
Customer: ENERGY INDUSTRIES OF OHIO

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

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

Part: /

Drawing ID: SE141-114

Revision: 7

Customer P.O.: S005242-F/Ln:2
Serial No./Qty: 1

Reported By: MIKE GRIFFITH

E-Mail: mGriffith@MajorTool.com

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

Problem: Inspection Test #: 130 rejected: OUTER AS CAST SURFACES: {g|,5|A|B|C}: -.092 TO .553
Inspection Test #: 140 rejected: 2 X .40: : .395 TO .435 ON E SIDE, .355 TO .410 ON D SIDE
Inspection Test #: 150 rejected: 4 X .03 X 45: : .035 ON E SIDE, .010 TO .035 ON D SIDE
Inspection Test #: 180 rejected: DATUM D SIDE
VERIFY SHELL INTERSECT CLEARANCE WITH GAGE MTMFX-3473: : REJECT - MODEL DOES NOT ALLOW FOR CLEARANCE
Inspection Test #: 190 rejected: M TO M1: {g|,02|R|T|S}: -.021 TO .012
Inspection Test #: 230 rejected: N TO N1: {g|,02|R|T|S}: -.017 TO .027
Inspection Test #: 240 rejected: 2 X .06/.09 X 45: : .025 TO .050
Inspection Test #: 260 rejected: : bd.625 y .188: .618 TO .627 DEPTH .165 TO .193
Inspection Test #: 280 rejected: DATUM E FLANGE: {f|,01}: .015
Inspection Test #: 290 rejected: DATUM D FLANGE: {f|,01}: .032
Inspection Test #: 330 rejected: 8X Ø1-8 UNC: {#|,010|A|B|C}: .016 TO .060
Inspection Test #: 350 rejected: 8X Ø1-8 UNC: {d|,010|A|B|C}: .016 TO .066
Inspection Test #: 460 rejected: : 6X .25-20 UNC y .5
.5 X 82` CHAMFER: THE THREADS ARE ACCEPTABLE BUT THE CHAMFER IS TOO BIG .500
Inspection Test #: 480 rejected: Ø1.885: {#|d,06|N|A|E}: .003 TO .074
Inspection Test #: 540 rejected: : 6X .25 - 20 UNC y .6
d.5 X 82` CHAMFER: .375 DIA. CHAMFER
Inspection Test #: 780 rejected: INNER AS CAST SURFACES: {g|,5|A|B|C}: -.034 TO -.337 / -.341 TO .073
Inspection Test #: 790 rejected: WING SURFACES: {g|-,12;;;-,25|A|B|C}: -.164 TO -.197 / -.016 TO -.206

Additional Items:

- 1) Tool Gouge on top edge of T, datum D side. Gouge is approximately .300" long and .015" in depth. See pictures.
- 2) G11 shim is below flush on the outer surface of the datum D flange. G11 is approximately .08" below flange surface. See pictures.
- 3) Tool marks did not clean up on the short leg of the D flange from holes 16 to 19. Tool marks appear to be less than .005" in depth. See pictures.

Proposed Disposition:

Propose to accept deviations As-Is.

Number of additional pages: Dimensional IDC and Final Visual Pictures

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

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

MTM N/C: 20080

Page: 2
Date: 06/27/06
User ID: GRIFFITH

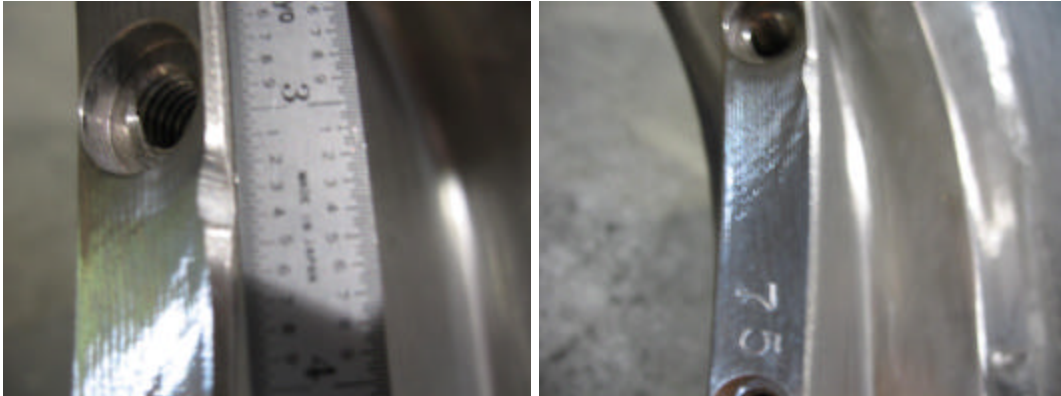
Major Tool Implemented By: _____ **Title:** _____ **Date:** _____

