

Customer: ENERGY INDUSTRIES OF OHIO

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Part: SE141-114 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-114 Revision: 6
Links: 1-Type:W: 65709/1.0 Sub: 1 Op: 50

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: A1

Reported By: MIKE GRIFFITH
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Problem: Reference sheet 4, zone G7.

There is a tool gouge along the short leg of the T section on the Datum -D- side. The gouge is approximately 13.5" long, .900" wide and .200 deep. See attachments for clarification.

Proposed Disposition:

Propose to weld repair the tool gouge. Indicators would be applied on and around the T section to monitor any part movement caused by welding. The welding process would altered as needed to minimize movement. A local mag permeability and PT inspection would be performed. This gouge is located on the short leg in the area designated as "High Stress". During the RT of the High Stress area an additional shot would be taken of the repaired area. It is likely that this RT shot would prove inconclusive due to it's location.

Number of additional pages: _____

Customer Disposition: Use As Is Rework Repair Scrap Replace

NCSX agrees with MTM's recommended disposition to weld repair, followed by local mag. perm. Inspection, PT inspection, and RT during the RT of the high stress area. MTM is requested to provide documentation after the repair is completed.

Tech. Rep.: _____ **Title:** _____ **Date:** _____

RLM: _____ **Title:** _____ **Date:** _____

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

Root Cause 1: 816-PROGRAMMING ERROR

Resource: CAD/CAM - MEDIUM MILLING Equipment:

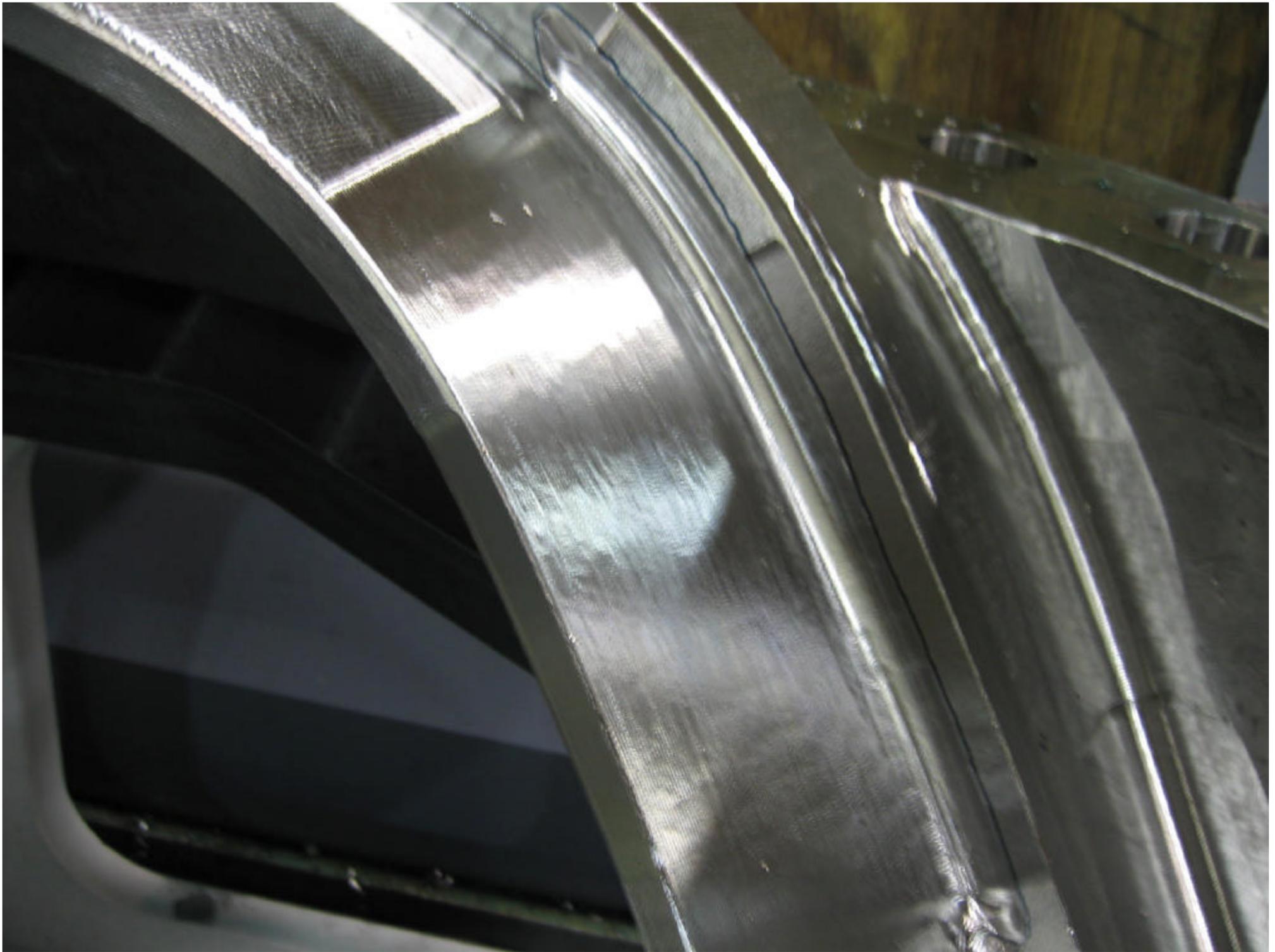
Description: There are 2 root causes here.

