
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: 8
W/O Links: 1-Type:W: 65709/5.0 Sub: 1

Customer P.O.: S005242-F/Ln:5
Serial No./Qty: A5

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

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

Problem: FOUR REJECTABLE INDICATIONS WERE FOND AT TIME OF INSPECTION.

1. LINEAR .900"
2. LINEAR .400"
3. LINEAR 1"
4. LINEAR .300"

See attachment for details.

Proposed Disposition:

MTM Proposes to accept indications As-Is.

Number of additional pages: 4 page PT attachment

Customer Disposition: Use As Is Rework Repair Scrap Replace

The indications were reviewed by David Williamson; his comments are below:
Indication #1 - Datum-E, edge of flange, near tee hole #90, very low stress, acceptable
#2 - Datum-E, edge of flange, near tee hole #26, ~4-ksi, acceptable
#3 - Winding side-B, tee hole #80-81, stress=~3-ksi, acceptable
#4 - Winding side-A, base at tee hole #76, stress = ~3-ksi, acceptable
None of the indications occur in the high stress regions, tee hole #41-48, #61-65.

Accepted by:

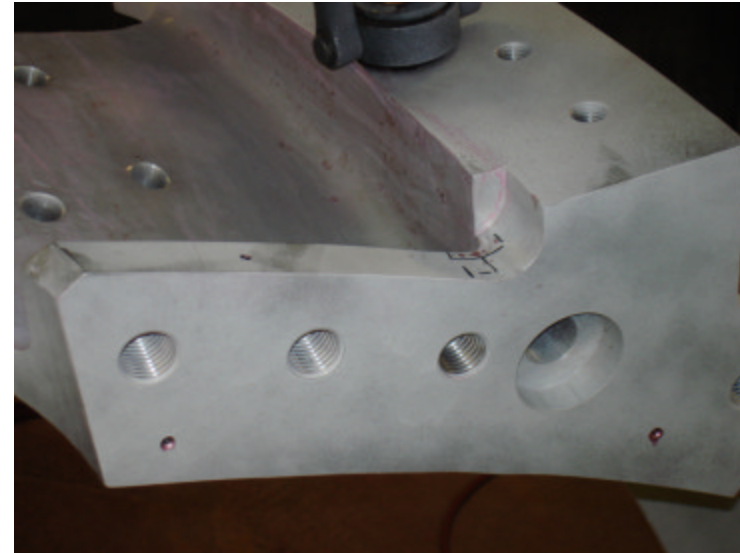
Tech. Representative

RLM

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

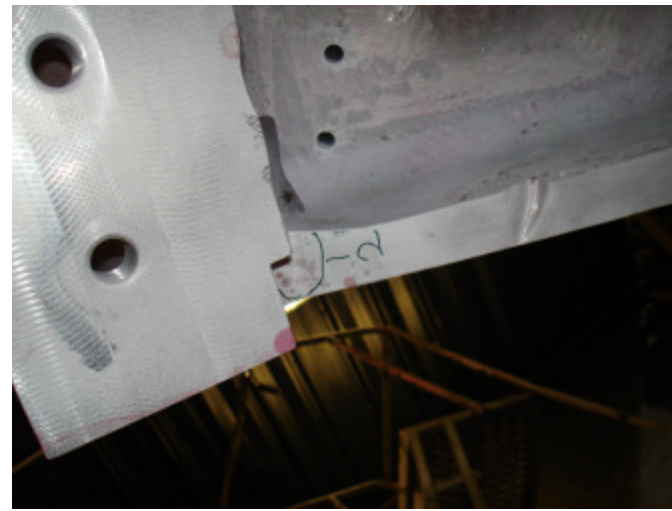
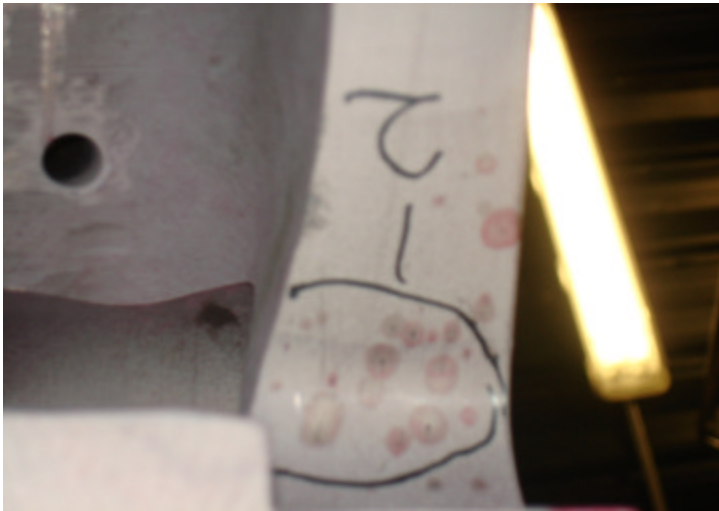
NC21242 – A5 PT Rejections

Indication 1 is a .900" linear located on the perimeter of the datum E flange adjacent to flange hole 19.



NC21242 – A5 PT Rejections

Indication 2 is a cluster of porosity on the perimeter of the datum E flange adjacent to flange hole #10. Longest indication is approx. .400" long.





NC21242 – A5 PT Rejections

Indication 3 is a 1” linear located thru the VPI groove between T holes 80 & 81 on the datum E side of the part. There appears to be a small cluster of indications in this area. The measurable size of these indications are less than the rejectable size. One indication in particular appears to have some depth even though the discontinuity size is acceptable. This is the area shown with the sizeable bleed out are on the short leg adjacent to the 1” linear.



NC21242 – A5 PT Rejections

Indication 4 is a .300" linear located in the radius below the VPI groove between holes 76 & 77 on the datum D side.

