

Customer: ENERGY INDUSTRIES OF OHIO

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Part: SE141-115 / MODULAR COIL, TYPE B

Drawing ID: SE141-115 Revision: 9
W/O Links: 1-Type:W: 65708/2.0 Sub: 1

Customer P.O.: S005242-F/Ln:2
Serial No./Qty: B2

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

Telephone: 317-636-6433
Fax: 317-634-9420

Problem: Workorder: 65708/2.0 Sub:1 Op:132

Inspection Test #: 60 rejected: : {h|.02|A}: .027
Inspection Test #: 90 rejected: OUTER AS CAST SURFACES: {g|.5|A|C|B}: -.0129 TO .306
Inspection Test #: 130 rejected: 2X R.11: : .110 TO .120 E SIDE HOLE#BREAK TO 7 18-25 38-43 48-57
59-64 73-84 ARE .250R
Inspection Test #: 150 rejected: MACHINED SURFACES
M TO M1: {g|.02|R|S|T}: -.0178 TO .0251
Inspection Test #: 160 rejected: DATUM D SIDE
VERIFY SHELL INTERSECT CLEARANCE
USING GAGE MTMFX-3473: : ACCEPT IN ALL AREAS EXCEPT BETWEEN HOLE #83-84 AND 88-94
Inspection Test #: 170 rejected: P TO M: {g|.2|R|S|T}: -.0316 TO .1214
Inspection Test #: 190 rejected: MACHINED SURFACES
N TO N1: {g|.02|R|S|T}: -.0282 TO .0265
Inspection Test #: 200 rejected: DATUM E SIDE
VERIFY SHELL INTERSECT CLEARANCE
USING GAGE MTMFX-3473: : ACCEPT IN ALL AREAS EXCEPT BETWEEN HOLE #30-46 49-56 & 82-84
Inspection Test #: 210 rejected: Q TO N: {g|.2|R|S|T}: .022 TO .1179
Inspection Test #: 240 rejected: : 84X .375-16 UNC y .75
: ALL THREADS ARE GOOD EXCEPT 1 HOLE IS REJECTED HOLE #91 IS TAPPED AT A ANGLE
Inspection Test #: 250 rejected: : 84X b.625 y .188: .156 TO .190 44 HOLES ARE UNDERSIZED ON
DEPTH
Inspection Test #: 260 rejected: : {#|.06|R|S|T}: .003 TO .144
Inspection Test #: 340 rejected: DATUM E: {f|.01}: .045
Inspection Test #: 360 rejected: DATUM D: {f|.01}: .032
Inspection Test #: 510 rejected: : 14X
d1.885 ~ .003 THRU: 1.884 TO 1.886 HOLE #6 1.884 - 1.889 HOLE #10 1.884 - 1.893
Inspection Test #: 540 rejected: : 10X
d1.885 ~ .003 THRU: 1.884 TO 1.886 HOLE #19 HAS A GROOVE .400 TALL BY .018 DEEP
Inspection Test #: 560 rejected: 10 X Ø1.885: {#|.06|M|A|D}: .0316 TO .063
Inspection Test #: 580 rejected: : 3x bd2.000 - 2.001
y .990 - 1.000: 3X - 2.0002 BY 1.003
Inspection Test #: 590 rejected: 3X Ø1.130: {#|d.06|M|A|D}: .054 TO .066
Inspection Test #: 610 rejected: Ø1.375-6UNC: {#|.06|M|A|D}: .022 TO .072
Inspection Test #: 630 rejected: : d.03 x 45` CHAMFER: .500
Inspection Test #: 650 rejected: : d.03 x 45` CHAMFER: .505
Inspection Test #: 680 rejected: 3X Ø1.50: : 1.476 TO 1.491
Inspection Test #: 840 rejected: 2X .88/1.13: : 1.090 AND 1.170
Inspection Test #: 880 rejected: 2X 1.56: : 1.78 TO 1.81
Inspection Test #: 900 rejected: : 6X
.375-16UNC-2B TAP y .75
.03 X 45` CHAMFER: ALL GOOD EXCEPT ONE HOLE THE NOGO GOES 4 TURNS
Inspection Test #: 1010 rejected: AS CAST SURFACES: {g|.5|A|B|C}: -.309 TO .435

