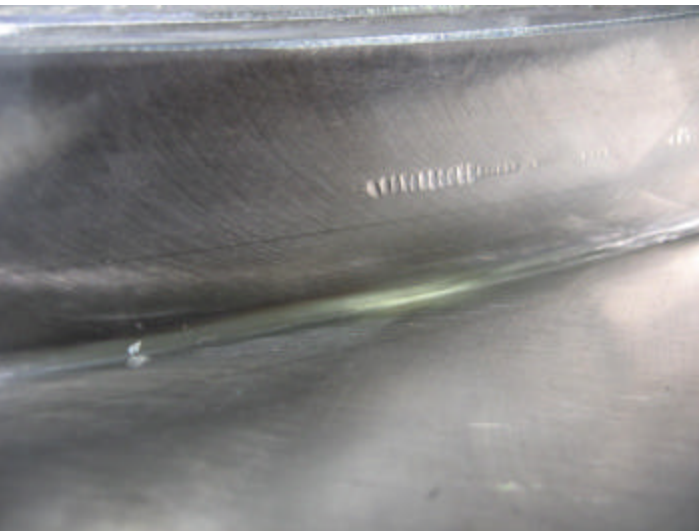
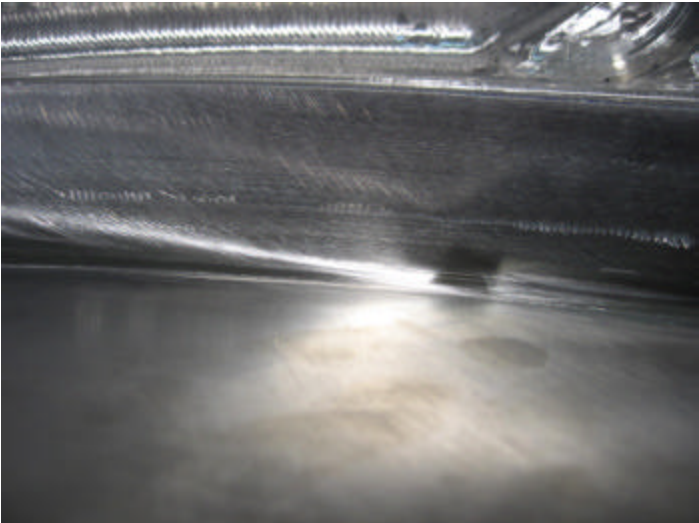
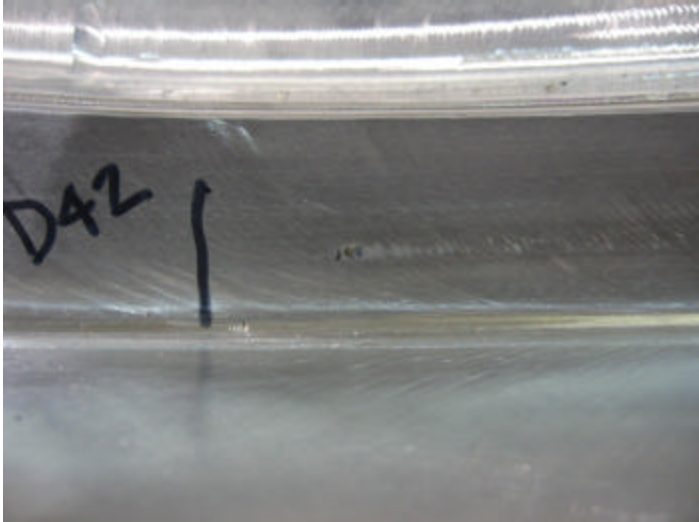
7. Various tool cutter marks on the D side short leg between holes 34 and 42. Cutter marks are no deeper than .010".



Cont. on next page.



SE141-114 A1
NC19933 attachment



Mike Griffith

Page 5 of 10

5/31/2006

SE141-114 A1
NC19933 attachment

8. Various cutter marks on the E side of the T section. Cutter marks are no more than .010" deep.

Short leg of T near hole 79.



In radius between long and short legs near hole 89.

