Major Tool & Machine, Inc.
1458 East 19th Street
Indianapolis, IN 46218-4289

MTM N/C: 21757

Date: 05/04/07
User ID: GRIFFITH

Customer: ENERGY INDUSTRIES OF OHIO
Contact: NANCY HORTON — Telephone: 216-496-2314
E-Mail: NKHFlowen@aol.com — Fax: 216-328-2001

Part: SE141-116 / MODULAR COIL WINDING FORM TYPE — Customer P.O.: S005242-F/Ln:6
Drawing ID: SE141-116 — Revision: 8 — Serial No./Qty: C6
W/O Links: 1-Type:W: 65707/6.0 Sub: 1

Reported By: MIKE GRIFFITH — Telephone: 317-636-6433
E-Mail: mGriffith@MajorTool.com — Fax: 317-634-9420

Problem: 10 indication were found at time of inspection.

1. .600" linear indication on large wing D side.
2. .400" linear in VPI groove near D51.
3. .300" line porosity in radius below VPI groove between T holes D48 and D50.
4. .300" linear in radius below VPI near T hole D14.
5. .200" linear in radius below VPI near T hole D11.
6. .200" linear in radius below VPI near T hole D10.
7. .350" line porosity on perimeter of D flange.
8. .300" line porosity E flange perimeter.
9. .300" line porosity E flange large wing.
10. .600" linear in 3" counterbore of D flange.

Proposed Disposition:
MTM Proposes that indications be accepted as is.

Number of additional pages: 5 page attachment

Customer Disposition: **[x] Use As Is** **[ ] Rework** **[ ] Repair** **[ ] Scrap** **[ ] Replace**

Rationale for acceptance:
#1, 2,4,5, and 6 are all in thick base or wing sections where the stress is low.
#3 is in a thick overcast region outside of the high stress web of the T.
#7 is in the edge of the flange in a low stress region.
#8 in a low stress region adjacent to the pillow shim tube groove for a large wing.
#9 is in the thick low stress foot region.
#10 is in the bore of a hole near sheet 4, zone C5 (lower outboard foot, which is in a low stress region).

Accepted by:

Phil Heitzenroeder
Digitally signed by Phil Heitzenroeder
DN: cn=Phil Heitzenroeder, c=US, o=PPPL, ou=Mech. Eng. Division
Date: 2007.05.20 20:30:07 -04'00'

Brad Nelson
Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US, o=ORNL, ou=FED, email=nelsonbe@ornl.gov
Date: 2007.05.21 09:58:41 -04'00'

Tech. Rep. RLM:

