
Customer: ENERGY INDUSTRIES OF OHIO

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Part: SE141-115 / MODULAR COIL, TYPE B

Drawing ID: SE141-102 Revision: 3
W/O Links: 1-Type:W: 65708/6.0 Sub: 0

Customer P.O.: S005242-F/Ln:6
Serial No./Qty: B6

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

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

Problem: Various defects identified during the visual review of the casting. See attached report for details.

Proposed Disposition:

MTM proposes that deviations be accepted as is based on the similarity of these deviations to previously accepted B castings.

Number of additional pages: 11 page attachment

Customer Disposition: Use As Is Rework Repair Scrap Replace

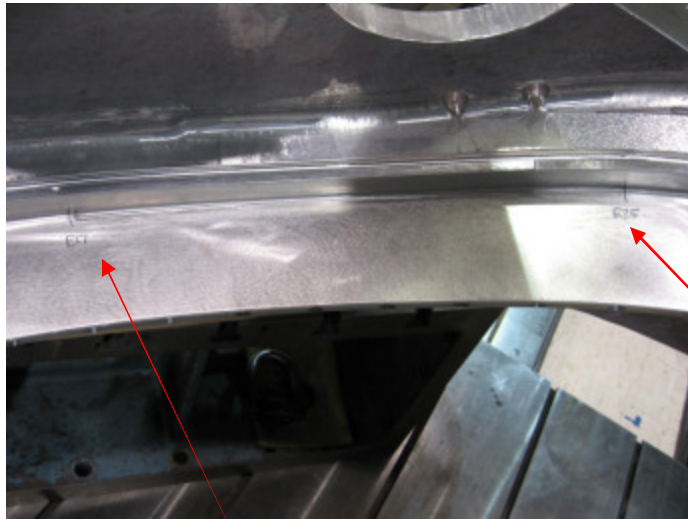
The attached inspection report was examined by Jim Chrzanowski on 5/23/07. All of the deviations are accepted as is, since they will not cause any problems during coil manufacture.

Approved by:

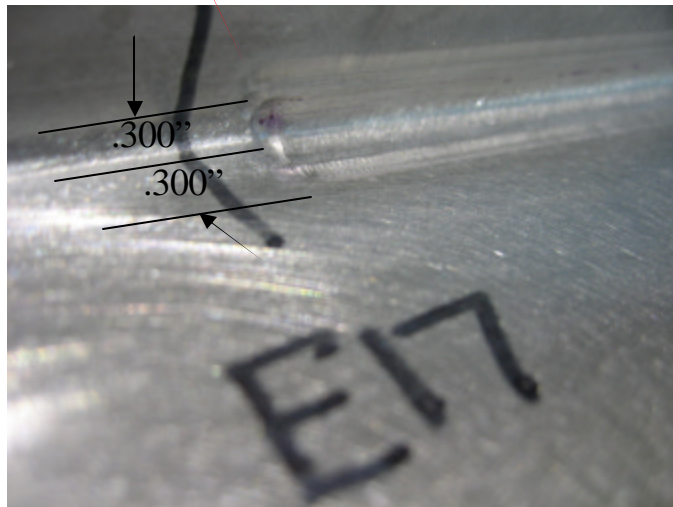
Tech. Rep.:

RLM:

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



There is an undercut in the area of the 1/8" radius on both the long and short legs of E side between holes 17 and 25. The undercut extends outward in each direction approximately .300" from each wall. The undercut is deepest near E17 (approximately .040") and gradually tapers until E25.