Proposed Disposition:

STEP 130 REJECTION FOR OVERSIZE RADIUS TO BE REWORKED PER DIRECTION FROM PPPL:

- Non-conforming radii are to be ground to a corner radius of 0.06-0.1 1".
- Steps or undercuts not to exceed 0.03" are acceptable.
- Use care to not gouge adjacent areas, since these surfaces are used in measurements.

MTM PROPOSES THAT ALL OTHER REJECTIONS BE ACCEPTED AS IS.

Number of additional pages: 13 PAGE IDC ATTACHMENT

Customer Disposition: Use As Is Rework Repair Scrap Replace

All except Step 130 were accepted as is (which is dispositioned above) after a review held during a conference call on 10/26/06 attended by L. Dudek, L. Sutton, D. Williamson, F. Malinowski, J. Chrzanowski, T. Brown, and P. Heitzenroeder



Following text added 10/31/2006

Each dimensional deviation was discussed and can be accommodated during assembly. However, MTM was requested to review the machining setup processes since it was noted that these accommodations do take some effort on NCSX's part and the perception is that there has been some gradual loosening of achieved tolerances. MTM has such a review in progress already- we request that this be reported back during a Quality conference call.

Accepted by:

Tech. Rep.

RLM

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



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: REWORK - Item: 8

Workorder: 65708/2-0 Sub:15 Op:40

Part: REWORK - REWORK / REPAIR PER N/C - N/C # _____

| Drawing ID: SE141-115 Rev: 9 | | INSPECTION INSTRUCTIONS | | | RESULTS | | INSPECTED BY | | | |
|------------------------------|------|--|-------------|----|---------|--------|----------------|----------|-------|-------|
| SHEET | ZONE | CHARACTERISTIC | GAGE/EQUIP | BY | SAMPLE | SER# | DATA/REMARKS | INSP | VERFD | AUDIT |
| * | | NC 20449 PERMEABILITY OF WELD TO BE LESS THAN 1.02μ. | MASTER GAGE | QA | | J-1165 | LESS THAN 1.02 | 854-R.UP | | |
| (10) | | | | | | | | 10-04-06 | | |

A

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-102 - Item: 11

Workorder: 65708/2-0 Sub:1 Op:140

Part: SE141-102 - 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 | |
| * | | <u>T E S T 1</u> RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE MID-PLANE POLOIDAL BREAK SHIM AND THE WINDING FORM. | MULTIMETER | QA | | J-1358 | 2.2 G KOHMS | 503-B.HC | | | A |
| (10) | | | | | | | | 10-23-06 | | | |
| * | | <u>T E S T 2</u> RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE JUMPERED BOLTS AND JUMPERED MID-PLANE CASTING AND WINDING FORM. | MULTIMETER | QA | | J-1358 | 2.2G KOHMS | 503-B.HC | | | A |
| (20) | | | | | | | | 10-23-06 | | | |

Quality Assurance Documentation for Part ID: SE141-115 - Item: 18

Workorder: 65708/2-0 Sub:1 Op:130

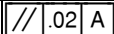
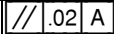
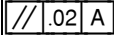
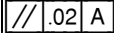

Part: SE141-115 - MODULAR COIL, TYPE B -

| 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. | | MFG | | | LESS THAN .002 | 825-B.JA 10-19-06 | | | A |
| * (15) | | THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002" | | MFG | | | LESS THAN .002 | 825-B.JA 10-19-06 | | | 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-1144 | .005 | 771-B.SC 10-25-06 | | | A |
| * (30) | | THE MAX. GAP AT THE POLOIDAL BREAK PERIMETER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE. | FEELER GAGES | MFG | | J-1144 | .013 | 771-B.SC 10-25-06 | | | A |
| 1* (40) | F3 | TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15. | TORQUE MULTIPLIE | MFG | | J-1240 | 1500 | 825-B.JA 10-19-06 | | | A |