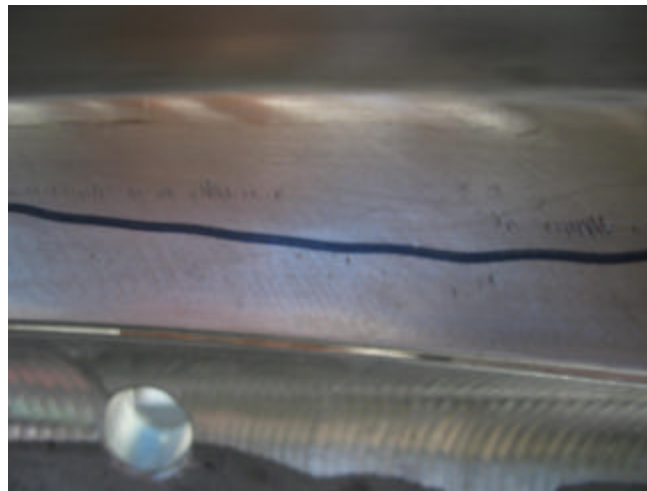
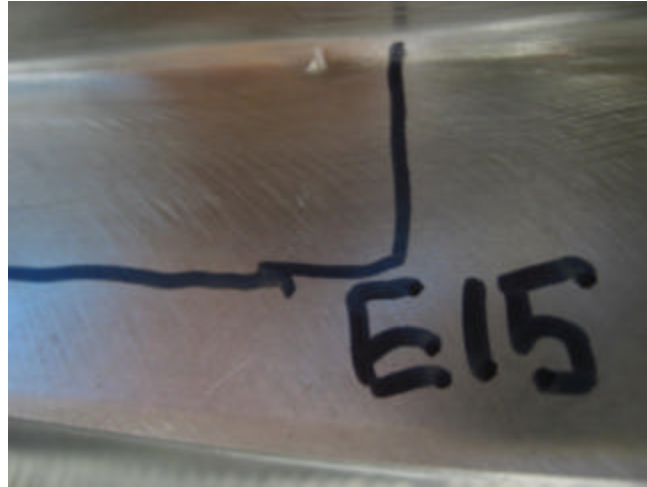


In radius between long and short legs near hole 87.



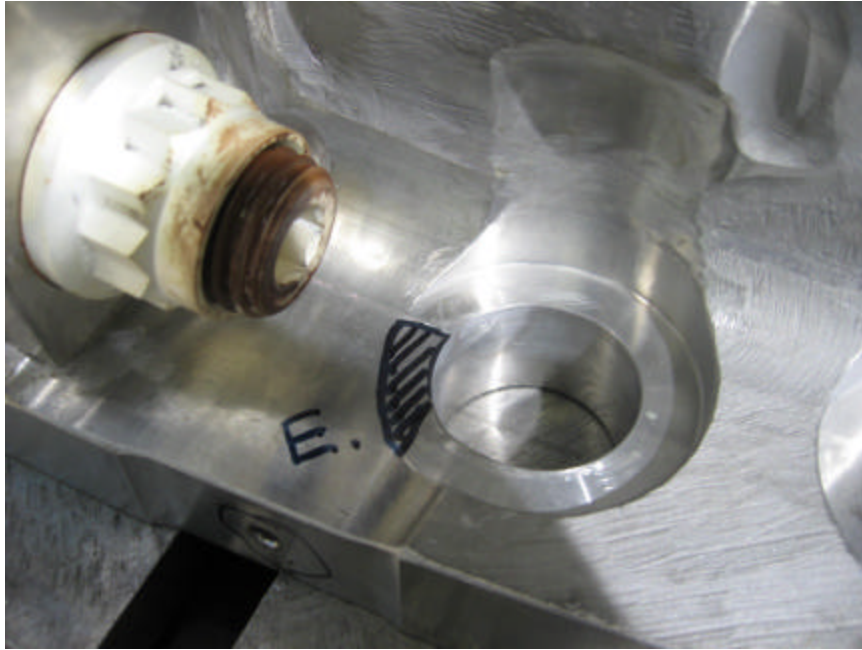
SE141-114 A1
NC19933 attachment

The following photos are of the short leg of T between holes 15 and 19.

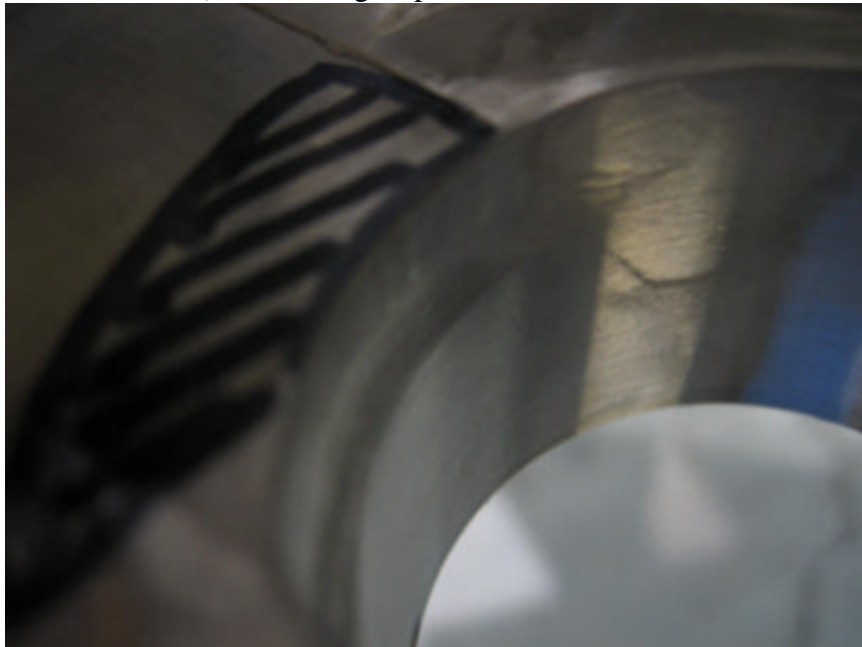


SE141-114 A1
NC19933 attachment

9. Approx. 20% of counterbore did not clean up to 100%. Hole is located on the datum E flange next to the poloidal break. (area shaded in photo below).

