

Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
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Telephone: 216-496-2314
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Part: SE141-116 /WINDING FORM TYPE -C
Drawing ID: SE141-116 Revision: 7
Links: 1-Type:W: 65707/3.0 Sub: 1 Op: 70

Customer P.O.: S005242-F/Ln:3
Serial No./Qty: C3

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

Telephone: 317-636-6433
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Problem: SHEET 2. DETAIL C; 35 OF THE 98.625 X .188 C-BORES IN THE FACE OF THE T-SECTION MEASURE
.317-.325 DEEP. (UP TO .127" OUT OF TOLERANCE).

Proposed Disposition:

RECOMMEND TO USE AS IS.

Number of additional pages: 0

Customer Disposition: Use As Is Rework Repair Scrap Replace

Requested that Major Tool mark the non-conforming holes so PPPL can find them easier.

Technical Contact Approval:

Phil
Heitzenroeder
Digitally signed by Phil Heitzenroeder
DN: cn=Phil Heitzenroeder, c=US,
o=PPPL, ou=Mech. Eng. OM&son
Reason: I agree to 'specified' portions
of this document
Date: 2006.02.10 17:39:45 -05'00'

Title: _____ **Date:** _____

RLM:

Brad
Nelson
Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US,
o=ORNL, ou=FED,
email=nelsonbe@ornl.gov
Date: 2006.02.10 17:53:07
-05'00'

Title: _____ **Date:** _____

Root Cause 1: 809-PROCESS INSTRUCTION

Resource: CAD/CAM – MEDIUM MILLING Equipment:
Description: THE COUNTERBORE TOOL IS PROGRAMMED FROM THE TIP OF THE PILOT DRILL. THE TOOL SHEET FOR THE COUNTERBORE TOOL DID NOT DEFINE A TOLERANCE FROM THE TIP OF THE PILOT TO THE COUNTERBORE CUTTING EDGE. WHEN THE TOOL WAS CHANGED OUT DURING THE MACHINING PROCESS IT WAS REPLACED BY A TOOL WITH A SHORTER PILOT. THIS RESULTED IN SEVERAL COUNTERBORES BEING MACHINED TOO DEEP.

Corrective Action 1:

Action: 02/09/06 By: 242-M.GRIFFITH

Description: THE TOOL SHEET WILL BE MODIFIED TO CLEARLY DEFINE A TOLERANCE FOR THE RELATIONSHIP BETWEEN THE TOOL TIP AND THE COUNTERBORE CUTTING EDGE. THE TOLERANCE WILL BE LESS THAN THE $\pm .010$ " REQUIRED BY THE DRAWING.