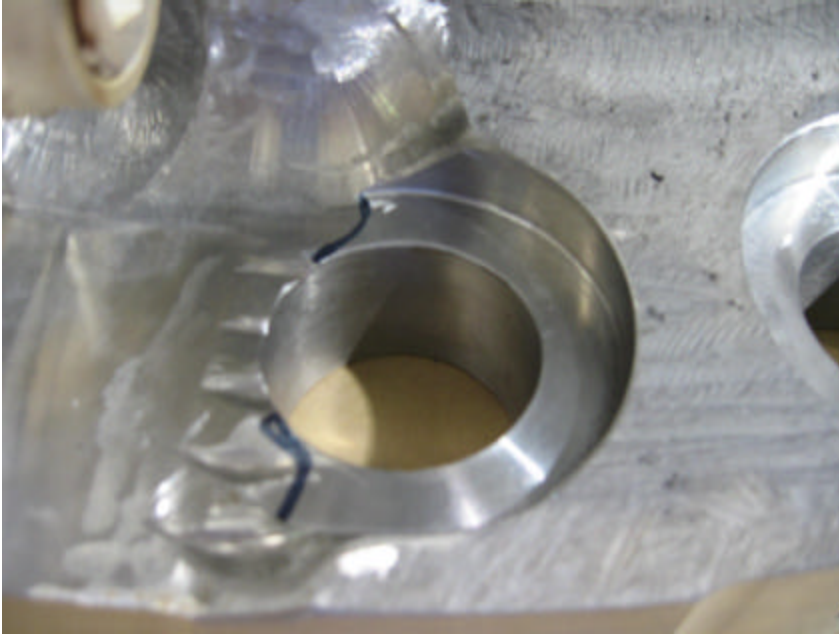


Miscellaneous Machining and Casting Issues



Counterbore adjacent to Poloidal Break on E Flange.JPG

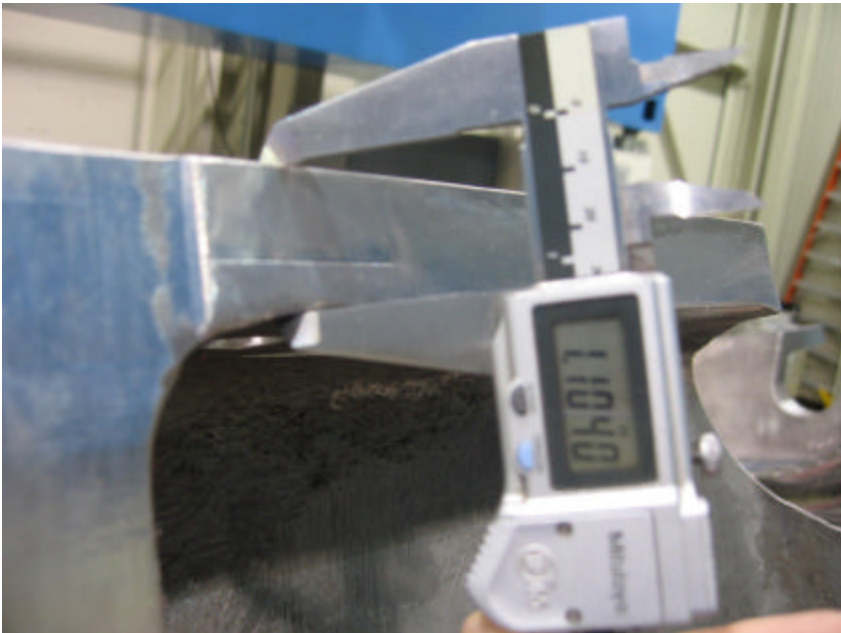
Counterbore is next to Poloidal Break on the E flange. Approximately 60% of counterbore cleaned up 100%. The area of non cleanup has tooling gouges and is approximately .050" in depth.