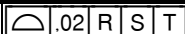

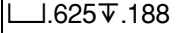
Quality Assurance Documentation for Part ID: SE141-115 - Item: 19

Workorder: 65708/2-0 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 | 533-B.CL 10-26-06 | | | A |
| 1* (20) | C3 | RECORD FINAL PART WEIGHT | | QA | | VISUAL | 5540 | 533-B.CL 10-26-06 | | | A |
| 1* (30) | F3 | NOTE 14 BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP. | | QA | | MTMFX-3564 | ACCEPT | 533-B.CL 10-25-06 | | | A |
| 1* (40) | E7 |  | CMM | QA | | 00064 | .0089 | 533-B.CL 10-25-06 | | | A |
| 1* (50) | E6 |  | CMM | QA | | 00064 | .0105 | 533-B.CL 10-25-06 | | | A |
| 1* (60) | B6 |  | CMM | QA | | 00064 | .027 [N/C:20676] | 533-B.CL 10-25-06 | | | R |
| 1* (70) | B5 |  | CMM | QA | | 00064 | .007 | 533-B.CL 10-25-06 | | | A |
| 1* (90) | D3 |  OUTER AS CAST SURFACES | CMM | QA | | 00064 | -.0129 TO .306 [N/C :20676] | 533-B.CL 10-26-06 | | | R |
| 2* (100) | G7 | 2X .03 X 45° | | QA | | VISUAL | ACCEPT | 533-B.CL 10-25-06 | | | A |
| 2* (110) | G7 | .40 | CALIPER | QA | | J-707 | .390 TO .400 | 533-B.CL 10-25-06 | | | A |
| 2* (120) | G7 | 2X .03 X 45° | | QA | | VISUAL | ACCEPT | 533-B.CL 10-25-06 | | | A |
| 2* | G8 | | RADIUS GAGE | QA | | R-21 | .110 TO .120 E SI DE HOLE#BREAK TO 7 18-25 38-43 48-57 59-64 73-84 ARE .25 | 533-B.CL | | | R |

INSPECTION DATA CHECKLIST

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|-------------|----|--|------------------|----|------------|---|----------------------|--|---|
| (130) | | 2X R.11 | | | | OR [N/C:20676] | 10-25-06 | | |
| 2* (140) | H7 | 2X .31 | CALIPER | QA | J-707 | .305 TO .317 | 533-B.CL 10-25-06 | | A |
| 2* (150) | H6 |  MACHINED SURFACES M TO M1 | CMM | QA | 00064 | -.0178 TO .0251 [N/ C:20676] | 533-B.CL 10-26-06 | | R |
| 2* (160) | F5 | DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473 | | QA | MTMFX-3473 | ACCEPT IN ALL AREAS EXCEPT BETWEEN HOL E #83-84 AND 88-94 [N/C:20676] | 533-B.CL 10-25-06 | | R |
| 2* (170) | E6 |  P TO M | CMM | QA | 00064 | -.0316 TO .1214 [N/ C:20676] | 533-B.CL 10-26-06 | | R |
| 2* (180) | H4 |  MACHINED SURFACES M1 TO N1 | CMM | QA | 00064 | -.0322 TO .0315 | 533-B.CL 10-26-06 | | A |
| 2* (190) | G3 |  MACHINED SURFACES N TO N1 | | QA | | -.0282 TO .0265 [N/ C:20676] | 533-B.CL 10-26-06 | | R |
| 2* (200) | F3 | DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473 | | QA | MTMFX-3473 | ACCEPT IN ALL AREAS EXCEPT BETWEEN HOL E #30-46 49-56 & 82 -84 [N/C:20676] | 533-B.CL 10-25-06 | | R |
| 2* (210) | F3 |  Q TO N | CMM | QA | 00064 | .022 TO .1179 [N/C: 20676] | 533-B.CL 10-26-06 | | R |
| 2* (220) | D6 |  HOLE 63 THRU 73 | | QA | VISUAL | NO COUNTERBORE ON P ART DUE TO REV CHAN GE | 533-B.CL 10-25-06 | | A |
| 2* (230) | C5 | 2X .06-.09 X 45° | | QA | VISUAL | ACCEPT | 533-B.CL 10-25-06 | | A |
| 2* | C4 | 84X .375-16 UNC ∇ .75 | THREAD PLUG GAGE | QA | A-233 | ALL THREADS ARE GOO D EXCEPT 1 HOLE IS REJECTED HOLE #91 I S TAPPED AT A ANGLE | 533-B.CL | | R |

