
Customer: ENERGY INDUSTRIES OF OHIO

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

Drawing ID: SE141-115 Revision: 9
W/O Links: 1-Type:W: 65708/3.0 Sub: 1

Customer P.O.: S005242-F/Ln:3
Serial No./Qty: B3

Reported By: MIKE GRIFFITH
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Fax: 317-634-9420

Problem: Workorder: 65708/3.0 Sub:1 Op:132

Inspection Test #: 90 rejected: OUTER AS CAST SURFACES: {g|.5|A|C|B}: -.001 TO .386
Inspection Test #: 100 rejected: : 2X .03 X 45` TO SMALL OR INCOMPLETE
Inspection Test #: 110 rejected: .40: : .300-.506
Inspection Test #: 120 rejected: : 2X .03 X 45` TO SMALL OR INCOMPLETE
Inspection Test #: 140 rejected: 2X .31: : .295-.325
Inspection Test #: 150 rejected: MACHINED SURFACES M TO M1: {g|.02|R|S|T}: .0206 TO -.023
Inspection Test #: 160 rejected: DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE
USING GAGE MTMFX-3473: : REJECTED BETWEEN T HOLES 68-70 AND 81-84
Inspection Test #: 170 rejected: P TO M: {g|.2|R|S|T}: -.007 TO .110
Inspection Test #: 190 rejected: MACHINED SURFACES N TO N1: {g|.02|R|S|T}: -.0272 TO .0265
Inspection Test #: 200 rejected: DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE
USING GAGE MTMFX-3473: : REJECTED BETWEEN T HOLES 32-46, 49-56 AND 85-90
Inspection Test #: 210 rejected: Q TO N: {g|.2|R|S|T}: .0119 TO .1136
Inspection Test #: 260 rejected: : {#.06|R|S|T}: .013 TO .138
Inspection Test #: 340 rejected: DATUM E: {f|.01}: .0187
Inspection Test #: 360 rejected: DATUM D: {f|.01}: .0277
Inspection Test #: 390 rejected: : 2X d2.50: 2.472 - 2.475
Inspection Test #: 730 rejected: : 3X d1.885 ~.003 THRU: 1.886 (1 HOLE HAS NON-CLEANUP UP TO 1.902")
Inspection Test #: 840 rejected: 2X .88/1.13: : 1.10 - 1.16
Inspection Test #: 1020 rejected: WING SURFACES: {g|-.12;;-.25|A|B|C}: -.115 - .158

Proposed Disposition: MTM proposes to accept as is

Number of additional pages: IDC attachment

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

The IDC attachment was reviewed by D. Williamson; his assessment is contained in his e-mail of 4 January ("B3 IDC Review). All non-conforming conditions were accepted as is, with the exception of Inspection Test 100 and 120 which refers to the chamfers for the O-ring grooves. These must be corrected prior to shipment.

Accepted by:

Tech. Rep.

RLM

Verified by:

MTM

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-115 - Item: 6

Workorder: 65708/3-0 Sub:1 Op:130

Part: SE141-115 - MODULAR COIL, TYPE B -

Drawing ID: SE141-102 Rev: 3			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
2* (10)	D2	Ø.001 - Ø.002 CHECK CLEARANCE OF ITEM 5 TO ITEM 6.	FEELER GAGES	MFG		J-1203	LESS THAN .002	825-B.JA 12-13-06			A
* (15)		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"	FEELER GAGES	MFG		J-1203	LES THAN .002	825-B.JA 12-13-06			A
* (20)		ENSURE THAT THE CUMULATIVE GAPS AT ANY SINGLE CROSS SECTION OF THE POLOIDAL FLANGE ELEMENTS IS LESS THAN .005".	FEELER GAGES	MFG		J-1203	LESS THAN .002	825-B.JA 12-13-06			A
* (30)		THE MAX. GAP AT THE POLOIDAL BREAK PERIMETER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE.	FEELER GAGES	MFG		J-1203	LESS THAN .002	825-B.JA 12-13-06			A
1* (40)	F3	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLIE	MFG		J-1240	1500 #	825-B.JA 12-13-06			A