Miscellaneous Machining and Casting Issues



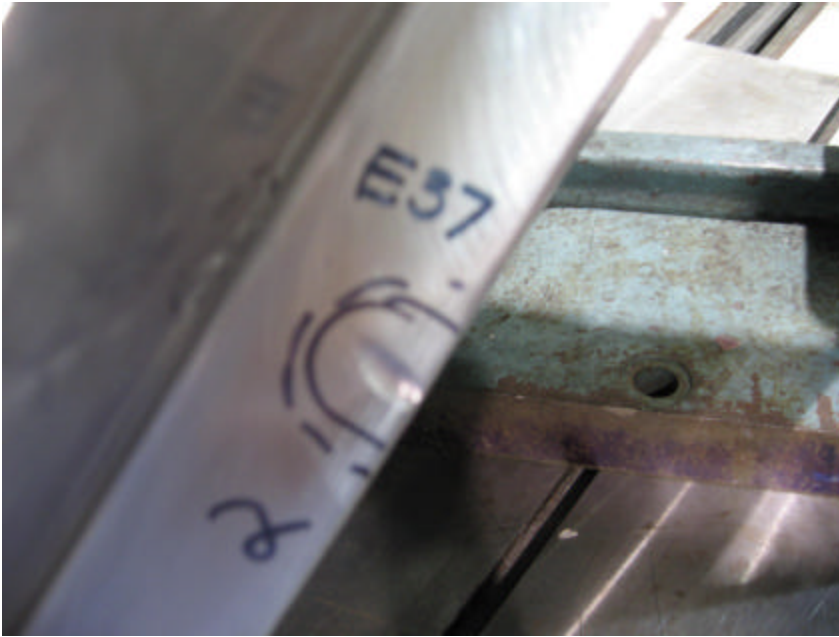
Noncleanup of foot on back side of D flange.JPG

This area is beneath the leg shown on sheet 4, zone C5. Instead of the 2.38" spot face on the back side, we typically machine this entire surface to a full cleanup. The two holes in this view do not have a 100% cleanup. The photo below shows that the flange thickness in this area is approximately 1.100" in the thinnest cross section.



D flange foot thickness of 1.100.JPG

Miscellaneous Machining and Casting Issues



Tool Gouge short leg E37 wide view.JPG

This is a tooling gouge on the short leg of the “T” on the E flange side located close to hole 37. The gouge is approximately .590” in length by .200” wide and .005” in depth.



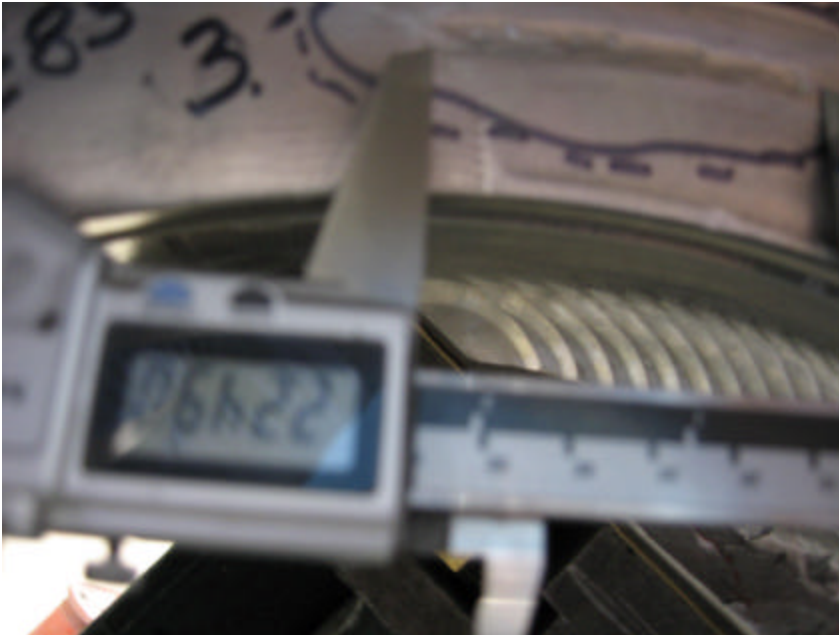
Tool Gouge short leg E side adjacent to hole 37.JPG

Miscellaneous Machining and Casting Issues



Tooling Gouge short leg E83 wide veiw.JPG

This is a tooling gouge on the short leg of the "T" on the E flange side located close to hole 83. The gouge is approximately 2.200" in length by .200" wide and .008" in depth.