INSPECTION DATA CHECKLIST

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|-------|----|---|------------------|----|--|--------|---|----------|--|---|
| (240) | | | DEPTH MICROMETE | | | J-1024 | [N/C:20676] | 10-26-06 | | |
| 2* | C4 | 84X \perp .625 ∇ .188 | CALIPER | QA | | J-707 | .156 TO .190 44 HOLES ARE UNDERSIZE D ON DEPTH [N/C:206 | 533-B.CL | | R |
| (250) | | | DEPTH MICROMETE | | | J-1062 | 76] | 10-25-06 | | |
| 2* | C4 | \varnothing .06 R S T | CMM | QA | | 00064 | .003 TO .144 [N/C:2 | 533-B.CL | | R |
| (260) | | | | | | | 0676] | 10-26-06 | | |
| 3* | G7 | | | QA | | VISUAL | SEE IGES DATA | 533-B.CL | | A |
| (270) | | 9.00 | | | | | | 10-25-06 | | |
| 3* | G7 | | | QA | | VISUAL | SEE IGES DATA | 533-B.CL | | A |
| (280) | | 4.50 | | | | | | 10-25-06 | | |
| 3* | G6 | | | QA | | VISUAL | SEE IGES DATA | 533-B.CL | | A |
| (290) | | 3.00 | | | | | | 10-25-06 | | |
| 3* | F7 | | | QA | | VISUAL | SEE IGES DATA | 533-B.CL | | A |
| (300) | | 1.50 | | | | | | 10-25-06 | | |
| 3* | F7 | 4X \varnothing 1.0-8UNC ∇ 2.1 | THREAD PLUG GAGE | QA | | A-670 | ACCEPT | 533-B.CL | | A |
| (310) | | | | | | | | 10-25-06 | | |
| 3* | G5 | | | QA | | VISUAL | SEE IGES DATA | 533-B.CL | | A |
| (320) | | 17.00 AT MOUNTING AREA | | | | | | 10-25-06 | | |
| 3* | H2 | \sqrt{R} DATUM E | PROFILOMETER | QA | | J-1152 | 11 TO 62 | 533-B.CL | | A |
| (330) | | | | | | | | 10-25-06 | | |
| 3* | G1 | \square .01 DATUM E | CMM | QA | | 00064 | .045 [N/C:20676] | 533-B.CL | | R |
| (340) | | | | | | | | 10-26-06 | | |
| 3* | G3 | .25 \pm .01 DATUM E | CMM | QA | | 00064 | .250 | 533-B.CL | | A |
| (350) | | | | | | | | 10-26-06 | | |
| 3* | | \square .01 DATUM D | CMM | QA | | 00064 | .032 [N/C:20676] | 533-B.CL | | R |
| (360) | | | | | | | | 10-26-06 | | |
| 3* | E2 | .25 \pm .01 DATUM D | CMM | QA | | 00064 | .250 | 533-B.CL | | A |
| (370) | | | | | | | | 10-26-06 | | |
| 3* | E2 | \sqrt{R} DATUM D | PROFILOMETER | QA | | J-1152 | 18 TO 47 TWO SPO TS HAVE CIRCULAR TO OL DAMAGE | 533-B.CL | | A |
| (380) | | | | | | | | 10-26-06 | | |
| 3* | F4 | 2X \varnothing 2.50 | CALIPER | QA | | J-707 | 2.510 | 533-B.CL | | A |
| (390) | | | | | | | | 10-25-06 | | |
| 3* | F4 | 4X \varnothing 1.0 -8UNC ∇ 2.5 | THREAD PLUG GAGE | QA | | A-185 | ACCEPT | 533-B.CL | | A |
| (400) | | | | | | | | 10-26-06 | | |