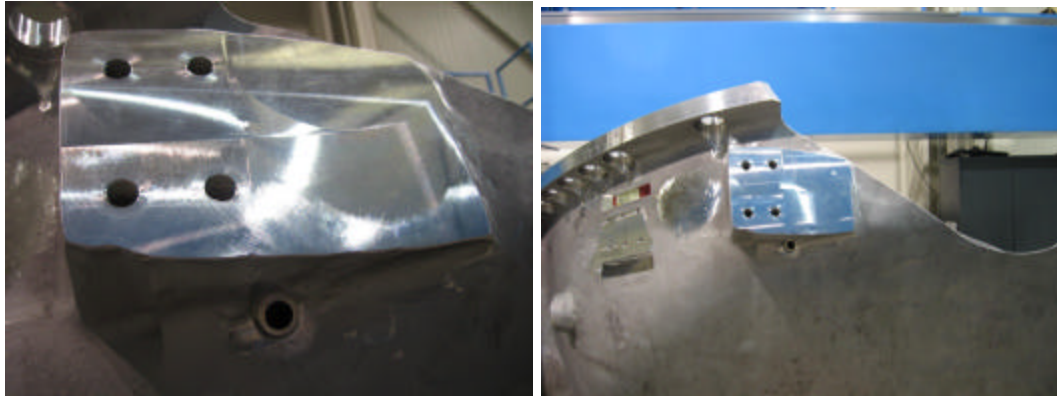


10. There is also an oversized area in this same 1.885 hole. The hole checks $\text{Ø}1.884''$ from the datum E face to a depth of .950". The oversized area extends approximately 1/3 around the diameter (the oversized area is offset to the centerline of the bore). At its largest point, the bore checks $\text{Ø}1.948''$.

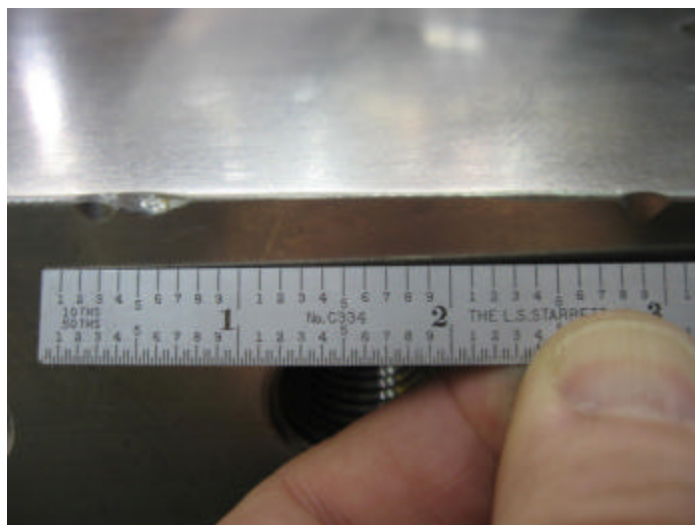
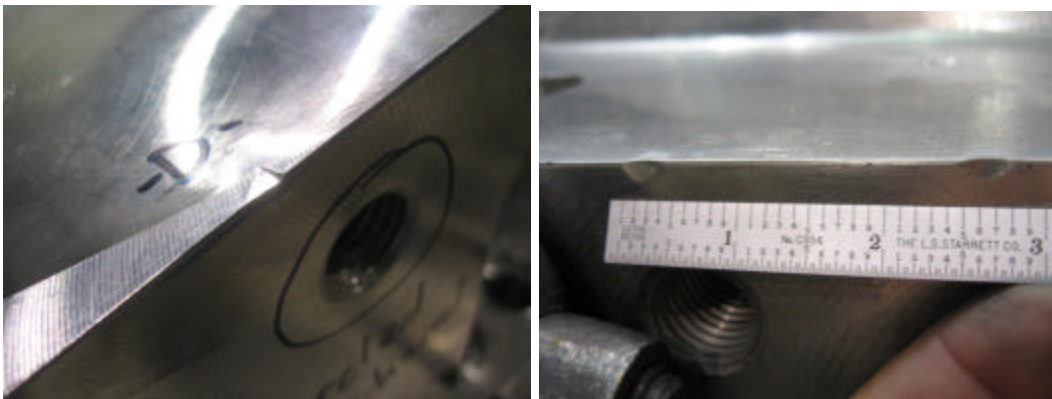


SE141-114 A1
NC19933 attachment

11. The pad shown below has excess casting stock which was machined flush with the pad face. See detail J in section F2 on sheet 7.



12. Various dings on the datum flange edges. Dings are being caused by swivel hoist rings when lifting the parts. Any raised metal around the areas have been polished flush to the surrounding surfaces.



SE141-114 A1
NC19933 attachment

13. There are two impressions on the datum E flange face that were caused by handling damage. Any raised metal around the areas have been polished flush to the surrounding surfaces.



14. The area shown below on the datum E flange exceeds the v^{125} surface finish requirement. Area checks approximately v^{250} . This area is located on sheet 5, zone D5.

