

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

MTM N/C: 20483

Page: 1
Date: 09/17/06
User ID: GRIFFITH

Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
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Part: SE141-115 / MODULAR COIL, TYPE B

Drawing ID: SE141-115 Revision: 8
W/O Links: 1-Type:W: 65708/1.0 Sub: 1

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: B1

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

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

Problem: PART IS REJECTED PER ASTM A903/A903M LEVEL 1.
SEE ATTACHMENT FOR SIZES AND LOCATIONS.

Proposed Disposition:

MTM proposes that indications be accepted as is.

Number of additional pages: 11 page PT summary

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

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

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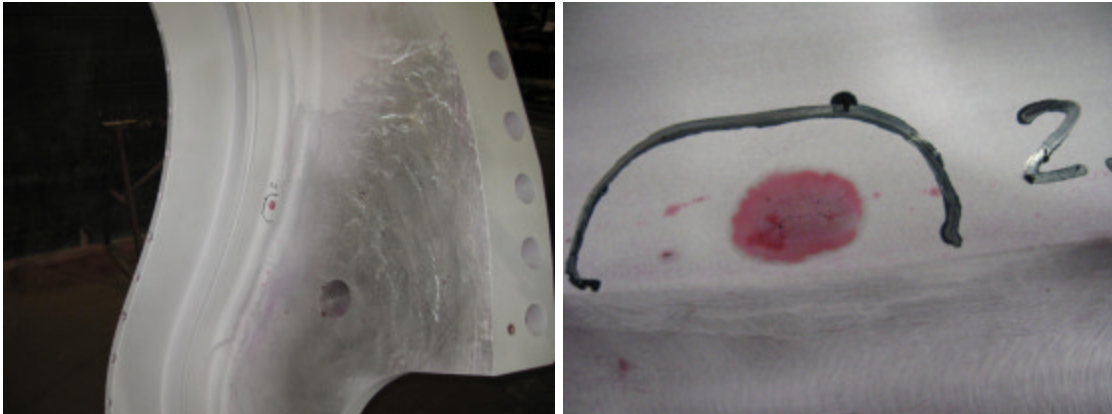
Major Tool and Machine, Inc. 1458 East 19th Street, Indianapolis, IN 46218-4289 Tel: 317-636-6433 Fax: 317-634-9420

PT Inspection Results of B1 – NC20483

1. .250" linear located on large wing of D flange.



2. .350" linear located in radius below VPI groove. (D flange side near T hole 31)

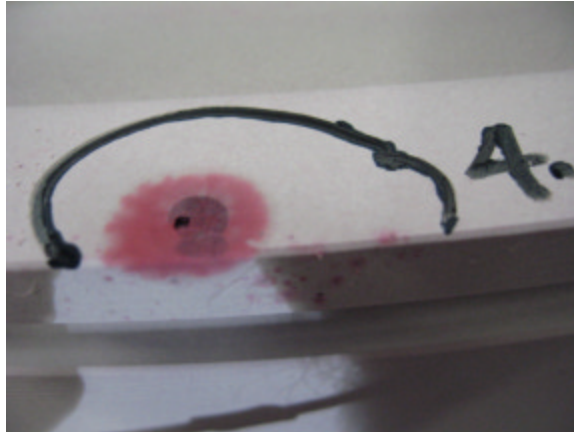


3. .150" linear located on small land between VPI groove and short leg of T. (D flange side near T hole 24)

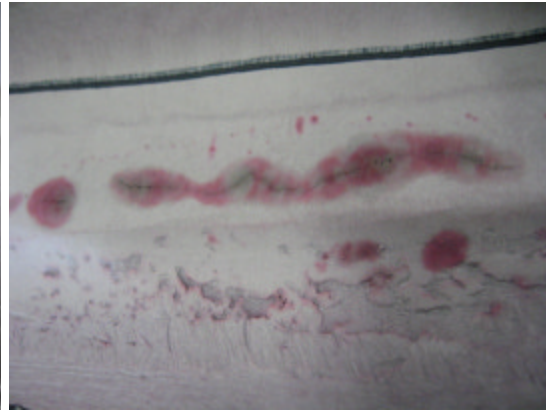
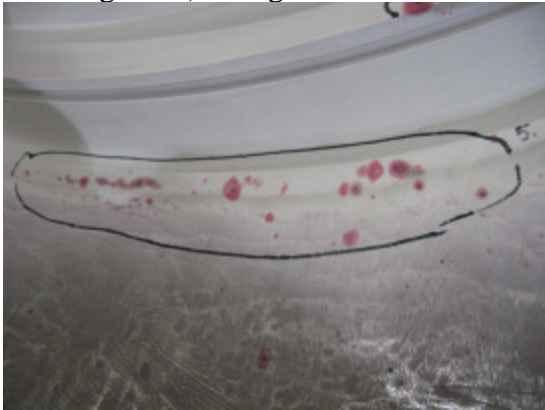


PT Inspection Results of B1 – NC20483

4. .250" rounded inclusion on short leg of T outer edge. (D flange side near hole 22)



5. Cluster of indications in radius below VPI groove between T holes 18 and 22. (D flange side) Longest indication is a 2.1" linear.

