

INSPECTION DATA CHECKLIST

C4

Workorder: 65707/4-0 Sub:1 Op:132

Revision: 03/24/06 14:27

Part: SE141-116 - MODULAR COIL WINDING FORM TYPE-C - PRODUCTION MODULAR COIL WINDING FORM TYPE-C








| Drawing ID: SE141-116 Rev: 8 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | |
|------------------------------|------|---|-------------------------|----|--------|------------|------------------------------------|----------------------|-------|-------|
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT |
| 1* (10) | E8 | 47.19 ± .03 | CMM | QA | | 00064 | 47.169 | 339-E.RO 03-24-06 | | |
| 1* (20) | B8 | 47.19 ± .03 | CMM | QA | | 00064 | 47.169 | 339-E.RO 03-24-06 | | |
| 1* (30) | D6 | 47.19 ± .03 | CMM | QA | | 00064 | 47.169 | 339-E.RO 03-24-06 | | |
| 1* (40) | C6 | 47.19 ± .03 | CMM | QA | | 00064 | 47.169 | 339-E.RO 03-24-06 | | |
| 1* (50) | E6 | <div><div>//</div><div>.02</div><div>A</div></div> | CMM | QA | | 00064 | ACCEPT | 339-E.RO 03-24-06 | | |
| 1* (60) | B6 | <div><div>//</div><div>.02</div><div>A</div></div> | CMM | QA | | 00064 | ACCEPT | 339-E.RO 03-24-06 | | |
| 2* (80) | H6 | 2X R.187 +.025 -.005 | PIN GAGE | QA | | J-652 | ACCEPT | 339-E.RO 03-24-06 | | |
| 2* (90) | G8 | 2X .03 X 45° | | QA | | VISUAL | ACCEPT | 339-E.RO 03-24-06 | | |
| 2* (100) | G8 | .40 ± .010 | CALIPER | QA | | J-707 | .39 TO .41 | 339-E.RO 03-24-06 | | |
| 2* (110) | G8 | 2X .030 X 45° | | QA | | VISUAL | ACCEPT | 339-E.RO 03-24-06 | | |
| 2* (120) | F7 | 2X .32 | CALIPER | QA | | J-707 | .315 TO .330 | 339-E.RO 03-24-06 | | |
| 2* (130) | F7 | 2X R.11 | RADIUS GAGE | QA | | R-21 | 0.10 | 339-E.RO 03-24-06 | | |
| 2* (140) | G6 | <div><div><div><div></div></div></div><div>.2</div><div>R</div><div>S</div><div>T</div></div> <div>P TO M</div> | CMM | QA | | 00064 | -0.062 TO .079 | 339-E.RO 03-24-06 | | |
| 2* | G6 | 4.790 OR SHELL INTERSECT. | | QA | | MTMFX-3473 | ACCEPT (AREAS OF CONCERN REPORTED) | 242-M.G | | |

