Major Tool & Machine, Inc.
1458 East 19th Street
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MTM N/C: 20338

Date: 08/22/06
User ID: GRIFFITH

Customer: ENERGY INDUSTRIES OF OHIO
Contact: NANCY HORTON — Telephone: 216-496-2314
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Part: SE141-115 / MODULAR COIL, TYPE B — Customer P.O.: S005242-F/Ln:2
Drawing ID: SE141-115 Revision: 8 — Serial No./Qty: B2

Reported By: MIKE GRIFFITH — Telephone: 317-636-6433
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Problem: Sheet 7, zone B3; three of the 3/8-16 UNC-2B holes cannot be machined into the casting pad. The machining qualification relative to the cast stock resulted in a shift of approximately .350" from the ideal location for this feature.
Attatch is the MTM proposal for the rework of this area.

Proposed Disposition:
PROPOSE TO REPAIR PER ATTACHMENT.

Number of additional pages: 1 page rework proposal

Customer Disposition: [ ] Use As Is x Rework [ ] Repair [ ] Scrap [ ] Replace

NCSX agrees with EIO's repair proposal (attached). This repair approach avoids strength concerns because the "insert block" will have clearance holes in order that the bolts will engage tapped holes which will extend ¾" (2D) into the casting instead of having tapped holes in the insert and thus raising concern about the strength of the welds. David Williamson also reviewed the details of the proposed rework and is in agreement with it.

Approved by:

Phil Heitzenroeder
Digitally signed by Phil Heitzenroeder
DN: cn=Phil Heitzenroeder, c=US, o=PPPL, ou=Mech. Eng. Division
Date: 2006.08.28 17:19:26 -04'00'

Tech. Rep.

Brad Nelson
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Date: 2006.08.28 15:31:22 -04'00'

RLM

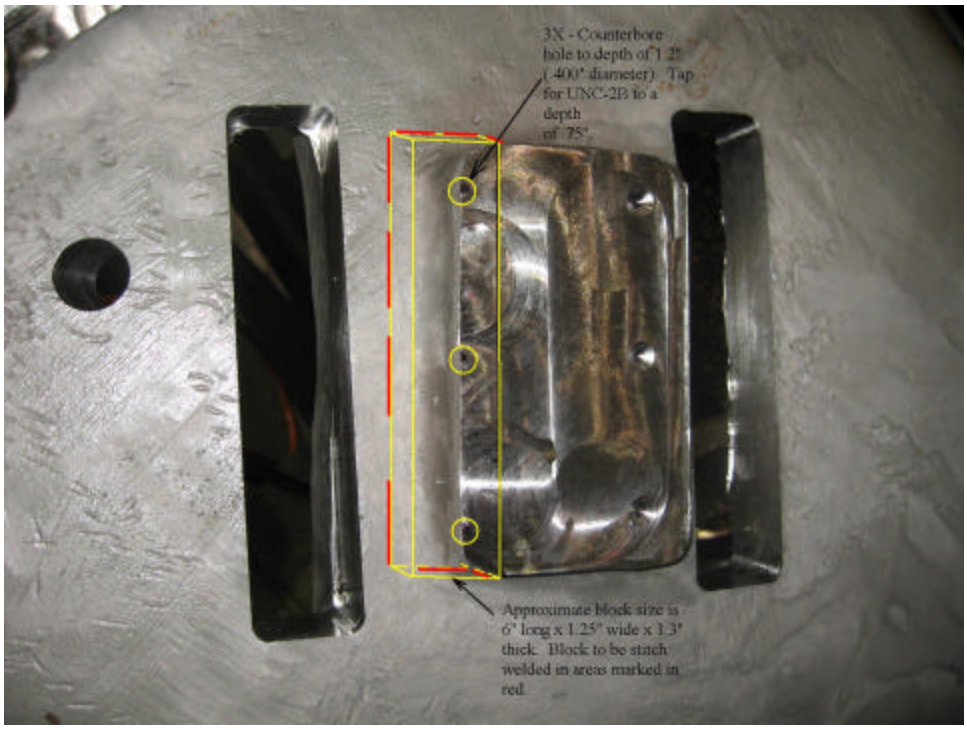
Major Tool Implemented By: _____ **Title:** _____ **Date:** _____

SE141-115 B2

NC20338 - Lead Block Repair

The following proposal is in regards to the repair of the lead block pad for the B2 casting. After the establishment of the machining datums relative to the casting stock, this particular area will not meet the drawing requirements for three of the 3/8-16 tapped holes. In order to re-establish the functionality of the lead block pad, Major Tool is proposing the following fix **at no cost to EIO/PPPL**.

1. Machine a 1.25”clearance slot along the side of the existing lead block pad. Approximately .5” of stock from the edge of the existing pad would be included in this 1.25” wide slot. The slot would be machined flush to the cast wall at the top of the pad and would cut into the wall approximately .100” at the bottom of the pad. An 1/8 radius would be used on the cutter to eliminate any sharp edges on the casting.
2. A block will be machined from one of the B casting drops. The block dimensions will be approximately 6”x1.25”x1.3”. The block would also have a radius on the mating surface along the edge of the pad.
3. The block will be stitch welded to the casting wall along the perimeter of the block.
4. The pad will then be faced so that the inserted block and existing pad are flush. Three clearance holes for the 3/8-16 hardware would be drilled to a depth of 1.2” in the inserted block. The 3/8-16 holes would be tapped to a depth of .75” from the bottom of the clearance hole, into the casting wall. The three remaining 3/8-16 tapped holes would be put in to the original drawing specification.



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