INSPECTION DATA CHECKLIST

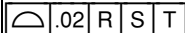
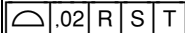
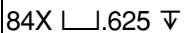
Quality Assurance Documentation for Part ID: SE141-115 - Item: 7

Workorder: 65708/3-0 Sub:1 Op:132

Part: SE141-115 - MODULAR COIL, TYPE B -

Drawing ID: SE141-115 Rev: 9			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1* (10)	C3	VERIFY PART MARKING: MAJOR TOOL SE141-115 B(casting number) (weight) LBS.		QA		VISUAL	ACCEPT	503-B.HO 12-15-06			A
1* (20)	C3	RECORD FINAL PART WEIGHT		QA			5380 LBS	503-B.HO 12-15-06			A
1* (30)	F3	NOTE 14 BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.		QA		VISUAL	ACCEPT	503-B.HO 12-15-06			A
1* (40)	E7		CMM	QA		00064	.0016	339-E.RO 12-18-06			A
1* (50)	E6		CMM	QA		00064	.0053	339-E.RO 12-18-06			A
1* (60)	B6		CMM	QA		00064	.0032	339-E.RO 12-18-06			A
1* (70)	B5		CMM	QA		00064	.0010	339-E.RO 12-18-06			A
1* (90)	D3	 OUTER AS CAST SURFACES	CMM	QA		00064	-.001 TO .386 [N/C: 20917]	339-E.RO 12-19-06			R
2* (100)	G7	2X .03 X 45°		QA			TO SMALL OR INCOMPL ETE [N/C:20917]	503-B.HO 12-15-06			R
2* (110)	G7	.40	CALIPER	QA		P-2056	.300-.506 [N/C:2091 7]	503-B.HO 12-15-06			R
2* (120)	G7	2X .03 X 45°		QA			TO SMALL OR INCOMPL ETE [N/C:20917]	503-B.HO 12-15-06			R
2* (130)	G8	2X R.11	RADIUS GAGE	QA		R-25	ACCEPT	503-B.HO 12-15-06			A
2*	H7		CALIPER	QA		P-2056	.295-.325 [N/C:2091	503-B.HO			R

INSPECTION DATA CHECKLIST

(140)		2X .31					7]	12-15-06		
2*	H6	 MACHINED SURFACES M TO M1	CMM	QA		00064	.0206 TO -.023 [N/C :20917]	242-M.G		R
(150)								12-22-06		
2*	F5	DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	REJECTED BETWEEN T HOLES 68-70 AND 81- 84 [N/C:20917]	242-M.G		R
(160)								12-16-06		
2*	E6	 P TO M	CMM	QA		00064	-.007 TO .110 [N/C: 20917]	339-E.RO		R
(170)								12-19-06		
2*	H4	 MACHINED SURFACES M1 TO N1		QA			-.0098 TO .017	242-M.G		A
(180)								12-22-06		
2*	G3	 MACHINED SURFACES N TO N1	CMM	QA		00064	-.0272 TO .0265 [N/ C:20917]	242-M.G		R
(190)								12-22-06		
2*	F3	DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	REJECTED BETWEEN T HOLES 32-46, 49-56 AND 85-90 [N/C:2091 7]	242-M.G		R
(200)								12-16-06		
2*	F3	 Q TO N	CMM	QA		00064	.0119 TO .1136 [N/C :20917]	339-E.RO		R
(210)								12-19-06		
2*	C5	2X .06-.09 X 45°	CALIPER	QA		P-2056	ACCEPT	503-B.HO		A
(230)								12-15-06		
2*	C4	84X .375-16 UNC ▽ .75	THREAD PLUG GAGE	QA		A-443	ACCEPT	242-M.G		A
(240)								12-22-06		
2*	C4	84X  ▽ .188	CALIPER	QA		P-2056	.623/.178-.198	503-B.HO		A
(250)								12-15-06		
2*	C4		CMM	QA		00064	.013 TO .138 [N/C:2 0917]	242-M.G		R
(260)								12-22-06		
3*	G7		CMM	QA		00064	SEE IGES	339-E.RO		A
(270)		9.00						12-18-06		
3*	G7			QA			SEE IGES	339-E.RO		

