

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: SE141-115 Revision: 9
W/O Links: 1-Type:W: 65708/2.0 Sub: 1

Customer P.O.: S005242-F/Ln:2
Serial No./Qty: B2

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

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

Problem: Workorder: 65708/2.0 Sub:1 Op:132

Inspection Test #: 60 rejected: : {h|.02|A}: .027
Inspection Test #: 90 rejected: OUTER AS CAST SURFACES: {g|.5|A|C|B}: -.0129 TO .306
Inspection Test #: 130 rejected: 2X R.11: : .110 TO .120 E SIDE HOLE#BREAK TO 7 18-25 38-43 48-57
59-64 73-84 ARE .250R
Inspection Test #: 150 rejected: MACHINED SURFACES
M TO M1: {g|.02|R|S|T}: -.0178 TO .0251
Inspection Test #: 160 rejected: DATUM D SIDE
VERIFY SHELL INTERSECT CLEARANCE
USING GAGE MTMFX-3473: : ACCEPT IN ALL AREAS EXCEPT BETWEEN HOLE #83-84 AND 88-94
Inspection Test #: 170 rejected: P TO M: {g|.2|R|S|T}: -.0316 TO .1214
Inspection Test #: 190 rejected: MACHINED SURFACES
N TO N1: {g|.02|R|S|T}: -.0282 TO .0265
Inspection Test #: 200 rejected: DATUM E SIDE
VERIFY SHELL INTERSECT CLEARANCE
USING GAGE MTMFX-3473: : ACCEPT IN ALL AREAS EXCEPT BETWEEN HOLE #30-46 49-56 & 82-84
Inspection Test #: 210 rejected: Q TO N: {g|.2|R|S|T}: .022 TO .1179
Inspection Test #: 240 rejected: : 84X .375-16 UNC y .75
: ALL THREADS ARE GOOD EXCEPT 1 HOLE IS REJECTED HOLE #91 IS TAPPED AT A ANGLE
Inspection Test #: 250 rejected: : 84X b.625 y .188: .156 TO .190 44 HOLES ARE UNDERSIZED ON
DEPTH
Inspection Test #: 260 rejected: : {#|.06|R|S|T}: .003 TO .144
Inspection Test #: 340 rejected: DATUM E: {f|.01}: .045
Inspection Test #: 360 rejected: DATUM D: {f|.01}: .032
Inspection Test #: 510 rejected: : 14X
d1.885 ~ .003 THRU: 1.884 TO 1.886 HOLE #6 1.884 - 1.889 HOLE #10 1.884 - 1.893
Inspection Test #: 540 rejected: : 10X
d1.885 ~ .003 THRU: 1.884 TO 1.886 HOLE #19 HAS A GROOVE .400 TALL BY .018 DEEP
Inspection Test #: 560 rejected: 10 X Ø1.885: {#|.06|M|A|D}: .0316 TO .063
Inspection Test #: 580 rejected: : 3x bd2.000 - 2.001
y .990 - 1.000: 3X - 2.0002 BY 1.003
Inspection Test #: 590 rejected: 3X Ø1.130: {#|d.06|M|A|D}: .054 TO .066
Inspection Test #: 610 rejected: Ø1.375-6UNC: {#|.06|M|A|D}: .022 TO .072
Inspection Test #: 630 rejected: : d.03 x 45` CHAMFER: .500
Inspection Test #: 650 rejected: : d.03 x 45` CHAMFER: .505
Inspection Test #: 680 rejected: 3X Ø1.50: : 1.476 TO 1.491
Inspection Test #: 840 rejected: 2X .88/1.13: : 1.090 AND 1.170
Inspection Test #: 880 rejected: 2X 1.56: : 1.78 TO 1.81
Inspection Test #: 900 rejected: : 6X
.375-16UNC-2B TAP y .75
.03 X 45` CHAMFER: ALL GOOD EXCEPT ONE HOLE THE NOGO GOES 4 TURNS
Inspection Test #: 1010 rejected: AS CAST SURFACES: {g|.5|A|B|C}: -.309 TO .435

Proposed Disposition:

STEP 130 REJECTION FOR OVERSIZE RADIUS TO BE REWORKED PER DIRECTION FROM PPPL:

- Non-conforming radii are to be ground to a corner radius of 0.06-0.1 1".
- Steps or undercuts not to exceed 0.03" are acceptable.
- Use care to not gouge adjacent areas, since these surfaces are used in measurements.

