



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: 65708/4.0 Sub: 0

Customer P.O.: S005242-F/Ln:4
Serial No./Qty: B4

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

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

Problem: Several tooling gouges were identified during the visual review of the casting. See attachment for details.

Proposed Disposition:

Propose to accept as is.

Number of additional pages: 8 page attachment

Customer Disposition: Use As Is Rework Repair Scrap Replace

All of the visual indications on the attachment were reviewed on site by F. Malinowski and P. Heitzenroeder and then sent to T. Brown and D. Williamson for their review. All agreed that the indications are similar to those in B3. Some of the deep tool gouges will have to be filled with epoxy by J. Chrzanowski – he is requested to evaluate all and decide which require filling prior to starting winding operations..

Accepted by:

Tech. Rep.

RLM

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



NC21038 – B4 Visual Review

E side undercut

Long - Hole #94 to #5 is .010 to .012

Long - Hole #38 to #42 is .010 to .014

Long - Hole #60 to #62 is .010 to .012

Long - Hole #84 to #87 is .010 to .013

Short - Hole #90 to #92 is .010 to .012

D side undercut

Long - Hole #3 to #4 is .010 to .012

Long - Hole #10 to #11 is .010 to .012

Long - Hole #32 to 33 is .010 to .011

Long - Hole #43 to #45 is .010 to .012

Long - Hole #71 to #75 is .010 to .012

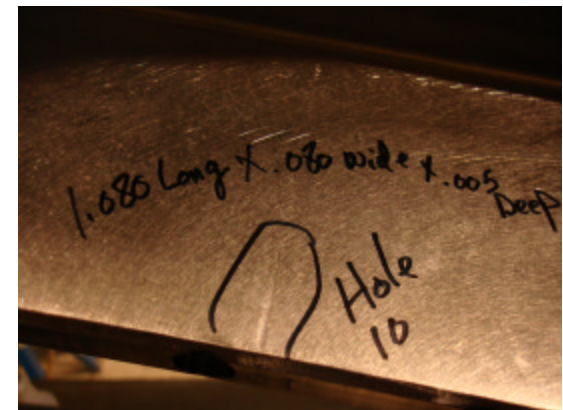
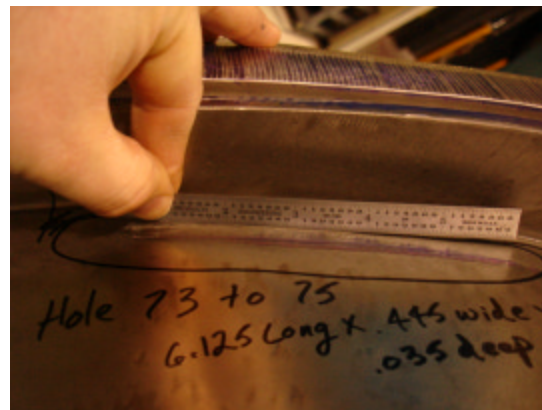
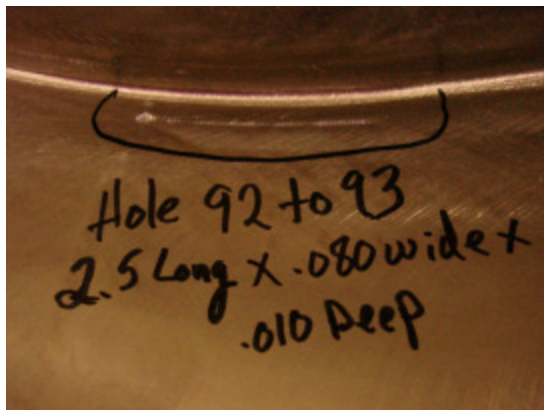
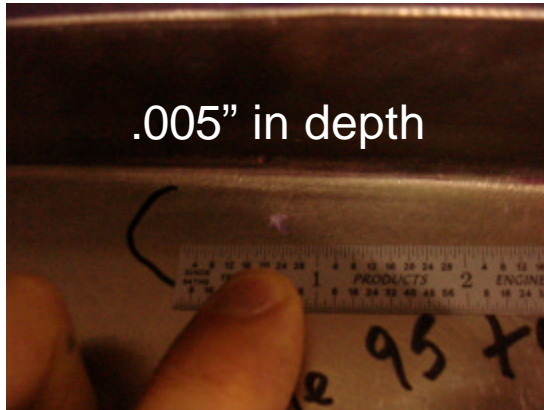
Short - Hole #53 to #55 is .010 to .011