n:\mtmapps\Mtnonc14.qrp

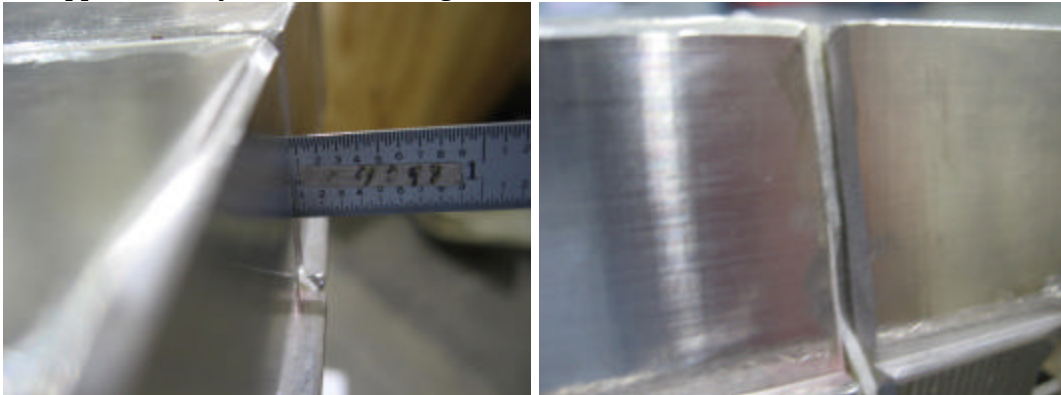
Major Tool and Machine, Inc. 1458 East 19th Street, Indianapolis, IN 46218-4289 Tel: 317-636-6433 Fax: 317-634-9420

SE141-114 A2
NC20080 attachment

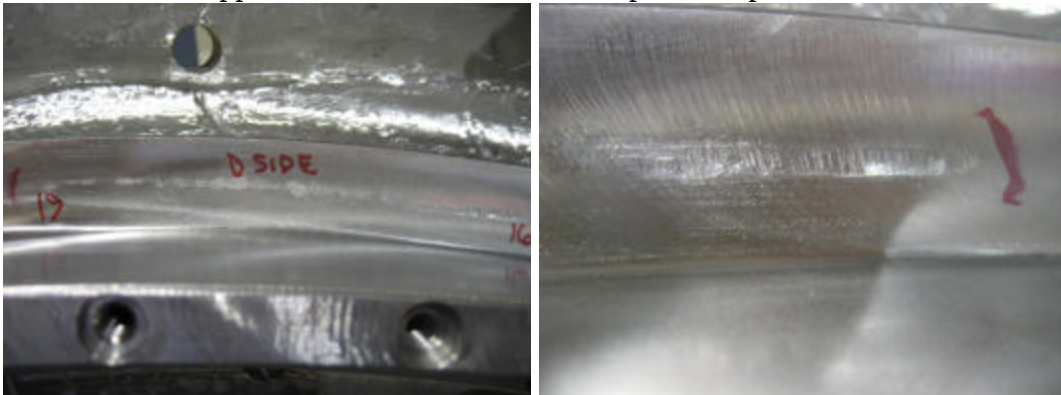
1. Tool gouge on top edge of T section on the datum D side of the part. Gouge is near hole 76.



2. G11 shim is below flush on the outer surface of the datum D flange. G11 is approximately .08" below flange surface.



3. Tool marks did not clean up on the short leg of the D flange from holes 16 to 19. Tool marks appear to be less than .005" in depth. See pictures.

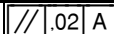
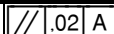
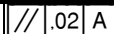
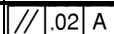


INSPECTION DATA CHECKLIST

Workorder: 65709/2-0 Sub:1 Op:132

Revision: 06/24/06 0:03

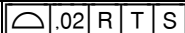
Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