INSPECTION DATA CHECKLIST

(280)		4.50						12-18-06		
3* (290)	G6	3.00	CMM	QA		00064	SEE IGES	339-E.RO 12-18-06		A
3* (300)	F7	1.50	CMM	QA		00064	SEE IGES	339-E.RO 12-18-06		A
3* (310)	F7	4X Ø1.0-8UNC ▽2.1	THREAD PLUG GAGE	QA		A-666	ACCEPT	503-B.HO 12-15-06		A
3* (320)	G5	17.00 AT MOUNTING AREA	CMM	QA		00064	SEE IGES	339-E.RO 12-18-06		A
3* (330)	H2	¹²⁵ √ DATUM E	PROFILOMETER	QA		J-1152	65RA	711-J.DA 12-16-06		A
3* (340)	G1	 DATUM E		QA			.0187 [N/C:20917]	242-M.G 12-22-06		R
3* (350)	G3	.25± .01 DATUM E		QA			ACCEPT	242-M.G 12-22-06		A
3* (360)		 DATUM D		QA			.0277 [N/C:20917]	242-M.G 12-22-06		R
3* (370)	E2	.25± .01 DATUM D		QA			ACCEPT	242-M.G 12-22-06		A
3* (380)	E2	¹²⁵ √ DATUM D	PROFILOMETER	QA		J-1152	32/115	503-B.HO 12-15-06		A
3* (390)	F4	2X Ø2.50	DIAL BORE GAGE	QA		J-1401	2.472 - 2.475 [N/C: 20917]	242-M.G 12-22-06		R
3* (400)	F4	4X Ø1.0 -8UNC ▽2.5	THREAD PLUG GAGE	QA		A-666	ACCEPT	503-B.HO 12-15-06		A
3* (410)	F4	1.72	SCALE	QA		J-922	1.72	503-B.HO 12-15-06		A
3* (420)	D5	8X Ø1-8UNC ▽ 1.5	THREAD PLUG GAGE	QA		A-666	ACCEPT	503-B.HO 12-15-06		A
3* (430)	B7	4X 1-8UNC ▽ 2.5	THREAD PLUG GAGE	QA		A-666	ACCEPT	503-B.HO 12-15-06		A
3* (440)	C1	1.50	CMM	QA		00064	SEE IGES	339-E.RO 12-18-06		A
3*	C1		CMM	QA		00064	SEE IGES	339-E.RO		A

INSPECTION DATA CHECKLIST

(450)		3.00						12-18-06		
3* (460)	C1	4X Ø 1-8UNC ▽ 2.1	THREAD PLUG GAGE	QA		A-666	ACCEPT	503-B.HO 12-15-06		A
3* (470)	C1	4.50	CMM	QA		00064	SEE IGES	339-E.RO 12-18-06		A
3* (480)	B1	9.00	CMM	QA		00064	SEE IGES	339-E.RO 12-18-06		A
4* (500)	H6	Ø1.375-6UNC THRU OR Ø1.375-6UNC X ▽1.5 MIN FOR FLANGE THK GREATER THAN 1.5	THREAD PLUG GAGE	QA		A-735	ACCEPT	503-B.HO 12-15-06		A
4* (510)	E6	14X Ø1.885 ± .003 THRU	CALIPER	QA		J-1389	1.884-1.887"	711-J.DA 12-16-06		A
4* (520)	E6	14X └┐Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP	CALIPER	QA		P-2056	2.995	503-B.HO 12-15-06		A
4* (530)	E6	Φ .06 M A D 14 X Ø1.885	CMM	QA		00064	.034 TO .060 (ALL D HOLES)	242-M.G 12-22-06		A
4* (540)	D6	10X Ø1.885 ± .003 THRU	CALIPER	QA		J-1389	1.884-1.887"	711-J.DA 12-16-06		A
4* (550)	D6	10X └┐Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP	CALIPER	QA		P-2056	2.995	503-B.HO 12-15-06		A
4* (560)	D6	Φ .06 M A D 10 X Ø1.885	CMM	QA		00064	.034 TO .060 (ALL D HOLES)	242-M.G 12-22-06		A
4* (580)	C7	3X └┐Ø2.000 - 2.001 ▽ .990 - 1.000	CALIPER	QA		J-96	2.000-2.001X.998	503-B.HO 12-15-06		A
4* (590)	C7	Φ Ø.06 M A D 3X Ø1.130	CMM	QA		00064	.034 TO .060 (ALL D HOLES)	242-M.G 12-22-06		A

