

**Customer: ENERGY INDUSTRIES OF OHIO**

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**Part: SE141-114 / MODULAR COIL WINDING FORM TYPE**

Drawing ID: SE141-114                      Revision: 8  
W/O Links: 1-Type:W: 65709/4.0 Sub: 1

Customer P.O.: S005242-F/Ln:4  
Serial No./Qty: A4

Reported By: MIKE GRIFFITH  
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Problem: Workorder: 65709/4.0 Sub:1 Op:132

- Inspection Test #: 20 rejected: FLANGE PROFILE +/--.25 IN THIS AREA: : .008 (NCSX note: check A's)
- Inspection Test #: 100 rejected: : {h|,02|A}: .023
- Inspection Test #: 130 rejected: OUTER AS CAST SURFACES: {g|,5|A|B|C}: -.0356 TO .3954
- Inspection Test #: 150 rejected: 4 X .03 X 45: : .010 TO .060
- Inspection Test #: 170 rejected: P TO M: {g|,2|R|T|S}: .0375 TO .1141
- Inspection Test #: 180 rejected: DATUM D SIDE
- VERIFY SHELL INTERSECT CLEARANCE
- USING GAGE MTMFX-3473: : REJECTED LOC # 2-11, 14-42, 75-77, 86-95
- Inspection Test #: 190 rejected: M TO M1: {g|,02|R|T|S}: -.0216 TO .0200
- Inspection Test #: 220 rejected: DATUM E SIDE
- VERIFY SHELL INTERSECT CLEARANCE
- USING GAGE MTMFX-3473: : REJECTED LOC# 47-55, 79-81, 86-92
- Inspection Test #: 230 rejected: N TO N1: {g|,02|R|T|S}: -.0164 TO .0265
- Inspection Test #: 260 rejected: : bd.625 y .188: .160 TO .201 REJECT LOC # 35,37-43,45,49-52,55,60-70,73,75,79,82,83,88-93
- Inspection Test #: 270 rejected: .375-16 HOLES: {#,06|R|T|S}: .016 TO .081
- Inspection Test #: 280 rejected: DATUM E FLANGE: {f|,01}: .028
- Inspection Test #: 290 rejected: DATUM D FLANGE: {f|,01}: .017
- Inspection Test #: 295 rejected: DATUM D FLANGE: /!@%: 80 TO 136
- Inspection Test #: 330 rejected: 8X Ø1-8 UNC: {#,010|A|B|C}: .012 TO .026
- Inspection Test #: 350 rejected: 8X Ø1-8 UNC: {d|,010|A|B|C}: .003 TO .068
- Inspection Test #: 390 rejected: : bd2.000-2.001 y0.990-1.000: 1.9995 TO 1.9999 DEPTH .992 TO .994
- Inspection Test #: 640 rejected: 2X .88 - 1.13: : 1.110 TO 1.140
- Inspection Test #: 780 rejected: INNER AS CAST SURFACES: {g|,5|A|B|C}: -.3301 TO .3954
- Inspection Test #: 790 rejected: WING SURFACES: {g|-,12;;;-,25|A|B|C}: -.0005 TO -.1940, -.1387 TO -.1942
- Inspection Test #: 795 rejected: WING POCKET SURFACES: {g|+0;;;-,25|A|C|B}: +.091 TO -.798

**Proposed Disposition:**

PROPOSE TO ACCEPT AS IS.

Number of additional pages: 9 PAGE IDC ATTACHMENT

**Customer Disposition:**     Use As Is     Rework     Repair     Scrap     Replace

These rejections were reviewed in a conference call on 11/14/06 attended by D. Williamson, J. Chrzanowski, L. Sutton, F. Malinowski, L. Dudek, P. Heitzenroeder, M. Griffith, N. Horton, P. Djordjevich, and R. Sheppard. In general, these are similar to the other coils and are such that we can accept them since they will not cause interference problems or excessive time to remediate. A few specific inspections were discussed related to hole positions and clearances in wing areas and were concluded to be workable as is. In the case of Inspection #330 and 350, NCSX will review the drawing tolerances (which are felt to be too tight) and likely open them up. On Inspection #20, NCSX did not specify inspection points; M. Griffith will measure A4 and provide the results for possible NCSX action.

Accepted by:

Tech. Rep.