Drawing ID: SE141-114 Rev: 7			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		MTMFX3564	ACCEPT	339-E.RO 06-27-06		
1* (20)	E8	FLANGE PROFILE +/- .25 IN THIS AREA	CMM	QA		00064	-.0027 TO -.0065	339-E.RO 06-27-06		
1* (30)	D8		CMM	QA		00064	.006	339-E.RO 06-27-06		
1* (40)	D8	54.20 ± .03	CMM	QA		00064	54.206	339-E.RO 06-27-06		
1* (50)	C8	54.20 ± .03	CMM	QA		00064	54.205	339-E.RO 06-27-06		
1* (60)	B8		CMM	QA		00064	.005	339-E.RO 06-27-06		
1* (70)	D5		CMM	QA		00064	.002	339-E.RO 06-27-06		
1* (80)	D5	48.50 ± .03	CMM	QA		00064	48.498	339-E.RO 06-27-06		
1* (90)	C5	48.50 ± .03	CMM	QA		00064	48.494	339-E.RO 06-27-06		
1* (100)	B5		CMM	QA		00064	.006	339-E.RO 06-27-06		
1* (110)	D4	VERIFY PART MARKING: MAJOR TOOL SE141-114 A(casting number) (weight) LBS.		QA		VISUAL	ACCEPT	339-E.RO 06-27-06		
1* (120)	D4	RECORD WEIGHT		QA			5180	242-M.G 06-21-06		
1*	D3		CMM	QA		00064	-.092 TO .553 [N/C:	339-E.RO		

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INSPECTION DATA CHECKLIST

(130)		OUTER AS CAST SURFACES					20080-Doc:NC20080]	06-27-06			*
2*	F8		CALIPER	QA		P-5075	.395 TO .435 ON DATUM E SIDE, .355 TO .410 ON DATUM D SIDE [N/C:20080-Doc:NC20080]	533-B.CL			R
(140)		2 X .40						06-23-06			*
2*	F8		CALIPER	QA		P-5075	.035 ON DATUM E SIDE, .010 TO .035 ON DATUM D SIDE [N/C:20080-Doc:NC20080]	533-B.CL			R
(150)		4 X .03 X 45						06-23-06			*
2*	G6		PIN GAGE	QA		J-651-2	.187 ON DATUM E SIDE, .183 TO .192 ON DATUM D SIDE	533-B.CL			A
(160)		2 X R.187 +.025 / -.005						06-23-06			*
2*	G5		CMM	QA		00064	-.003 TO .081	339-E.RO			A
(170)		P TO M						06-27-06			*
2*	G5			QA		MTMFX-3473	REJECT - MODEL DOES NOT ALLOW FOR CLEARANCE [N/C:20080-Doc:NC20080]	339-E.RO			R
(180)		DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473						06-27-06			*
2*	F5		CMM	QA		00064	-.021 TO .012 [N/C:20080-Doc:NC20080]	339-E.RO			R
(190)		M TO M1						06-27-06			*
2*	E5		CMM	QA		00064	-.015 TO .017	339-E.RO			A
(200)		M1 TO N1						06-27-06			*
2*	G3		CMM	QA		00064	.015 TO .092	339-E.RO			A
(210)		Q TO N						06-27-06			*
2*	F3			QA		MTMFX-3473	ACCEPT	339-E.RO			A
(220)		DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473						06-27-06			*
2*	F3		CMM	QA		00064	-.017 TO .027 [N/C:20080-Doc:NC20080]	339-E.RO			R
(230)		N TO N1						06-27-06			*
2*	B4		CALIPER	QA		P-5075	.025 TO .050 [N/C:2	533-B.CL			R
											*