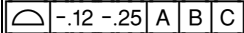
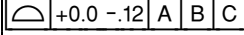
INSPECTION DATA CHECKLIST

4* (600)	D4	Ø1.375-6UNC THRU OR Ø1.375-6UNC X 1.5 MIN FOR FLANGE THK GREATER 1.5	THREAD PLUG GAGE	QA		A-375	ACCEPT	503-B.HO 12-15-06			A
4* (610)	D4	Φ .06 M A D Ø1.375-6UNC	CMM	QA		00064	.034 TO .060 (ALL D HOLES)	242-M.G 12-22-06			A
4* (620)	E2	10X .25-20UNC-2B	THREAD PLUG GAGE	QA		A-235	ACCEPT	503-B.HO 12-15-06			A
4* (630)	E2	Ø.03 X 45° CHAMFER		QA		VISUAL	ACCEPT	503-B.HO 12-15-06			A
5* (640)	F7	12X .25-20UNC-2B	THREAD PLUG GAGE	QA		A-728	ACCEPT	242-M.G 12-16-06			A
5* (650)	F7	Ø.03 X 45° CHAMFER	SCALE	QA		P-3385	ACCEPT	242-M.G 12-16-06			A
5* (660)	G6	3X 1.0	CALIPER	QA		J-96	.998-.1001	503-B.HO 12-15-06			A
5* (670)	G6	3X Ø3.00		QA			2.996-2.998	242-M.G 12-16-06			A
5* (680)	G6	3X Ø1.50	CALIPER	QA		J-1103	1.512	242-M.G 12-16-06			A
5* (690)	E3	12XØ1.375-6UNC THRU OR Ø1.375-6UNC X ∇1.5 MIN FOR FLANGE THK GREATER THAN 1.5	THREAD PLUG GAGE	QA		A-375	ACCEPT	242-M.G 12-16-06			A
5* (700)	E3	Φ .06 N A E 12X Ø1.375-6	CMM	QA		00064	.001 TO .0452 (ALL DATUM E HOLES)	242-M.G 12-22-06			A
5* (710)	D4	14XØ1.375-6UNC THRU OR Ø1.375-6UNC X ∇1.5 MIN FOR FLANGE THK GREATER THAN 1.5	THREAD PLUG GAGE	QA		A-375	ACCEPT	242-M.G 12-16-06			A
5* (720)	D4	Φ .06 N A E 14X Ø1.375-6	CMM	QA		00064	.001 TO .0452 (ALL DATUM E HOLES)	242-M.G 12-22-06			A
5*	E3	3X Ø1.885 ±.003 THRU	CALIPER	QA		J-707	1.886 (1 HOLE HAS N ON-CLEANUP UP TO 1.	242-M.G			R

