
Customer: ENERGY INDUSTRIES OF OHIO

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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

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Problem: Workorder: 65709/1.0 Sub:1 Op:132

Inspection Test #: 70 rejected: {h,02|A}: .046
Inspection Test #: 80 rejected: 48.50 ± .03: : 48.454
Inspection Test #: 130 rejected: OUTER AS CAST SURFACES: {g,5|A|B|C}: -0.165 TO 0.288
Inspection Test #: 140 rejected: 2 X .40: : .350 TO .420
Inspection Test #: 150 rejected: 4 X .03 X 45: : .010 TO .040
Inspection Test #: 170 rejected: P TO M: {g,2|R|T|S}: POINTS NOT COLLECTED
Inspection Test #: 180 rejected: DATUM D SIDE
VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473: : AREAS BY T HOLES 5-10,
15 - 42, 84 - 94 WILL NOT ACCEPT GAGE
Inspection Test #: 190 rejected: M TO M1: {g,02|R|T|S}: -.0287 TO .268
Inspection Test #: 210 rejected: Q TO N: {g,2|R|T|S}: POINTS NOT COLLECTED
Inspection Test #: 230 rejected: N TO N1: {g,02|R|T|S}: -.0297 TO .0321
Inspection Test #: 240 rejected: 2 X .06/.09 X 45: : .030 TO .060
Inspection Test #: 270 rejected: .375-16 HOLES: {#,06|R|T|S}: .002 TO .066
Inspection Test #: 280 rejected: DATUM E FLANGE: {f,01}: .029
Inspection Test#: 285 rejected: surface 250
Inspection Test #: 290 rejected: DATUM D FLANGE: {f,01}: .028
Inspection Test #: 410 rejected: Ø1.375-6: {#,06|M|A|D}: .062
Inspection Test #: 480 rejected: Ø1.885: {#,06|N|A|E}: .007 TO .076
Inspection Test #: 640 rejected: 2X .88 - 1.13: : 1.13 TO 1.14
Inspection Test #: 780 rejected: INNER AS CAST SURFACES: {g,5|A|B|C}: -.321 TO .149
Inspection Test #: 790 rejected: WING SURFACES: {g-,12;,,\,25|A|B|C}: .009 TO -.150

Workorder: 65709/1.0 Sub:1 Op:130

Inspection Test #: 10 rejected: CHECK CLEARANCE OF ITEM 5 TO
ITEM 6.

: d.001 - d.002: .004 TO.005

Proposed Disposition:

PROPOSE TO USE AS IS.

Number of additional pages: 9 Page IDC Attachment

Customer Disposition: Use As Is Rework Repair Scrap Replace

The list was reviewed during a conference call held on 6/1/06 at 4 pm. Tom Brown and Dave Williamson spent the morning reviewing the dimensional documentation and discrepancies. D. Williamson used the attached slide set while discussing some of the points, and went item by item through the remainder of the list. It was agreed that all will be accepted "as is". Attendees included M. Griffith, T. Brown, D. Williamson, L. Sutton, F. Malinowski, N. Horton, P. Heitzenroeder, and (part time) S. Raftopoulos and A. Brooks.

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

Workorder: 65709/1-0 Sub:1 Op:120

Revision: 03/22/06 7:44

Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

Drawing ID: SE141-114 Rev: 6			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		D A T U M - E - S I D E MAG PERMEABILITY TO BE NO GREATER THAN 1.02μ. CHECK 3 PLACES ADJACENT TO EVERY 5TH HOLE IN T SECTION.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	854-R.UP			A
(10)								05-31-06			*
*		D A T U M - D - S I D E MAG PERMEABILITY TO BE NO GREATER THAN 1.02μ. CHECK 3 PLACES ADJACENT TO EVERY 5TH HOLE IN T SECTION.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	854-R.UP			A
(20)								05-31-06			*

Workorder: 65709/1-0 Sub:1 Op:130

Revision: 03/22/06 6:07

Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

Drawing ID: SE141-101 Rev: 3			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
2*	D3	∅.001 - ∅.002 CHECK CLEARANCE OF ITEM 5 TO ITEM 6.		QA			.004 TO.005	242-M.G			R
(10)								05-25-06			*
*		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"		QA			.001	242-M.G			A
(15)								05-25-06			*
2*	F2	ENSURE THAT THE CUMULATIVE GAPS AT ANY SINGLE CROSS SECTION OF THE POLOIDAL FLANGE ELEMENTS IS LESS THAN .005".		QA			LESS THAN .002	242-M.G			A
(20)								05-25-06			*
*		THE MAX. GAP AT THE POLOIDAL		QA			LESS THAN .002	242-M.G			A

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(30)	BREAK PERIMETER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE.						06-01-06		*
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Workorder: 65709/1-0 Sub:1 Op:132