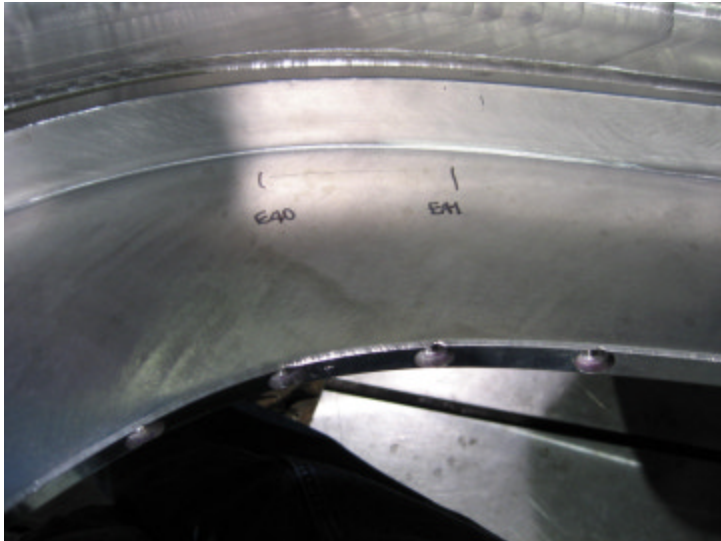


5/23/2007

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Tool gouge on E side long leg
between T holes 40 and 41. This
tool gouge is less than .005" deep.