RLM

Major Tool Implemented By: \_\_\_\_\_ Title: \_\_\_\_\_ Date: \_\_\_\_\_

**INSPECTION DATA CHECKLIST**

Workorder: 65709/4-0 Sub:1 Op:130

Revision:

**Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A**

Drawing ID: SE141-101 Rev: 3			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
2* (10)	D3	Ø.001 - Ø.002 CHECK CLEARANCE OF ITEM 5 TO ITEM 6.	FEELER GAGES	MFG		J-1144	LESS THAN .002	825-B.JA 11-08-06			A *
* (15)		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"	FEELER GAGES	MFG		J-1144	LESS THAN .002	825-B.JA 11-08-06			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	LESS THAN .005	825-B.JA 11-08-06			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	ACCEPT	825-B.JA 11-08-06			A *
1* (40)	F2	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLIE	MFG		J-1240	1500#S	825-B.JA 11-08-06			A *

Workorder: 65709/4-0 Sub:1 Op:132

Revision: 11/13/06 14:54

**Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A**

Drawing ID: SE141-114 Rev: 8			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1* (10)	F3	NOTE 14 - BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.		QA		MTMFX-3564	ACCEPT	533-B.CL 11-10-06			A *
1*	E8		CMM	QA		00064	.008 [N/C:20759-Doc	339-E.RO			R

\* To Far Right Indicates Data Package Requirement

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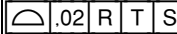

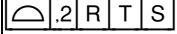
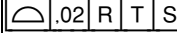
### INSPECTION DATA CHECKLIST

(20)		FLANGE PROFILE +0.0/-0.25 IN THIS AREA				:NC20759]	11-13-06		*
1* (30)	D8		CMM	QA	00064	.003	339-E.RO 11-13-06		A *
1* (40)	D8	54.20 ± .03	CMM	QA	00064	54.189	533-B.CL 11-10-06		A *
1* (50)	C8	54.20 ± .03	CMM	QA	00064	54.197	533-B.CL 11-10-06		A *
1* (60)	B8		CMM	QA	00064	.006	339-E.RO 11-13-06		A *
1* (70)	D5		CMM	QA	00064	.010	339-E.RO 11-13-06		A *
1* (80)	D5	48.50 ± .03	CMM	QA	00064	48.482	533-B.CL 11-10-06		A *
1* (90)	C5	48.50 ± .03	CMM	QA	00064	48.494	533-B.CL 11-10-06		A *
1* (100)	B5		CMM	QA	00064	.023 [N/C:20759-Doc :NC20759]	339-E.RO 11-13-06		R *
1* (110)	D4	VERIFY PART MARKING: MAJOR TOOL SE141-114 A(casting number) (weight) LBS.		QA		VISUAL ACCEPT	533-B.CL  11-10-06		A *
1* (120)	D4	RECORD WEIGHT		QA		VISUAL 5365	533-B.CL 11-10-06		A *
1* (130)	D3	 OUTER AS CAST SURFACES	CMM	QA	00064	-.0356 TO .3954 [N/ C:20759-Doc:NC20759 ]	339-E.RO 11-13-06		R *
2* (140)	F8	2 X .40	CALIPER	QA	J-707	E SIDE .40 TO .41 D SIDE .39 TO .41	533-B.CL 11-10-06		A *
2* (150)	F8	4 X .03 X 45	CALIPER	QA	J-707	.010 TO .060 [N/C:2 0759-Doc:NC20759]	533-B.CL 11-10-06		R *
2* (160)	G6	2 X R.187 +.025 / -.005	PIN GAGE	QA	J-652-1	.182 TO .212 BOTH S IDES	533-B.CL 11-10-06		A *

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INSPECTION DATA CHECKLIST

2* (170)	G5	 P TO M	CMM	QA		00064	.0375 TO .1141 [N/C :20759-Doc:NC20759]	339-E.RO 11-13-06			R *
2* (180)	G5	DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	REJECTED LOC # 2-11 , 14-42, 75-77, 86- 95 [N/C:20759-Doc:N C20759]	533-B.CL 11-10-06			R *
2* (190)	F5	 M TO M1	CMM	QA		00064	-.0216 TO .0200 [N/ C:20759-Doc:NC20759 ]	339-E.RO 11-13-06			R *
2* (200)	E5	 M1 TO N1	CMM	QA		00064	-.0112 TO .0172	339-E.RO 11-13-06			A *
2* (210)	G3	 Q TO N	CMM	QA		00064	-.0196 TO .0879	339-E.RO 11-13-06			A *
2* (220)	F3	DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	REJECTED LOC# 47-55 , 79-81, 86-92 [N/C :20759-Doc:NC20759]	533-B.CL 11-10-06			R *
2* (230)	F3	 N TO N1	CMM	QA		00064	-.0164 TO .0265 [N/ C:20759-Doc:NC20759 ]	339-E.RO 11-13-06			R *
2* (240)	B4	2 X .06/.09 X 45		QA		VISUAL	ACCEPT	533-B.CL 11-10-06			A *
2* (250)	B5	Ø .375-16 UNC ▽ .750 +.1 -0 96 X	THREAD PLUG GAGE	QA	100%	A-275	ACCEPT	533-B.CL 11-10-06			A *
2* (250)	B5	└┐Ø.625 ▽ .188	CALIPER	QA		P-5075	.160 TO .201 REJEC T LOC # 35,37-43,45 ,49-52,55,60-70,73, 75,79,82,83,88-93 [ N/C:20759-Doc:NC207	533-B.CL			R

