
Customer: ENERGY INDUSTRIES OF OHIO

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

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

Part: SE141-114 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-114

Revision: 6

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: A1

Reported By: MIKE GRIFFITH

E-Mail: mGriffith@MajorTool.com

Telephone: 317-636-6433

Fax: 317-634-9420

Problem: Workorder: 65709/1.0 Sub:1 Op:132

Inspection Test #: 70 rejected: : {h,02|A}: .046
Inspection Test #: 80 rejected: 48.50 ± .03: : 48.454
Inspection Test #: 130 rejected: OUTER AS CAST SURFACES: {g,5|A|B|C}: -0.165 TO 0.288
Inspection Test #: 140 rejected: 2 X .40: : .350 TO .420
Inspection Test #: 150 rejected: 4 X .03 X 45: : .010 TO .040
Inspection Test #: 170 rejected: P TO M: {g,2|R|T|S}: POINTS NOT COLLECTED
Inspection Test #: 180 rejected: DATUM D SIDE
VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473: : AREAS BY T HOLES 5-10,
15 - 42, 84 - 94 WILL NOT ACCEPT GAGE
Inspection Test #: 190 rejected: M TO M1: {g,02|R|T|S}: -.0287 TO .268
Inspection Test #: 210 rejected: Q TO N: {g,2|R|T|S}: POINTS NOT COLLECTED
Inspection Test #: 230 rejected: N TO N1: {g,02|R|T|S}: -.0297 TO .0321
Inspection Test #: 240 rejected: 2 X .06/.09 X 45: : .030 TO .060
Inspection Test #: 270 rejected: .375-16 HOLES: {#,06|R|T|S}: .002 TO .066
Inspection Test #: 280 rejected: DATUM E FLANGE: {f,01}: .029
Inspection Test#: 285 rejected: surface 250
Inspection Test #: 290 rejected: DATUM D FLANGE: {f,01}: .028
Inspection Test #: 410 rejected: Ø1.375-6: {#,d,06|M|A|D}: .062
Inspection Test #: 480 rejected: Ø1.885: {#,d,06|N|A|E}: .007 TO .076
Inspection Test #: 640 rejected: 2X .88 - 1.13: : 1.13 TO 1.14
Inspection Test #: 780 rejected: INNER AS CAST SURFACES: {g,5|A|B|C}: -.321 TO .149
Inspection Test #: 790 rejected: WING SURFACES: {g,-,12;;;\\,25|A|B|C}: .009 TO -.150

Workorder: 65709/1.0 Sub:1 Op:130

Inspection Test #: 10 rejected: CHECK CLEARANCE OF ITEM 5 TO
ITEM 6.
: d.001 - d.002: .004 TO.005

Proposed Disposition:

PROPOSE TO USE AS IS.

Number of additional pages: 9 Page IDC Attachment

Customer Disposition: ☐ Use As Is ☐ Rework ☐ Repair ☐ Scrap ☐ Replace

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

MTM N/C: 19942

Page: 2
Date: 06/01/06
User ID: GRIFFITH

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

INSPECTION DATA CHECKLIST

Workorder: 65709/1-0 Sub:1 Op:120

Revision: 03/22/06 7:44

Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

Drawing ID: SE141-114 Rev: 6			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-1165	LESS THAN 1.02	854-R.UP		
(10)								05-31-06		
*		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-1165	LESS THAN 1.02	854-R.UP		
(20)								05-31-06		

Workorder: 65709/1-0 Sub:1 Op:130

Revision: 03/22/06 6:07

Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

Drawing ID: SE141-101 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.		QA			.004 TO.005	242-M.G		
(10)								05-25-06		
*		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"		QA			.001	242-M.G		
(15)								05-25-06		
2*	F2	ENSURE THAT THE CUMULATIVE GAPS AT ANY SINGLE CROSS SECTION OF THE POLOIDAL FLANGE ELEMENTS IS LESS THAN .005".		QA			LESS THAN .002	242-M.G		
(20)								05-25-06		
*		THE MAX. GAP AT THE POLOIDAL		QA			LESS THAN .002	242-M.G		

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INSPECTION DATA CHECKLIST

(30)		BREAK PERIMETER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE.						06-01-06		*
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Workorder: 65709/1-0 Sub:1 Op:132

Revision: 05/31/06 10:28

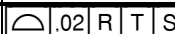
Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

