

Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
E-Mail: NKHFlowen@aol.com

Telephone: 216-496-2314
Fax: 216-328-2001

Part: SE141-116 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-116 Revision: 8
W/O Links: 1-Type:W: 65707/6.0 Sub: 1

Customer P.O.: S005242-F/Ln:6
Serial No./Qty: C6

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

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

Problem: Workorder: 65707/6.0 Sub:1 Op:132

- Inspection Test #: 130 rejected: : 2X R.11: E SIDE .05 TO .120 D SIDE .08 TO .120
- Inspection Test #: 150 rejected: 4.790 OR SHELL INTERSECT. VERIFY USING TEMPLATE PER DRAWING NOTE 16 (MTMFX-3473): : AREAS THAT DO NOT ACCEPT GAGE ARE 9-13, 26-36, 41-52
- Inspection Test #: 160 rejected: Q TO N: {g|.2|R|S|T}: .015 TO .104
- Inspection Test #: 180 rejected: M TO MI: {g|.02|R|S|T}: -.020 TO .024
- Inspection Test #: 182 rejected: N TO NI: {g|.02|R|S|T}: -.018 TO .024
- Inspection Test #: 190 rejected: 96X .375-16 UNC .750 DEEP .625 C'BORE .188 DEEP: {#|.06|R|S|T}: .004-.065 POSITION, 24 C'BORE OUT OF TOL. (.623 TO .628 RANGE)
- Inspection Test #: 200 rejected: : 2X .06-.09 X 45°: .04 TO .07
- Inspection Test #: 230 rejected: DATUM -E- FLANGE: {f|.01}: .014
- Inspection Test #: 250 rejected: DATUM -D- FLANGE: {f|.01}: .014
- Inspection Test #: 300 rejected: 3X 2.000" COUNTERBORE 1.00 DP: {#|d.06|D|A|N}: .0176, .007, .0272 DEPTH SHALLOW .981, .983, .981
- Inspection Test #: 980 rejected: : {g|-.12;;-.25|A|B|C}: .049 TO .109
- Inspection Test #: 990 rejected: DATUM -D- SIDE INNER CAST: {g|.5|A|B|C}: -.250 TO .348
- Inspection Test #: 1010 rejected: SMALL WING E SIDE: {g|-.12;;-.25|A|B|C}: .006 TO .062
- Inspection Test #: 1030 rejected: DATUM -E- SIDE INNER CAST: {g|.5|A|B|C}: -.216 TO .341
- Inspection Test #: 1035 rejected: MACHINE / GRIND THIS AREA TO PROFILE OF +.05/- .10: : -.1249 TO .0139

Proposed Disposition:

MTM Proposes that deviations be accepted as is based on similarity of defects to previous C castings.

Number of additional pages: 13 page IDC attachment

Customer Disposition: Use As Is Rework Repair Scrap Replace

This list of deviations was reviewed in detail by David Williamson on 5/9/07; all were found to be acceptable. The summary of his review is attached.

Approved by:

Tech. Rep.

RLM

Major Tool Implemented By: _____

Title: _____

Date: _____



INSPECTION DATA CHECKLIST

1458 E. 19th Street, Indianapolis, In 4621
TEL:(317)636-6433 FAX:(317)634-9420

REV. 1 - STEP 210 OF OPERATION 132 CORRECTED.

Workorder: 65707/6-0 Sub:1 Op:88

Revision: 05/03/07 8:04

Part: SE141-116 - MODULAR COIL WINDING FORM TYPE-C - PRODUCTION MODULAR COIL WINDING FORM TYPE-C

| Drawing ID: SE141-116 Rev: 8 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
|------------------------------|------|--|-------------------------|-----|--------|---------|--------------|--------------|-------|-------|---|
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| * | | 22 PLACES DATUM E FLAN GE VERIFY 2" CLEARANCE ABOVE 3" COUNTERBORE SURFACE USING MTMFX-3564. | | MFG | | | ACC | 524 | | | A |
| (20) | | | | | | | | 05-03-07 | | | * |
| * | | 26 PLACES DATUM D FLAN GE VERIFY 2" CLEARANCE ABOVE 3" COUNTERBORE SURFACE USING MTMFX-3564. | | MFG | | | ACC | 524 | | | A |
| (30) | | | | | | | | 05-03-07 | | | * |