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### INSPECTION DATA CHECKLIST

(260)						59]	11-10-06			*
2* (270)	B5	$\Phi$ .06 R T S 375-16 HOLES	CMM	QA	00064	.016 TO .081 [N/C:2 0759-Doc:NC20759]	339-E.RO 11-13-06			R *
3* (280)	H3	$\square$ .01 DATUM E FLANGE	CMM	QA	00064	.028 [N/C:20759-Doc :NC20759]	339-E.RO 11-13-06			R *
3* (285)	H4	$\surd$ <sup>125</sup> DATUM E FLANGE	PROFILOMETER	QA	J-1152	22 TO 79	533-B.CL 11-10-06			A *
3* (290)	F2	$\square$ .01 DATUM D FLANGE	CMM	QA	00064	.017 [N/C:20759-Doc :NC20759]	339-E.RO 11-13-06			R *
3* (295)	F3	$\surd$ <sup>125</sup> DATUM D FLANGE	PROFILOMETER	QA	J-1152	80 TO 136 [N/C:2075 9-Doc:NC20759]	533-B.CL 11-10-06			R *
3* (300)	E4	$\varnothing$ 2.50 THRU	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
3* (310)	F4	$\Phi$ .060 A B C $\varnothing$ 2.50	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
3* (320)	C7	8X $\varnothing$ 1-8UNC $\nabla$ 2	THREAD PLUG GAGE	QA	A-670	ACCEPT	533-B.CL 11-10-06			A *
3* (330)	C7	$\Phi$ .010 A B C 8X $\varnothing$ 1-8 UNC	CMM	QA	00064	.012 TO .026 [N/C:2 0759-Doc:NC20759]	339-E.RO 11-13-06			R *
3* (340)	D5	8X $\varnothing$ 1-8UNC THRU	THREAD PLUG GAGE	QA	A-670	ACCEPT	533-B.CL 11-10-06			A *
3* (350)	D5	$\varnothing$ .010 A B C 8X $\varnothing$ 1-8 UNC	CMM	QA	00064	.003 TO .068 [N/C:2 0759-Doc:NC20759]	339-E.RO 11-13-06			R *
3* (360)	D3	$\varnothing$ 2.50 THRU	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
3* (370)	D3	$\Phi$ .060 A B C $\varnothing$ 2.5	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
3* (380)	D1	40.90	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
4*	H6	$\square$ $\varnothing$ 2.000-2.001 $\nabla$ 0.990-1.000	DIAL BORE GAGE		J-1401	1.9995 TO 1.9999 DEPTH .992 TO .994 [N/C:20759-Doc:NC20				R

