
Customer: ENERGY INDUSTRIES OF OHIO

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Part: SE141-114 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-101 Revision: 3
W/O Links: 1-Type:W: 65709/6.0 Sub: 0

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

Reported By: MIKE GRIFFITH
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Problem: SEVERAL ITEMS DOCUMENTED DURING VISUAL REVIEW OF CASTING. SEE ATTACHED.

Proposed Disposition:

MTM PROPOSES TO ACCEPT AS-IS.

Number of additional pages: 9 page attachment

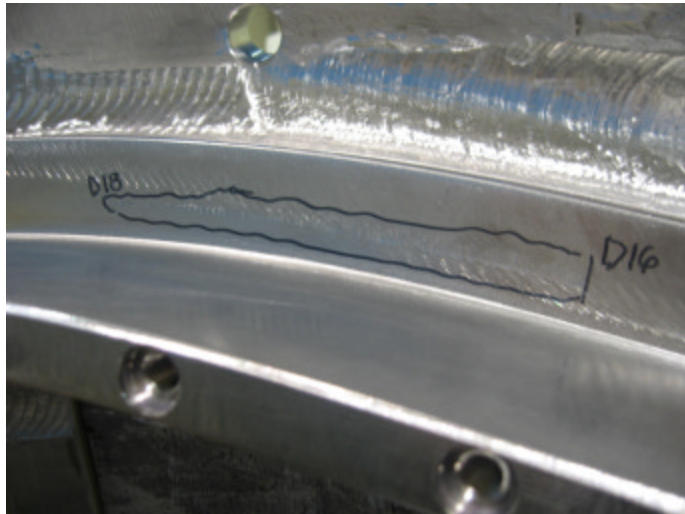
Customer Disposition: Use As Is Rework Repair Scrap Replace

These indications were reviewed at a pre-release meeting with T. Brown, J. Chrzanowski, L. Dudek, F. Malinowski, & L. Sutton. The number of discontinuities is greater than on recent castings, but there are none that cannot be readily remediated during winding prep. Based on this evaluation, the disposition is to use as-is.

Procurement Technical Representative

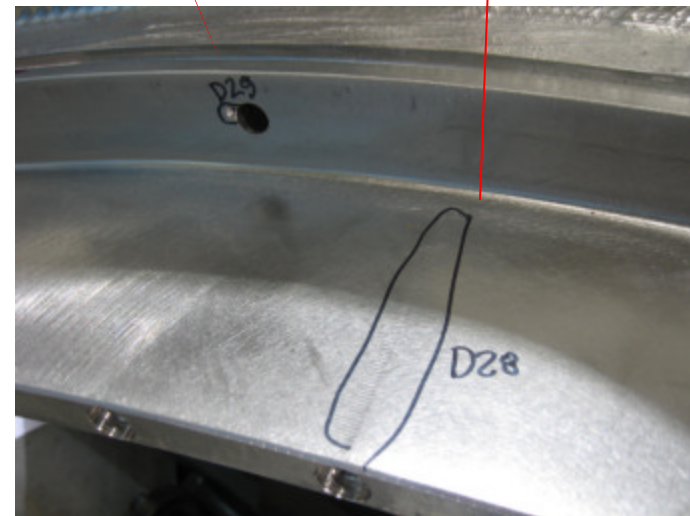
Responsible Line Manager:

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

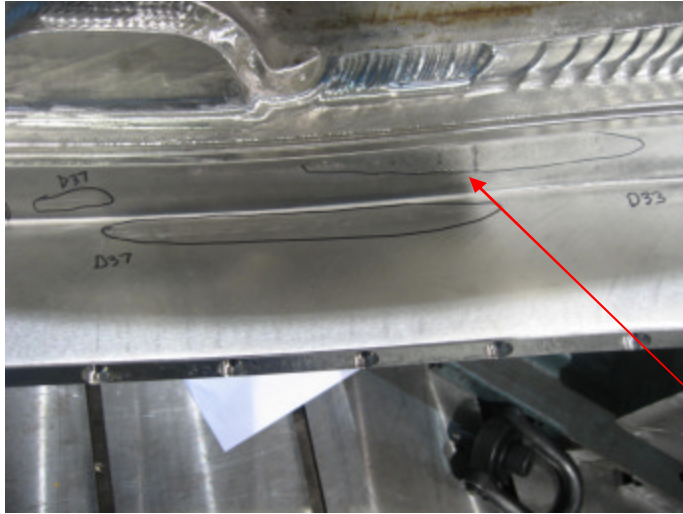


Shallow tool gouges on D side short leg (D16-D18) and long leg (D76-D78)