INSPECTION DATA CHECKLIST

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|-------------|----|---|-------------------------------------|----|--|-----------------|--|----------------------|--|--|---|
| 3* (410) | F4 | 1.72 | CALIPER | QA | | J-707 | 1.710 | 533-B.CL 10-25-06 | | | A |
| 3* (420) | D5 | 8X Ø1-8UNC ▽ 1.5 | THREAD PLUG GAGE | QA | | A-185 | ACCEPT | 533-B.CL 10-26-06 | | | A |
| 3* (430) | B7 | 4X 1-8UNC ▽ 2.5 | THREAD PLUG GAGE | QA | | A-185 | ACCEPT | 533-B.CL 10-26-06 | | | A |
| 3* (440) | C1 | 1.50 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | | A |
| 3* (450) | C1 | 3.00 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | | A |
| 3* (460) | C1 | 4X Ø 1-8UNC ▽ 2.1 | THREAD PLUG GAGE DEPTH MICROMETE | QA | | A-670 J-1024 | ACCEPT | 533-B.CL 10-25-06 | | | A |
| 3* (470) | C1 | 4.50 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | | A |
| 3* (480) | B1 | 9.00 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | | 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-375 | ACCEPT | 533-B.CL 10-26-06 | | | A |
| 4* (510) | E6 | 14X Ø1.885 ± .003 THRU | DIAL BORE GAGE | QA | | J-1400 | 1.884 TO 1.886 HO LE #6 1.884 - 1.889 HOLE #10 1.884 - 1.893 [N/C:20676] | 533-B.CL 10-25-06 | | | R |
| 4* (520) | E6 | 14X └┘Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP | | QA | | MTMFX-3564 | ACCEPT | 533-B.CL 10-26-06 | | | A |
| 4* (530) | E6 | $\text{⌀} \begin{matrix} .06 & & M & & A & & D \end{matrix}$ 14 X Ø1.885 | CMM | QA | | 00064 | .046 TO .060 | 533-B.CL 10-26-06 | | | A |
| 4* (540) | D6 | 10X Ø1.885 ± .003 THRU | DIAL BORE GAGE | QA | | J-1400 | 1.884 TO 1.886 HOLE #19 HAS A GROO VE .400 TALL BY .01 8 DEEP [N/C:20676] | 533-B.CL 10-25-06 | | | R |
| 4* (540) | D6 | 10X └┘Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP | | QA | | MTMFX-3564 | ACCEPT | 533-B.CL | | | A |