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INSPECTION DATA CHECKLIST

(240)		2 X .06/.09 X 45					0080-Doc:NC20080]	06-23-06			
2* (250)	B5	Ø .375-16 UNC ▽ .750 +.1 -0 96 X	THREAD PLUG GAGE	QA	100%	A-151	ACCEPT	339-E.RO 06-27-06			A *
2* (260)	B5	└┐Ø.625 ▽ .188	PIN GAGE	QA		J-652-3	.618 TO .627 DEP TH .165 TO .193 [N/ C:20080-Doc:NC20080]	533-B.CL 06-23-06			R *
2* (270)	B5	Φ .06 R T S .375-16 HOLES	CMM	QA		00064	.005 TO .055	339-E.RO 06-27-06			A *
3* (280)	H3	▱ .01 DATUM E FLANGE	CMM	QA		00064	.015 [N/C:20080-Doc :NC20080]	339-E.RO 06-27-06			R *
3* (285)	H4	√ ¹²⁵ DATUM E FLANGE	PROFILOMETER	QA		J-1109	25 TO 81	533-B.CL 06-23-06			A *
3* (290)	F2	▱ .01 DATUM D FLANGE	CMM	QA		00064	.032 [N/C:20080-Doc :NC20080]	339-E.RO 06-27-06			R *
3* (295)	F3	√ ¹²⁵ DATUM D FLANGE	PROFILOMETER	QA		J-1109	32 TO 78	533-B.CL 06-23-06			A *
3* (300)	E4	Ø2.50 THRU	DIAL BORE GAGE	QA		J-1401	2.495	533-B.CL 06-23-06			A *
3* (310)	F4	Φ .060 A B C Ø2.50	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06			A *
3* (320)	C7	8X Ø1-8UNC ▽ 2	THREAD PLUG GAGE	QA		A-347	ACCEPT	533-B.CL 06-22-06			A *
3* (330)	C7	Φ .010 A B C 8X Ø1-8 UNC	CMM	QA		00064	.016 TO .060 [N/C:2 0080-Doc:NC20080]	339-E.RO 06-27-06			R *
3* (340)	D5	8X Ø1-8UNC THRU	THREAD PLUG GAGE	QA		A-347	ACCEPT	533-B.CL 06-22-06			A *
3* (350)	D5	Ø .010 A B C 8X Ø1-8 UNC	CMM	QA		00064	.016 TO .066 [N/C:2 0080-Doc:NC20080]	339-E.RO 06-27-06			R *
3* (360)	D3	Ø2.50 THRU	DIAL BORE GAGE	QA		J-1401	2.491	533-B.CL 06-23-06			A *
3* (370)	D3	Φ .060 A B C Ø2.5	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06			A *
3* (380)	D1		CMM	QA		00064	SEE IGES DATA	339-E.RO			A

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INSPECTION DATA CHECKLIST

(380)		40.90						06-27-06		*
4*	H6	$\square \text{ } \varnothing 2.000-2.001 \text{ } \nabla 0.990-1.000$	DIAL BORE GAGE	QA		J-1401	2.0005, 2.0007, 2.0009 DEPTH .992 TO .996	533-B.CL		A
(390)			CALIPER			P-5075		06-24-06		*
4*	F4	$\varnothing 1.375-6\text{UNC THRU}$	THREAD PLUG GAGE	QA		A-375	ACCEPT	533-B.CL		A
(400)								06-23-06		*
4*	F4	$\oplus \varnothing .06 \text{ M A D}$	CMM	QA		00064	.036	339-E.RO		A
(410)		$\varnothing 1.375-6$						06-27-06		*
4*	D4 &	$\varnothing 1.885 \pm .003 \text{ THRU}$	DIAL BORE GAGE	QA		J-1400	1.883 TO 1.887	533-B.CL		A
(420)								06-23-06		*
4*	D4 &	$\oplus \varnothing .06 \text{ M A D}$	CMM	QA		00064	.012 TO .059	339-E.RO		A
(430)		$\varnothing 1.885$						06-27-06		*
4*	B6	3X $\varnothing 1.5$	CALIPER	QA		J-1103	1.500 TO 1.502	533-B.CL		A
(440)								06-23-06		*
4*	B6	$\oplus .06 \text{ M A D}$	CMM	QA		00064	.020 TO .058	339-E.RO		A
(450)		3X $\varnothing 1.5$						06-27-06		*
4*	A4	6X .25-20 UNC $\nabla .5$.5 X 82° CHAMFER	THREAD PLUG GAGE	QA		A-715	THE THREADS ARE ACCEPTABLE BUT THE CHAMFER IS TOO BIG .500 [N/C:20080-Doc:N	533-B.CL		R
(460)			CALIPER			P-5075	C20080]	06-24-06		*
5*	D8/D6	$\varnothing 1.885 \pm .003$	DIAL BORE GAGE	QA		J-1400	1.8835 TO 1.884	533-B.CL		A
(470)								06-22-06		*
5*	D8/D6	$\oplus \varnothing .06 \text{ N A E}$	CMM	QA		00064	.003 TO .074 [N/C:20080-Doc:NC20080]	339-E.RO		R
(480)		$\varnothing 1.885$						06-27-06		*
5*	F8	$\varnothing 1.375-6\text{UNC THRU}$	THREAD PLUG GAGE	QA		A-375	ACCEPT	533-B.CL		A
(490)								06-23-06		*
5*	F8	$\oplus \varnothing .06 \text{ N A E}$	CMM	QA		00064	.043	339-E.RO		A
(500)		$\varnothing 1.375-6 \text{ UNC}$						06-27-06		*
5*	F6	8X 1/4 -20 UNC-2B	THREAD PLUG GAGE	QA		A-715	ACCEPT	533-B.CL		A
(510)								06-23-06		*
5*	D6	3X $\varnothing 1.5 \text{ } \nabla 2.33$	CALIPER	QA		J-1103	1.498 TO 1.500	533-B.CL		A
(520)			CALIPER			P-5075	DEPTH 2.330 TO 2.340	06-22-06		*