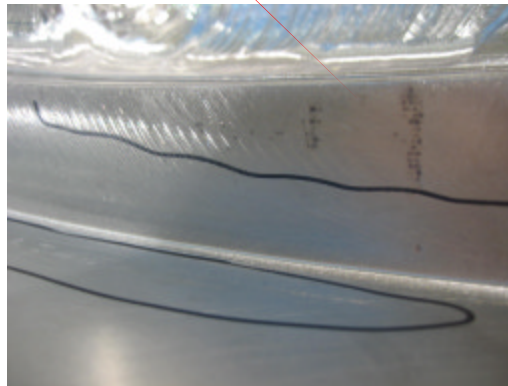


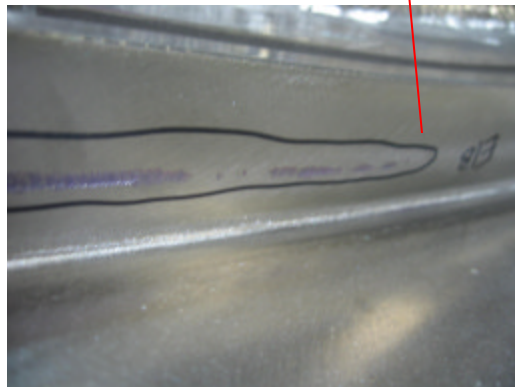
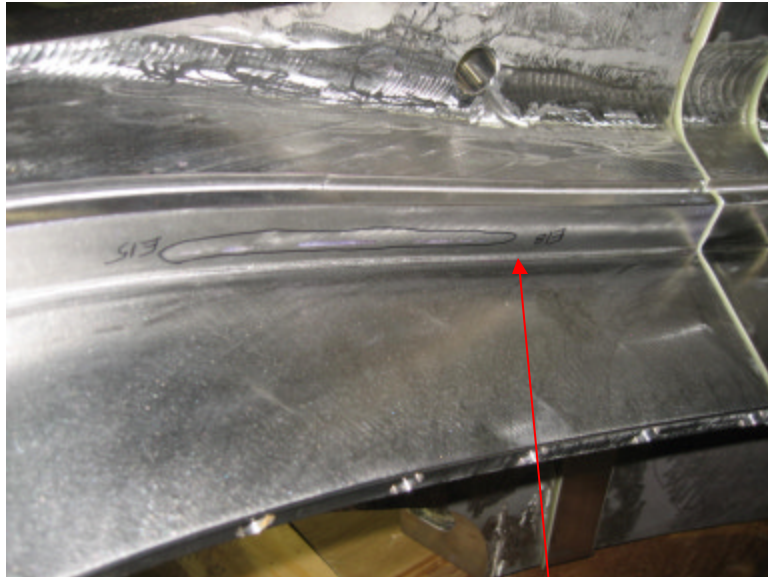
D29 is a tool gouge on the edge of the VPI bleed hole ($\text{Ø}.218''$ x $.06''$ deep). All other tool marks on this page are very shallow ($<.005''$)



D33 through D37 are shallow tool marks on the long and short side of Datum D.

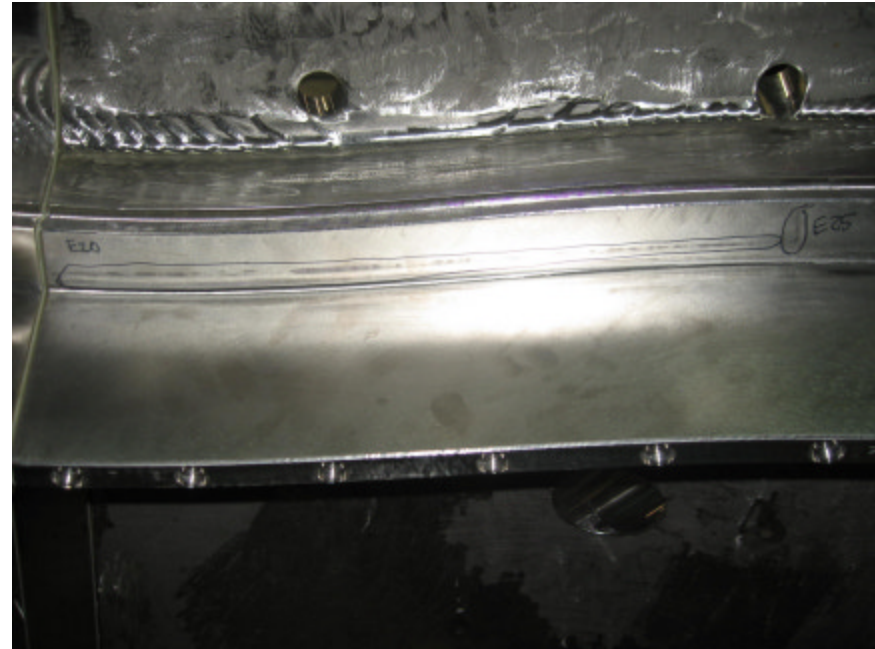
These tool marks are also $<.005''$.