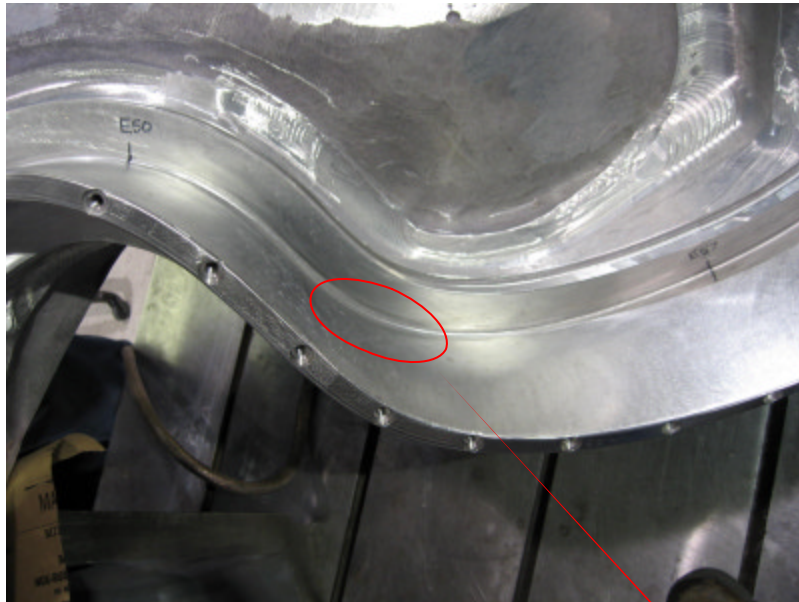


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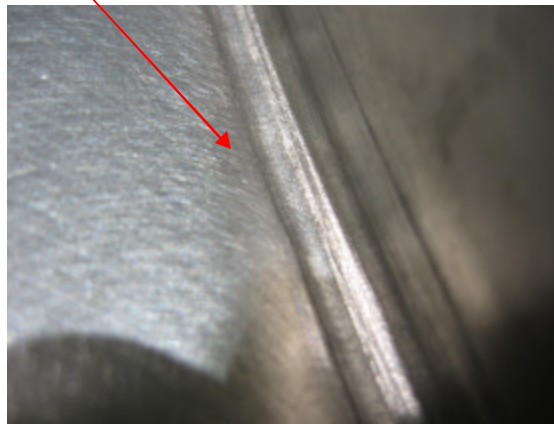
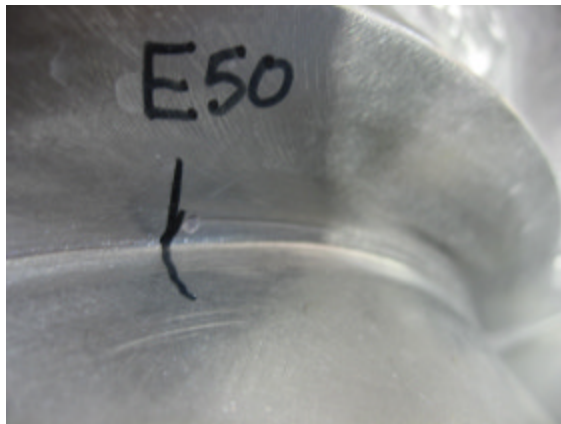
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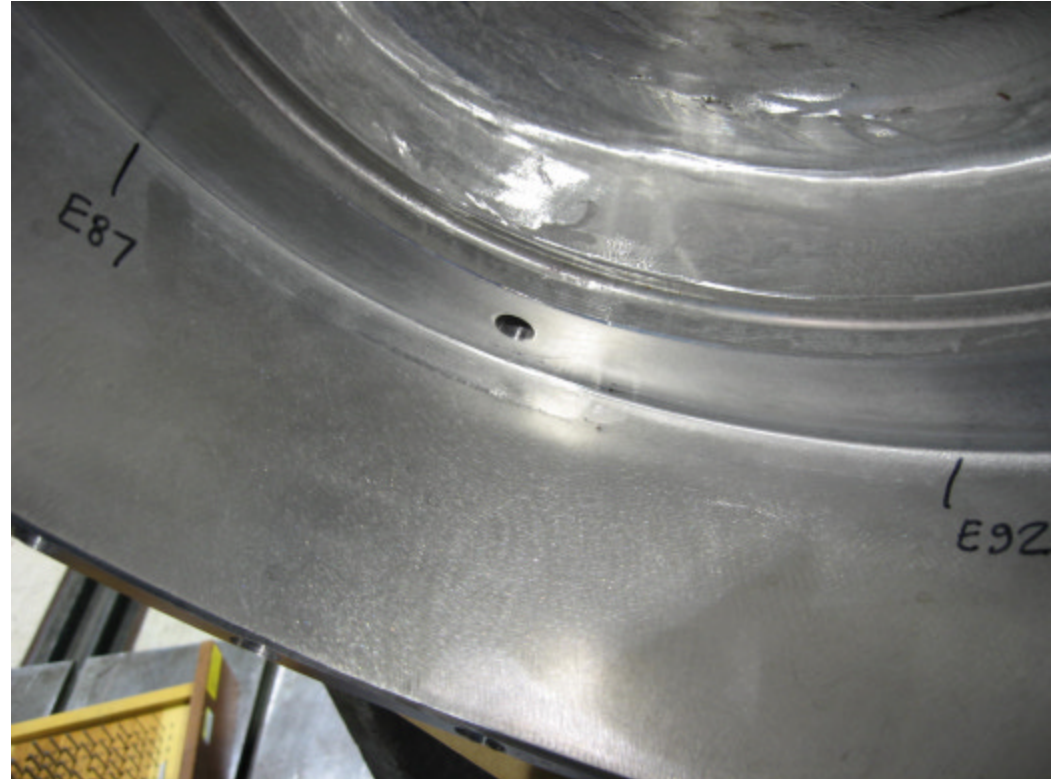


There is an undercut in the area of the 1/8" radius on both the long and short legs of E side between holes 50 and 57. The undercut extends outward in each direction approximately .200" from each wall. The undercut is deepest along the long leg between 54 and 55 (approximately .043" deep). The undercut along the short leg is less than .010" in depth.