MTM PROPOSES THAT ALL OTHER REJECTIONS BE ACCEPTED AS IS.

Number of additional pages: 13 PAGE IDC ATTACHMENT

Customer Disposition: Use As Is Rework Repair Scrap Replace

All except Step 130 were accepted as is (which is dispositioned above) after a review held during a conference call on 10/26/06 attended by L. Dudek, L. Sutton, D. Williamson, F. Malinowski, J. Chrzanowski, T. Brown, and P. Heitzenroeder



Following text added 10/31/2006

Each dimensional deviation was discussed and can be accommodated during assembly. However, MTM was requested to review the machining setup processes since it was noted that these accommodations do take some effort on NCSX's part and the perception is that there has been some gradual loosening of achieved tolerances. MTM has such a review in progress already- we request that this be reported back during a Quality conference call.

Accepted by:

Tech. Rep.

RLM

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



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: REWORK - Item: 8

Workorder: 65708/2-0 Sub:15 Op:40

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

Drawing ID: SE141-115 Rev: 9		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		NC 20449 PERMEABILITY OF WELD TO BE LESS THAN 1.02μ.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	854-R.UP		
(10)								10-04-06		

A

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-102 - Item: 11

Workorder: 65708/2-0 Sub:1 Op:140

Part: SE141-102 - MODULAR COIL, TYPE B -

Drawing ID: SE141-102 Rev: 3		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		<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	2.2 G KOHMS	503-B.HC			A
(10)								10-23-06			
*		<u>T E S T 2</u> RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE JUMPERED BOLTS AND JUMPERED MID-PLANE CASTING AND WINDING FORM.	MULTIMETER	QA		J-1358	2.2G KOHMS	503-B.HC			A
(20)								10-23-06			

Quality Assurance Documentation for Part ID: SE141-115 - Item: 18

Workorder: 65708/2-0 Sub:1 Op:130

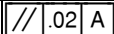
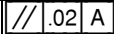
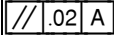
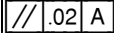

Part: SE141-115 - MODULAR COIL, TYPE B -

Drawing ID: SE141-102 Rev: 3			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
2* (10)	D2	Ø.001 - Ø.002 CHECK CLEARANCE OF ITEM 5 TO ITEM 6.		MFG			LESS THAN .002	825-B.JA 10-19-06			A
* (15)		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"		MFG			LESS THAN .002	825-B.JA 10-19-06			A
* (20)		ENSURE THAT THE CUMULATIVE GAPS AT ANY SINGLE CROSS SECTION OF THE POLOIDAL FLANGE ELEMENTS IS LESS THAN .005".	FEELER GAGES	MFG		J-1144	.005	771-B.SC 10-25-06			A
* (30)		THE MAX. GAP AT THE POLOIDAL BREAK PERIMETER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE.	FEELER GAGES	MFG		J-1144	.013	771-B.SC 10-25-06			A
1* (40)	F3	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLIE	MFG		J-1240	1500	825-B.JA 10-19-06			A




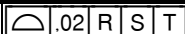

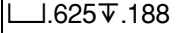
Quality Assurance Documentation for Part ID: SE141-115 - Item: 19