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

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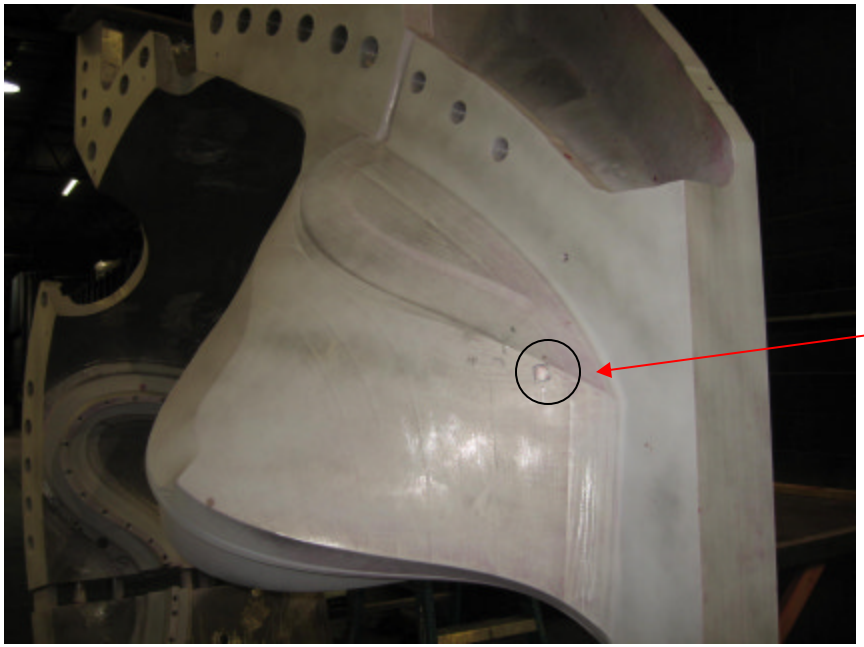
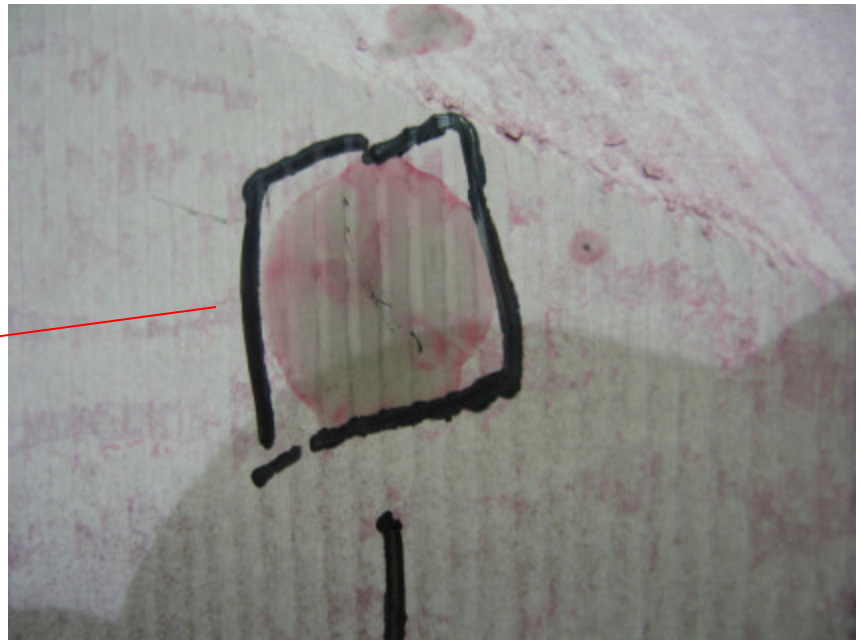
NC21757 – C6 PT Rejections