Short - Hole #58 to #59 is .010 to .012



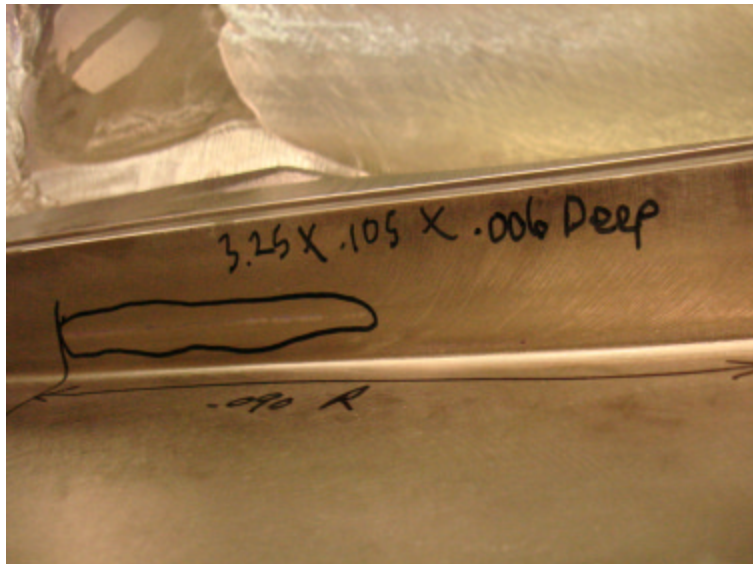
NC21038 – B4 Visual Review

Tool Gouges on Datum E side



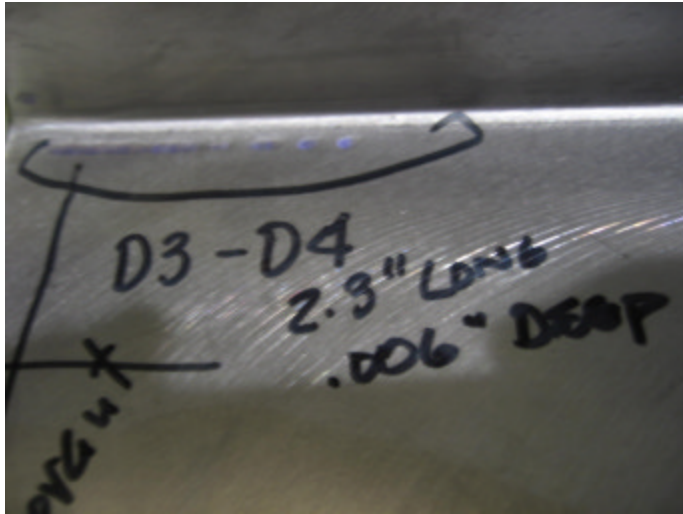


Tool Gouges on Datum E side cont.