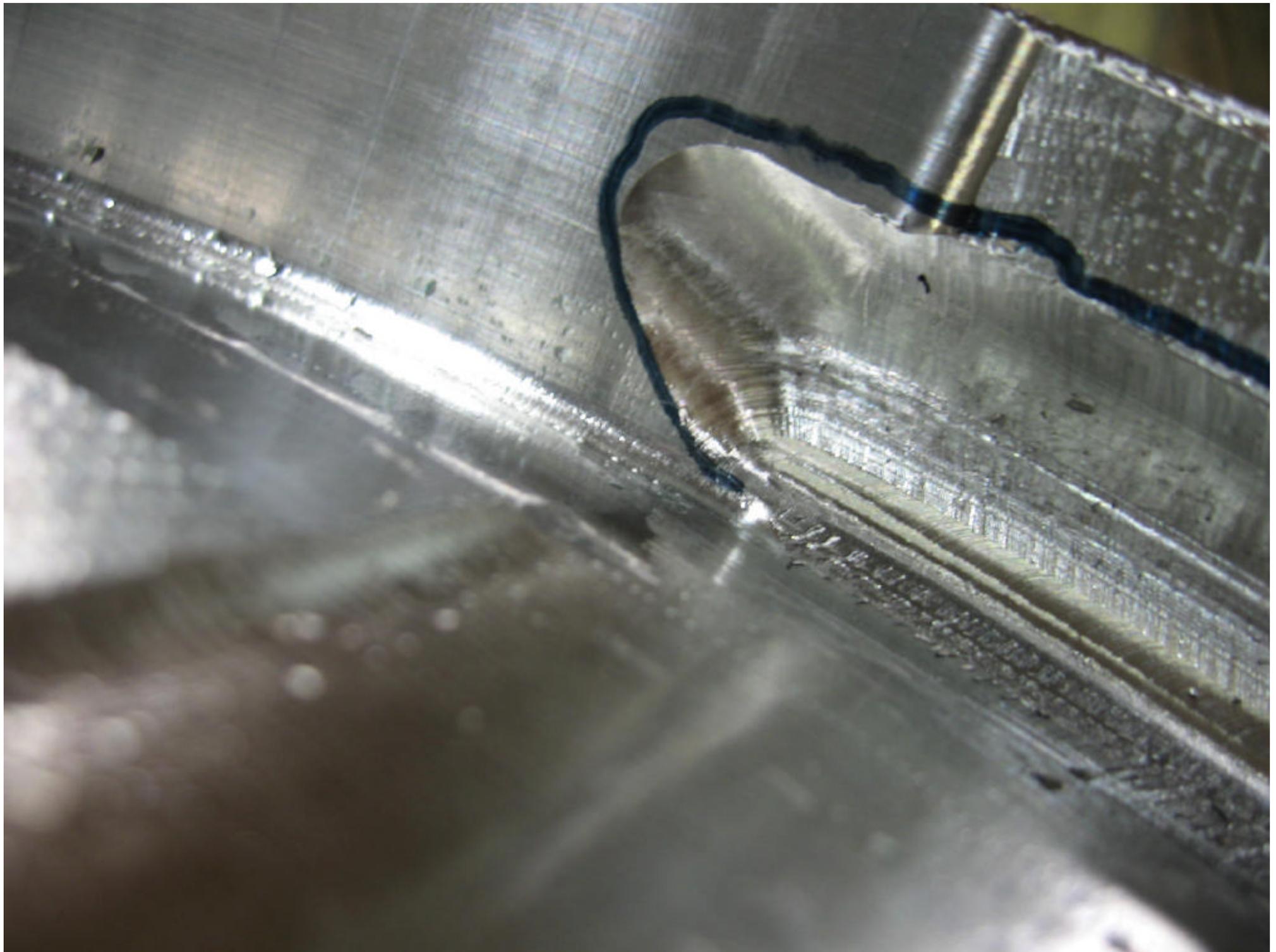
- 1) The tool gouged the wall because the toolpath was generated incorrectly. The check surface (back wall) was not selected and therefore the toolpath gouged the back wall.
- 2) The toolpath (n/c program 31501) was released as a good program because the verification did not show / flag an error of the toolpath violating the design model.