INSPECTION DATA CHECKLIST

(730)							902") [N/C:20917]	12-16-06		
5*	E3	3X $\perp$ Ø3.00 SPOTFACE BACKSIDE MINIMUM CLEAN UP	CALIPER	QA		P-2056	3.002	503-B.HO		A
(740)								12-15-06		
5*	E3	Φ .06 N A E 3X Ø1.885	CMM	QA		00064	.001 TO .0452 (ALL DATUM E HOLES)	242-M.G 12-22-06		A
(750)										
6*	G7		CMM	QA		00064	SEE IGES	339-E.RO 12-18-06		A
(760)		5.00								
6*	H7		CMM	QA		00064	SEE IGES	339-E.RO 12-18-06		A
(770)		5.00								
6*	H6		CMM	QA		00064	SEE IGES	339-E.RO 12-18-06		A
(780)		5.00								
6*	C6		CMM	QA		00064	SEE IGES	339-E.RO 12-18-06		A
(790)		6.00								
6*	C6		CMM	QA		00064	SEE IGES	339-E.RO 12-18-06		A
(800)		5.00								
6*	F6		PIN GAGE	QA		J-921	ACCEPT	242-M.G 12-16-06		
(810)		4X Ø1.00								
6*	F7		CMM	QA		00064	SEE IGES	339-E.RO 12-18-06		A
(820)		6.50								
6*	F6		CMM	QA		00064	SEE IGES	339-E.RO 12-18-06		A
(830)		2.00								
6*	H5		SCALE	QA		P-3385	1.10 - 1.16 [N/C:20 917]	242-M.G 12-16-06		R
(840)		2X .88/1.13								
6*	C5	2.250 ± .010	CALIPER	QA		J-1103	2.255	242-M.G 12-16-06		A
(850)										
6*	F4	.06 - .09 × 45°	SCALE	QA		P-3385	ACCEPT	242-M.G 12-16-06		A
(860)										
7*	C4		CALIPER	QA		J-96	1.56-1.558	242-M.G 12-16-06		A
(880)		2X 1.56								
7*	C4		CALIPER	QA		J-1103	5.192	242-M.G 12-16-06		A
(890)		5.190								
7*	C3	6X .375-16UNC-2B TAP ∇ .75	THREAD PLUG GAGE	QA		A-47	ACCEPT	503-B.HO		A

INSPECTION DATA CHECKLIST

(900)		.03 X 45° CHAMFER						12-15-06			
7* (910)	B3	3.75	CMM	QA		00064	SEE IGES	339-E.RO 12-18-06			A
7* (920)	B3	7.50	CALIPER	QA		J-1103	7.502	242-M.G 12-16-06			
8* (930)	C5	4X Ø1.0 THRU	CALIPER	QA		J-96	.998-1.003	503-B.HO 12-15-06			A
9* (940)	C7	2X Ø.50 THRU	CALIPER	QA		J-96	.498-.502	503-B.HO 12-15-06			A
9* (950)	F4	10.15	CMM	QA		00064	SEE IGES	339-E.RO 12-18-06			A
9* (960)	F4	1.63	SCALE	QA		P-3385	1.62	242-M.G 12-16-06			A
9* (970)	D4	Ø.25 ▽5.0 └┐Ø.625 ▽3.0	PIN GAGE CALIPER	QA		J-652-1 J-707	ACCEPT BOTH DEPTH A ND DIAMETER	242-M.G 12-16-06			A
9* (980)	E2	Ø.25 └┐Ø.625 DETAIL D	CALIPER	QA		P-2056	.249 /.627	242-M.G 12-16-06			A
9* (990)	F2	4X Ø1.0 THRU	CALIPER	QA		J-96	1.00/1.003	503-B.HO 12-15-06			A
11* (1010)	E5	 AS CAST SURFACES	CMM	QA		00064	-.169 TO .170	242-M.G 12-22-06			A
11* (1020)	C8	 WING SURFACES	CMM	QA		00064	-.115 - .158 [N/C:2 0917]	242-M.G 12-22-06			R
11* (1030)	D1	 WING POCKET	CMM	QA		00064	-.004 - .055	242-M.G 12-22-06			A
Drawing ID: ECN-5185 Rev: NONE			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
2* (1040)		VERIFY 9.00" +/- .05" CLEARANCE	SCALE	QA		J-922	9.00	242-M.G 12-16-06			A
*		VERIFY CLEARANCE ABOVE SPOTFACE	OD MICROMETER	QA		J-21	ACCEPT	242-M.G			A



Major

Tool & Machine, Inc.