Workorder: 65707/6-0 Sub:1 Op:130

Revision: 05/03/07 13:43

Part: SE141-116 - MODULAR COIL WINDING FORM TYPE-C - PRODUCTION MODULAR COIL WINDING FORM TYPE-C

| Drawing ID: SE141-103 Rev: 3 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
|------------------------------|------|---|-------------------------|----|--------|---------|--|--------------|-------|-------|---|
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 2* | D3 | Ø.001 - Ø.002 CHECK CLEARANCE OF ITEM 5 TO ITEM 6. | FEELER GAGES | QA | | J-1144 | LESS THAN .002 | 711 | | | A |
| (10) | | | | | | | | 05-03-07 | | | * |
| * | | THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002" | FEELER GAGES | QA | | J-1144 | LESS THAN .002 | 711 | | | A |
| (15) | | | | | | | | 05-03-07 | | | * |
| 2* | F2 | | FEELER GAGES | QA | | J-1144 | .018" WILL PASS THR OUGH THIN SECTION O FT [N/C:21762-Doc: | 242 | | | R |

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REV. 1 - STEP 210 OF OPERATION 132 CORRECTED.

| | | | | | | | | | |
|------|--|---|--------------|----|--|----------|----------------|----------|---|
| (20) | | ENSURE THAT THE CUMULATIVE GAPS AT ANY SINGLE CROSS SECTION OF THE POLOIDAL FLANGE ELEMENTS IS LESS THAN .005". | | | | NC21762] | | 05-08-07 | * |
| * | | THE MAX. GAP AT THE POLOIDAL BREAK PERIMETER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE. | FEELER GAGES | QA | | J-1144 | LESS THAN .015 | 711 | A |
| (30) | | | | | | | | 05-03-07 | * |

Workorder: 65707/6-0 Sub:1 Op:132

Revision: 05/09/07 8:20

Part: SE141-116 - MODULAR COIL WINDING FORM TYPE-C - PRODUCTION MODULAR COIL WINDING FORM TYPE-C

| Drawing ID: SE141-116 Rev: 8 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | |
|------------------------------|------|----------------------|-------------------------|----|--------|---------|--------------|-----------------|-------|--------|
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT |
| 1* (10) | E8 | 47.19 ± .03 | CMM | QA | | 00064 | 47.192 | 533 05-07-07 | | A * |
| 1* (20) | B8 | 47.19 ± .03 | CMM | QA | | 00064 | 47.185 | 533 05-07-07 | | A * |
| 1* (30) | D6 | 47.19 ± .03 | CMM | QA | | 00064 | 47.185 | 533 05-07-07 | | A * |
| 1* (40) | C6 | 47.19 ± .03 | CMM | QA | | 00064 | 47.192 | 533 05-07-07 | | A * |
| 1* (50) | E6 | // .02 A | CMM | QA | | 00064 | .007 | 533 05-07-07 | | A * |
| 1* (60) | B6 | // .02 A | CMM | QA | | 00064 | .009 | 533 05-07-07 | | A * |
| 2* (80) | H6 | 2X R.187 +.025 -.005 | RADIUS GAGE | QA | | R-25 | ACCEPT | 533 05-07-07 | | A * |
| 2* (90) | C8 | 2X .03 X 45° | CHAMPHER GAGE | QA | | 29205 | ACCEPT | 533 05-07-07 | | A * |
| 2* | C8 | .40 ± .010 | CALIPER | QA | | J-707 | ACCEPT | 533 | | A |

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REV. 1 - STEP 210 OF OPERATION 132 CORRECTED.