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(390)						759]			*
4* (400)	F4	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA	A-375	ACCEPT	533-B.CL 11-13-06		A *
4* (410)	F4	Φ   Ø.06   M   A   D Ø1.375-6	CMM	QA	00064	.007 TO .039	339-E.RO 11-13-06		A *
4* (420)	D4 &	Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA	J-1400	1.885 TO 1.8865	533-B.CL 11-10-06		A *
4* (430)	D4 &	Φ   Ø.06   M   A   D Ø1.885	CMM	QA	00064	.002 TO .018	339-E.RO 11-13-06		A *
4* (440)	B6	3X Ø1.5	CALIPER	QA	J-1103	1.508 TO 1.510	533-B.CL 11-13-06		A *
4* (450)	B6	Φ   .06   M   A   D 3X Ø1.5	CMM	QA	00064	.013 TO .024	339-E.RO 11-13-06		A *
4* (460)	A4	6X .25-20 UNC ▽ .5 .03" X 45° CHAMFER	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 11-10-06		A *
5* (470)	D8/D6	Ø1.885 ±.003	DIAL BORE GAGE	QA	J-1400	1.884 TO 1.8865	533-B.CL 11-10-06		A *
5* (480)	D8/D6	Φ   Ø.06   N   A   E Ø1.885	CMM	QA	00064	.020 TO .034	339-E.RO 11-13-06		A *
5* (490)	F8	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA	A-375	ACCEPT	339-E.RO 11-13-06		A *
5* (500)	F8	Φ   Ø.06   N   A   E Ø1.375-6 UNC	CMM	QA	00064	.007 TO .054	339-E.RO 11-13-06		A *
5* (510)	F6	8X 1/4 -20 UNC-2B	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 11-10-06		A *
5* (520)	D6	3X Ø1.5 ▽ 2.33	CALIPER CALIPER	QA	J-1103 J-1389	1.508 TO 1.509 DEP TH 2.325 TO 2.33	533-B.CL 11-13-06		A *
5* (530)	D6	Φ   Ø.06   N   A   E 3X Ø1.5	CMM	QA	00064	.028 TO .040	339-E.RO 11-13-06		A *
5*	B3	6X .25 - 20 UNC ▽ .5 Ø.03" X 45° CHAMFER	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL		A

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### INSPECTION DATA CHECKLIST

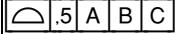
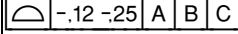
(540)								11-10-06		*
6* (550)	H7	6.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (560)	H7	1.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (570)	G8	6.70		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (600)	F8	6.70		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (610)	E7	5.75		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (620)	E7	1.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (630)	E6	4X Ø1.00	PIN GAGE	QA		J-921	.993 TO .996	533-B.CL 11-10-06		A *
6* (640)	G5	2X .88 - 1.13	CALIPER	QA		P-5075	1.110 TO 1.140 [N/C :20759-Doc:NC20759]	533-B.CL 11-10-06		R *
6* (650)	F5	.06-.09 X 45° TYP		QA		VISUAL	ACCEPT	533-B.CL 11-10-06		A *
7* (660)	G2	19.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
7* (670)	F2	2.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
7* (680)	F2	6.75		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
7* (690)	F2	3.75		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
7* (700)	F1	4X Ø.75-10 UNC ▽ 1.50	THREAD PLUG GAGE	QA		A-167	ACCEPT	533-B.CL 11-10-06		A *
7* (710)	D1	2X 1.56 OPEN THRU	CALIPER	QA		J-707	1.55	533-B.CL 11-10-06		A *

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### INSPECTION DATA CHECKLIST

7* (720)	C1	.375-16 UNC-2B TAP $\nabla$ .75 .03 X 45° CHAMFER 6X	THREAD PLUG GAGE	QA		A-233	ACCEPT	533-B.CL	11-10-06	A *	
7* (730)	C4	VERIFY THAT HOLE LOCATIONS ARE SCRIBED ON THE PART.		QA		VISUAL	ACCEPT	533-B.CL	11-10-06	A *	
7* (740)	B3	8.50 DISTANCE BETWEEN SCRIBE MARKINGS.		QA		VISUAL	ACCEPT	533-B.CL	11-10-06	A *	
9* (750)	H1	2X $\varnothing$ .50	PIN GAGE	QA		J-652-3	.501	533-B.CL	11-13-06	A *	
9* (760)	B7	TC2 HOLE TO BE .625" IN DIAMETER APPROX. 2.52" DEEP AND .25" IN DIAMETER AT LEAST 1" DEEP.	PIN GAGE  CALIPER	QA		J-652-3  J-1389	$\varnothing$ .625 DEPT 2.567 $\varnothing$ .250 DEPTH 1.017	533-B.CL	11-13-06	A *	
* (770)		TC1 LOCATION AND CONFIGURATION MODIFIED. HOLE TO HAVE .625 CLEARANCE AND AT LEAST 1" OF DEPTH AT THE .25" DIA	PIN GAGE  CALIPER	QA		J-652-3  J-1389	$\varnothing$ .622 $\varnothing$ .250 DE PTH 1.125	533-B.CL	11-13-06	A *	
10* (780)	F5	 INNER AS CAST SURFACES	CMM	QA		00064	-.3301 TO .3954 [N/ C:20759-Doc:NC20759 ]	339-E.RO	11-13-06	R *	
10* (790)	D5	 WING SURFACES	CMM	QA		00064	-.0005 TO -.1940, - .1387 TO -.1942 [N/ C:20759-Doc:NC20759 ]	339-E.RO	11-13-06	R *	
<b>Drawing ID: NCSX-CSPEC-141-03 Rev: 11</b>			<b>INSPECTION INSTRUCTIONS</b>			<b>RESULTS</b>			<b>INSPECTED BY</b>		
<b>SHEET</b>	<b>ZONE</b>	<b>CHARACTERISTIC</b>	<b>GAGE/EQUIP</b>	<b>BY</b>	<b>SAMPLE</b>	<b>SER#</b>	<b>DATA/REMARKS</b>	<b>INSP</b>	<b>VERFD</b>	<b>AUDIT</b>	
4* (800)	3.1.1.4 <sup>125</sup>	THE TWO "L" MACHINED SURFACES OF TEE MUST HAVE A RMS OF 125.	PROFILOMETER	QA		J-1152	20 TO 100	533-B.CL	11-10-06	A *	