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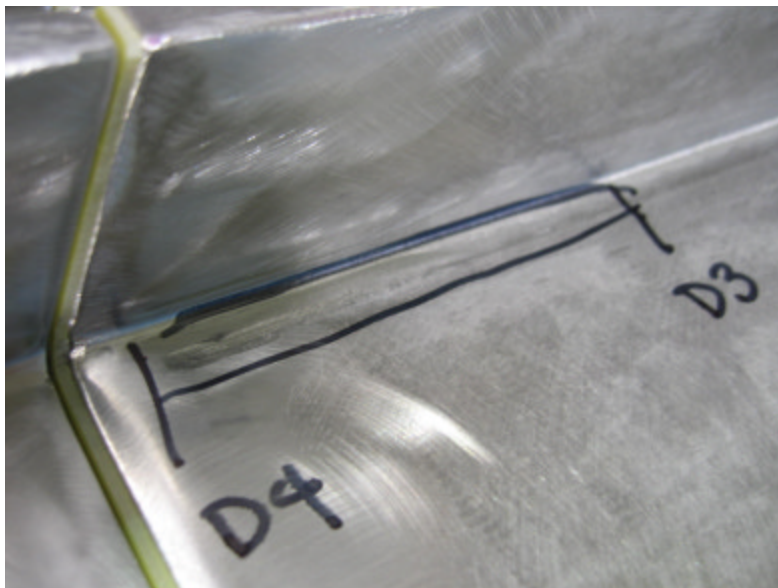
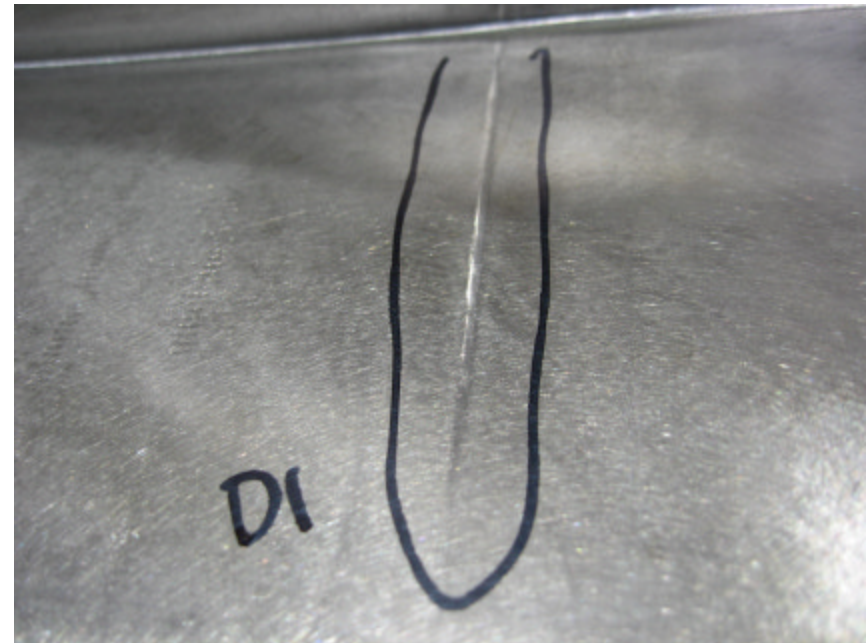
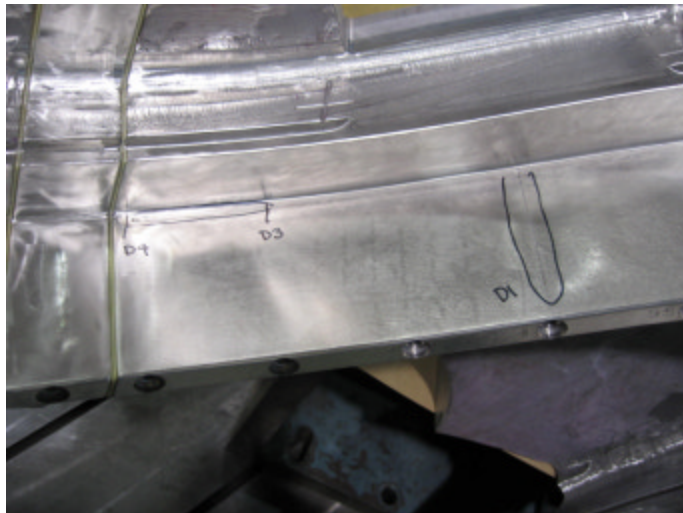


Tool gouge between holes 87 and 92 along long leg of datum E side. Depth of gouge is between .005” and .008”.

Tool marks near hole 95 are less than .005” in depth.