| | | | | | | | | | | |
|-------------|----|--|---------------|----|--|------------|--|-----------------|--|--------|
| (100) | | | | | | | | 05-07-07 | | * |
| 2* (110) | G8 | 2X .030 X 45° | CHAMPHER GAGE | QA | | 29205 | ACCEPT | 339 05-08-07 | | A * |
| 2* (120) | F7 | 2X .32 | CALIPER | QA | | J-707 | .314 TO .318 | 533 05-07-07 | | A * |
| 2* (130) | F7 | 2X R.11 | RADIUS GAGE | QA | | R-25 | E SIDE .05 TO .120 D SIDE .08 TO .120 [N/C:21790-Doc:NC21790] | 533 05-07-07 | | R * |
| 2* (140) | G6 | P TO M | CMM | QA | | 00064 | -.008 TO .070 | 533 05-07-07 | | A * |
| 2* (150) | G6 | 4.790 OR SHELL INTERSECT. VERIFY USING TEMPLATE PER DRAWING NOTE 16 (MTMFX-3473) | | QA | | MTMFX-3473 | AREAS THAT DO NOT ACCEPT GAGE ARE 9-13, 26-36, 41-52 [N/C:21790-Doc:NC21790] | 339 05-08-07 | | R * |
| 2* (160) | G3 | Q TO N | CMM | QA | | 00064 | .015 TO .104 [N/C:21790-Doc:NC21790] | 533 05-07-07 | | R * |
| 2* (170) | G3 | 4.790 OR SHELL INTERSECT. VERIFY USING TEMPLATE PER DRAWING NOTE 16 (MTMFX-3473) | | QA | | MTMFX-3473 | ACCEPT | 533 05-07-07 | | A * |
| 2* (180) | E6 | M TO MI | CMM | QA | | 00064 | -.020 TO .024 [N/C:21790-Doc:NC21790] | 533 05-07-07 | | R * |
| 2* | F3 | | CMM | QA | | 00064 | -.018 TO .024 [N/C:21790-Doc:NC21790] | 533 | | R |

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REV. 1 - STEP 210 OF OPERATION 132 CORRECTED.

| (182) | | N TO NI | | | | | | 05-07-07 | | | * |
|---------------------------------------|---------|---|------------------------------|----|--------|------------------|---|-----------------|--------------|-------|--------|
| 2* (185) | E5 | | CMM | QA | | 00064 | -.010 TO .025 | 533 05-07-07 | | | A * |
| Drawing ID: NCSX-CSPEC-141-03 Rev: 11 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | | INSPECTED BY | | |
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 4* (188) | 3.1.1.4 | ¹²⁵ THE TWO "L" MACHINED SURFACES OF TEE. | PROFILOMETER PROFILOMETER | QA | | J-1308 J-775 | D SIDE 54 E SIDE 88 | 533 05-07-07 | | | A * |
| Drawing ID: SE141-116 Rev: 8 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | | INSPECTED BY | | |
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 2* (190) | B5 | R S T 96X .375-16 UNC .750 DEEP .625 C'BORE .188 DEEP | CMM PIN GAGE | QA | 50% | 00064 J-652-3 | .004-.065 POSITION, 24 C'BORE OUT OF TO L. (.623 TO .628 RA NGE) [N/C:21790-Doc :NC21790] | 339 05-08-07 | | | R * |
| 2* (195) | B5 | .375-16 UNC .750 DEEP GAGE 100% OF THE HOLES AND VERIFY CLEANLINES. | THREAD PLUG GAGE | QA | 100% | A-151 | ACCEPT | 339 05-08-07 | | | A * |
| 2* (200) | B4 | 2X .06-.09 X 45° | CALIPER | QA | | J-707 | .04 TO .07 [N/C:217 90-Doc:NC21790] | 339 05-08-07 | | | R * |
| 3* (210) | G7 | A B C 8X Ø1-8 UNC THRU | CMM THREAD PLUG GAGE | QA | | 00064 A-666 | ACCEPT | 339 05-09-07 | | | A * |
| 3* (230) | H3 | | CMM | QA | | 00064 | .014 [N/C:21790-Doc :NC21790] | 533 05-07-07 | | | R * |
| 3* (230) | H4 | ¹²⁵ | PROFILOMETER | QA | | J-775 | 55 | 533 | | | A |

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REV. 1 - STEP 210 OF OPERATION 132 CORRECTED.