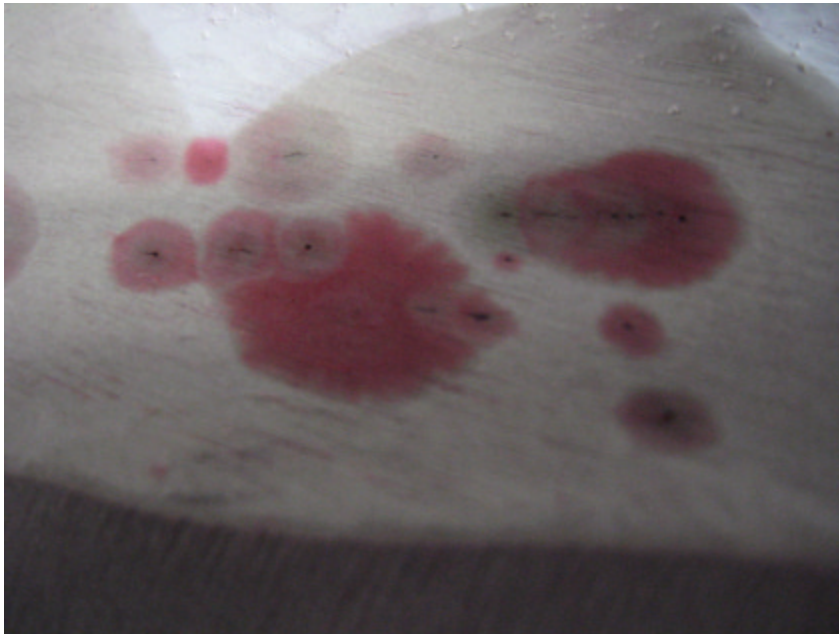


Picture at right is location of reject numbers 3, 4 and 5.



PT Inspection Results of B1 – NC20483

6. Cluster of indications in radius below VPI groove between T holes 8 and 12. (D flange side) Longest indication is a .400" linear.

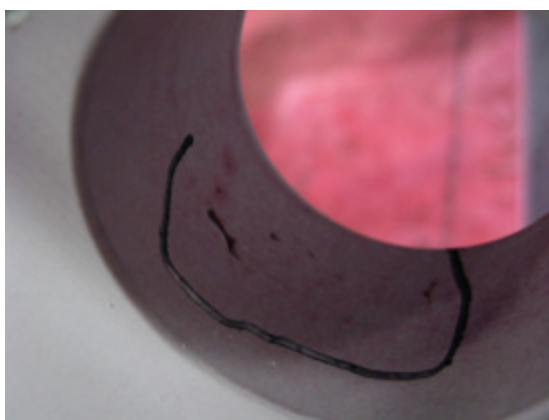


7. 1.6" linear indication on flange face of poloidal break.



PT Inspection Results of B1 – NC20483

8. .300" long inclusion in D flange hole 14.



9. .200" linear on counterbore diameter of D flange hole 6.



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10. .200" linear on counterbore diameter of D flange hole 9.



Picture below is location of rejections 9 and 10.



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11. .700" linear on outer edge of E flange near flange hole 5.