Drawing ID: SE141-114 Rev: 6			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1* (10)	F3	NOTE 14 - BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.		QA			1 HOLE DID NOT CLEAN UP 100% (NC19933)	242-M.G 05-31-06		
1* (20)	E8	FLANGE PROFILE +/- .25 IN THIS AREA	CMM	QA		00064	.0104	339-E.RO 06-01-06		
1* (30)	D8	///.02 A	CMM	QA		00064	.006	339-E.RO 05-31-06		
1* (40)	D8	54.20 ± .03	CMM	QA		00064	54.194	339-E.RO 05-31-06		
1* (50)	C8	54.20 ± .03	CMM	QA		00064	54.194	339-E.RO 05-31-06		
1* (60)	B8	///.02 A	CMM	QA		00064	.006	339-E.RO 05-31-06		
1* (70)	D5	///.02 A	CMM	QA		00064	.046	339-E.RO 05-31-06		
1* (80)	D5	48.50 ± .03	CMM	QA		00064	48.454	339-E.RO 05-31-06		
1* (90)	C5	48.50 ± .03	CMM	QA		00064	48.503	339-E.RO 05-31-06		
1* (100)	B5	///.02 A	CMM	QA		00064	.003	339-E.RO 05-31-06		
1* (110)	D4	VERIFY PART MARKING: MAJOR TOOL SE141-114 A(casting number) (weight) LBS.		QA		VISUAL	ACCEPT	242-M.G 05-31-06		
1*	D4			QA		VISUAL	5280 LBS	242-M.G		

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INSPECTION DATA CHECKLIST

(120)		RECORD WEIGHT						05-31-06		*
1* (130)	D3	 .5 A B C OUTER AS CAST SURFACES	CMM	QA		00064	-0.165 TO 0.288	339-E.RO 05-31-06		R *
2* (140)	F8	2 X .40	CALIPER	QA		P-5075	.350 TO .420	533-B.CL 05-30-06		R *
2* (150)	F8	4 X .03 X 45	CALIPER	QA		P-5075	.010 TO .040	533-B.CL 05-30-06		R *
2* (160)	G6	2 X R.187 +.025 / -.005	PIN GAGE	QA		J-651-2	.184 TO .205	533-B.CL 05-30-06		A *
2* (170)	G5	 .2 R T S P TO M	CMM	QA		00064	POINTS NOT COLLECTE D	339-E.RO 05-31-06		R *
2* (180)	G5	DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	5-10, 15 - 42, 84 - 94 OUT OF SPEC.	339-E.RO 06-01-06		R *
2* (190)	F5	 .02 R T S M TO M1	CMM	QA		00064	-.0287 TO .268	339-E.RO 05-31-06		R *
2* (200)	E5	 .1 R T S M1 TO N1	CMM	QA		00064	-.0223 TO .0294	339-E.RO 05-31-06		A *
2* (210)	G3	 .2 R T S Q TO N	CMM	QA		00064	POINTS NOT COLLECTE D	339-E.RO 05-31-06		R *
2* (220)	F3	DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	ACCEPT	339-E.RO 06-01-06		A *
2* (230)	F3	 .02 R T S N TO N1	CMM	QA		00064	-.0297 TO .0321	339-E.RO 05-31-06		R *
2* (240)	B4	2 X .06/.09 X 45	CALIPER	QA		P-5075	.030 TO .060	533-B.CL 05-30-06		R *
2* (250)	B5	Ø .375-16 UNC ▽ .750 +.1 -0 96 X	THREAD PLUG GAGE	QA	100%	A-444	ACCEPT	242-M.G 05-31-06		A *
2* (260)	B5	└┐ Ø.625 ▽ .188	CALIPER	QA		P-5075	.622 DEPT H .188 TO .310 (NC1 9783)	242-M.G 06-01-06		R *