Workorder: 65708/2-0 Sub:1 Op:132

Part: SE141-115 - MODULAR COIL, TYPE B -

Drawing ID: SE141-115 Rev: 9			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1* (10)	C3	VERIFY PART MARKING: MAJOR TOOL SE141-115 B(casting number) (weight) LBS.		QA		VISUAL	ACCEPT	533-B.CL 10-26-06			A
1* (20)	C3	RECORD FINAL PART WEIGHT		QA		VISUAL	5540	533-B.CL 10-26-06			A
1* (30)	F3	NOTE 14 BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.		QA		MTMFX-3564	ACCEPT	533-B.CL 10-25-06			A
1* (40)	E7		CMM	QA		00064	.0089	533-B.CL 10-25-06			A
1* (50)	E6		CMM	QA		00064	.0105	533-B.CL 10-25-06			A
1* (60)	B6		CMM	QA		00064	.027 [N/C:20676]	533-B.CL 10-25-06			R
1* (70)	B5		CMM	QA		00064	.007	533-B.CL 10-25-06			A
1* (90)	D3	 OUTER AS CAST SURFACES	CMM	QA		00064	-.0129 TO .306 [N/C :20676]	533-B.CL 10-26-06			R
2* (100)	G7	2X .03 X 45°		QA		VISUAL	ACCEPT	533-B.CL 10-25-06			A
2* (110)	G7	.40	CALIPER	QA		J-707	.390 TO .400	533-B.CL 10-25-06			A
2* (120)	G7	2X .03 X 45°		QA		VISUAL	ACCEPT	533-B.CL 10-25-06			A
2*	G8		RADIUS GAGE	QA		R-21	.110 TO .120 E SI DE HOLE#BREAK TO 7 18-25 38-43 48-57 59-64 73-84 ARE .25	533-B.CL			R

INSPECTION DATA CHECKLIST

(130)		2X R.11				OR [N/C:20676]	10-25-06		
2* (140)	H7		CALIPER	QA	J-707	.305 TO .317	533-B.CL 10-25-06		A
2* (150)	H6	 MACHINED SURFACES M TO M1	CMM	QA	00064	-.0178 TO .0251 [N/ C:20676]	533-B.CL 10-26-06		R
2* (160)	F5			QA	MTMFX-3473	ACCEPT IN ALL AREAS EXCEPT BETWEEN HOL E #83-84 AND 88-94 [N/C:20676]	533-B.CL 10-25-06		R
		DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473							
2* (170)	E6	 P TO M	CMM	QA	00064	-.0316 TO .1214 [N/ C:20676]	533-B.CL 10-26-06		R
2* (180)	H4	 MACHINED SURFACES M1 TO N1	CMM	QA	00064	-.0322 TO .0315	533-B.CL 10-26-06		A
2* (190)	G3	 MACHINED SURFACES N TO N1		QA		-.0282 TO .0265 [N/ C:20676]	533-B.CL 10-26-06		R
2* (200)	F3			QA	MTMFX-3473	ACCEPT IN ALL AREAS EXCEPT BETWEEN HOL E #30-46 49-56 & 82 -84 [N/C:20676]	533-B.CL 10-25-06		R
		DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473							
2* (210)	F3	 Q TO N	CMM	QA	00064	.022 TO .1179 [N/C: 20676]	533-B.CL 10-26-06		R
2* (220)	D6	 HOLE 63 THRU 73		QA	VISUAL	NO COUNTERBORE ON P ART DUE TO REV CHAN GE	533-B.CL 10-25-06		A
2* (230)	C5	2X .06-.09 X 45°		QA	VISUAL	ACCEPT	533-B.CL 10-25-06		A
2*	C4	84X .375-16 UNC ∇ .75	THREAD PLUG GAGE	QA	A-233	ALL THREADS ARE GOO D EXCEPT 1 HOLE IS REJECTED HOLE #91 I S TAPPED AT A ANGLE	533-B.CL		R