Tool Gouges on Datum D side



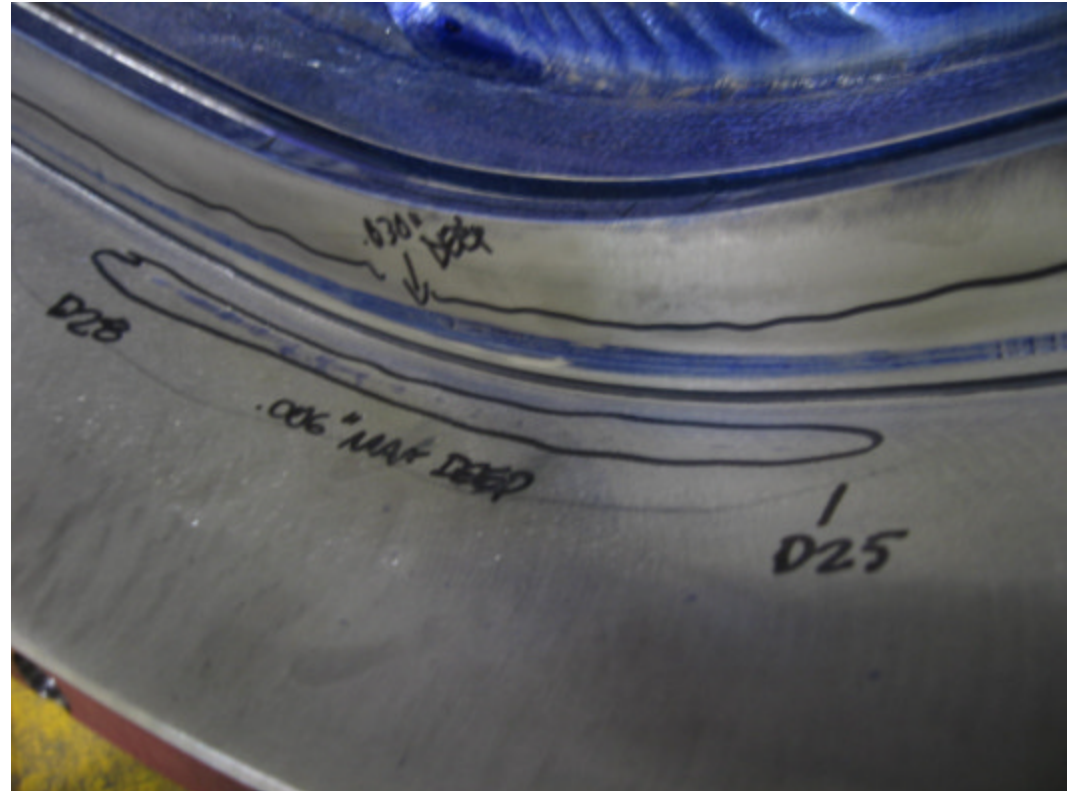
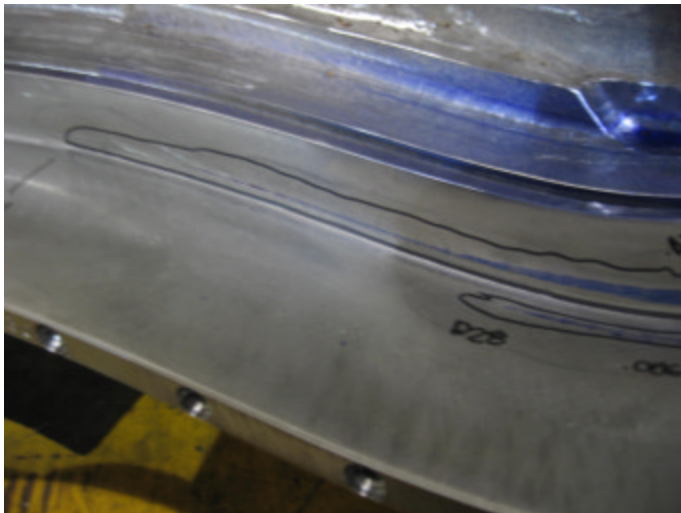
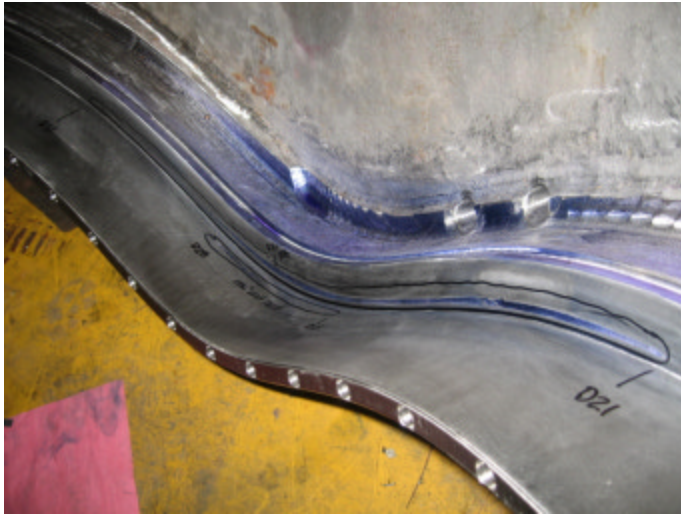


Tool Gouges on Datum D side cont.





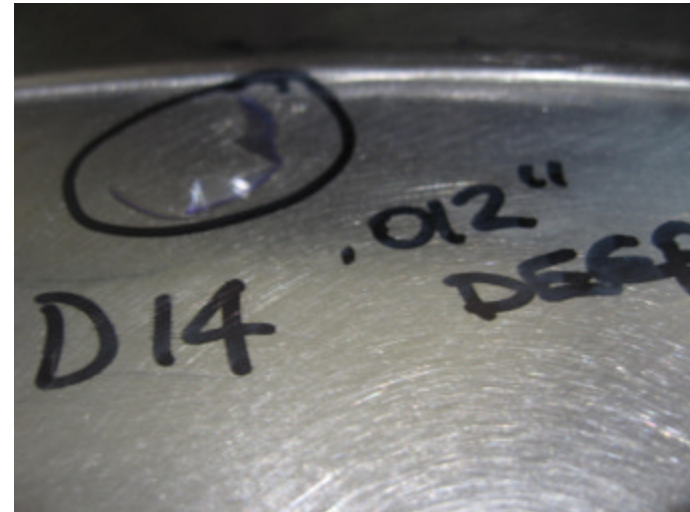
Tool Gouges on Datum D side cont.



Tool gouges on long and short legs of datum D side between T holes D21 and D31 (see previous slide). Gouges are in approximately the same location as reported on B3. Long leg gouge is up to .006" deep and short leg has an area up to .03" in depth.



Tool Gouges on Datum D side cont.





Tool Gouges on Datum D side cont.



Tooling gouges between holes 76 and 80 on the datum D side of the T. Gouges are very shallow ($<.005''$) except where noted on picture. One area measures up to $.025''$ deep.