Revision: 05/31/06 10:28



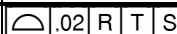


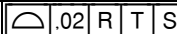
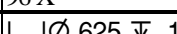
Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

Drawing ID: SE141-114 Rev: 6			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1* (10)	F3	NOTE 14 - BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.		QA			1 HOLE DID NOT CLEAN UP 100% (NC19933)	242-M.G 05-31-06			R *
1* (20)	E8	FLANGE PROFILE +/- .25 IN THIS AREA	CMM	QA		00064	.0104	339-E.RO 06-01-06			A *
1* (30)	D8	∥.02 A	CMM	QA		00064	.006	339-E.RO 05-31-06			A *
1* (40)	D8	54.20 ± .03	CMM	QA		00064	54.194	339-E.RO 05-31-06			A *
1* (50)	C8	54.20 ± .03	CMM	QA		00064	54.194	339-E.RO 05-31-06			A *
1* (60)	B8	∥.02 A	CMM	QA		00064	.006	339-E.RO 05-31-06			A *
1* (70)	D5	∥.02 A	CMM	QA		00064	.046	339-E.RO 05-31-06			R *
1* (80)	D5	48.50 ± .03	CMM	QA		00064	48.454	339-E.RO 05-31-06			R *
1* (90)	C5	48.50 ± .03	CMM	QA		00064	48.503	339-E.RO 05-31-06			A *
1* (100)	B5	∥.02 A	CMM	QA		00064	.003	339-E.RO 05-31-06			A *
1* (110)	D4	VERIFY PART MARKING: MAJOR TOOL SE141-114 A(casting number) (weight) LBS.		QA		VISUAL	ACCEPT	242-M.G 05-31-06			A *
1*	D4			QA		VISUAL	5280 LBS	242-M.G			A

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INSPECTION DATA CHECKLIST

(120)		RECORD WEIGHT						05-31-06		*
1*	D3		CMM	QA	00064	-0.165 TO 0.288	339-E.RO			R
(130)		OUTER AS CAST SURFACES					05-31-06			*
2*	F8		CALIPER	QA	P-5075	.350 TO .420	533-B.CL			R
(140)		2 X .40					05-30-06			*
2*	F8		CALIPER	QA	P-5075	.010 TO .040	533-B.CL			R
(150)		4 X .03 X 45					05-30-06			*
2*	G6		PIN GAGE	QA	J-651-2	.184 TO .205	533-B.CL			A
(160)		2 X R.187 +.025 / -.005					05-30-06			*
2*	G5		CMM	QA	00064	POINTS NOT COLLECTE	339-E.RO			R
(170)		P TO M				D	05-31-06			*
2*	G5			QA	MTMFX-3473	5-10, 15 - 42, 84 - 94 OUT OF SPEC.	339-E.RO			R
(180)		DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473					06-01-06			*
2*	F5		CMM	QA	00064	-.0287 TO .268	339-E.RO			R
(190)		M TO M1					05-31-06			*
2*	E5		CMM	QA	00064	-.0223 TO .0294	339-E.RO			A
(200)		MI TO N1					05-31-06			*
2*	G3		CMM	QA	00064	POINTS NOT COLLECTE	339-E.RO			R
(210)		Q TO N				D	05-31-06			*
2*	F3			QA	MTMFX-3473	ACCEPT	339-E.RO			A
(220)		DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473					06-01-06			*
2*	F3		CMM	QA	00064	-.0297 TO .0321	339-E.RO			R
(230)		N TO N1					05-31-06			*
2*	B4		CALIPER	QA	P-5075	.030 TO .060	533-B.CL			R
(240)		2 X .06/.09 X 45					05-30-06			*
2*	B5	∅ .375-16 UNC ∇ .750 +.1 -0	THREAD PLUG GAGE	QA	100%	A-444	ACCEPT	242-M.G		A
(250)		96 X					05-31-06			*
2*	B5		CALIPER	QA	P-5075	.622 DEPT H .188 TO .310 (NC1 9783)	242-M.G			R
(260)							06-01-06			*