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C4

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|---------------------------------------|---------|---|-------------------------|----|--------|--------------------|---|----------------------|-------|-------|--------|
| (150) | | VERIFY USING TEMPLATE PER DRAWING NOTE 16 (MTMFX-3473) | | | | | | 03-24-06 | | | * |
| 2* (160) | G3 |  .2 R S T Q TO N | CMM | QA | | 00064 | -.009 TO .097 | 339-E.RO 03-24-06 | | | A * |
| 2* (170) | G3 | 4.790 OR SHELL INTERSECT. VERIFY USING TEMPLATE PER DRAWING NOTE 16 (MTMFX-3473) | | QA | | MTMFX-3473 | ACCEPT | 339-E.RO 03-24-06 | | | A * |
| 2* (180) | E6 |  .02 R S T M TO MI | CMM | QA | | 00064 | -.022 TO .029 | 339-E.RO 03-24-06 | | | A * |
| 2* (182) | F3 |  .02 R S T N TO NI | CMM | QA | | 00064 | -.019 TO .023 | 339-E.RO 03-24-06 | | | A * |
| 2* (185) | E5 |  .1 R S T MI TO NI | CMM | QA | | 00064 | -.019 TO .028 | 339-E.RO 03-24-06 | | | A * |
| 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* (188) | 3.1.1.4 | ¹²⁵ THE TWO "L" MACHINED SURFACES OF TEE. | PROFILOMETER | QA | | J-1152 | ACCEPT | 339-E.RO 03-24-06 | | | A * |
| Drawing ID: SE141-116 Rev: 8 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 2* (190) | B5 |  .06 R S T 96X .375-16 UNC .750 DEEP .625 C'BORE .188 DEEP | CMM CALIPER | QA | 50% | 00064 J-707 | .005 TO .040 / .75 / .625 / .187 TO .1 88 | 339-E.RO 03-24-06 | | | A * |
| 2* (195) | B5 | .375-16 UNC .750 DEEP GAGE 100% OF THE HOLES AND VERIFY CLEANLINESS. | THREAD PLUG GAGE | QA | 100% | A-443 | ACCEPT | 339-E.RO 03-24-06 | | | A * |
| 2* (200) | B4 | 2X .06-.09 X 45° | | QA | | VISUAL | CHAMFER NOT PRESEN - RADIUS | 339-E.RO 03-24-06 | | | R * |
| 3* (210) | G7 |  .01 A B C 8X Ø1-8 UNC THRU | CMM THREAD PLUG GAGE | QA | | 00064 A-347 | ACCEPT | 242-M.G 03-24-06 | | | A * |
| 3* | H3 |  .01 | CMM | QA | | 00064 | .020 | 339-E.RO | | | R |

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C4

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|-------------|----|--|-------------------|----|--|----------------|--|----------------------|--|--------|
| (230) | | DATUM -E- FLANGE | | | | | | 03-24-06 | | * |
| 3* (240) | H4 | $\sqrt{125}$ DATUM -E- FLANGE | PROFILOMETER | QA | | J-1152 | 41 TO 70 | 339-E.RO 03-24-06 | | A * |
| 3* (250) | F3 | $\square .01$ DATUM -D- FLANGE | CMM | QA | | 00064 | .025 | 339-E.RO 03-24-06 | | R * |
| 3* (260) | F3 | $\sqrt{125}$ DATUM -D- FLANGE | PROFILOMETER | QA | | J-1152 | 44 TO 76 | 339-E.RO 03-24-06 | | A * |
| 3* (280) | E4 | $\Phi .01$ A B C 8X Ø1.13 THRU BACK SPOT FACE Ø2.38 MIN DEPTH FOR C'UP | CMM | QA | | 00064 | .005 TO .067 / ACCE PT SPOT / 1.125 - 1 .129 | 339-E.RO 03-24-06 | | R * |
| 4* (290) | H8 | $\Phi .060$ D A N 3X Ø1.885 THRU | CMM | QA | | 00064 | .026 - .033 | 339-E.RO 03-24-06 | | A * |
| 4* (291) | H8 | 3X Ø1.885 +/- .003 Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP | CMM | QA | | 00064 | ACCEPT SPOT / 1.88 4 - 1.888 | 339-E.RO 03-24-06 | | A * |
| 4* (300) | H7 | $\Phi \varnothing .06$ D A N 3X 2.000" COUNTERBORE 1.00 DP | CMM CALIPER | QA | | 00064 J-707 | .010 TO .014 / .99 DEEP | 339-E.RO 03-24-06 | | A * |
| 4* (305) | H7 | $\varnothing \square$ 2.000 - 2.001 | MICROMETER - INTE | QA | | J-999 | 2.000 TO 2.001 | 339-E.RO 03-24-06 | | A * |
| 4* (310) | H6 | $\Phi \varnothing .060$ D A N 17X Ø1.885 THRU | CMM | QA | | 00064 | 1.882 - 1.887 | 339-E.RO 03-24-06 | | A * |
| 4* (311) | H6 | 3X Ø1.885 +/- .003 THRU Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP | CMM | QA | | 00064 | SEE 290 / ACCEPT SP OT | 339-E.RO 03-24-06 | | A * |
| 4* (320) | H5 | $\Phi \varnothing .060$ D A N 3X Ø1.13 | CMM | QA | | 00064 | .029 TO .067 | 339-E.RO 03-24-06 | | R * |
| 4* (321) | H5 | 3X Ø1.13 +/- .010 Ø2.38 BACK SPOTFACE VERIFY MIN CLEANUP | CMM CALIPER | QA | | 00064 J-707 | SEE 280 / ACCEPT SP OT | 339-E.RO 03-24-06 | | A * |