E side tool marks on short leg from
E15 to E18 and E20 to E25 (these are
left and right of the break).

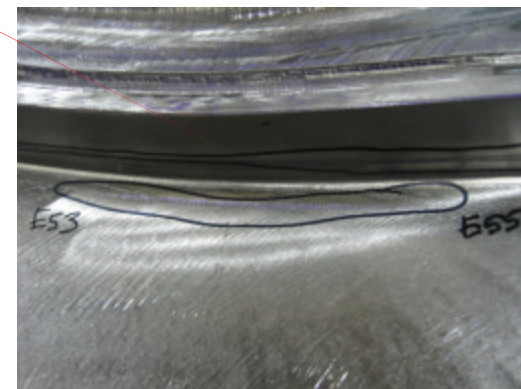
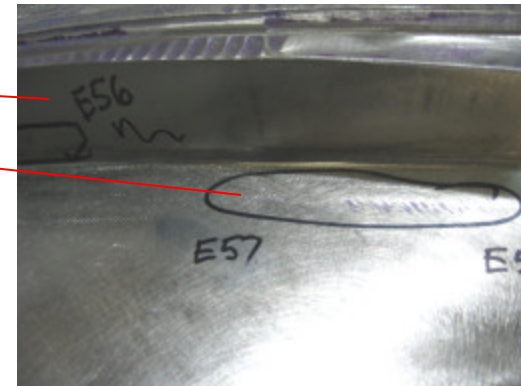
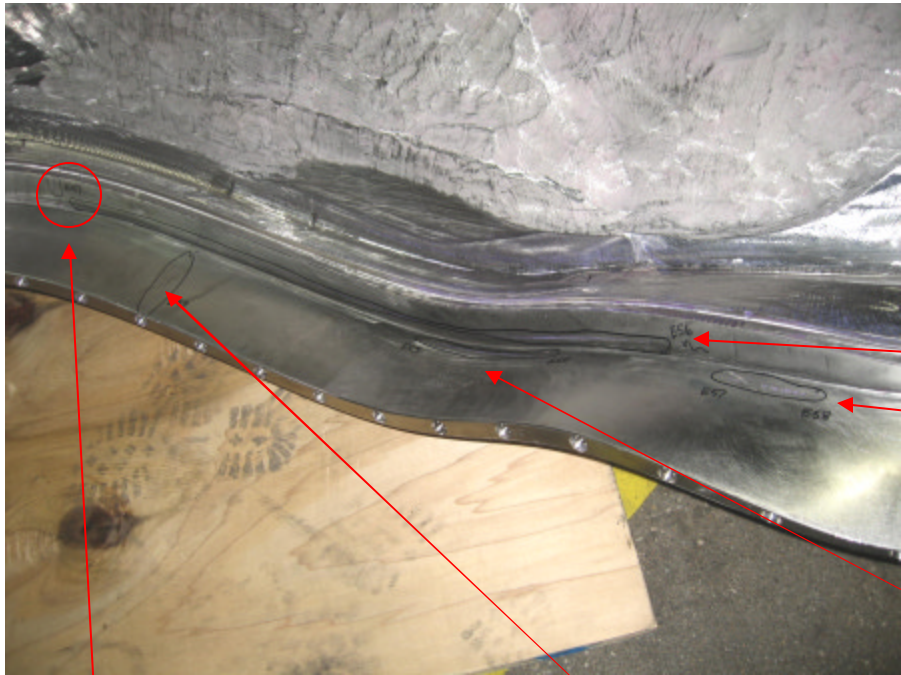
<.005" deep