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INSPECTION DATA CHECKLIST

2* (270)	B5	Φ .06 R T S 375-16 HOLES	CMM	QA		00064	.002 TO .066	339-E.RO 05-31-06			R *
3* (280)	H3	\square .01 DATUM E FLANGE	CMM	QA		00064	.029	339-E.RO 05-31-06			R *
3* (285)	H4	\surd ¹²⁵ DATUM E FLANGE		QA		VISUAL	250	339-E.RO 06-01-06			R *
3* (290)	F2	\square .01 DATUM D FLANGE	CMM	QA		00064	.028	339-E.RO 05-31-06			R *
3* (295)	F3	\surd ¹²⁵ DATUM D FLANGE		QA		VISUAL	ACCEPT	339-E.RO 06-01-06			A *
3* (300)	E4	\varnothing 2.50 THRU	CALIPER	QA		P-5075	2.500	533-B.CL 05-31-06			A *
3* (310)	F4	Φ .060 A B C \varnothing 2.50	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
3* (320)	C7	8X \varnothing 1-8UNC ∇ 2	THREAD PLUG GAGE	QA		A-665	ACCEPT	533-B.CL 05-31-06			A *
3* (330)	C7	Φ .010 A B C 8X \varnothing 1-8 UNC	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
3* (340)	D5	8X \varnothing 1-8UNC THRU	THREAD PLUG GAGE	QA		A-665	ACCEPT	533-B.CL 05-31-06			A *
3* (350)	D5	\varnothing .010 A B C 8X \varnothing 1-8 UNC	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
3* (360)	D3	\varnothing 2.50 THRU	CALIPER	QA		P-5075	2.500	533-B.CL 05-31-06			A *
3* (370)	D3	Φ .060 A B C \varnothing 2.5	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
3* (380)	D1	40.90	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
4* (390)	H6	\square \varnothing 2.000-2.001 ∇ 0.990-1.000	DIAL BORE GAGE CALIPER			J-1401 P-5075	2.0000 TO 2.0002 DEPTH .991 T O .997	533-B.CL 05-30-06			A *
4* (400)	F4	\varnothing 1.375-6UNC THRU	THREAD PLUG GAGE	QA		A-375	ACCEPT	533-B.CL 05-31-06			A *
4* (400)	F4	Φ \varnothing .06 M A D	CMM	QA		00064	.062	339-E.RO			R *

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INSPECTION DATA CHECKLIST

(410)		Ø1.375-6					05-31-06		*
4* (420)	D4 &	Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA	J-1400	1.884 TO 1.886	533-B.CL 05-31-06		A *
4* (430)	D4 &	Φ .06 M A D Ø1.885	CMM	QA	00064	.012 TO .060	339-E.RO 05-31-06		A *
4* (440)	B6	3X Ø1.5	CALIPER	QA	J-1103	1.500	533-B.CL 05-31-06		A *
4* (450)	B6	Φ .06 M A D 3X Ø1.5	CMM	QA	00064	.030 TO .040	339-E.RO 05-31-06		A *
4* (460)	A4	6X .25-20 UNC ∇ .5 .5 X 82° CHAMFER	THREAD PLUG GAGE	QA	A-235	ACCEPT	533-B.CL 05-30-06		A *
5* (470)	D8/D6	Ø1.885 ± .003	DIAL BORE GAGE	QA	J-1400	1.884 TO 1.886	533-B.CL 05-31-06		A *
5* (480)	D8/D6	Φ .06 N A E Ø1.885	CMM	QA	00064	.007 TO .076	339-E.RO 05-31-06		R *
5* (490)	F8	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA	A-375	ACCEPT	533-B.CL 05-31-06		A *
5* (500)	F8	Φ .06 N A E Ø1.375-6 UNC	CMM	QA	00064	.044	339-E.RO 05-31-06		A *
5* (510)	F6	8X 1/4 -20 UNC-2B	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 05-31-06		A *
5* (520)	D6	3X Ø1.5 ∇ 2.33	CALIPER	QA	J-1103	1.500 DEPTH 2.335 TO 2.340	533-B.CL 05-31-06		A *
5* (530)	D6	Φ .06 N A E 3X Ø1.5	CMM	QA	00064	.004 TO .034	339-E.RO 05-31-06		A *
5* (540)	B3	6X .25 - 20 UNC ∇ .6 Ø.5 X 82° CHAMFER	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 05-31-06		A *
6* (550)	H7	6.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
6* (560)	H7	1.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
6*	G8		CMM	QA	00064	SEE IGES DATA	339-E.RO		A

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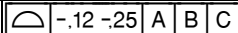
INSPECTION DATA CHECKLIST