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C4

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|-------------|----|--|------------------|----|--|---------------------|---------------------------|----------------------|--|--------|
| 4* (340) | E6 | Φ .060 D A N 3X Ø1.375-6 UNC THRU | CMM | QA | | 00064 | .0068 TO .027 | 339-E.RO 03-24-06 | | A * |
| 4* (350) | E6 | Φ .060 D A N 5X Ø1.885 THRU | CMM | QA | | 00064 | .0036 TO .017 | 339-E.RO 03-24-06 | | A * |
| 4* (351) | E6 | 5X Ø1.885 +/- .003 THRU Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP | CMM | QA | | 00064 MTMFX-3564 | SEE 290 / ACCEPT SP OT | 339-E.RO 03-24-06 | | A * |
| 4* (360) | D4 | Φ .060 D A N Ø1.885 THRU | CMM | QA | | 00064 | .021 | 339-E.RO 03-24-06 | | A * |
| 4* (361) | D4 | Ø1.885 +/- .003 THRU Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP | CMM | QA | | 00064 MTMFX-3564 | SEE 290 / ACCEPT SP OT | 339-E.RO 03-24-06 | | A * |
| 4* (370) | B5 | Φ .060 D A N 3X Ø1.13 | CMM | QA | | 00064 | .0054 TO .017 | 339-E.RO 03-24-06 | | A * |
| 4* (371) | B5 | 3X Ø1.13 +/- .010 Ø2.38 BACK SPOTFACE VERIFY MIN CLEANUP | CMM CALIPER | QA | | 00064 J-707 | SEE 280 / ACCEPT SP OT | 339-E.RO 03-24-06 | | A * |
| 4* (375) | D1 | 12X .25-20 UNC -2B | THREAD PLUG GAGE | QA | | A-234 | ACCEPT | 339-E.RO 03-24-06 | | A * |
| 4* (376) | G8 | Φ .06 D A N 12X .25-20 UNC -2B SUMMARY OF HOLE POSITIONS. ACTUAL FEATURE CONTROL FRAME IS NOT ON DRAWING. | CMM | QA | | 00064 | .004 - .067 | 339-E.RO 03-24-06 | | R * |
| 5* (380) | E8 | Φ .060 E A J Ø1.885 THRU | CMM | QA | | 00064 | .020 | 339-E.RO 03-24-06 | | A * |
| 5* (381) | E8 | Ø1.885 +/- .003 THRU Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP | CMM | QA | | 00064 MTMFX-3564 | SEE 380 / ACCEPT SP OT | 339-E.RO 03-24-06 | | A * |
| 5* (400) | F6 | Φ .060 E A J 3X Ø1.375-6 UNC THRU | CMM | QA | | 00064 | .0094 TO .026 | 339-E.RO 03-24-06 | | A * |