5/23/2007

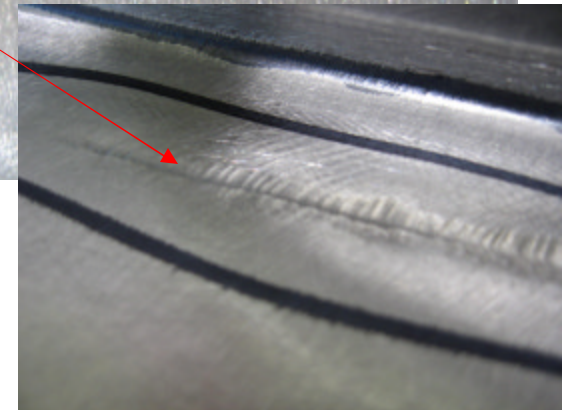
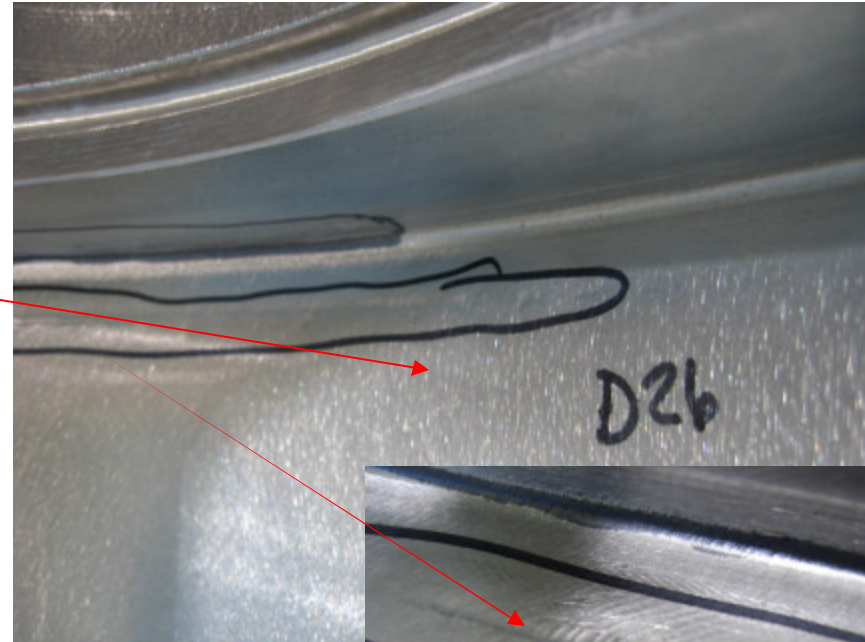
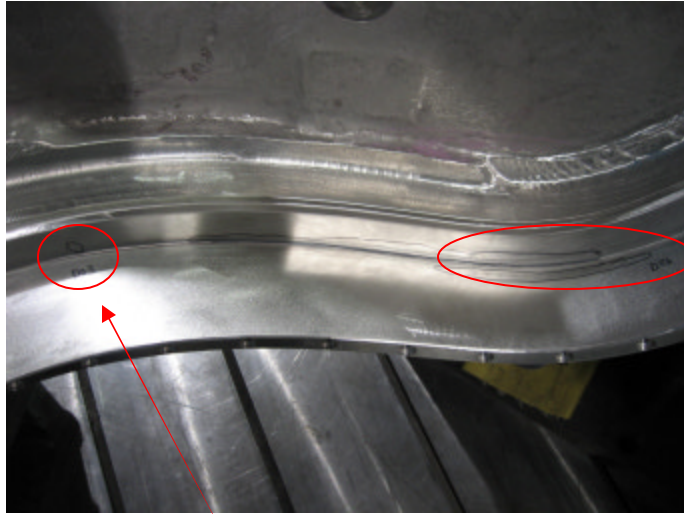
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These pictures show tooling gouges on the long leg of the T on the datum D side near hole 1 and between holes 3 and 4. Gouge at D1 is $<.005''$ in depth and between D3 and D4 are $<.010''$ in depth.