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INSPECTION DATA CHECKLIST

2* (270)	B5	$\Phi .06$ R T S 375-16 HOLES	CMM	QA		00064	.002 TO .066	339-E.RO 05-31-06		R
3* (280)	H3	$\square .01$ DATUM E FLANGE	CMM	QA		00064	.029	339-E.RO 05-31-06		R
3* (285)	H4	$\sqrt{125}$ DATUM E FLANGE		QA		VISUAL	250	339-E.RO 06-01-06		R
3* (290)	F2	$\square .01$ DATUM D FLANGE	CMM	QA		00064	.028	339-E.RO 05-31-06		R
3* (295)	F3	$\sqrt{125}$ DATUM D FLANGE		QA		VISUAL	ACCEPT	339-E.RO 06-01-06		A
3* (300)	E4	$\varnothing 2.50$ THRU	CALIPER	QA		P-5075	2.500	533-B.CL 05-31-06		A
3* (310)	F4	$\Phi .060$ A B C $\varnothing 2.50$	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06		A
3* (320)	C7	8X $\varnothing 1-8$ UNC $\nabla 2$	THREAD PLUG GAGE	QA		A-665	ACCEPT	533-B.CL 05-31-06		A
3* (330)	C7	$\Phi .010$ A B C 8X $\varnothing 1-8$ UNC	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06		A
3* (340)	D5	8X $\varnothing 1-8$ UNC THRU	THREAD PLUG GAGE	QA		A-665	ACCEPT	533-B.CL 05-31-06		A
3* (350)	D5	$\varnothing .010$ A B C 8X $\varnothing 1-8$ UNC	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06		A
3* (360)	D3	$\varnothing 2.50$ THRU	CALIPER	QA		P-5075	2.500	533-B.CL 05-31-06		A
3* (370)	D3	$\Phi .060$ A B C $\varnothing 2.5$	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06		A
3* (380)	D1	40.90	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06		A
4* (390)	H6	$\square \varnothing 2.000-2.001 \nabla 0.990-1.000$	DIAL BORE GAGE CALIPER			J-1401 P-5075	2.0000 TO 2.0002 DEPTH .991 T O .997	533-B.CL 05-30-06		A
4* (400)	F4	$\varnothing 1.375-6$ UNC THRU	THREAD PLUG GAGE	QA		A-375	ACCEPT	533-B.CL 05-31-06		A
4*	F4	$\Phi \varnothing .06$ M A D	CMM	QA		00064	.062	339-E.RO		R

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INSPECTION DATA CHECKLIST

(410)		Ø1.375-6					05-31-06		*
4* (420)	D4 &	Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA		J-1400	1.884 TO 1.886	533-B.CL 05-31-06	A *
4* (430)	D4 &	Φ Ø.06 M A D Ø1.885	CMM	QA		00064	.012 TO .060	339-E.RO 05-31-06	A *
4* (440)	B6	3X Ø1.5	CALIPER	QA		J-1103	1.500	533-B.CL 05-31-06	A *
4* (450)	B6	Φ .06 M A D 3X Ø1.5	CMM	QA		00064	.030 TO .040	339-E.RO 05-31-06	A *
4* (460)	A4	6X .25-20 UNC ▽ .5 .5 X 82° CHAMFER	THREAD PLUG GAGE	QA		A-235	ACCEPT	533-B.CL 05-30-06	A *
5* (470)	D8/D6	Ø1.885 ±.003	DIAL BORE GAGE	QA		J-1400	1.884 TO 1.886	533-B.CL 05-31-06	A *
5* (480)	D8/D6	Φ Ø.06 N A E Ø1.885	CMM	QA		00064	.007 TO .076	339-E.RO 05-31-06	R *
5* (490)	F8	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA		A-375	ACCEPT	533-B.CL 05-31-06	A *
5* (500)	F8	Φ Ø.06 N A E Ø1.375-6 UNC	CMM	QA		00064	.044	339-E.RO 05-31-06	A *
5* (510)	F6	8X 1/4 -20 UNC-2B	THREAD PLUG GAGE	QA		A-716	ACCEPT	533-B.CL 05-31-06	A *
5* (520)	D6	3X Ø1.5 ▽ 2.33	CALIPER	QA		J-1103	1.500 DEPTH 2.335 TO 2.340	533-B.CL 05-31-06	A *
5* (530)	D6	Φ Ø.06 N A E 3X Ø1.5	CMM	QA		00064	.004 TO .034	339-E.RO 05-31-06	A *
5* (540)	B3	6X .25 - 20 UNC ▽ .6 Ø.5 X 82° CHAMFER	THREAD PLUG GAGE	QA		A-716	ACCEPT	533-B.CL 05-31-06	A *
6* (550)	H7	6.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06	A *
6* (560)	H7	1.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06	A *
6*	G8		CMM	QA		00064	SEE IGES DATA	339-E.RO	A

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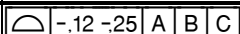
INSPECTION DATA CHECKLIST