(570)		6.70					05-31-06		*
6* (600)	F8	6.70	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
6* (610)	E7	5.75	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
6* (620)	E7	1.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
6* (630)	E6	4X Ø1.00	PIN GAGE	QA	J-921	.999	533-B.CL 05-30-06		A *
6* (640)	G5	2X .88 - 1.13	CALIPER	QA	J-1389	1.13 TO 1.14	533-B.CL 05-30-06		R *
6* (650)	F5	.06-.09 X 45° TYP	CALIPER	QA	P-5075	ACCEPT	533-B.CL 05-31-06		A *
7* (660)	G2	19.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
7* (670)	F2	2.00	CALIPER	QA	P-5075	2.001	533-B.CL 05-31-06		A *
7* (680)	F2	6.75	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
7* (690)	F2	3.75	CALIPER	QA	P-5075	3.752	533-B.CL 05-31-06		A *
7* (700)	F1	4X Ø.75-10 UNC ▽ 1.50	THREAD PLUG GAGE	QA	A-232	ACCEPT	533-B.CL 05-30-06		A *
7* (710)	D1	2X 1.56 OPEN THRU	CALIPER	QA	P-5075	1.558 TO 1.560	533-B.CL 05-30-06		A *
7* (720)	C1	.375-16 UNC-2B TAP ▽ .75 .03 X 45° CHAMFER 6X	THREAD PLUG GAGE	QA	A-52	ACCEPT	533-B.CL 05-30-06		A *
7* (730)	C4	VERIFY THAT HOLE LOCATIONS ARE SCRIBED ON THE PART.		QA	VISUAL	ACCEPT	533-B.CL 05-31-06		A *
7*	B3	8.50 DISTANCE BETWEEN SCRIBE	CALIPER	QA	P-5075	8.500	533-B.CL		A

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INSPECTION DATA CHECKLIST

(740)		MARKINGS.						05-31-06		*	
9* (750)	H1	2X Ø.50	CALIPER	QA		P-5075	.502	533-B.CL 05-31-06		A *	
9* (760)	B7	TC2 HOLE TO BE .625" IN DIAMETER APPROX. 2.52" DEEP AND .25" IN DIAMETER AT LEAST 1" DEEP.	CALIPER	QA		P-5075	.625 DEPTH 2.5 30	533-B.CL 05-31-06		A *	
* (770)		TC1 LOCATION AND CONFIGURATION MODIFIED. HOLE TO HAVE .625 CLEARANCE AND AT LEAST 1" OF DEPTH AT THE .25" DIA	CALIPER	QA		P-5075	.625	533-B.CL 05-31-06		A *	
10* (780)	F5	 INNER AS CAST SURFACES	CMM	QA		00064	-.321 TO .149	339-E.RO 05-31-06		R *	
10* (790)	D5	 WING SURFACES	CMM	QA		00064	.009 TO -.150	339-E.RO 05-31-06		R *	
Drawing ID: NCSX-CSPEC-141-03 Rev: 11			INSPECTION INSTRUCTIONS			RESULTS			INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
4* (800)	3.1.1.4 ¹²⁵	THE TWO "L" MACHINED SURFACES OF TEE MUST HAVE A RMS OF 125.		QA		VISUAL	ACCEPT	533-B.CL 05-31-06		A *	

Workorder: 65709/1-0 Sub:1 Op:140

Revision: 03/22/06 7:50

Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

Drawing ID: SE141-101 Rev: 3			INSPECTION INSTRUCTIONS			RESULTS			INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
* (10)		<u>T E S T 1</u> RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE MID-PLANE POLOIDAL BREAK SHIM AND THE WINDING FORM.	MULTIMETER	QA		J-1358	218 TO 225 MEGA OHM S	840-G.M 06-01-06		A *	
*		<u>T E S T 2</u>	MULTIMETER	QA		J-1358	280 TO 330 MEGA OHM	840-G.M		A	

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(20)	RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE JUMPERED BOLTS AND JUMPERED MID-PLANE CASTING AND WINDING FORM.					S				06-01-06	*
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Workorder: 65709/1-0 Sub:17 Op:50

Revision: 04/25/06 16:37

Part: REWORK - REWORK / REPAIR PER N/C - N/C #

Drawing ID: SE141-116 Rev: 8			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		N C 19709	MASTER GAGE	QA		J-1165	NO PERMEABILITY RESPONSE EQUAL TO OR GREATER THAN 1.02μ (ORSTEADS)	840-G.M			A
(10)		RECORD PERMEABILITY READINGS OF THE REPAIRED AREA. MAG PERMEABILITY TO BE NO GREATER THAN 1.02μ.						06-01-06			*

Workorder: 65709/1-0 Sub:18 Op:30

Revision: 05/08/06 9:52

Part: SE141-141 - BEARING PLATE DETAIL TYPE "A" SHORT -

Drawing ID: SE141-141 Rev: 1			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1*	G2	RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1271	LESS THAN 1.02	261-T.DU			A
(10)								05-16-06			*

Workorder: 65709/1-0 Sub:19 Op:30

Revision: 05/08/06 9:51

Part: SE141-142 - BEARING PLATE DETAIL TYPE "A" LONG -

Drawing ID: SE141-142 Rev: 1			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1*	G2	RECORD MAGNETIC PERMEABILITY.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	503-B.HO			A

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(10)	RESULTS TO BE NO GREATER THAN 1.02μ.							05-18-06		*
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Major Tool Implemented By: _____ **Title:** _____ **Date:** _____