| | | | | | | | | | |
|-------|----|--|------------------|----|------------|---|----------|--|---|
| (240) | | DATUM -E- FLANGE | | | | | 05-07-07 | | * |
| 3* | F3 | | CMM | QA | 00064 | .014 [N/C:21790-Doc :NC21790] | 533 | | R |
| (250) | | DATUM -D- FLANGE | | | | | 05-07-07 | | * |
| 3* | F3 | | PROFILOMETER | QA | J-1308 | 53 | 533 | | A |
| (260) | | DATUM -D- FLANGE | | | | | 05-07-07 | | * |
| 3* | E4 | 8X Ø1.13 THRU BACK SPOT FACE Ø2.38 MIN DEPTH FOR C'UP | CMM | QA | 00064 | .001 TO .0049 | 533 | | A |
| (280) | | | | | | | 05-07-07 | | * |
| 4* | H8 | 3X Ø1.885 THRU | CMM | QA | 00064 | .0228, .0236, .0238 | 533 | | A |
| (290) | | | | | | | 05-07-07 | | * |
| 4* | H8 | 3X Ø1.885 +/- .003 Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP | CMM | QA | 00064 | 1.8832, 1.8842, 1.8 844 ACCEPT SPOTFACE | 533 | | A |
| (291) | | | | | MTMFX-3564 | | 05-07-07 | | * |
| 4* | H7 | | CMM | QA | 00064 | .0176, .007, .0272 DEPTH SHALLOW .981, .983, .981 [N/C:217 90-Doc:NC21790] | 339 | | R |
| (300) | | 3X 2.000" COUNTERBORE 1.00 DP | DEPTH MICROMETER | | J-1062 | | 05-08-07 | | * |
| 4* | H7 | Ø | DIAL BORE GAGE | QA | J-1401 | 2.0003, 2.0004, 2.0 005 | 533 | | A |
| (305) | | | | | | | 05-07-07 | | * |
| 4* | H6 | 17X Ø1.885 THRU | CMM | QA | 00064 | .0022 TO .039 | 533 | | A |
| (310) | | | | | | | 05-07-07 | | * |
| 4* | H6 | | CMM | QA | 00064 | 1.8832 TO 1.8862 AC | 533 | | A |

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REV. 1 - STEP 210 OF OPERATION 132 CORRECTED.

| | | | | | | | | | |
|-------|----|--|------------------|----|------------|--------------------------------------|---------------|----------|---|
| (311) | | 3X Ø1.885 +/- .003 THRU Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP | | | | MTMFX-3564 | CEPT SPOTFACE | 05-07-07 | * |
| 4* | H5 | ⊕ Ø.060 D A N 3X Ø1.13 | CMM | QA | 00064 | .041, .034, .036 | 533 | 05-07-07 | A |
| (320) | | | | | | | | 05-07-07 | * |
| 4* | H5 | 3X Ø1.13 +/- .010 Ø2.38 BACK SPOTFACE VERIFY MIN CLEANUP | CMM | QA | 00064 | 1.1259, 1.1257, 1.1265 | 533 | 05-07-07 | A |
| (321) | | | CALIPER | | | | | 05-07-07 | * |
| 4* | E6 | ⊕ Ø.060 D A N | CMM | QA | 00064 | .0026, .0312, .0312 | 533 | 05-07-07 | A |
| (340) | | 3X Ø1.375-6 UNC THRU | THREAD PLUG GAGE | | A-375 | , ACCEPT THREADS | | 05-07-07 | * |
| 4* | E6 | ⊕ Ø.060 D A N 5X Ø1.885 THRU | CMM | QA | 00064 | .0078 TO .009 | 533 | 05-07-07 | A |
| (350) | | | | | | | | 05-07-07 | * |
| 4* | E6 | 5X Ø1.885 +/- .003 THRU Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP | CMM | QA | 00064 | 1.8856 TO 1.8859 AC CEPT SPOTFACE | 533 | 05-07-07 | A |
| (351) | | | | | MTMFX-3564 | | | 05-07-07 | * |
| 4* | D4 | ⊕ Ø.060 D A N Ø1.885 THRU | CMM | QA | 00064 | .0068 | 533 | 05-07-07 | A |
| (360) | | | | | | | | 05-07-07 | * |
| 4* | D4 | Ø1.885 +/- .003 THRU Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP | CMM | QA | 00064 | 1.8847 ACCEPT SPOTFACE | 533 | 05-07-07 | A |
| (361) | | | | | MTMFX-3564 | | | 05-07-07 | * |
| 4* | B5 | ⊕ Ø.060 D A N | CMM | QA | 00064 | .010, .010, .004 | 533 | | A |