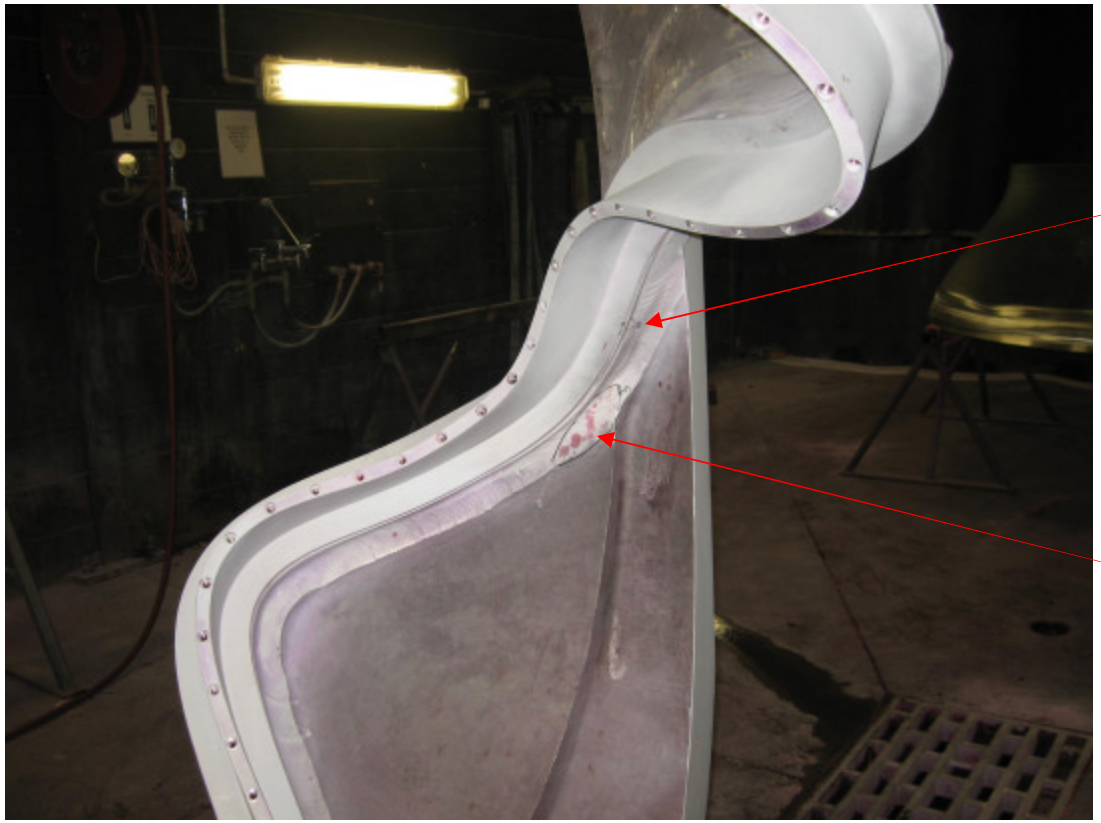




Indication 1 is a .600” linear on large wing
datum D side

Mike Griffith

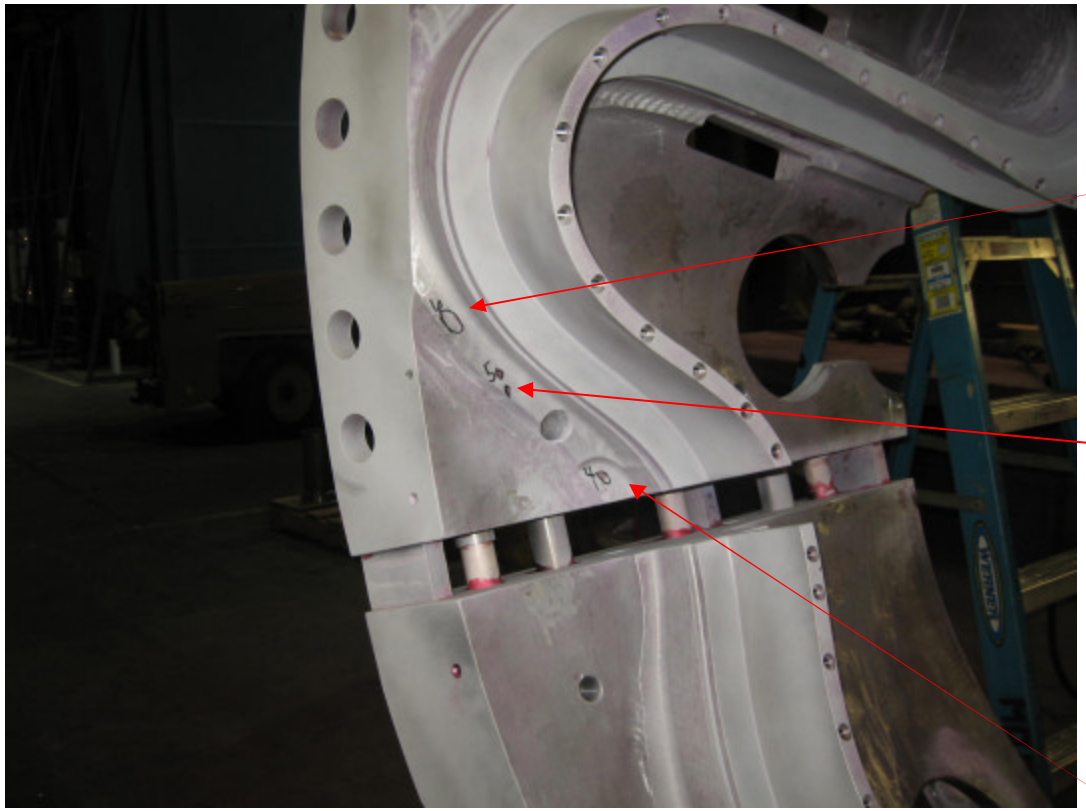
NC21757 – C6 PT Rejections



Indication 2 is a .400” linear in the VPI groove near T hole 51 on the datum D side.