5/23/2007

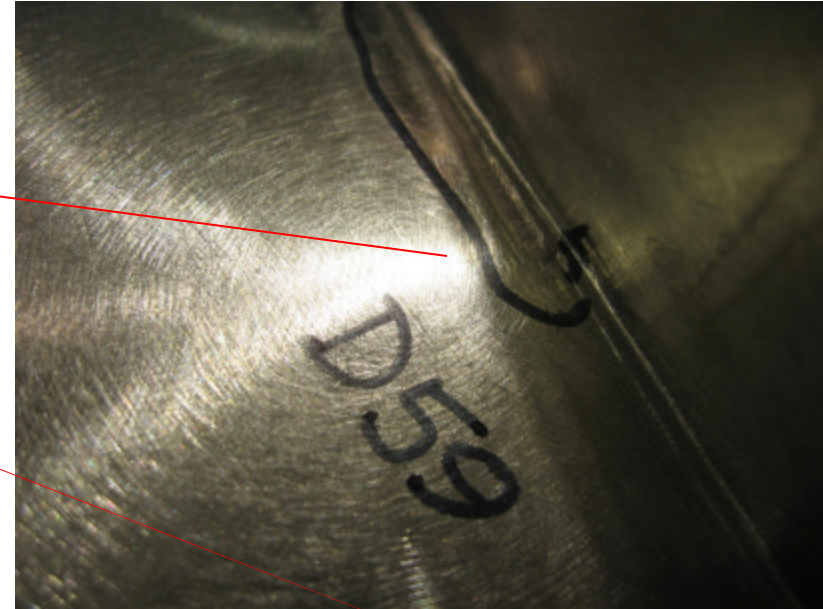
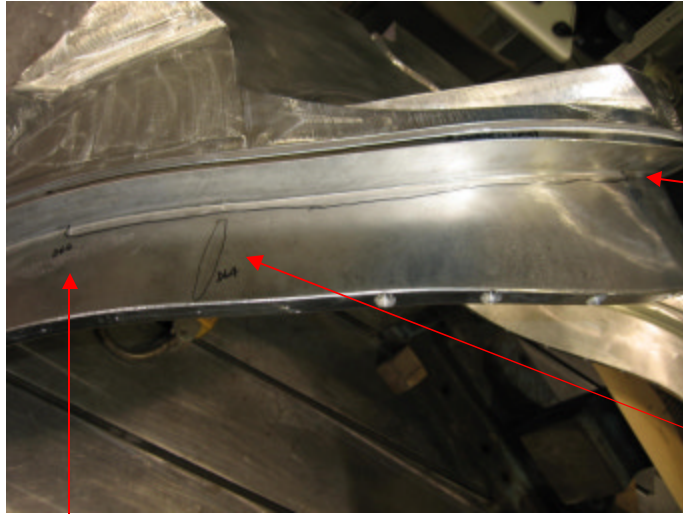
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Tool gouges on D side long and short leg
between T holes 26 and 33. All gouges are
<.010" in depth.

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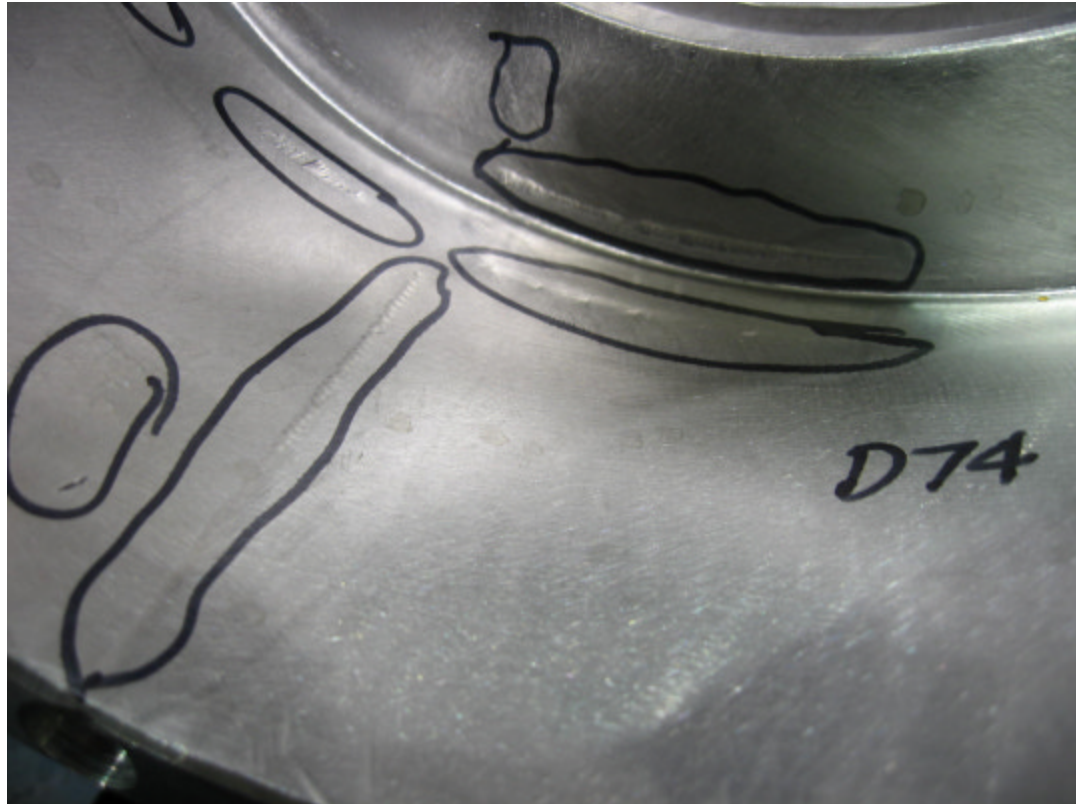
Tool gouges on D side long leg between T holes 59 and 66. Gouge near radius between D59 and D66 is $<.010''$ in depth. Gouge at D64 is $<.005''$ in depth.