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REV. 1 - STEP 210 OF OPERATION 132 CORRECTED.

| | | | | | | | | | | | |
|-------------|----|--|-------------------------|----|--|---------------------|---|-----------------|--|--|--------|
| 5* (415) | F7 | 7X 1/4-20 UNC -2B | THREAD PLUG GAGE | QA | | A-730 | ACCEPT THREADS | 533 05-07-07 | | | A * |
| 5* (420) | F7 | $\varnothing .06$ E A J 7X 1/4-20 UNC -2B SUMMARY OF HOLE POSITIONS. ACTUAL FEATURE CONTROL FRAME IS NOT ON DRAWING. | CMM | QA | | 00064 | .011 TO .037 | 533 05-07-07 | | | A * |
| 5* (430) | E7 | $\varnothing .060$ E A J 24X $\varnothing 1.885$ THRU | CMM | QA | | 00064 | .0008 TO .036 | 533 05-07-07 | | | A * |
| 5* (431) | E7 | 24X $\varnothing 1.885 \pm .003$ THRU $\varnothing 3.00$ BACK SPOTFACE VERIFY MIN CLEANUP | CMM | QA | | 00064 MTMFX-3564 | 1.883 TO 1.886 ACCE PT SPOTFACE | 533 05-07-07 | | | A * |
| 5* (440) | E7 | $\varnothing .060$ E A J 3X $\varnothing 1.5$ TO 2.00 DEEP $\varnothing 3.00$ TO 1.00 DEEP | CMM DEPTH MICROMETER | QA | | 00064 J-1062 | .011, .013, .016 DE PTH 2.00 AND 1.005 | 533 05-07-07 | | | A * |
| 5* (450) | D7 | 3X $\varnothing 1.885 \pm .003$ THRU $\varnothing 3.00$ BACK SPOTFACE VERIFY MIN CLEANUP | CMM | QA | | 00064 MTMFX-3564 | 1.883, 1.884, 1.883 5 ACCEPT SPOTFACE | 533 05-07-07 | | | A * |
| 6* (470) | E3 | 4X $\varnothing 1.00$ THRU | CALIPER | QA | | J-707 | .995, 1.001, 1.005, 1.006 | 533 05-07-07 | | | A * |
| 8* (650) | G7 | 4.00 $\pm .010$ | CMM | QA | | 00064 | ACCEPT | 339 05-08-07 | | | A * |
| 8* | D7 | 6X $\varnothing .375-16$ UNC TO .75 DEEP .03 X 45° CHAMFER | THREAD PLUG GAGE | QA | | A-151 | ACCEPT THREADS ACCE PT CHAMFER | 533 | | | A |

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REV. 1 - STEP 210 OF OPERATION 132 CORRECTED.

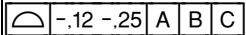

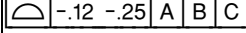

| | | | | | | | | | | |
|-------------|----|--|-------------|----|--|-------|-----------------------------|-----------------|--|--------|
| (750) | | | CALIPER | | | J-707 | | 05-07-07 | | * |
| 8* (760) | D7 | 13.6 ° | CMM | QA | | 00064 | ACCEPT | 339 05-08-07 | | A * |
| 8* (770) | D7 | 5.88 VERIFY THAT PAD MEETS THE MINIMUM OF 5.88 | SCALE | QA | | J-922 | GREATER THAN 5.88 | 533 05-07-07 | | A * |
| 8* (780) | D7 | 2.19 ± .010 | CMM | QA | | 00064 | ACCEPT | 339 05-08-07 | | A * |
| 8* (790) | D7 | 2.19 ± .010 | CMM | QA | | 00064 | ACCEPT | 339 05-08-07 | | A * |
| 8* (830) | C8 | 2X 1.56 ± .010 THRU | CALIPER | QA | | J-707 | 1.55 TO 1.56 | 533 05-07-07 | | A * |
| 8* (850) | C8 | 2X 7.50 ± .010 THRU | CMM | QA | | 00064 | ACCEPT | 339 05-08-07 | | A * |
| 8* (860) | C8 | 8X R.25 | RADIUS GAGE | QA | | R-25 | .250 TO .260 | 533 05-07-07 | | A * |
| 8* (870) | C8 | 2X 2.52 ± .010 | CMM | QA | | 00064 | ACCEPT | 339 05-08-07 | | A * |
| 9* (900) | E7 | 2.54 ± .010 | CMM | QA | | 00064 | ACCEPT | 339 05-08-07 | | A * |
| 9* (910) | E7 | 5.08 ± .010 | CMM | QA | | 00064 | ACCEPT | 339 05-08-07 | | A * |
| 9* (920) | F3 | 4X Ø1.0 THRU VERIFY THAT HOLES BREAK COMPLETELY THROUGH INSIDE OF CASTING | CALIPER | QA | | J-707 | .999, 1.0, 1.003, 1 .004 | 533 05-07-07 | | A * |
| 9* (930) | F3 | 2X Ø .50 ± .010 THRU | CALIPER | QA | | J-707 | .495, .496 | 533 05-07-07 | | A * |