INSPECTION DATA CHECKLIST

(240)			DEPTH MICROMETE			J-1024	[N/C:20676]	10-26-06		
2*	C4	84X \perp .625 ∇ .188	CALIPER	QA		J-707	.156 TO .190 44 HOLES ARE UNDERSIZE D ON DEPTH [N/C:206	533-B.CL		R
(250)			DEPTH MICROMETE			J-1062	76]	10-25-06		
2*	C4	\varnothing .06 R S T	CMM	QA		00064	.003 TO .144 [N/C:2	533-B.CL		R
(260)							0676]	10-26-06		
3*	G7			QA		VISUAL	SEE IGES DATA	533-B.CL		A
(270)		9.00						10-25-06		
3*	G7			QA		VISUAL	SEE IGES DATA	533-B.CL		A
(280)		4.50						10-25-06		
3*	G6			QA		VISUAL	SEE IGES DATA	533-B.CL		A
(290)		3.00						10-25-06		
3*	F7			QA		VISUAL	SEE IGES DATA	533-B.CL		A
(300)		1.50						10-25-06		
3*	F7	4X \varnothing 1.0-8UNC ∇ 2.1	THREAD PLUG GAGE	QA		A-670	ACCEPT	533-B.CL		A
(310)								10-25-06		
3*	G5			QA		VISUAL	SEE IGES DATA	533-B.CL		A
(320)		17.00 AT MOUNTING AREA						10-25-06		
3*	H2	\sqrt{R} DATUM E	PROFILOMETER	QA		J-1152	11 TO 62	533-B.CL		A
(330)								10-25-06		
3*	G1	\square .01 DATUM E	CMM	QA		00064	.045 [N/C:20676]	533-B.CL		R
(340)								10-26-06		
3*	G3	.25 \pm .01 DATUM E	CMM	QA		00064	.250	533-B.CL		A
(350)								10-26-06		
3*		\square .01 DATUM D	CMM	QA		00064	.032 [N/C:20676]	533-B.CL		R
(360)								10-26-06		
3*	E2	.25 \pm .01 DATUM D	CMM	QA		00064	.250	533-B.CL		A
(370)								10-26-06		
3*	E2	\sqrt{R} DATUM D	PROFILOMETER	QA		J-1152	18 TO 47 TWO SPO TS HAVE CIRCULAR TO OL DAMAGE	533-B.CL		A
(380)								10-26-06		
3*	F4	2X \varnothing 2.50	CALIPER	QA		J-707	2.510	533-B.CL		A
(390)								10-25-06		
3*	F4	4X \varnothing 1.0 -8UNC ∇ 2.5	THREAD PLUG GAGE	QA		A-185	ACCEPT	533-B.CL		A
(400)								10-26-06		

INSPECTION DATA CHECKLIST

3* (410)	F4	1.72	CALIPER	QA		J-707	1.710	533-B.CL 10-25-06			A
3* (420)	D5	8X Ø1-8UNC ▽ 1.5	THREAD PLUG GAGE	QA		A-185	ACCEPT	533-B.CL 10-26-06			A
3* (430)	B7	4X 1-8UNC ▽ 2.5	THREAD PLUG GAGE	QA		A-185	ACCEPT	533-B.CL 10-26-06			A
3* (440)	C1	1.50		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06			A
3* (450)	C1	3.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06			A
3* (460)	C1	4X Ø 1-8UNC ▽ 2.1	THREAD PLUG GAGE DEPTH MICROMETE	QA		A-670 J-1024	ACCEPT	533-B.CL 10-25-06			A
3* (470)	C1	4.50		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06			A
3* (480)	B1	9.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06			A
4* (500)	H6	Ø1.375-6UNC THRU OR Ø1.375-6UNC X ▽1.5 MIN FOR FLANGE THK GREATER THAN 1.5	THREAD PLUG GAGE	QA		A-375	ACCEPT	533-B.CL 10-26-06			A
4* (510)	E6	14X Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA		J-1400	1.884 TO 1.886 HO LE #6 1.884 - 1.889 HOLE #10 1.884 - 1.893 [N/C:20676]	533-B.CL 10-25-06			R
4* (520)	E6	14X └┘Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP		QA		MTMFX-3564	ACCEPT	533-B.CL 10-26-06			A
4* (530)	E6	$\text{⌀} \begin{matrix} .06 & & M & & A & & D \end{matrix}$ 14 X Ø1.885	CMM	QA		00064	.046 TO .060	533-B.CL 10-26-06		A	
4* (540)	D6	10X Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA		J-1400	1.884 TO 1.886 HOLE #19 HAS A GROO VE .400 TALL BY .01 8 DEEP [N/C:20676]	533-B.CL 10-25-06			R
4* (540)	D6	10X └┘Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP		QA		MTMFX-3564	ACCEPT	533-B.CL			A