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|-------------|----|---|-------------------|----|--|---------------------|---|----------------------|--|--------|
| 5* (410) | F6 | Φ .06 E A J 3X 2.000" COUNTERBORE 1.00 DP | CMM CALIPER | QA | | 00064 J-707 | .013 TO .028 / .99 DP | 339-E.RO 03-24-06 | | A * |
| 5* (412) | F6 | Φ 2.000 - 2.001 | MICROMETER - INTE | QA | | J-999 | 2.0000 - 2.0001 | 339-E.RO 03-24-06 | | A * |
| 5* (415) | F7 | 7X 1/4-20 UNC -2B | THREAD PLUG GAGE | QA | | A-234 | ACCEPT | 339-E.RO 03-24-06 | | A * |
| 5* (420) | F7 | Φ .06 E A J 7X 1/4-20 UNC -2B SUMMARY OF HOLE POSITIONS. ACTUAL FEATURE CONTROL FRAME IS NOT ON DRAWING. | CMM | QA | | 00064 | .010 - .039 | 339-E.RO 03-24-06 | | A * |
| 5* (430) | E7 | Φ .060 E A J 24X Ø1.885 THRU | CMM | QA | | 00064 | .013 TO .028 | 339-E.RO 03-24-06 | | A * |
| 5* (431) | E7 | 24X Ø1.885 +/- .003 THRU Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP | CMM | QA | | 00064 MTMFX-3564 | 1.884 - 1.888 / ACC EPT SPOT | 339-E.RO 03-24-06 | | A * |
| 5* (440) | E7 | Φ .060 E A J 3X Ø1.5 TO 2.00 DEEP Ø3.00 TO 1.00 DEEP | CMM | QA | | 00064 | .008 - .012 / 1.5 / 1.99 DP | 339-E.RO 03-24-06 | | A * |
| 5* (450) | D7 | 3X Ø1.885 +/- .003 THRU Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP | CMM | QA | | 00064 MTMFX-3564 | 1.887 - 1.888 / ACC EPT | 339-E.RO 03-24-06 | | A * |
| 6* (470) | E3 | 4X Ø1.00 THRU | CMM | QA | | 00064 | 1.00 - 1.002 THRU | 339-E.RO 03-24-06 | | A * |
| 8* (650) | G7 | 4.00 ± .010 | CALIPER | QA | | J-707 | 3.918 | 339-E.RO 03-24-06 | | R * |
| 8* (750) | D7 | 6X Ø.375-16 UNC TO .75 DEEP .03 X 45° CHAMFER | THREAD PLUG GAGE | QA | | A-442 VISUAL | ACCEPT / 2 AT .700 DEEP / CHAMFER ACCE PTED | 339-E.RO 03-24-06 | | R * |
| 8* (760) | D7 | 13.6 ° | | QA | | VISUAL | SEE IGES | 339-E.RO 03-24-06 | | A * |
| 8* | D7 | 5.88 | | QA | | VISUAL | ACCEPT | 339-E.RO | | A |