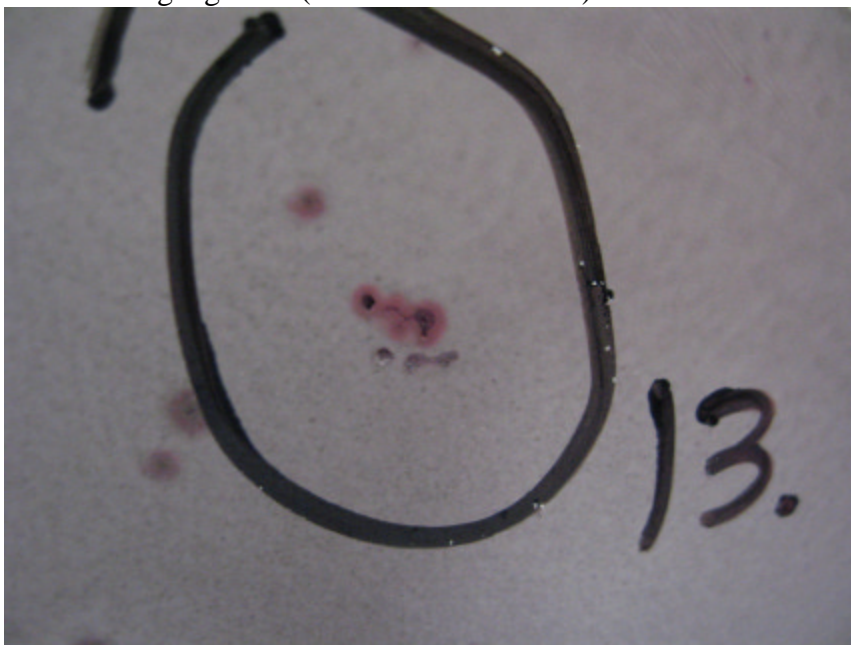


12. Cluster of indications that start on the E flange face and wrap around to the inside of the casting in the radius below the VPI groove. The longest indication is a .300" linear. The indications start between E flange holes 9 and 10.



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13. .200" linear on long leg of T. (E side near T hole 27)

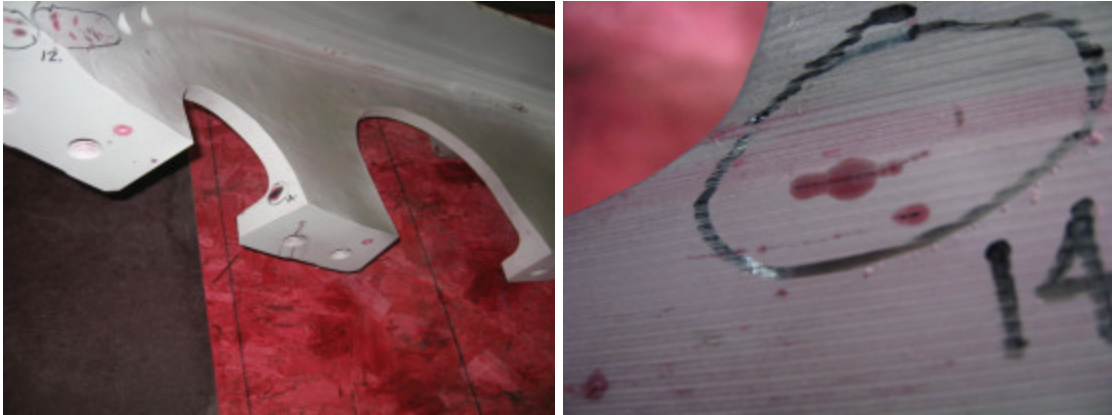


Picture below is location of rejections 12 and 13.



PT Inspection Results of B1 – NC20483

14. .700" linear in the cutout between E flange holes 10 and 11.



15. Cluster of indications in radius below VPI groove (E side near T hole 9). Longest is a .300" linear.



16. Cluster of indications in radius below VPI groove (E side near T hole 94). Longest is a .250" linear.



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17. Cluster of indications in radius below VPI groove (E side near T hole 50). Longest is a .350" linear.



18. .300" linear on edge between E flange and inner casting wall. Indication is near 1/4-20 tapped hole located at drawing zone D2 of sheet 5.

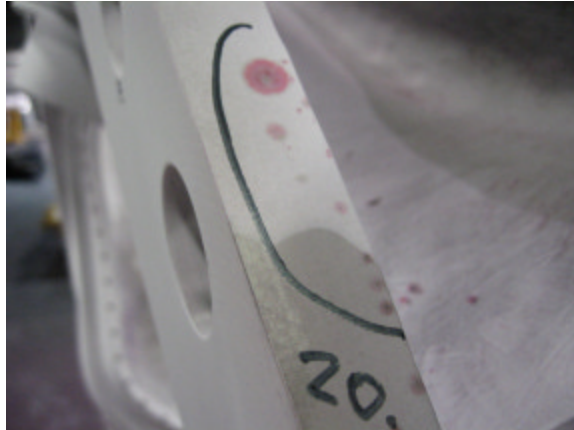


19. .100" linear on diameter of E flange hole 29.



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20. .150" linear on outer edge of E flange near flange hole 28.



21. 1.200" linear on outer edge of E flange between flange holes 26 and 27.



Location of rejections 19, 20 and 21



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22. 1.00" linear on pad (sheet 3, zone C6 of drawing).