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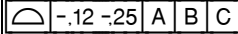
INSPECTION DATA CHECKLIST

5* (530)	D6	Φ .06 N A E 3X Ø1.5	CMM	QA		00064	.024 TO .029	339-E.RO 06-27-06		A *
5* (540)	B3	6X .25 - 20 UNC ∇ .6 Ø.5 X 82° CHAMFER	CALIPER	QA		P-5075	.375 DIA. CHAMFER [N/C:20080-Doc:NC20080]	533-B.CL 06-23-06		R *
6* (550)	H7	6.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A *
6* (560)	H7	1.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A *
6* (570)	G8	6.70	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A *
6* (600)	F8	6.70	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A *
6* (610)	E7	5.75	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A *
6* (620)	E7	1.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A *
6* (630)	E6	4X Ø1.00	PIN GAGE	QA		J-921	.995	533-B.CL 06-23-06		A *
6* (640)	G5	2X .88 - 1.13	CALIPER	QA		P-5075	1.115 TO 1.130	533-B.CL 06-23-06		A *
6* (650)	F5	.06-.09 X 45° TYP	CALIPER	QA		P-5075	.065	533-B.CL 06-22-06		A *
7* (660)	G2	19.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A *
7* (670)	F2	2.00	CALIPER	QA		P-5075	2.00	533-B.CL 06-22-06		A *
7* (680)	F2	6.75	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A *
7* (690)	F2	3.75	CALIPER	QA		P-5075	3.745 TO 3.750	533-B.CL 06-22-06		A *
7* (700)	F1	4X Ø.75-10 UNC ∇ 1.50	THREAD PLUG GAGE	QA		A-167	ACCEPT	533-B.CL 06-22-06		A *
7* (710)	D1		CALIPER	QA		P-5075	1.560	533-B.CL		A

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INSPECTION DATA CHECKLIST

(710)		2X 1.56 OPEN THRU						06-22-06		*
7*	C1	.375-16 UNC-2B TAP ∇ .75 .03 X 45° CHAMFER	THREAD PLUG GAGE	QA		A-444	ACCEPT CHAMFE	533-B.CL		A
(720)		6X	CALIPER			P-5075	R .035	06-22-06		*
7*	C4	VERIFY THAT HOLE LOCATIONS ARE SCRIBED ON THE PART.		QA		VISUAL	ACCEPT	533-B.CL		A
(730)								06-22-06		*
7*	B3	8.50 DISTANCE BETWEEN SCRIBE MARKINGS.	CALIPER	QA		J-1389	ACCEPT	533-B.CL		A
(740)								06-22-06		*
9*	H1	2X $\varnothing$.50	PIN GAGE	QA		J-652-3	.500	533-B.CL		A
(750)								06-23-06		*
9*	B7	TC2 HOLE TO BE .625" IN DIAMETER APPROX. 2.52" DEEP AND .25" IN DIAMETER AT LEAST 1" DEEP.	PIN GAGE	QA		J-652-3	2.570 DEEP .623 D IA. 1 DEEP . 252 DIA.	533-B.CL		A
(760)			CALIPER			P-5075		06-23-06		*
*		TC1 LOCATION AND CONFIGURATION MODIFIED. HOLE TO HAVE .625 CLEARANCE AND AT LEAST 1" OF DEPTH AT THE .25" DIA	PIN GAGE	QA		J-652-3	.623 DIA. 1.150 D EEP .252 DIA.	533-B.CL		A
(770)			CALIPER			P-5075		06-23-06		*
10*	F5		CMM	QA		00064	-.034 TO -.337 / -. 341 TO .073 [N/C:20 080-Doc:NC20080]	339-E.RO		R
(780)		INNER AS CAST SURFACES						06-27-06		*
10*	D5		CMM	QA		00064	-.164 TO -.197 / -. 016 TO -.206 [N/C:2 0080-Doc:NC20080]	339-E.RO		R
(790)		WING SURFACES						06-27-06		*
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*	3.1.1.4	¹²⁵ THE TWO "L" MACHINED SURFACES OF	PROFILOMETER	QA		J-1109	15 TO 30	533-B.CL		A

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INSPECTION DATA CHECKLIST

Page: 7
Date: 06/27/06
User ID: GRIFFITH

(800)		TEE MUST HAVE A RMS OF 125.						06-23-06			*
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Employees: 242-M.Griffith / 339-E.Root / 533-B.Clevenger

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