INSPECTION DATA CHECKLIST

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|-------------|----|--|------------------|----|-----------|--------------------------------------|----------------------|----------|--|---|
| (550) | | | | | | | | 10-26-06 | | |
| 4* (560) | D6 | Φ .06 M A D 10 X \varnothing 1.885 | CMM | QA | 00064 | .0316 TO .063 [N/C :20676] | 533-B.CL 10-26-06 | | | R |
| 4* (580) | C7 | 3X \square \varnothing 2.000 - 2.001 ∇ .990 - 1.000 | | QA | LARGE DEA | 3X - 2.0002 BY 1.00 3 [N/C:20676] | 854-R.UP 10-03-06 | | | R |
| 4* (590) | C7 | Φ \varnothing .06 M A D 3X \varnothing 1.130 | CMM | QA | 00064 | .054 TO .066 [N/C:2 0676] | 533-B.CL 10-26-06 | | | R |
| 4* (600) | D4 | \varnothing 1.375-6UNC THRU OR \varnothing 1.375-6UNC X 1.5 MIN FOR FLANGE THK GREATER 1.5 | THREAD PLUG GAGE | QA | A-375 | ACCEPT | 533-B.CL 10-26-06 | | | A |
| 4* (610) | D4 | Φ .06 M A D \varnothing 1.375-6UNC | CMM | QA | 00064 | .022 TO .072 [N/C:2 0676] | 533-B.CL 10-26-06 | | | R |
| 4* (620) | E2 | 10X .25-20UNC-2B | THREAD PLUG GAGE | QA | A-716 | ACCEPT | 533-B.CL 10-25-06 | | | A |
| 4* (630) | E2 | \varnothing .03 X 45° CHAMFER | CALIPER | QA | J-707 | .500 [N/C:20676] | 533-B.CL 10-25-06 | | | R |
| 5* (640) | F7 | 12X .25-20UNC-2B | THREAD PLUG GAGE | QA | A-716 | ACCEPT | 533-B.CL 10-25-06 | | | A |
| 5* (650) | F7 | \varnothing .03 X 45° CHAMFER | CALIPER | QA | J-707 | .505 [N/C:20676] | 533-B.CL 10-25-06 | | | R |
| 5* (660) | G6 | 3X 1.0 | DEPTH MICROMETE | QA | J-1024 | ACCEPT | 533-B.CL 10-25-06 | | | A |
| 5* (670) | G6 | 3X \varnothing 3.00 | CALIPER | QA | J-707 | 3.003 | 533-B.CL 10-25-06 | | | A |
| 5* (680) | G6 | 3X \varnothing 1.50 | CALIPER | QA | J-1103 | 1.476 TO 1.491 [N/C :20676] | 533-B.CL 10-25-06 | | | R |
| 5* (690) | E3 | 12X \varnothing 1.375-6UNC THRU OR \varnothing 1.375-6UNC X ∇ 1.5 MIN FOR FLANGE THK GREATER THAN 1.5 | THREAD PLUG GAGE | QA | A-375 | ACCEPT | 533-B.CL 10-25-06 | | | A |
| 5* (700) | E3 | Φ .06 N A E 12X \varnothing 1.375-6 | CMM | QA | 00064 | .010 TO .028 | 533-B.CL 10-26-06 | | | A |
| 5* | D4 | 14X \varnothing 1.375-6UNC THRU OR \varnothing 1.375-6UNC X ∇ 1.5 MIN FOR FLANGE THK GREATER THAN 1.5 | THREAD PLUG GAGE | QA | A-375 | ACCEPT | 533-B.CL | | | A |

INSPECTION DATA CHECKLIST

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|-------------|----|--|------------------|----|--|------------|---------------------------------|----------------------|--|---|
| (710) | | | | | | | | 10-25-06 | | |
| 5* (720) | D4 | Φ .06 N A E 14X Ø1.375-6 | CMM | QA | | 00064 | .006 TO .052 | 533-B.CL 10-26-06 | | A |
| 5* (730) | E3 | 3X Ø1.885 ±.003 THRU | DIAL BORE GAGE | QA | | J-1400 | 1.886 | 533-B.CL 10-25-06 | | A |
| 5* (740) | E3 | 3X \perp Ø3.00 SPOTFACE BACKSIDE MINIMUM CLEAN UP | | QA | | MTMFX-3564 | ACCEPT | 533-B.CL 10-26-06 | | A |
| 5* (750) | E3 | Φ .06 N A E 3X Ø1.885 | CMM | QA | | 00064 | .024 TO .026 | 533-B.CL 10-26-06 | | A |
| 6* (760) | G7 | 5.00 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | A |
| 6* (770) | H7 | 5.00 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | A |
| 6* (780) | H6 | 5.00 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | A |
| 6* (790) | C6 | 6.00 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | A |
| 6* (800) | C6 | 5.00 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | A |
| 6* (810) | F6 | 4X Ø1.00 | CALIPER | QA | | J-707 | 1.001 TO 1.002 | 533-B.CL 10-25-06 | | A |
| 6* (820) | F7 | 6.50 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | A |
| 6* (830) | F6 | 2.00 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | A |
| 6* (840) | H5 | 2X .88/1.13 | CALIPER | QA | | J-707 | 1.090 AND 1.170 [N/ C:20676] | 533-B.CL 10-25-06 | | R |
| 6* (850) | C5 | 2.250 ± .010 | CALIPER | QA | | J-707 | 2.240 | 533-B.CL 10-25-06 | | A |
| 6* (860) | F4 | .06 - .09 X 45° | CALIPER | QA | | J-707 | .070 | 533-B.CL 10-25-06 | | A |
| 7* (880) | C4 | 2X 1.56 | CALIPER | QA | | J-707 | 1.78 TO 1.81 [N/C:2 0676] | 533-B.CL 10-25-06 | | R |
| 7* (890) | C4 | 5.190 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | A |
| 7* (900) | C3 | 6X | THREAD PLUG GAGE | QA | | A-233 | ALL GOOD EXCEPT ONE | 533-B.CL | | R |

