
Customer: ENERGY INDUSTRIES OF OHIO

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

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

Part: SE141-115 / MODULAR COIL, TYPE B

Drawing ID: SE141-102 Revision: 3
W/O Links: 1-Type:W: 65708/1.0 Sub: 0

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: B1

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

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

Problem: Various issues were identified during the final review of the castings. See attachment for details.

Proposed Disposition:

Customer to review and provide remedial action.

Number of additional pages: 6 page attachment

Customer Disposition: Use As Is Rework Repair Scrap Replace

The article to be dispositioned as follows, item numbers refer to the sections in the NC20519 attachment:

- Item 1. Rework- Trim the bearing plate back to match the shape of the G-11CR insulator it's resting on
- Item 2. Use As Is
- Item 3. Use As Is
- Item 4. Use As Is
- Item 5. Use As Is
- Item 6. Use As Is
- Item 7. Use As Is
- Item 8. Rework - The counterbores around the flange holes need to be enlarged to a 3" diameter cylinder by 3" high from the spot face surface. The blend-in corner radius at the upper extent of this machined area shall be 1/4".

The B1 casting may be released for shipment pending completion of item 8 of the corrective action of this NC.

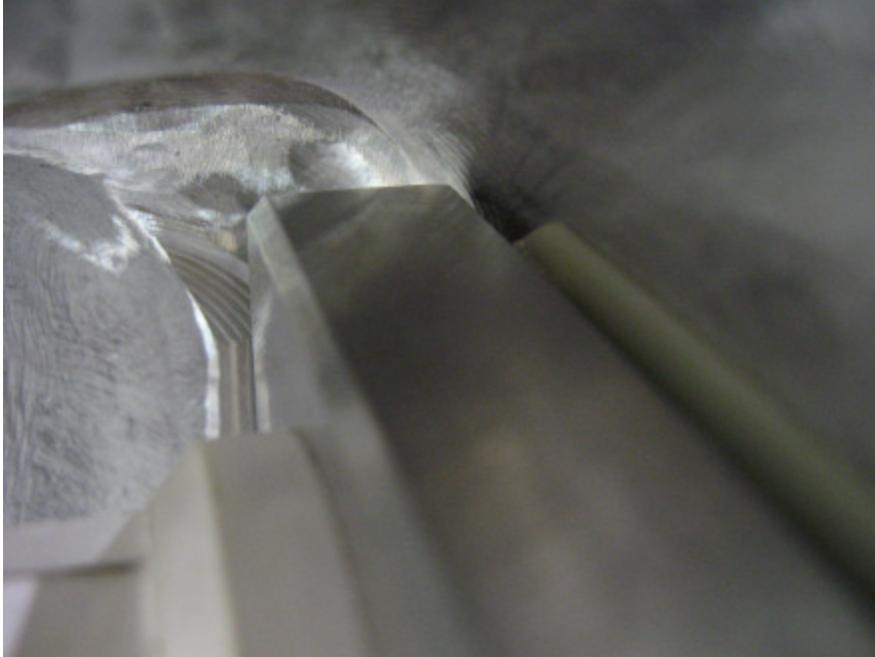
Tech Rep Approval: _____ Date: _____

RLM Approval: _____ Date: _____

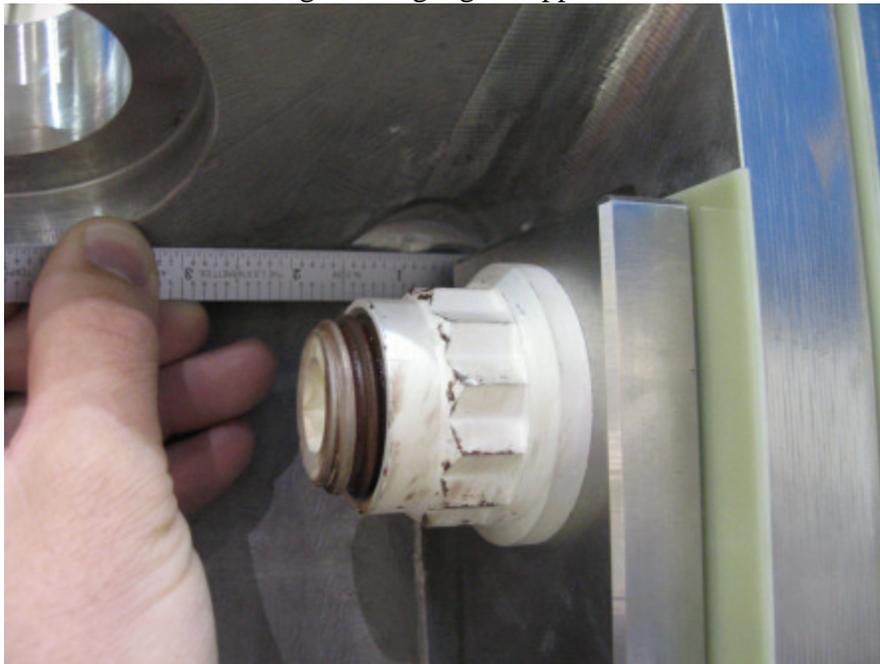
Major Tool Implemented By: _____ **Title:** _____ **Date:** _____