INSPECTION DATA CHECKLIST

Page: 9

Date: 01/05/07

User ID: GRIFFIT#

(1050)	3" DIAMTER CYLINDER 3" HIGH 1/4" BLEND IN RADIUS WERE APPLICABLE.	SCALE			P-3385			12-16-06		
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INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-115 - Item: 9

Workorder: 65708/3-0 Sub:1 Op:136

Part: SE141-115 - MODULAR COIL, TYPE B -

Drawing ID: SE141-115 Rev: 9			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	<1.02 AT SPECIFIED AREA	854-R.UP		
(10)								12-16-06		
*		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	<1.02 AT SPECIFIED AREA	854-R.UP		
(20)								12-16-06		

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INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-139 - Item: 20

Workorder: 65708/3-0 Sub:11 Op:30

Part: SE141-139 - SHORT BEARING PLATE TYPE "B" -

Drawing ID: SE141-139 Rev: 1			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1* (10)	G2	RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1270	LESS THAN 1.02	854-R.UP 07-09-06		

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INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-140 - Item: 23

Workorder: 65708/3-0 Sub:12 Op:30

Part: SE141-140 - LONG BEARING PLATE TYPE "B" -

Drawing ID: SE141-140 Rev: 1			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1* (10)	G2	RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	854-R.UP 07-16-06		

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Employees: 242-M.Griffith / 339-E.Root / 503-B.Houk / 711-J.Davis / 825-B.Jarrett / 854-R.Upchurch

Phil Heitzenroeder

From: Williamson, David E. [williamsonde@ornl.gov]
Sent: Thursday, January 04, 2007 10:27 AM
To: Phil Heitzenroeder; Frank A. Malinowski
Cc: Thomas G. Brown
Subject: B3 IDC review

Phil, Frank,
 Here are my notes on the B3 IDC:

MCWF	DWG	# REJECT
B1	SE141-115-R9	24
B2	same rev	22
B3	same rev	18

Rejects that are new in B3: VPI groove distance from winding surface and edge chamfer, VV support thru hole diam

Rejects that are corrected in B3: flange hole positions better than B2

STEP	B1	B2	B3	Description	Comments
10					
20					
30					
40					
50					
60	x				
70					
80	x				
90	x	x	x	outer as-cast profile	ok, see Tom vgs
100			x	vpi edge chamfer	visual ok?
110			x	dist from wind surf to groove	ok, ~.1 max oot
120			x	vpi edge chamfer	visual ok?
130	x				
140	x		x	depth of vpi groove	ok
150	x	x	x	profile m-m1	ok, see vgs
160	x	x	x	gage clearance	holes 68-70 are new, others same
170	x	x	x	profile below vpi groove	similar to B1,B2
180					
190	x	x	x	profile n-n1	ok, see vgs
200	x	x	x	gage clearance	same areas as B2
210	x		x	profile below vpi groove	similar to B1,B2
220	x				
230					
240		x			
250		x			
260	x	x	x	tee hole pos	similar to B1, B2
270					
280					
290					
300					
310					

320					
330					
340	x	x	x	flatness, datum-e	comparable to B1, better than B2
350	x				
360	x	x	x	flatness, datum-d	
370	x				
380					
390			x	vac ves support thru hole	ok, clearance hole
400					
410					
420					
430					
440					
450					
460					
470					
480					
500					
510		x			
520					
530					
540		x			
550					
560		x			
580	x	x			
590		x			
600					
610		x			
620					
630		x			
640					
650		x			
660					
670					
680		x			
690					
700					
710					
720					
730			x	flange hole diam	ok
740					
750					
760					
770					
780					
790					
800					
810					
820					
830					
840		x	x	pol break flange thk	ok
850					
860					

870x				
880x	x			
890				
900	x			
910				
920				
930				
940				
950				
960				
970				
980				
990				
1000x				
1010x	x			
1020x		x	profile wing surfs	see Tom vgs
1030x				