Indication 3 is a cluster of porosity in radius below the VPI groove between T holes 48 and 50 on the datum D side. The largest is a .300” linear.

NC21757 – C6 PT Rejections



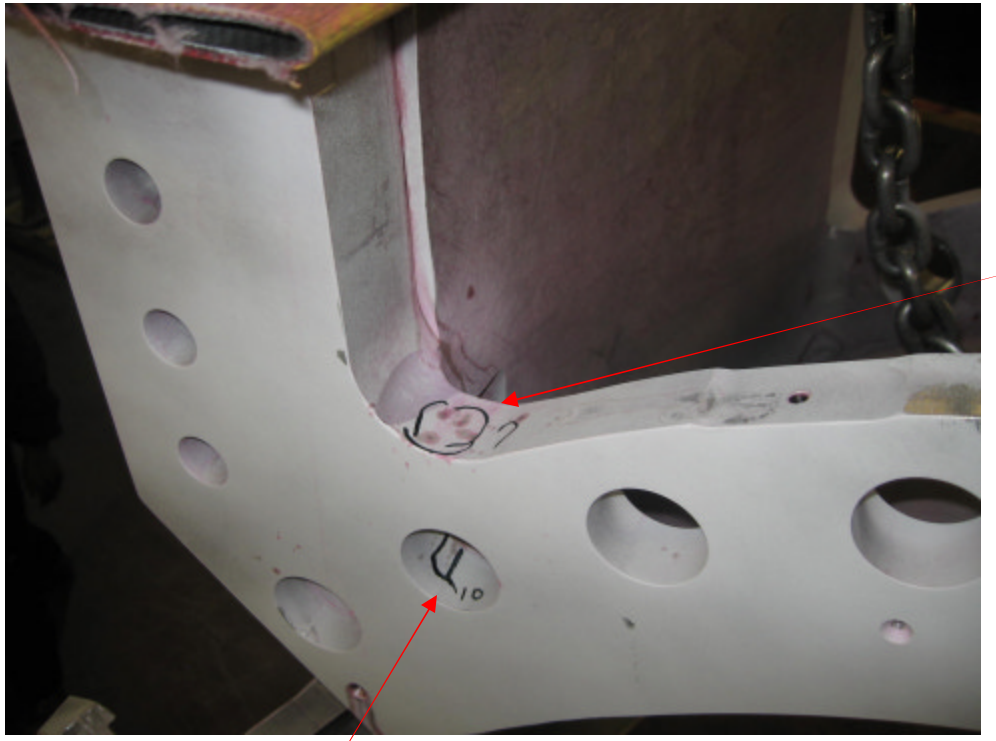
Indications 4, 5 & 6 are all in the radius below the VPI groove on the Datum D side between T holes 10 thru 14.