INSPECTION DATA CHECKLIST

| | | | | | | | | | | |
|---------------|----|---|----------|----|--|---------|---|----------------------|--|---|
| (900) | | .375-16UNC-2B TAP ∇ .75 .03 X 45° CHAMFER | | | | | HOLE THE NOGO GOES 4 TURNS [N/C:20676] | 10-25-06 | | |
| 7* (910) | B3 | 3.75 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | A |
| 7* (920) | B3 | 7.50 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | A |
| 8* (930) | C5 | 4 X \varnothing 1.0 T H R U | CALIPER | QA | | J-707 | 1.003 TO 1.010 | 533-B.CL 10-25-06 | | A |
| 9* (940) | C7 | 2X \varnothing .50 THRU | CALIPER | QA | | J-707 | .495 TO .499 | 533-B.CL 10-25-06 | | A |
| 9* (950) | F4 | 10.15 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | A |
| 9* (960) | F4 | 1.63 | | QA | | VISUAL | SEE IGES DATA | 533-B.CL 10-25-06 | | A |
| 9* (970) | D4 | \varnothing .25 ∇ 5.0 \perp \varnothing .625 ∇ 3.0 | PIN GAGE | QA | | J-652-1 | .245 DEPTH 5.7 .625 DPETH 3.6 | 533-B.CL 10-26-06 | | A |
| 9* (980) | E2 | \varnothing .25 \perp \varnothing .625 DETAIL D | PIN GAGE | QA | | J-652-1 | .625 .246 | 533-B.CL 10-26-06 | | A |
| 9* (990) | F2 | 4 X \varnothing 1.0 THRU | CALIPER | QA | | J-707 | 1.001 TO 1.004 | 533-B.CL 10-25-06 | | A |
| 11* (1010) | E5 | ∇ .5 A B C AS CAST SURFACES | CMM | QA | | 00064 | -.309 TO .435 [N/C: 20676] | 533-B.CL 10-26-06 | | R |
| 11* (1020) | C8 | ∇ -.12 -.25 A B C WING SURFACES | CMM | QA | | 00064 | -.029 TO .055 | 533-B.CL 10-26-06 | | A |
| 11* (1030) | D1 | ∇ +0.0 -.12 A B C WING POCKET | CMM | QA | | 00064 | -.035 TO .028 | 533-B.CL 10-26-06 | | A |

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-115 - Item: 21

Workorder: 65708/2-0 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 | |
| * | | <u>D A T U M - E - S I D E</u> 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 | 495-D.CO | | | A |
| (10) | | | | | | | | 10-23-06 | | | |
| * | | <u>D A T U M - D - S I D E</u> 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 | 495-D.CO | | | A |
| (20) | | | | | | | | 10-23-06 | | | |



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-139 - Item: 25

Workorder: 65708/2-0 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 | | |

A

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-140 - Item: 28

Workorder: 65708/2-0 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* | G2 | RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ. | MASTER GAGE | QA | | J-1165 | LESS THAN 1.02 | 854-R.UP | | |
| (10) | | | | | | | | 07-16-06 | | |

A

Employees: 495-D.Coffman / 503-B.Houk / 533-B.Clevenger / 771-B.Schultz / 825-B.Jarrett / 854-R.Upchurch