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NC20519 attachment

1. Insulating material does not extend beyond bearing plate in one place nearest the datum D flange. The area is approximately .5" x .5" along the corner of the plate.
Proposed Action: Remove material from corner of bearing plate to match insulating material.

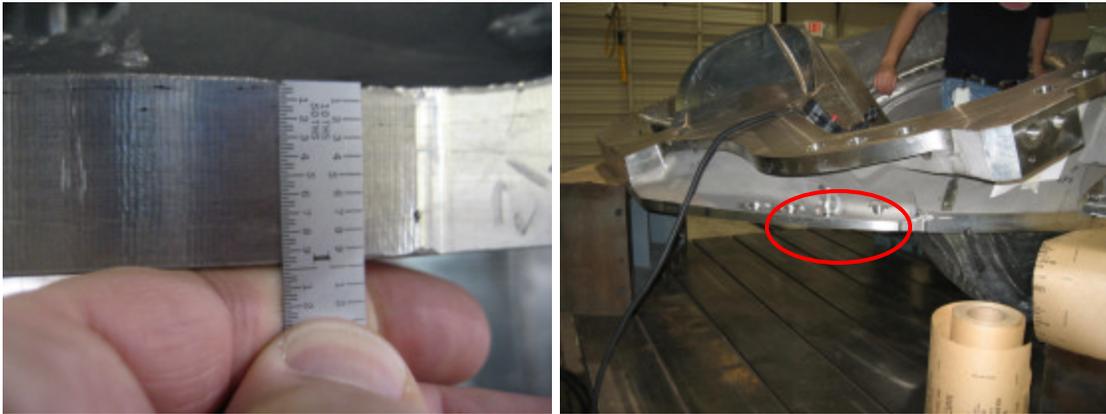


2. There is a tool gouge (eyebrow shape) near the poloidal break flange just underneath the datum D flange. The gouge is approx. 1.4" across.