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REV. 1 - STEP 210 OF OPERATION 132 CORRECTED.

| | | | | | | | | | | | |
|-------------------------------------|-------------|--|--------------------------------|-----------|---------------|----------------|---|-----------------|---------------------|--------------|--------|
| 9* (940) | E3 | 2.44 ± .010 | CMM | QA | | 00064 | ACCEPT | 339 05-08-07 | | | A * |
| 9* (950) | E3 | 1.22 ± .010 | CMM | QA | | 00064 | ACCEPT | 339 05-08-07 | | | A * |
| 9* (960) | C7 | 4X Ø1.0 THRU VERIFY THAT HOLES BREAK COMPLETELY THROUGH INSIDE OF CASTING | CALIPER | QA | | J-707 | .999, 1.0, 1.0, 1.0 01 | 533 05-07-07 | | | A * |
| 9* (970) | C6 | 2X Ø.25 T.C. HOLE | CALIPER | QA | | J-707 | .249, .251 | 533 05-07-07 | | | A * |
| 10* (980) | E8 |  | CMM | QA | | 00064 | .049 TO .109 [N/C:2 1790-Doc:NC21790] | 533 05-07-07 | | | R * |
| 10* (990) | D5 |  DATUM -D- SIDE INNER CAST | CMM | QA | | 00064 | -.250 TO .348 [N/C: 21790-Doc:NC21790] | 533 05-07-07 | | | R * |
| 10* (1010) | C4 |  SMALL WING E SIDE | CMM | QA | | 00064 | .006 TO .062 [N/C:2 1790-Doc:NC21790] | 533 05-07-07 | | | R * |
| 10* (1030) | D1 |  DATUM -E- SIDE INNER CAST | CMM | QA | | 00064 | -.216 TO .341 [N/C: 21790-Doc:NC21790] | 533 05-07-07 | | | R * |
| Drawing ID: SE141-116 Rev: 7 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | | INSPECTED BY | | |
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 10* (1035) | E1 | MACHINE / GRIND THIS AREA TO PROFILE OF +.05/-.10 | CMM | QA | | 00064 | -.1249 TO .0139 [N/ C:21790-Doc:NC21790] | 339 05-08-07 | | | R * |

* To Far Right Indicates Data Package Requirement

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INSPECTION DATA CHECKLIST

1458 E. 19th Street, Indianapolis, In 4621
TEL:(317)636-6433 FAX:(317)634-9420

REV. 1 - STEP 210 OF OPERATION 132 CORRECTED.

| Drawing ID: NCSX-CSPEC-141-03 Rev: 10 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
|---------------------------------------|---------|---|-------------------------|----|--------|---------|--------------|--------------|----------|-------|---|
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 4* | 3.1.1.4 | UOS ALL MACHINED SURFACES TO BE 250 RMS SURFACE FINISH RECORD RANGE | PROFILOMETER | QA | | J-1308 | 53 - 88 | 339 | | | A |
| (1040) | | | PROFILOMETER | | | J-775 | | 05-08-07 | | | * |
| Drawing ID: SE141-116 Rev: 8 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 1* | | NOTE 9 RECORD THE WEIGHT OF THE PART 6000LBS MAX | SCALE | QA | | J-1173 | 5645 | 533 | | | A |
| (1050) | | | | | | | | | 05-07-07 | | * |