Tooling Gouge short leg E side adjacnet to hole 83.JPG

Miscellaneous Machining and Casting Issues



Tool Gouge short leg E side adjacent to hole 57.JPG

This is a tooling gouge on the short leg of the “T” on the E flange side located close to hole 57. The gouge is approximately .800” in length by .200” wide and .010” in depth.



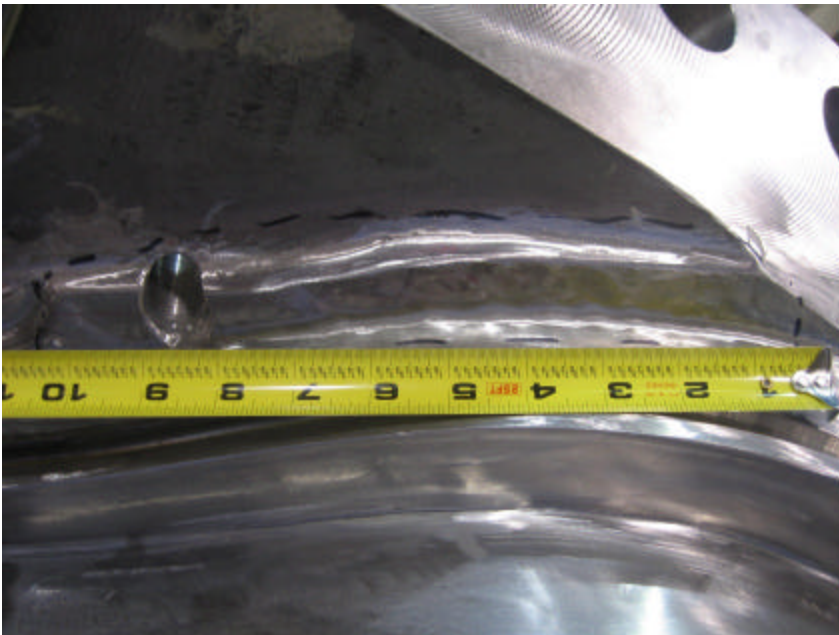
Tool Gouge short leg E57 wide view.JPG

Miscellaneous Machining and Casting Issues



D side interference below VPI groove location 1.JPG

These pictures show the interference below the VPI groove located adjacent to poloidal break on the D side from hole 11 to 13. The interference to the gage is approximately .100" - .200" over a length of about 10".



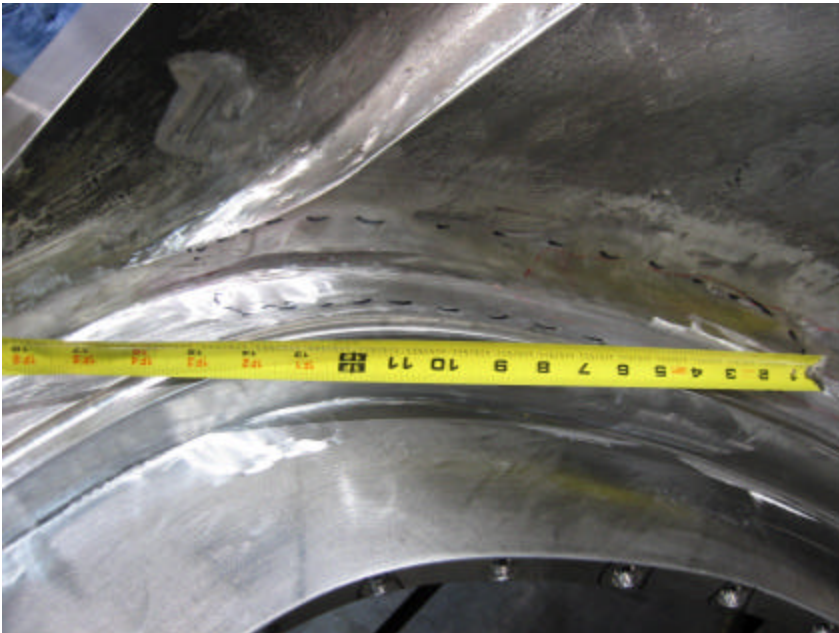
D side interference below VPI groove location 1 wide view.JPG