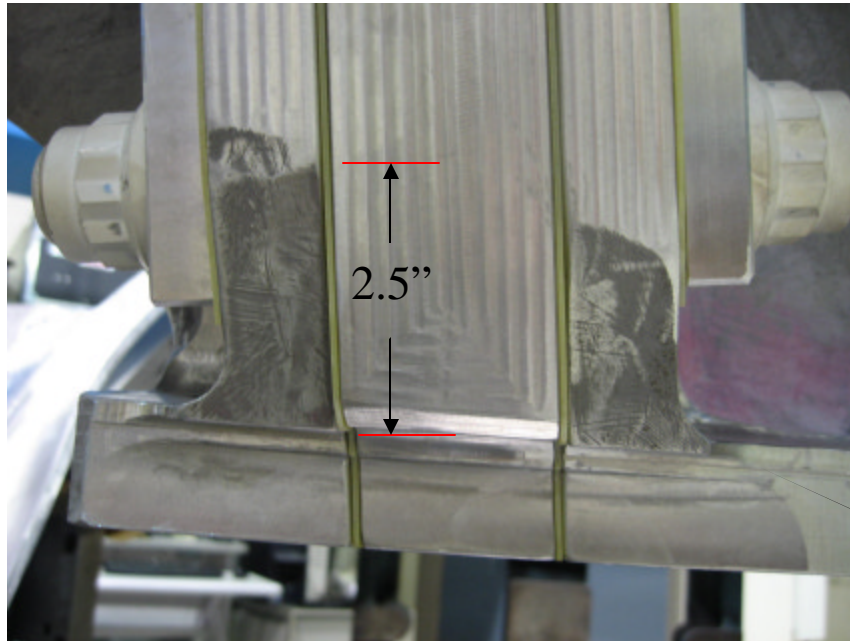
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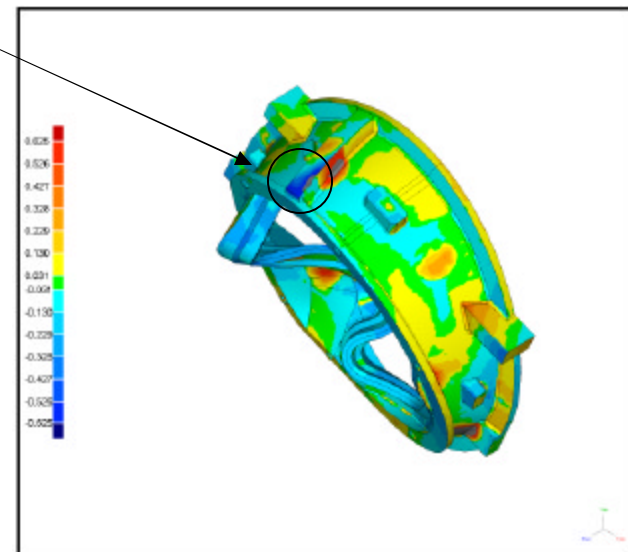
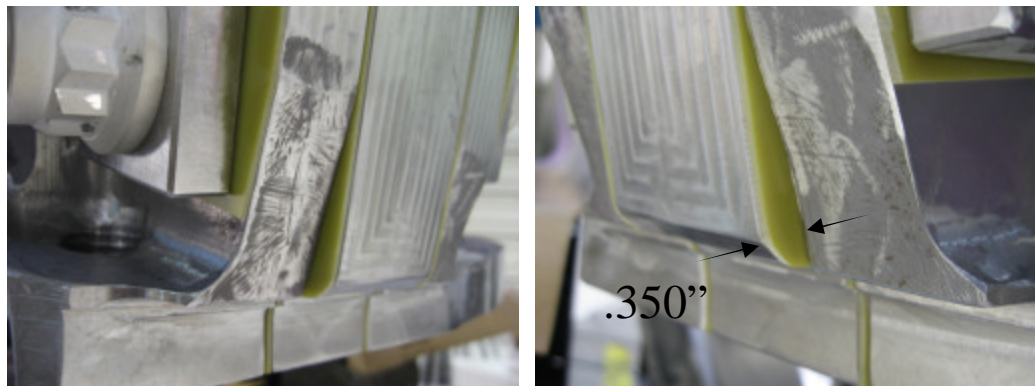