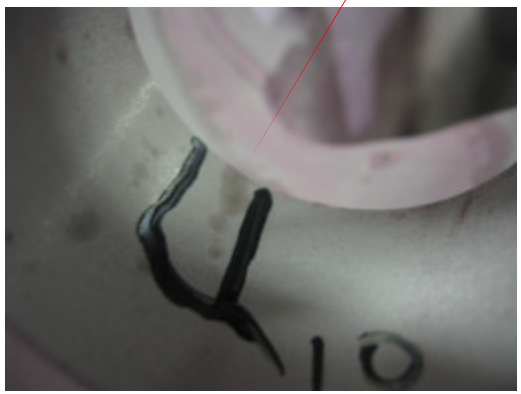
Indication 4 is a .300” linear

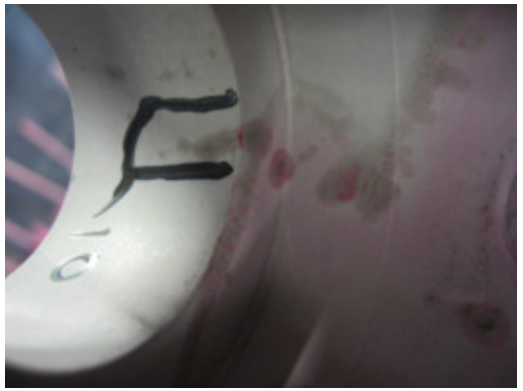
Indication 5 is a .200” linear (longest of two)

Indication 6 is a .200” linear (longest of two)

NC21757 – C6 PT Rejections







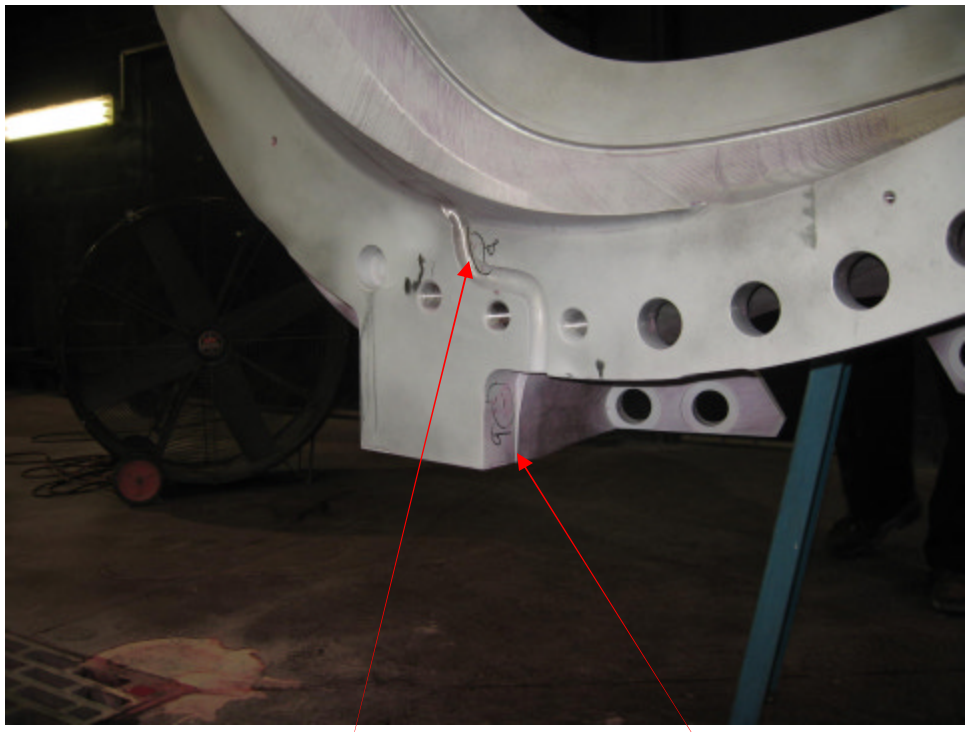
See sheet 4, zone C5 of drawing for locations of indications 7 and 10.

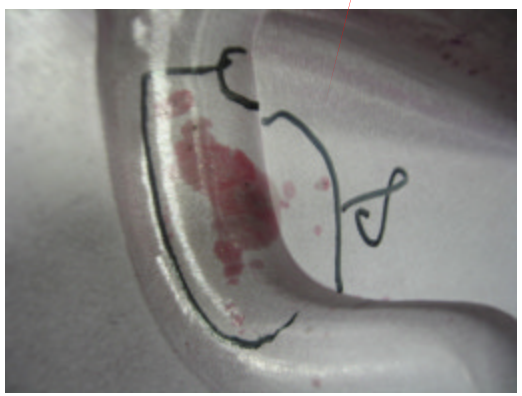
Indication 7 is a cluster of linear indications on the perimeter of the datum D flange (.350” longest).