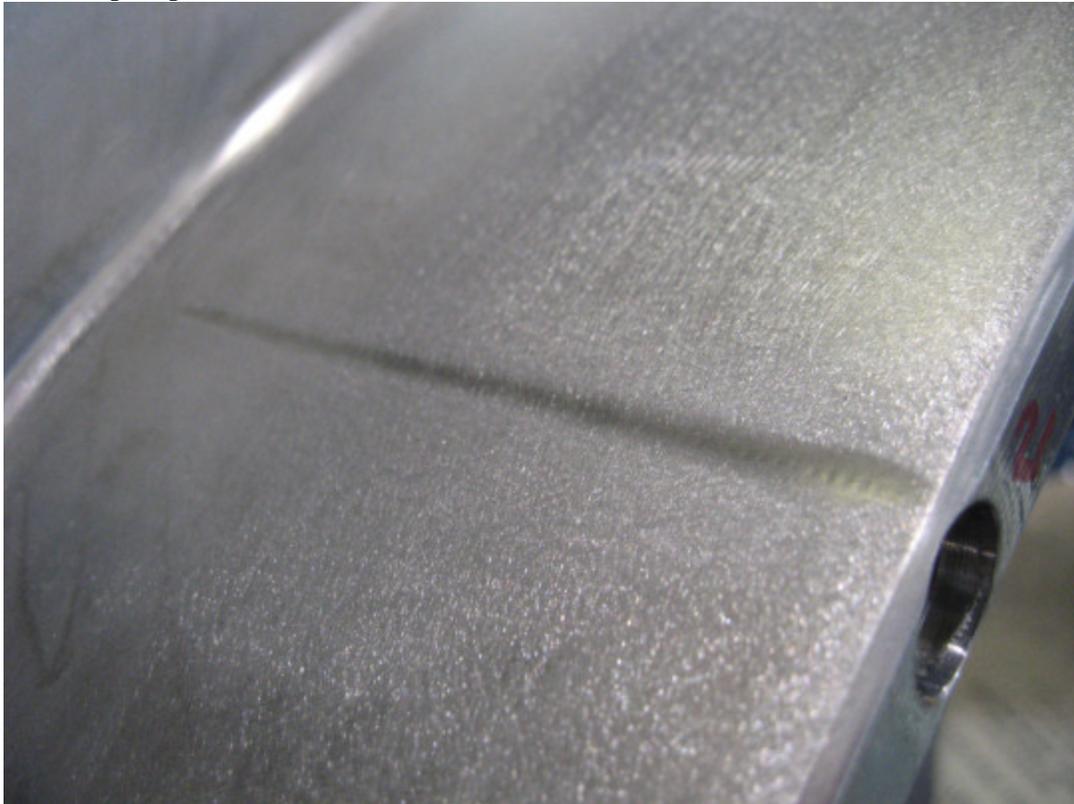


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3. There is an area of the datum E flange that is 1.00 thick on the outer edge. The area under the 1.25" minimum is approx. .20" long in the area circled below.



4. There is a cutter mark on the datum D side of the long leg of the T section near T hole 21. The cross section thickness of the T at this point checks .733". When compared to the surfaces adjacent to the mark, it measures approximately .011" at its deepest point.



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5. There are several tooling marks on the long and short legs of the T section on the datum E side near T hole 90. The cross section thickness of the T at this point checks .737". When compared to the surfaces adjacent to the mark, it measures approximately .013" at its deepest point. The deepest tool mark is shown next to the scale in the bottom-left photo. This gouge checks approx. .03" in depth.

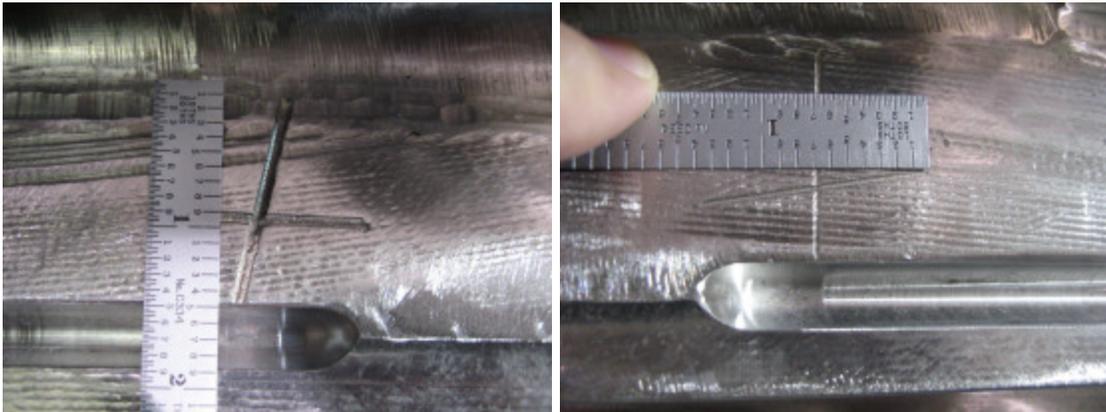


SE141-115 B1
NC20519 attachment

6. There is a tool gouge on the inner wall on the datum D side near the 8" port opening (sheet 8, zone B6). The gouge is approx. 1.5" wide.



7. The scribe marks do not match the drawing requirements as described on sheet 7, zone E6. The scribing was performed prior to notification of the revision 9 changes. The scribing is to be aligned with sections U2 and U3 of the drawing (perpendicular and parallel to the base of the T). The scale in the below pictures show what would be the correct orientation (This conditions exists on both the D and E sides).



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8. There are six counterbores that will not accept the 3" diameter gage. The holes are designated by the flange side (E or D) and flange hole number.



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NC20519 attachment