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Workorder: 65709/4-0 Sub:1 Op:136

Revision:

**Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A**

Drawing ID: SE141-114 Rev: 8			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	LESS THAN 1.02	503-B.HO			A
(10)								11-10-06			*
*		<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	LESS THAN 1.02	503-B.HO			A
(20)								11-10-06			*

Workorder: 65709/4-0 Sub:1 Op:140

Revision:

**Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A**

Drawing ID: SE141-101 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 GOHMS	503-B.HO			A
(10)								11-09-06			*
*		<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	2.2 GOHMS	503-B.HO			A
(20)								11-09-06			*

Workorder: 65709/4-0 Sub:13 Op:30

Revision:

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**Part: SE141-141 - BEARING PLATE DETAIL TYPE "A" SHORT -**

Drawing ID: SE141-141 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-1165	LESS THAN 1.02	503-B.HO  06-29-06			A  *

Workorder: 65709/4-0 Sub:14 Op:30

Revision:

**Part: SE141-142 - BEARING PLATE DETAIL TYPE "A" LONG -**

Drawing ID: SE141-142 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-1165	LESS THAN 1.02	503-B.HO  07-19-06			A  *

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**INSPECTION DATA CHECKLIST**

Workorder: 65709/4-0 Sub:1 Op:130

Revision:

**Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A**

Drawing ID: SE141-101 Rev: 3			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
2* (10)	D3	Ø.001 - Ø.002 CHECK CLEARANCE OF ITEM 5 TO ITEM 6.	FEELER GAGES	MFG		J-1144	LESS THAN .002	825-B.JA 11-08-06			A *
* (15)		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"	FEELER GAGES	MFG		J-1144	LESS THAN .002	825-B.JA 11-08-06			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	LESS THAN .005	825-B.JA 11-08-06			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	ACCEPT	825-B.JA 11-08-06			A *
1* (40)	F2	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLIE	MFG		J-1240	1500#S	825-B.JA 11-08-06			A *

Workorder: 65709/4-0 Sub:1 Op:132

Revision: 11/13/06 14:54

**Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A**

Drawing ID: SE141-114 Rev: 8			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1* (10)	F3	NOTE 14 - BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.		QA		MTMFX-3564	ACCEPT	533-B.CL 11-10-06			A *
1*	E8		CMM	QA		00064	.008 [N/C:20759-Doc	339-E.RO			R

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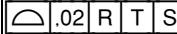

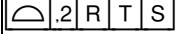
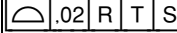
### INSPECTION DATA CHECKLIST

