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

MTM N/C: 18315

Page: 1
Date: 10/03/05
User ID: BOWLINK

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:1
Drawing ID: SE141-116 — Revision: 6 — Serial No./Qty: C1

Reported By: KEVIN BOWLING — Telephone: 317-636-6433
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Problem: THE FOLLOWING INSPECTION STEPS PER MTM SUBMITTED IDC REPORT DID NOT HAVE SUPPORTING DIMENSIONAL DATA FROM THE CMM:

510, 520, 530, 540, 620, 630, 640, 670, 690, 700, 710, 720, 730, 740, 900, 910, 940, 950,

ALSO ONE OF THE FLANGE FACES DID NOT HAVE THE 2" X 2" GRID POINTS IN THE IGES FILE AS REQUIRED BY THE PRODUCT SPECIFICATION..

Proposed Disposition:
SUBMIT TO CUSTOMER CONTINUE MANUFACTURING.

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

MTM is to take corrective actions to provide all supporting data from the CMM on subsequent winding forms. To address the situation in the flanges which resulted in inadequate dimensional information, Rev. 10 of NCSX-CSPEC-141-03 has been revised as indicated below:

4.2.5 Verification of Dimensions and Tolerances

All cast surfaces, machined surfaces and features such as holes, ports, supports, etc. shall be dimensionally checked to assure compliance with Section 3.2.2. Cast surfaces shall be checked with measurements taken to approximate 4” x 4” grid; machined surfaces shall be checked with measurements taken to approximate a 2” x 2” grid; features such as holes, ports, supports, etc. shall be verified per standard machine shop practices. On the winding tee flange, where a 2” x 2” grid would result in a single line of measurements, a minimum of 2 readings (two lines of measurements) shall be recorded.

Phil Heitzenroeder

Digitally signed by Phil Heitzenroeder
DN: CN = Phil Heitzenroeder, C = US, O = PPPL, OU = Mech. Eng. Division
Reason: I agree to 'specified' portions of this document
Date: 2005.11.28 20:11:23 -05'00'

Brad Nelson

Digitally signed by Brad Nelson
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Major Tool Implemented By:_____ **Title:**_____ **Date:**_____

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