Indication 10 is .600” linear on the ID and counterbore face of the 1.885” bore. The indication extends across both surfaces.

Mike Griffith

NC21757 – C6 PT Rejections

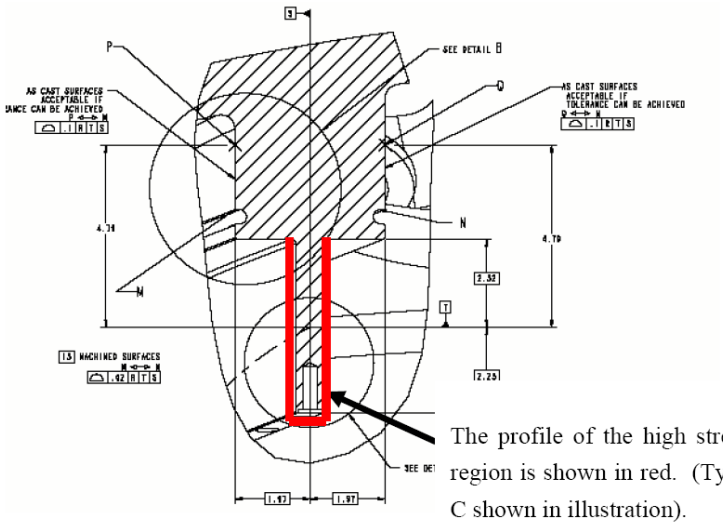




Indication 8 contains a cluster of linear indications on the large wing of the datum E side. The longest is .300".

Indication 9 is a small cluster of linear indications on the perimeter of the datum E flange. Longest is .600".

See zone G6 of drawing sheet 5.



The profile of the high stress region is shown in red. (Type C shown in illustration).

Figure 7-1 – Identification of High Stress Zones

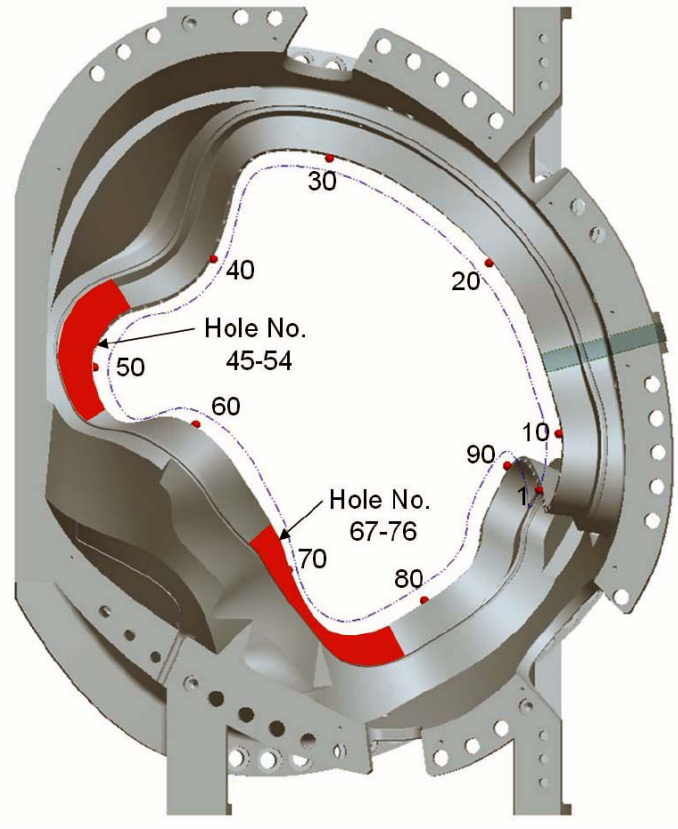


Figure 7-2 – High Stress Region Identification for Type-C MCWF