(20)		FLANGE PROFILE +0.0/-0.25 IN THIS AREA				:NC20759]	11-13-06		*
1* (30)	D8		CMM	QA	00064	.003	339-E.RO 11-13-06		A *
1* (40)	D8	54.20 ± .03	CMM	QA	00064	54.189	533-B.CL 11-10-06		A *
1* (50)	C8	54.20 ± .03	CMM	QA	00064	54.197	533-B.CL 11-10-06		A *
1* (60)	B8		CMM	QA	00064	.006	339-E.RO 11-13-06		A *
1* (70)	D5		CMM	QA	00064	.010	339-E.RO 11-13-06		A *
1* (80)	D5	48.50 ± .03	CMM	QA	00064	48.482	533-B.CL 11-10-06		A *
1* (90)	C5	48.50 ± .03	CMM	QA	00064	48.494	533-B.CL 11-10-06		A *
1* (100)	B5		CMM	QA	00064	.023 [N/C:20759-Doc :NC20759]	339-E.RO 11-13-06		R *
1* (110)	D4	VERIFY PART MARKING: MAJOR TOOL SE141-114 A(casting number) (weight) LBS.		QA		VISUAL ACCEPT	533-B.CL  11-10-06		A *
1* (120)	D4	RECORD WEIGHT		QA		VISUAL 5365	533-B.CL 11-10-06		A *
1* (130)	D3	 OUTER AS CAST SURFACES	CMM	QA	00064	-.0356 TO .3954 [N/ C:20759-Doc:NC20759 ]	339-E.RO 11-13-06		R *
2* (140)	F8	2 X .40	CALIPER	QA	J-707	E SIDE .40 TO .41 D SIDE .39 TO .41	533-B.CL 11-10-06		A *
2* (150)	F8	4 X .03 X 45	CALIPER	QA	J-707	.010 TO .060 [N/C:2 0759-Doc:NC20759]	533-B.CL 11-10-06		R *
2* (160)	G6	2 X R.187 +.025 / -.005	PIN GAGE	QA	J-652-1	.182 TO .212 BOTH S IDES	533-B.CL 11-10-06		A *

\* To Far Right Indicates Data Package Requirement

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### INSPECTION DATA CHECKLIST

2* (170)	G5	 P TO M	CMM	QA		00064	.0375 TO .1141 [N/C :20759-Doc:NC20759]	339-E.RO 11-13-06			R *
2* (180)	G5	DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	REJECTED LOC # 2-11 , 14-42, 75-77, 86- 95 [N/C:20759-Doc:N C20759]	533-B.CL 11-10-06			R *
2* (190)	F5	 M TO M1	CMM	QA		00064	-.0216 TO .0200 [N/ C:20759-Doc:NC20759 ]	339-E.RO 11-13-06			R *
2* (200)	E5	 M1 TO N1	CMM	QA		00064	-.0112 TO .0172	339-E.RO 11-13-06			A *
2* (210)	G3	 Q TO N	CMM	QA		00064	-.0196 TO .0879	339-E.RO 11-13-06			A *
2* (220)	F3	DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	REJECTED LOC# 47-55 , 79-81, 86-92 [N/C :20759-Doc:NC20759]	533-B.CL 11-10-06			R *
2* (230)	F3	 N TO N1	CMM	QA		00064	-.0164 TO .0265 [N/ C:20759-Doc:NC20759 ]	339-E.RO 11-13-06			R *
2* (240)	B4	2 X .06/.09 X 45		QA		VISUAL	ACCEPT	533-B.CL 11-10-06			A *
2* (250)	B5	Ø .375-16 UNC ▽ .750 +.1 -0 96 X	THREAD PLUG GAGE	QA	100%	A-275	ACCEPT	533-B.CL 11-10-06			A *
2* (250)	B5	└┘Ø.625 ▽ .188	CALIPER	QA		P-5075	.160 TO .201 REJEC T LOC # 35,37-43,45 ,49-52,55,60-70,73, 75,79,82,83,88-93 [ N/C:20759-Doc:NC207	533-B.CL			R

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(260)						59]	11-10-06			*
2* (270)	B5	$\Phi$ .06 R T S 375-16 HOLES	CMM	QA	00064	.016 TO .081 [N/C:2 0759-Doc:NC20759]	339-E.RO 11-13-06			R *
3* (280)	H3	$\square$ .01 DATUM E FLANGE	CMM	QA	00064	.028 [N/C:20759-Doc :NC20759]	339-E.RO 11-13-06			R *
3* (285)	H4	$\surd$ <sup>125</sup> DATUM E FLANGE	PROFILOMETER	QA	J-1152	22 TO 79	533-B.CL 11-10-06			A *
3* (290)	F2	$\square$ .01 DATUM D FLANGE	CMM	QA	00064	.017 [N/C:20759-Doc :NC20759]	339-E.RO 11-13-06			R *
3* (295)	F3	$\surd$ <sup>125</sup> DATUM D FLANGE	PROFILOMETER	QA	J-1152	80 TO 136 [N/C:2075 9-Doc:NC20759]	533-B.CL 11-10-06			R *
3* (300)	E4	$\varnothing$ 2.50 THRU	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
3* (310)	F4	$\Phi$ .060 A B C $\varnothing$ 2.50	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
3* (320)	C7	8X $\varnothing$ 1-8UNC $\nabla$ 2	THREAD PLUG GAGE	QA	A-670	ACCEPT	533-B.CL 11-10-06			A *
3* (330)	C7	$\Phi$ .010 A B C 8X $\varnothing$ 1-8 UNC	CMM	QA	00064	.012 TO .026 [N/C:2 0759-Doc:NC20759]	339-E.RO 11-13-06			R *
3* (340)	D5	8X $\varnothing$ 1-8UNC THRU	THREAD PLUG GAGE	QA	A-670	ACCEPT	533-B.CL 11-10-06			A *
3* (350)	D5	$\varnothing$ .010 A B C 8X $\varnothing$ 1-8 UNC	CMM	QA	00064	.003 TO .068 [N/C:2 0759-Doc:NC20759]	339-E.RO 11-13-06			R *
3* (360)	D3	$\varnothing$ 2.50 THRU	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
3* (370)	D3	$\Phi$ .060 A B C $\varnothing$ 2.5	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
3* (380)	D1	40.90	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
4*	H6	$\square$ $\varnothing$ 2.000-2.001 $\nabla$ 0.990-1.000	DIAL BORE GAGE		J-1401	1.9995 TO 1.9999 DEPTH .992 TO .994 [N/C:20759-Doc:NC20				R