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C4





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|-------------|----|--|-------------|----|--|--------|---------------|----------------------|--|--------|
| (770) | | VERIFY THAT PAD MEETS THE MINIMUM OF 5.88 | | | | | | 03-24-06 | | * |
| 8* (780) | D7 | 2.19 ± .010 | | QA | | VISUAL | SEE IGES | 339-E.RO 03-24-06 | | A * |
| 8* (790) | D7 | 2.19 ± .010 | | QA | | VISUAL | SEE IGES | 339-E.RO 03-24-06 | | A * |
| 8* (830) | C8 | 2X 1.56 ± .010 THRU | CALIPER | QA | | J-707 | 1.565 | 339-E.RO 03-24-06 | | A * |
| 8* (850) | C8 | 2X 7.50 ± .010 THRU | CALIPER | QA | | J-707 | 7.506 | 339-E.RO 03-24-06 | | A * |
| 8* (860) | C8 | 8X R.25 | RADIUS GAGE | QA | | R-21 | .25 | 339-E.RO 03-24-06 | | A * |
| 8* (870) | C8 | 2X 2.52 ± .010 | | QA | | VISUAL | SEE IGES | 339-E.RO 03-24-06 | | A * |
| 9* (900) | E7 | 2.54 ± .010 | | QA | | VISUAL | SEE IGES | 339-E.RO 03-24-06 | | A * |
| 9* (910) | E7 | 5.08 ± .010 | | QA | | VISUAL | SEE IGES | 339-E.RO 03-24-06 | | A * |
| 9* (920) | F3 | 4X Ø1.0 THRU VERIFY THAT HOLES BREAK COMPLETELY THROUGH INSIDE OF CASTING | CALIPER | QA | | J-707 | 1.00 THRU | 339-E.RO 03-24-06 | | A * |
| 9* (930) | F3 | 2X Ø .50 ± .010 THRU | CALIPER | QA | | J-707 | .50 | 339-E.RO 03-24-06 | | A * |
| 9* (940) | E3 | 2.44 ± .010 | CALIPER | QA | | J-707 | 2.46 | 339-E.RO 03-24-06 | | A * |
| 9* (950) | E3 | 1.22 ± .010 | | QA | | VISUAL | SEE IGES | 339-E.RO 03-24-06 | | A * |
| 9* (960) | C7 | 4X Ø1.0 THRU VERIFY THAT HOLES BREAK COMPLETELY THROUGH INSIDE OF CASTING | CALIPER | QA | | J-707 | 1.000 - 1.004 | 339-E.RO 03-24-06 | | A * |
| 9* | C6 | 2X Ø .25 T.C. HOLE | | QA | | | .25 / THRU | 339-E.RO | | |

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|---------------------------------------|---------|---|-------------------------|----|--------|---------|--------------|----------------------|-------|-------|--------|
| (970) | | | | | | | | 03-24-06 | | | * |
| Drawing ID: SE141-116 Rev: 7 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 10* (980) | C8 |  .125 A B C | CMM | QA | | 00064 | .017 TO .53 | 339-E.RO 03-24-06 | | | R * |
| Drawing ID: SE141-116 Rev: 8 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 10* (990) | D5 |  .5 A B C DATUM -D- SIDE INNER CAST | CMM | QA | | 00064 | -.98 TO .24 | 339-E.RO 03-24-06 | | | R * |
| Drawing ID: SE141-116 Rev: 7 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 10* (1010) | C4 |  .125 A B C DATUM -E- SIDE LARGE WING | CMM | QA | | 00064 | .011 TO .026 | 339-E.RO 03-24-06 | | | A * |
| Drawing ID: SE141-116 Rev: 8 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 10* (1030) | D1 |  .5 A B C DATUM -E- SIDE INNER CAST | CMM | QA | | 00064 | -.33 TO .59 | 339-E.RO 03-24-06 | | | R * |
| Drawing ID: SE141-116 Rev: 7 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 10* (1035) | E1 | MACHINE / GRIND THIS AREA TO PROFILE OF +.05/- .10 | CMM | QA | | 00064 | .062 - .075 | 242-M.G 03-24-06 | | | R * |
| Drawing ID: NCSX-CSPEC-141-03 Rev: 10 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 4* (1040) | 3.1.1.4 | UOS ALL MACHINED SURFACES TO BE 250 RMS SURFACE FINISH RECORD RANGE | PROFILOMETER | QA | | J-1152 | 41 - 75 | 339-E.RO 03-24-06 | | | A * |
| Drawing ID: SE141-116 Rev: 8 | | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT | |
| 1* (1040) | | NOTE 9 RECORD THE WEIGHT OF THE PART | SCALE | QA | | 2270 | 5,640 | 339-E.RO | | | A |

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|--------|-------------|--|--|--|--|--|--|----------|--|---|
| (1050) | 6000LBS MAX | | | | | | | 03-24-06 | | * |
|--------|-------------|--|--|--|--|--|--|----------|--|---|

Employees: 242-M.Griffith / 339-E.Root