INSPECTION DATA CHECKLIST

(550)							10-26-06		
4* (560)	D6	Φ .06 M A D 10 X Φ 1.885	CMM	QA	00064	.0316 TO .063 [N/C :20676]	533-B.CL 10-26-06		R
4* (580)	C7	3X \square Φ 2.000 - 2.001 ∇ .990 - 1.000		QA	LARGE DEA	3X - 2.0002 BY 1.00 3 [N/C:20676]	854-R.UP 10-03-06		R
4* (590)	C7	Φ Φ .06 M A D 3X Φ 1.130	CMM	QA	00064	.054 TO .066 [N/C:2 0676]	533-B.CL 10-26-06		R
4* (600)	D4	Φ 1.375-6UNC THRU OR Φ 1.375-6UNC X 1.5 MIN FOR FLANGE THK GREATER 1.5	THREAD PLUG GAGE	QA	A-375	ACCEPT	533-B.CL 10-26-06		A
4* (610)	D4	Φ .06 M A D Φ 1.375-6UNC	CMM	QA	00064	.022 TO .072 [N/C:2 0676]	533-B.CL 10-26-06		R
4* (620)	E2	10X .25-20UNC-2B	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 10-25-06		A
4* (630)	E2	Φ .03 X 45° CHAMFER	CALIPER	QA	J-707	.500 [N/C:20676]	533-B.CL 10-25-06		R
5* (640)	F7	12X .25-20UNC-2B	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 10-25-06		A
5* (650)	F7	Φ .03 X 45° CHAMFER	CALIPER	QA	J-707	.505 [N/C:20676]	533-B.CL 10-25-06		R
5* (660)	G6	3X 1.0	DEPTH MICROMETE	QA	J-1024	ACCEPT	533-B.CL 10-25-06		A
5* (670)	G6	3X Φ 3.00	CALIPER	QA	J-707	3.003	533-B.CL 10-25-06		A
5* (680)	G6	3X Φ 1.50	CALIPER	QA	J-1103	1.476 TO 1.491 [N/C :20676]	533-B.CL 10-25-06		R
5* (690)	E3	12X Φ 1.375-6UNC THRU OR Φ 1.375-6UNC X ∇ 1.5 MIN FOR FLANGE THK GREATER THAN 1.5	THREAD PLUG GAGE	QA	A-375	ACCEPT	533-B.CL 10-25-06		A
5* (700)	E3	Φ .06 N A E 12X Φ 1.375-6	CMM	QA	00064	.010 TO .028	533-B.CL 10-26-06		A
5*	D4	14X Φ 1.375-6UNC THRU OR Φ 1.375-6UNC X ∇ 1.5 MIN FOR FLANGE THK GREATER THAN 1.5	THREAD PLUG GAGE	QA	A-375	ACCEPT	533-B.CL		A

INSPECTION DATA CHECKLIST

(710)								10-25-06		
5* (720)	D4	Φ .06 N A E 14X Ø1.375-6	CMM	QA		00064	.006 TO .052	533-B.CL 10-26-06		A
5* (730)	E3	3X Ø1.885 ±.003 THRU	DIAL BORE GAGE	QA		J-1400	1.886	533-B.CL 10-25-06		A
5* (740)	E3	3X \perp Ø3.00 SPOTFACE BACKSIDE MINIMUM CLEAN UP		QA		MTMFX-3564	ACCEPT	533-B.CL 10-26-06		A
5* (750)	E3	Φ .06 N A E 3X Ø1.885	CMM	QA		00064	.024 TO .026	533-B.CL 10-26-06		A
6* (760)	G7	5.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (770)	H7	5.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (780)	H6	5.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (790)	C6	6.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (800)	C6	5.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (810)	F6	4X Ø1.00	CALIPER	QA		J-707	1.001 TO 1.002	533-B.CL 10-25-06		A
6* (820)	F7	6.50		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (830)	F6	2.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (840)	H5	2X .88/1.13	CALIPER	QA		J-707	1.090 AND 1.170 [N/ C:20676]	533-B.CL 10-25-06		R
6* (850)	C5	2.250 ± .010	CALIPER	QA		J-707	2.240	533-B.CL 10-25-06		A
6* (860)	F4	.06 - .09 X 45°	CALIPER	QA		J-707	.070	533-B.CL 10-25-06		A
7* (880)	C4	2X 1.56	CALIPER	QA		J-707	1.78 TO 1.81 [N/C:2 0676]	533-B.CL 10-25-06		R
7* (890)	C4	5.190		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
7* (900)	C3	6X	THREAD PLUG GAGE	QA		A-233	ALL GOOD EXCEPT ONE	533-B.CL		R