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(390)						759]			*
4* (400)	F4	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA	A-375	ACCEPT	533-B.CL 11-13-06		A *
4* (410)	F4	Φ   Ø.06   M   A   D Ø1.375-6	CMM	QA	00064	.007 TO .039	339-E.RO 11-13-06		A *
4* (420)	D4 &	Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA	J-1400	1.885 TO 1.8865	533-B.CL 11-10-06		A *
4* (430)	D4 &	Φ   Ø.06   M   A   D Ø1.885	CMM	QA	00064	.002 TO .018	339-E.RO 11-13-06		A *
4* (440)	B6	3X Ø1.5	CALIPER	QA	J-1103	1.508 TO 1.510	533-B.CL 11-13-06		A *
4* (450)	B6	Φ   .06   M   A   D 3X Ø1.5	CMM	QA	00064	.013 TO .024	339-E.RO 11-13-06		A *
4* (460)	A4	6X .25-20 UNC ▽ .5 .03" X 45° CHAMFER	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 11-10-06		A *
5* (470)	D8/D6	Ø1.885 ±.003	DIAL BORE GAGE	QA	J-1400	1.884 TO 1.8865	533-B.CL 11-10-06		A *
5* (480)	D8/D6	Φ   Ø.06   N   A   E Ø1.885	CMM	QA	00064	.020 TO .034	339-E.RO 11-13-06		A *
5* (490)	F8	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA	A-375	ACCEPT	339-E.RO 11-13-06		A *
5* (500)	F8	Φ   Ø.06   N   A   E Ø1.375-6 UNC	CMM	QA	00064	.007 TO .054	339-E.RO 11-13-06		A *
5* (510)	F6	8X 1/4 -20 UNC-2B	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 11-10-06		A *
5* (520)	D6	3X Ø1.5 ▽ 2.33	CALIPER CALIPER	QA	J-1103 J-1389	1.508 TO 1.509 DEP TH 2.325 TO 2.33	533-B.CL 11-13-06		A *
5* (530)	D6	Φ   Ø.06   N   A   E 3X Ø1.5	CMM	QA	00064	.028 TO .040	339-E.RO 11-13-06		A *
5*	B3	6X .25 - 20 UNC ▽ .5 Ø.03" X 45° CHAMFER	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL		A

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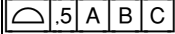
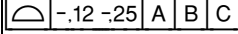
### INSPECTION DATA CHECKLIST

(540)								11-10-06		*
6* (550)	H7	6.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (560)	H7	1.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (570)	G8	6.70		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (600)	F8	6.70		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (610)	E7	5.75		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (620)	E7	1.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (630)	E6	4X Ø1.00	PIN GAGE	QA		J-921	.993 TO .996	533-B.CL 11-10-06		A *
6* (640)	G5	2X .88 - 1.13	CALIPER	QA		P-5075	1.110 TO 1.140 [N/C :20759-Doc:NC20759]	533-B.CL 11-10-06		R *
6* (650)	F5	.06-.09 X 45° TYP		QA		VISUAL	ACCEPT	533-B.CL 11-10-06		A *
7* (660)	G2	19.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
7* (670)	F2	2.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
7* (680)	F2	6.75		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
7* (690)	F2	3.75		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
7* (700)	F1	4X Ø.75-10 UNC ▽ 1.50	THREAD PLUG GAGE	QA		A-167	ACCEPT	533-B.CL 11-10-06		A *
7* (710)	D1	2X 1.56 OPEN THRU	CALIPER	QA		J-707	1.55	533-B.CL 11-10-06		A *

