

Customer: ENERGY INDUSTRIES OF OHIO

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Part: SE141-114 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-114 Revision: 8
W/O Links: 1-Type:W: 65709/6.0 Sub: 1

Customer P.O.: S005242-F/Ln:6
Serial No./Qty: A6

Reported By: MIKE GRIFFITH
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Problem: 14 rejectable indication were found a time of inspection.

D-side indications

1. Cluster .500 largest linear between holes 43 thru 45 on T-section.
2. Cluster .600 largest linear between holes 40 thru 43 on T-section.
3. Cluster 1" largest linear between holes 36 thru 40 on T-section.
4. Linear 1.5" on the break.
5. Cluster .700 largest linear between holes 8 thru 11.
6. Linear .400
7. Rounded .150 between holes 77 & 78 on T-section.
12. Linear .300 on large cut out.
13. Linear .700 on large cut out.
14. Linear .900 on large cut out.

E-side

8. Cluster 1" largest linear on outer flange.
9. Cluster .300 largest linear on outer flange.
10. Linear .700 bewteen hole 13 thru 14 on T-section.
11. Cluster .700 largest linear

All indications are numbered and photos have been taken as noted. (see attached).

Proposed Disposition:

MTM Proposes to accept indications as-is.

Number of additional pages: 9 page attachment

Customer Disposition: Use As Is Rework Repair Scrap Replace

These indications were reviewed at a pre-release meeting with T. Brown, J. Chrzanowski, L. Dudek, F. Malinowski, & L. Sutton. The locations were all outside of the designated high stress area and the severity was comparable to the indications accepted for A-4 & A-5. Based on this evaluation, the disposition is to use as-is.

Procurement Technical Representative

Responsible Line Manager:

Major Tool Implemented By: N/A Title: _____ Date: _____



NC21432 – A6 PT Rejections



Group 1 is a small cluster of linear indications, longest is .5". Cluster is located in the radius below the VPI groove on the datum D side between T holes 43 and 45.

Group 2 is a cluster with the longest indication being a .6" linear. Located between T holes 40 and 43.

Group 3 has a 1" linear as its longest indication. This cluster is located between T holes 36 and 40.



NC21432 – A6 PT Rejections



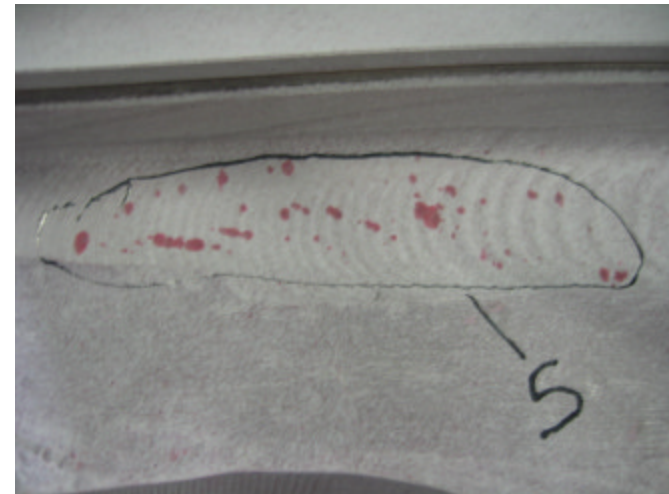
Indication 4 is a 1.5” linear located on the poloidal break (datum D side).



NC21432 – A6 PT Rejections



Group 5 is a cluster of indications on the datum D side in radius below VPI groove between T holes 8 and 11. The longest indication is a .7" linear.



NC21432 – A6 PT Rejections



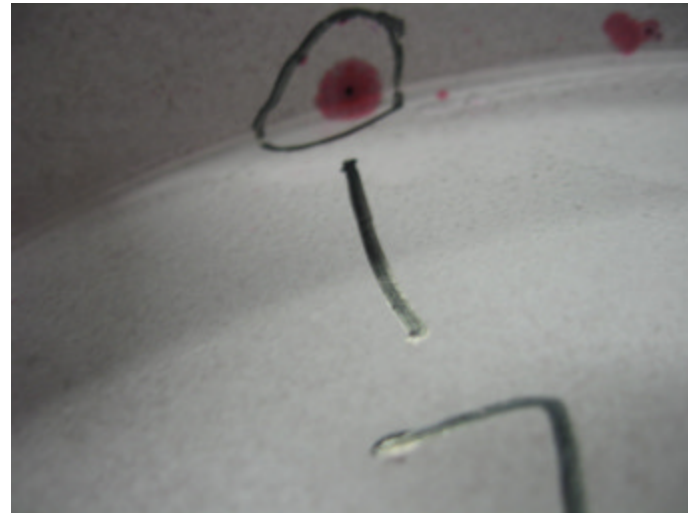
Indication 6 is a .400" linear located in large cutout of datum D flange between flange holes 16 and 17.



NC21432 – A6 PT Rejections



Indication 7 is a .15" rounded between T holes 77 and 78 on the datum D side.



NC21432 – A6 PT Rejections



Indication 8 is a 1” linear and Indication 9 is a .300” linear, both are located on the perimeter of the datum E flange.

Indications are on either side of foot between E flange holes 18 and 19.



NC21432 – A6 PT Rejections



Indication 10 is a .700" linear located in the radius below the VPI groove on the datum E side between T holes 13 and 14.



NC21432 – A6 PT Rejections



Group 11 is a cluster of indications on the small outer wing surface on the datum E side. Largest indication is a .700" linear.





NC21432 – A6 PT Rejections



Indications 12, 13 and 14 are a group of indications located on the large cutout on the datum D side between flange holes 4 and 5.

Indication 12 is a .300" linear

Indication 13 is a .700" linear

Indication 14 is a .900" linear