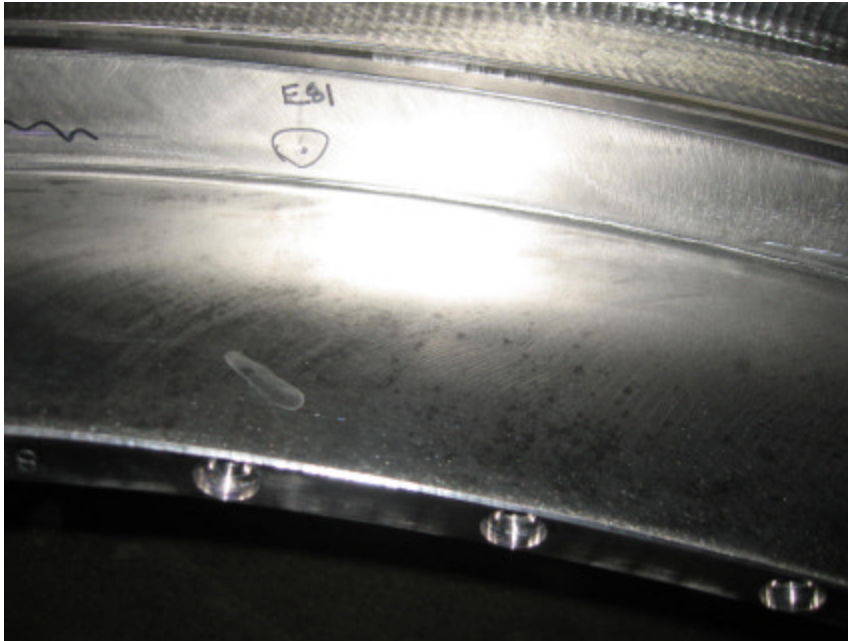




NC21482 – A6 Visual Review

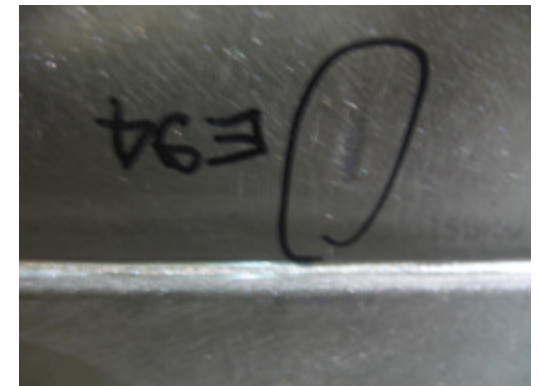
This slide shows several areas where tool marks did not clean up from E47 to E58 on both the long and short legs of the T section. All are less than .010" deep.





Small tool gouges near holes 81
and 94 on short leg of E side.

(<.010" deep)

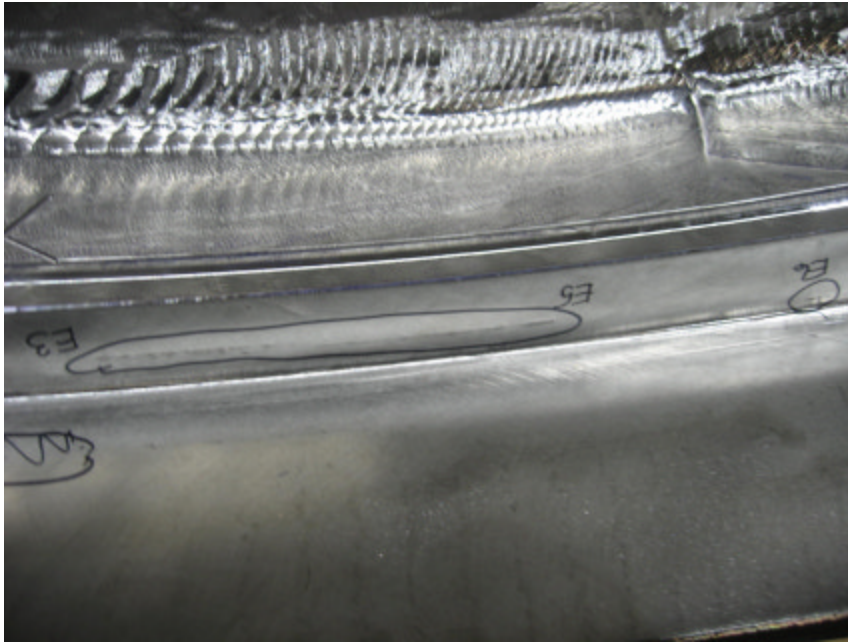




Three separate areas of cutter non-cleanup
on D side short leg between T section holes
84 thru 89

(<.010" deep)





Tool non-cleanup between T holes
3 and 6 on the short leg of the
datum E side
($<.005''$ deep)





D side undercut

Long Leg - Hole #36 to #39 is .010 to .011

Short Leg - Hole #16 to #19 is .010 to .015