

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

MTM N/C: 20449

Page: 1  
Date: 09/13/06  
User ID: GRIFFITH

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**Customer: ENERGY INDUSTRIES OF OHIO**

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

Telephone: 216-496-2314  
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**Part: SE141-115 / MODULAR COIL, TYPE B**

Drawing ID: SE141-115                      Revision: 8

Customer P.O.: S005242-F/Ln:2  
Serial No./Qty: B2

Reported By: MIKE GRIFFITH  
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Problem: Sheet 5, zone D4.  
8 of the 1.375 threaded holes on datum -E- are out of position by a 1/2 inch (holes 19 thru 26).

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**Proposed Disposition:**

MTM RECOMMENDS REPAIRING HOLES PER ATTACHED REWORK PROPOSAL.

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Number of additional pages: 2 Page Rework Proposal

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

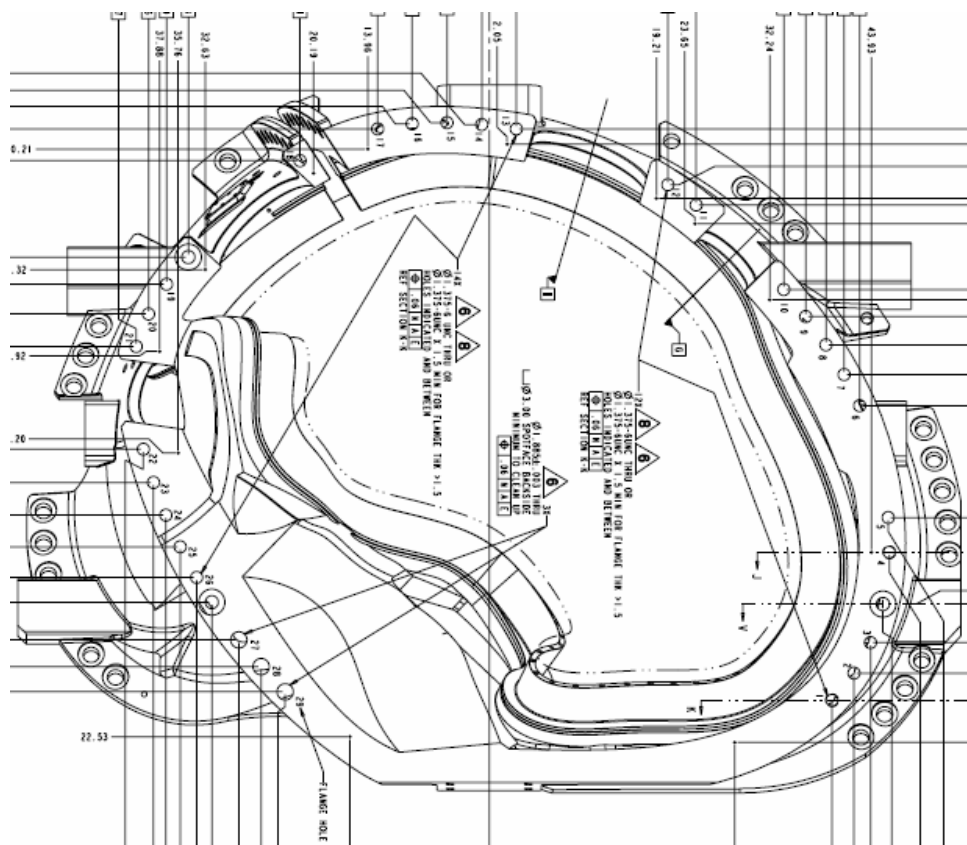
**Major Tool Implemented By:** \_\_\_\_\_ **Title:** \_\_\_\_\_ **Date:** \_\_\_\_\_



# SE141-115 Type B2 Flange Hole Rework Proposal

## Rework Proposal for Holes 19 thru 26:

- Oversize holes for a Ø2.50-6 UN insert.
- Inserts will be manufactured complete with the Ø1.375-6 ID thread.
- For 5 Blind Holes: bottom out insert in hole (approx. 1.6' deep) and tack weld in 4 places on flange.
- For 3 Thru Holes: install insert and tack weld in 4 places on flange face and 4 places on back side of flange.
- All inserts will be faced off flush with Datum -E- flange.



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## MTM REVISIONS

SYMBOL	ZONE	DESCRIPTION	DATE	BY
-		INITIAL RELEASE	9/13/08	MJB

Ø 1.375-6 UNC2B

Ø2.50-6 UN-2B

1.625

.06" CHAMFER

			8
			7
			6
			5
			4
			3
			2
			1
QTY	PART NUMBER/MATERIAL	DESCRIPTION	ITEM

## LIST OF MATERIAL

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES

.X Ø6	.XX Ø20	.XXX Ø10
FRACTIONS	ANGLES	

MATERIAL

STELLALLOY

Major  
TOOL & MACHINE, ENGINEERING  
DALLAS, TEXAS

MCWF FLANGE INSERT

SIZE A NUMBER SE141-INSERT-MTM

SCALE, ANVIL, SHEET 1 OF 1

DRWN BY: MIKE GRIFFITH

CHKD BY: NATHAN HIRSCHY

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