Workorder: 65707/6-0 Sub:1 Op:136

Revision: 05/07/07 15:05

Part: SE141-116 - MODULAR COIL WINDING FORM TYPE-C - PRODUCTION MODULAR COIL WINDING FORM TYPE-C

| Drawing ID: SE141-116 Rev: 8 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
|------------------------------|------|---|-------------------------|----|--------|---------|--------------------------------------|--------------|-------|-------|---|
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| * | | D A T U M - E - S I D E MAG PERMEABILITY TO BE NO GREATER THAN 1.02µ. CHECK 3 PLACES ADJACENT TO EVERY 5TH HOLE IN T SECTION. | MASTER GAGE | QA | | J-1270 | LESS THAN 1.02 ON MACHINED SURFACES. | 854 | | | A |
| (10) | | | | | | | | | | | |
| * | | D A T U M - D - S I D E MAG PERMEABILITY TO BE NO GREATER THAN 1.02µ. CHECK 3 PLACES ADJACENT TO EVERY 5TH HOLE IN T SECTION. | MASTER GAGE | QA | | J-1270 | LESS THAN 1.02 ON MACHINED SURFACES | 854 | | | A |
| (20) | | | | | | | | | | | |

Workorder: 65707/6-0 Sub:1 Op:140

Revision: 05/07/07 12:33

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INSPECTION DATA CHECKLIST

1458 E. 19th Street, Indianapolis, In 4621
TEL:(317)636-6433 FAX:(317)634-9420

REV. 1 - STEP 210 OF OPERATION 132 CORRECTED.

Part: SE141-116 - MODULAR COIL WINDING FORM TYPE-C - PRODUCTION MODULAR COIL WINDING FORM TYPE-C

| Drawing ID: SE141-103 Rev: 3 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
|------------------------------|------|--|-------------------------|----|--------|---------|--------------|--------------|-------|-------|---|
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| * | | <u>T E S T 1</u> RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE MID-PLANE POLOIDAL BREAK SHIM AND THE WINDING FORM. | MULTIMETER | QA | | J-1358 | 110 M OHMS | 503 | | | A |
| (10) | | | | | | | | 05-07-07 | | | * |
| * | | <u>T E S T 2</u> RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE JUMPERED BOLTS AND JUMPERED MID-PLANE CASTING AND WINDING FORM. | MULTIMETER | QA | | J-1358 | 110 M OHMS | 503 | | | A |
| (20) | | | | | | | | 05-07-07 | | | * |

Workorder: 65707/6-0 Sub:14 Op:30

Revision: 05/08/06 9:33

Part: SE141-137-CSM - MCWF BEARING PLATE TYPE C SHORT -

| Drawing ID: SE141-137 Rev: 2-A | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
|--------------------------------|------|--|-------------------------|----|--------|---------|----------------|--------------|-------|-------|---|
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 1* | G2 | RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ. | MASTER GAGE | QA | | J-1165 | LESS THAN 1.02 | 503 | | | A |
| (10) | | | | | | | | 07-10-06 | | | * |

Workorder: 65707/6-0 Sub:15 Op:30

Revision: 05/08/06 9:34

Part: SE141-138-CSM - MCWF BEARING PLATE TYPE "C" LONG -

| Drawing ID: SE141-138 Rev: 2-A | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
|--------------------------------|------|--|-------------------------|----|--------|---------|----------------|--------------|-------|-------|---|
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 1* | G2 | RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN | MASTER GAGE | QA | | J-1165 | LESS THAN 1.02 | 503 | | | A |

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INSPECTION DATA CHECKLIST

1458 E. 19th Street, Indianapolis, In 4621
TEL:(317)636-6433 FAX:(317)634-9420

REV. 1 - STEP 210 OF OPERATION 132 CORRECTED.

Table with 10 columns: (10), 1.02μ., and 07-13-06, with an asterisk in the final column.