INSPECTION DATA CHECKLIST

(900)		.375-16UNC-2B TAP ∇ .75 .03 X 45° CHAMFER					HOLE THE NOGO GOES 4 TURNS [N/C:20676]	10-25-06		
7* (910)	B3	3.75		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
7* (920)	B3	7.50		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
8* (930)	C5	4 X \varnothing 1.0 T H R U	CALIPER	QA		J-707	1.003 TO 1.010	533-B.CL 10-25-06		A
9* (940)	C7	2X \varnothing .50 THRU	CALIPER	QA		J-707	.495 TO .499	533-B.CL 10-25-06		A
9* (950)	F4	10.15		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
9* (960)	F4	1.63		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
9* (970)	D4	\varnothing .25 ∇ 5.0 \perp \varnothing .625 ∇ 3.0	PIN GAGE	QA		J-652-1	.245 DEPTH 5.7 .625 DPETH 3.6	533-B.CL 10-26-06		A
9* (980)	E2	\varnothing .25 \perp \varnothing .625 DETAIL D	PIN GAGE	QA		J-652-1	.625 .246	533-B.CL 10-26-06		A
9* (990)	F2	4 X \varnothing 1.0 THRU	CALIPER	QA		J-707	1.001 TO 1.004	533-B.CL 10-25-06		A
11* (1010)	E5	∇ .5 A B C AS CAST SURFACES	CMM	QA		00064	-.309 TO .435 [N/C: 20676]	533-B.CL 10-26-06		R
11* (1020)	C8	∇ -.12 -.25 A B C WING SURFACES	CMM	QA		00064	-.029 TO .055	533-B.CL 10-26-06		A
11* (1030)	D1	∇ +0.0 -.12 A B C WING POCKET	CMM	QA		00064	-.035 TO .028	533-B.CL 10-26-06		A

Quality Assurance Documentation for Part ID: SE141-115 - Item: 21

Workorder: 65708/2-0 Sub:1 Op:136

Part: SE141-115 - MODULAR COIL, TYPE B -

Drawing ID: SE141-115 Rev: 9		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		<u>D A T U M - E - S I D E</u> 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	< 1.02	495-D.CO			A
(10)								10-23-06			
*		<u>D A T U M - D - S I D E</u> 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	< 1.02	495-D.CO			A
(20)								10-23-06			



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-139 - Item: 25

Workorder: 65708/2-0 Sub:11 Op:30

Part: SE141-139 - SHORT BEARING PLATE TYPE "B" -

Drawing ID: SE141-139 Rev: 1		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1* (10)	G2	RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1270	LESS THAN 1.02	854-R.UP 07-09-06		

A

Quality Assurance Documentation for Part ID: SE141-140 - Item: 28

Workorder: 65708/2-0 Sub:12 Op:30

Part: SE141-140 - LONG BEARING PLATE TYPE "B" -

Drawing ID: SE141-140 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-1165	LESS THAN 1.02	854-R.UP		
(10)								07-16-06		

A

Employees: 495-D.Coffman / 503-B.Houk / 533-B.Clevenger / 771-B.Schultz / 825-B.Jarrett / 854-R.Upchurch