Miscellaneous Machining and Casting Issues



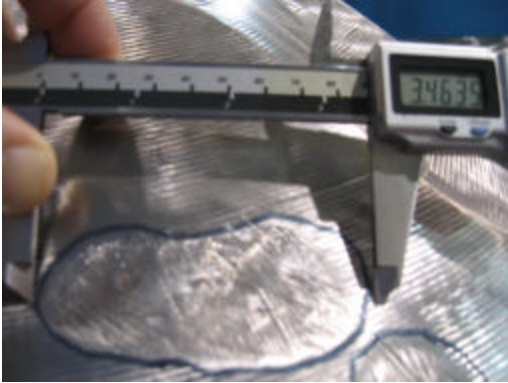
D side interference below VPI groove location 2.JPG

These pictures show the interference below the VPI groove located on the D side from hole 45 to 50. The interference to the gage is approximately .200" - .300" over a length of about 15".



D side interference below VPI groove location 2 wide view.JPG

Miscellaneous Machining and Casting Issues



Casting noncleanup on D side large wing.JPG



Casting noncleanup on D side large wing 2.JPG

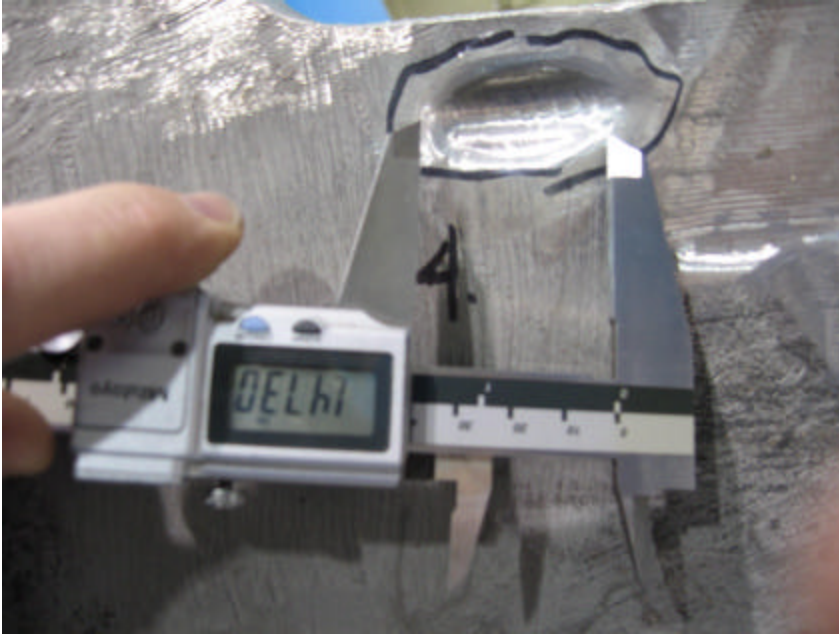


Casting noncleanup D side large wing wide view.JPG

The above pictures show noncleanup after final machining on the large flange of the D side. The depths are approximately .02 - .04".



Miscellaneous Machining and Casting Issues



Tool Gouge in cast wall D side section PT11 sheet 7.JPG

This photo shows a tooling gouge in the cast wall located below the 6.5" opening shown on sheet 7 section view PT11. Gouge is approximately 1.470" x .800. The casting wall in this area measures 1.3". The gouge is approximately .25" in depth.