(570)		6.70						05-31-06			*
6* (600)	F8	6.70	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
6* (610)	E7	5.75	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
6* (620)	E7	1.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
6* (630)	E6	4X Ø1.00	PIN GAGE	QA		J-921	.999	533-B.CL 05-30-06			A *
6* (640)	G5	2X .88 - 1.13	CALIPER	QA		J-1389	1.13 TO 1.14	533-B.CL 05-30-06			R *
6* (650)	F5	.06-.09 X 45° TYP	CALIPER	QA		P-5075	ACCEPT	533-B.CL 05-31-06			A *
7* (660)	G2	19.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
7* (670)	F2	2.00	CALIPER	QA		P-5075	2.001	533-B.CL 05-31-06			A *
7* (680)	F2	6.75	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
7* (690)	F2	3.75	CALIPER	QA		P-5075	3.752	533-B.CL 05-31-06			A *
7* (700)	F1	4X Ø.75-10 UNC ▽ 1.50	THREAD PLUG GAGE	QA		A-232	ACCEPT	533-B.CL 05-30-06			A *
7* (710)	D1	2X 1.56 OPEN THRU	CALIPER	QA		P-5075	1.558 TO 1.560	533-B.CL 05-30-06			A *
7* (720)	C1	.375-16 UNC-2B TAP ▽ .75 .03 X 45° CHAMFER 6X	THREAD PLUG GAGE	QA		A-52	ACCEPT	533-B.CL 05-30-06			A *
7* (730)	C4	VERIFY THAT HOLE LOCATIONS ARE SCRIBED ON THE PART.		QA		VISUAL	ACCEPT	533-B.CL 05-31-06			A *
7* (740)	B3	8.50 DISTANCE BETWEEN SCRIBE	CALIPER	QA		P-5075	8.500	533-B.CL			A

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INSPECTION DATA CHECKLIST

(740)		MARKINGS.						05-31-06			*
9* (750)	H1	2X Ø.50	CALIPER	QA		P-5075	.502	533-B.CL 05-31-06			A *
9* (760)	B7	TC2 HOLE TO BE .625" IN DIAMETER APPROX. 2.52" DEEP AND .25" IN DIAMETER AT LEAST 1" DEEP.	CALIPER	QA		P-5075	.625 DEPTH 2.5 30	533-B.CL 05-31-06			A *
* (770)		TC1 LOCATION AND CONFIGURATION MODIFIED. HOLE TO HAVE .625 CLEARANCE AND AT LEAST 1" OF DEPTH AT THE .25" DIA	CALIPER	QA		P-5075	.625	533-B.CL 05-31-06			A *
10* (780)	F5	 .5 A B C INNER AS CAST SURFACES	CMM	QA		00064	-.321 TO .149	339-E.RO 05-31-06			R *
10* (790)	D5	 .12 .25 A B C WING SURFACES	CMM	QA		00064	.009 TO -.150	339-E.RO 05-31-06			R *
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* (800)	3.1.1.4 ^{/125}	THE TWO "L" MACHINED SURFACES OF TEE MUST HAVE A RMS OF 125.		QA		VISUAL	ACCEPT	533-B.CL 05-31-06			A *

Workorder: 65709/1-0 Sub:1 Op:140

Revision: 03/22/06 7:50

Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

Drawing ID: SE141-101 Rev: 3			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
* (10)		<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	218 TO 225 MEGA OHM S	840-G.M 06-01-06			A *
* (10)		<u>T E S T 2</u>	MULTIMETER	QA		J-1358	280 TO 330 MEGA OHM	840-G.M			A

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INSPECTION DATA CHECKLIST

(20)		RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE JUMPERED BOLTS AND JUMPERED MID-PLANE CASTING AND WINDING FORM.					S					06-01-06		*
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Workorder: 65709/1-0 Sub:17 Op:50

Revision: 04/25/06 16:37

Part: REWORK - REWORK / REPAIR PER N/C - N/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	
*		N C 19709	MASTER GAGE	QA		J-1165	NO PERMEABILITY RES PONSE EQUAL TO OR G REATER THAN 1.02μ (ORSTEADS)	840-G.M			A
		RECORD PERMEABILITY READINGS OF THE REPAIRED AREA. MAG PERMEABILITY TO BE NO GREATER THAN 1.02μ.						06-01-06			*
(10)											

Workorder: 65709/1-0 Sub:18 Op:30

Revision: 05/08/06 9:52

Part: SE141-141 - BEARING PLATE DETAIL TYPE "A" SHORT -

Drawing ID: SE141-141 Rev: 1			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-1271	LESS THAN 1.02	261-T.DU		
(10)								05-16-06		

Workorder: 65709/1-0 Sub:19 Op:30

Revision: 05/08/06 9:51

Part: SE141-142 - BEARING PLATE DETAIL TYPE "A" LONG -

Drawing ID: SE141-142 Rev: 1			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1*	G2	RECORD MAGNETIC PERMEABILITY.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	503-B.HO		

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Major
Tool & Machine, Inc.

INSPECTION DATA CHECKLIST

Page: 9

Date: 06/01/06

User ID: GRIFFITH

(10)	RESULTS TO BE NO GREATER THAN 1.02 μ .							05-18-06		*
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