Several tool gouges on the datum D side long and short leg between T holes 74 and 79. None of these areas are greater than .010" in depth.





Non-cleanup of perimeter of poloidal break flange faces near datum E. The longest area of non-cleanup is 2.5" and both sides are approximately .350" at the widest point. MetalTek scan shows this area as minus stock.



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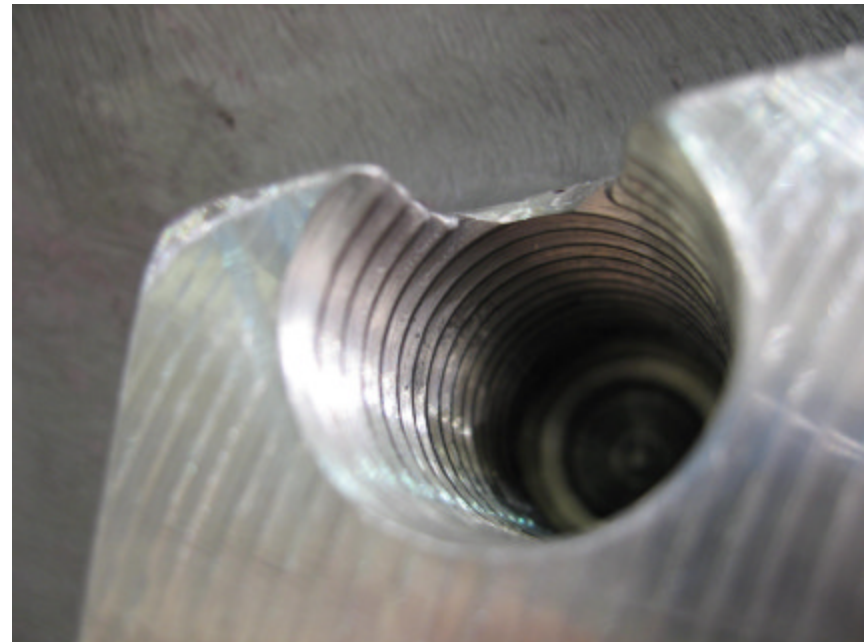
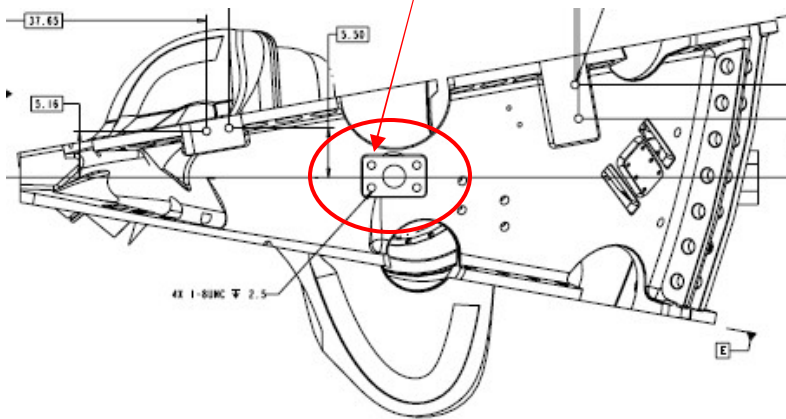
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Vacuum support pad located on drawing sheet 3 zone C6 has one of the 1-8” tapped holes breaking out the side of the pad. There are approximately 5 threads breaking out the side which leaves 15 functional threads remaining.





Mapping of Undercuts

(other than those previously reported in this report)

D Side

An area on the long leg near radius between holes 65 and 66 has up to a .012” undercut.

E Side

An area on the long leg near radius between holes 1 and 4 has up to a .016” undercut.