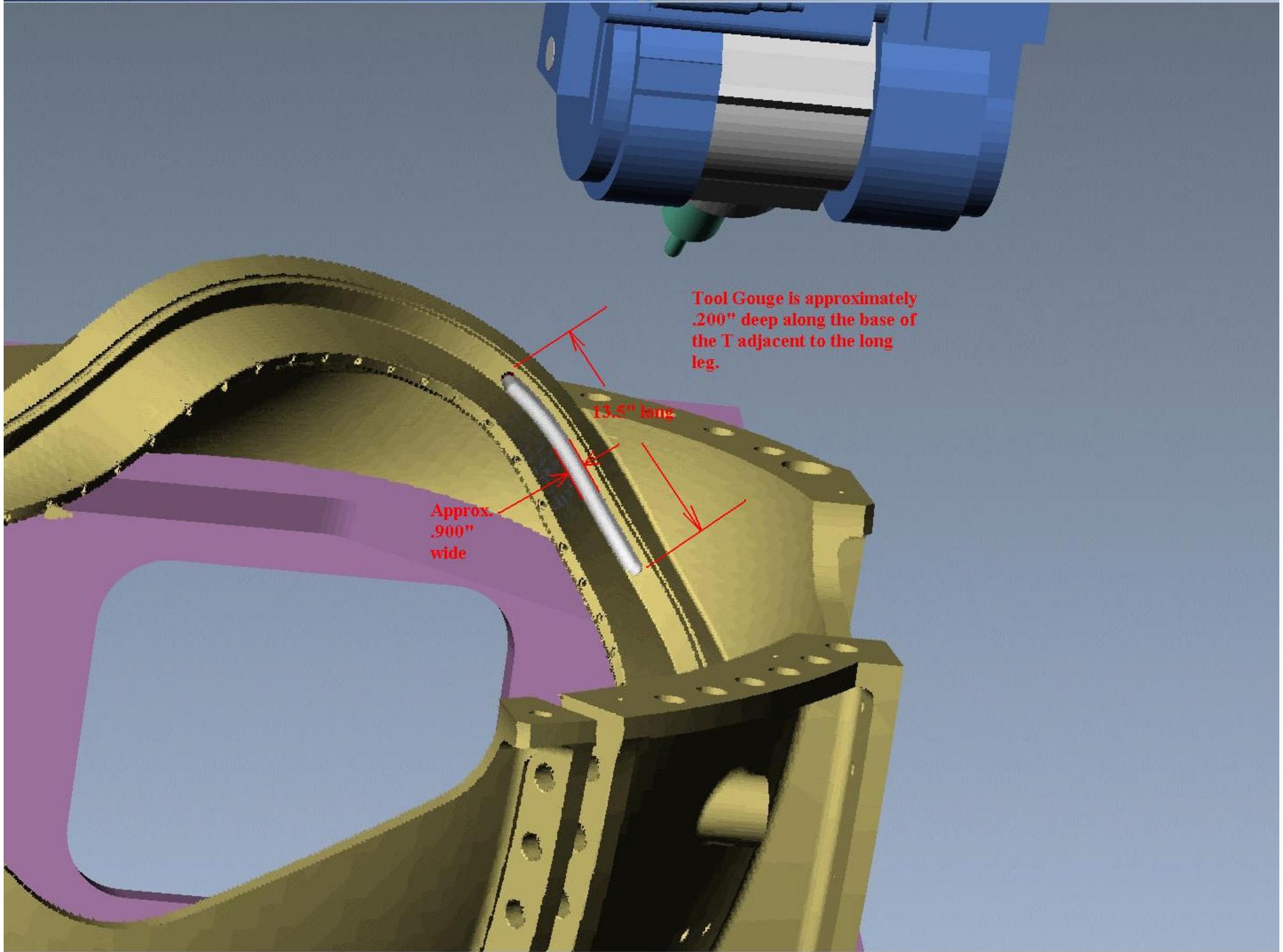
Corr Actn: 1:

Description:

Action: By:







Tool Gouge is approximately
.200" deep along the base of
the T adjacent to the long
leg.

13.5" long

Approx.
.900"
wide