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### INSPECTION DATA CHECKLIST

7* (720)	C1	.375-16 UNC-2B TAP $\nabla$ .75 .03 X 45° CHAMFER 6X	THREAD PLUG GAGE	QA		A-233	ACCEPT	533-B.CL	11-10-06	A *
7* (730)	C4	VERIFY THAT HOLE LOCATIONS ARE SCRIBED ON THE PART.		QA		VISUAL	ACCEPT	533-B.CL	11-10-06	A *
7* (740)	B3	8.50 DISTANCE BETWEEN SCRIBE MARKINGS.		QA		VISUAL	ACCEPT	533-B.CL	11-10-06	A *
9* (750)	H1	2X $\varnothing$ .50	PIN GAGE	QA		J-652-3	.501	533-B.CL	11-13-06	A *
9* (760)	B7	TC2 HOLE TO BE .625" IN DIAMETER APPROX. 2.52" DEEP AND .25" IN DIAMETER AT LEAST 1" DEEP.	PIN GAGE  CALIPER	QA		J-652-3  J-1389	$\varnothing$ .625 DEPT 2.567 $\varnothing$ .250 DEPTH 1.017	533-B.CL	11-13-06	A *
* (770)		TC1 LOCATION AND CONFIGURATION MODIFIED. HOLE TO HAVE .625 CLEARANCE AND AT LEAST 1" OF DEPTH AT THE .25" DIA	PIN GAGE  CALIPER	QA		J-652-3  J-1389	$\varnothing$ .622 $\varnothing$ .250 DE PTH 1.125	533-B.CL	11-13-06	A *
10* (780)	F5	 INNER AS CAST SURFACES	CMM	QA		00064	-.3301 TO .3954 [N/ C:20759-Doc:NC20759 ]	339-E.RO	11-13-06	R *
10* (790)	D5	 WING SURFACES	CMM	QA		00064	-.0005 TO -.1940, - .1387 TO -.1942 [N/ C:20759-Doc:NC20759 ]	339-E.RO	11-13-06	R *
<b>Drawing ID: NCSX-CSPEC-141-03 Rev: 11</b>			<b>INSPECTION INSTRUCTIONS</b>			<b>RESULTS</b>			<b>INSPECTED BY</b>	
<b>SHEET</b>	<b>ZONE</b>	<b>CHARACTERISTIC</b>	<b>GAGE/EQUIP</b>	<b>BY</b>	<b>SAMPLE</b>	<b>SER#</b>	<b>DATA/REMARKS</b>	<b>INSP</b>	<b>VERFD</b>	<b>AUDIT</b>
4* (800)	3.1.1.4 <sup>125</sup>	THE TWO "L" MACHINED SURFACES OF TEE MUST HAVE A RMS OF 125.	PROFILOMETER	QA		J-1152	20 TO 100	533-B.CL	11-10-06	A *

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Workorder: 65709/4-0 Sub:1 Op:136

Revision:

**Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A**

Drawing ID: SE141-114 Rev: 8			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	LESS THAN 1.02	503-B.HO			A
(10)								11-10-06			*
*		<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	LESS THAN 1.02	503-B.HO			A
(20)								11-10-06			*

Workorder: 65709/4-0 Sub:1 Op:140

Revision:

**Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A**

Drawing ID: SE141-101 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 GOHMS	503-B.HO			A
(10)								11-09-06			*
*		<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	2.2 GOHMS	503-B.HO			A
(20)								11-09-06			*

Workorder: 65709/4-0 Sub:13 Op:30

Revision:

\* To Far Right Indicates Data Package Requirement

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**Part: SE141-141 - BEARING PLATE DETAIL TYPE "A" SHORT -**

Drawing ID: SE141-141 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-1165	LESS THAN 1.02	503-B.HO  06-29-06			A  *

Workorder: 65709/4-0 Sub:14 Op:30

Revision:

**Part: SE141-142 - BEARING PLATE DETAIL TYPE "A" LONG -**

Drawing ID: SE141-142 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-1165	LESS THAN 1.02	503-B.HO  07-19-06			A  *

\* To Far Right Indicates Data Package Requirement

NOTE: the recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, title 18, chapter 47.