* To Far Right Indicates Data Package Requirement

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Phil Heitzenroeder

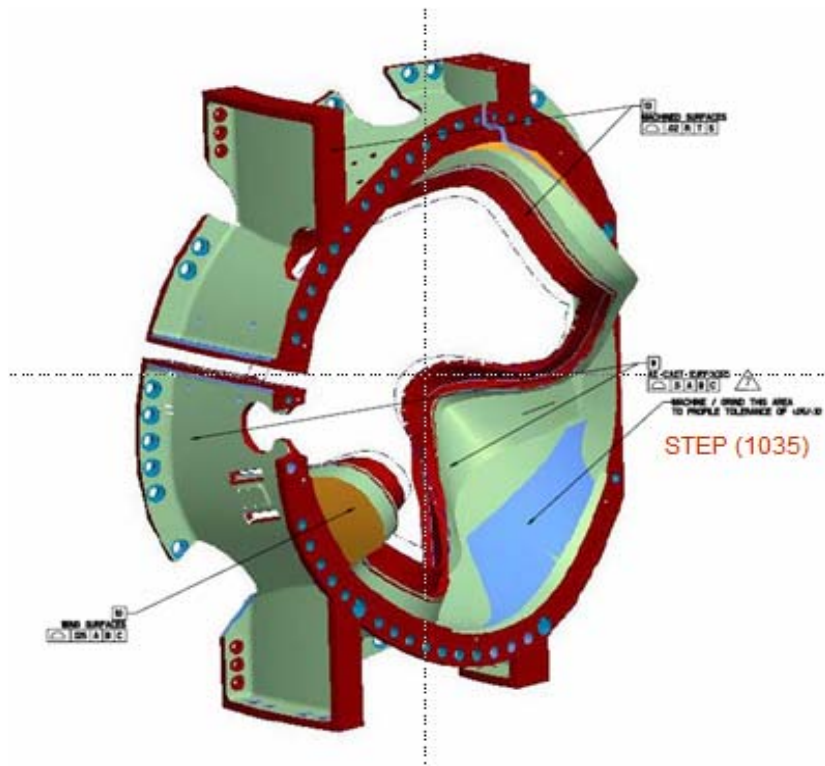
From: Williamson, David E. [williamsonde@ornl.gov]
Sent: Wednesday, May 09, 2007 9:48 AM
To: Phil Heitzenroeder; Frank A. Malinowski
Cc: Thomas G. Brown
Subject: c6 idc comments
Attachments: c6_idc_comments.xls

Phil, Frank,
It looks pretty clean per the IDC.
-David

COMMENTS ON C6 5/9/07

| STEP | C6 | DESCRIPTION | COMMENTS (C6) |
|------|----|---------------------|-------------------------------|
| 10 | | | |
| 20 | | | |
| 30 | | | |
| 40 | | | |
| 50 | | | |
| 60 | | | |
| 80 | | | |
| 90 | | | |
| 100 | | | |
| 110 | | | |
| 120 | | | |
| 130 | X | tee radius .11 | .05 min, .12 max OK |
| 140 | | | |
| 150 | X | side-a clearance | no gage at ~25 holes |
| 160 | X | profile side-a belo | .104 max similar to A5 |
| 165 | | | |
| 170 | | | |
| 180 | X | profile side-a winc | -.020/.024 similar to A5 |
| 182 | X | profile side-b winc | -.018/.024 |
| 185 | | | |
| 188 | | | |
| 190 | X | tee holes | pos ok, 24 cbore diam out, ok |
| 195 | | | |
| 200 | X | tee edge chamfer | .04 min ok |
| 210 | X | inb TF mount, 8x1 | one hole bad |
| 230 | X | datum-e flange flz | .014 |
| 240 | | | |
| 250 | X | datum-d flange flz | .014 same as above? |
| 260 | | | |
| 280 | | | |
| 290 | | | |
| 291 | | | |
| 295 | | | |
| 300 | X | spherical seat cbc | ok not used |

305
 310
 311
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 351
 360
 361
 370
 371
 375
 376
 380
 381
 400
 410
 412
 415
 420
 430
 431
 440
 450
 470
 650
 750
 760
 770
 780
 790
 830
 850
 860
 870
 900
 910
 920
 930
 940
 950
 960
 970
 980
 990
 1010
 1030
 1035
 1040



- X wing surfs -.12/-.2 .049/.109 check w/ Tom
- X side-a inner surf +/- .250/.348
- X small outer wing -.006/.062
- X side-b inner surf +/- superceded by 1035
- X side-b inner surf +/- .125/.014

