

**Customer: ENERGY INDUSTRIES OF OHIO**

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**Part: /**

Drawing ID: SE141-114

Revision: 7

Customer P.O.: S005242-F/Ln:2  
Serial No./Qty: 1

Reported By: MIKE GRIFFITH

E-Mail: mGriffith@MajorTool.com

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

Problem: Inspection Test #: 130 rejected: OUTER AS CAST SURFACES: {g|,5|A|B|C}: -.092 TO .553  
Inspection Test #: 140 rejected: 2 X .40: : .395 TO .435 ON E SIDE, .355 TO .410 ON D SIDE  
Inspection Test #: 150 rejected: 4 X .03 X 45: : .035 ON E SIDE, .010 TO .035 ON D SIDE  
Inspection Test #: 180 rejected: DATUM D SIDE  
VERIFY SHELL INTERSECT CLEARANCE WITH GAGE MTMFX-3473: : REJECT - MODEL DOES NOT ALLOW FOR CLEARANCE  
Inspection Test #: 190 rejected: M TO M1: {g|,02|R|T|S}: -.021 TO .012  
Inspection Test #: 230 rejected: N TO N1: {g|,02|R|T|S}: -.017 TO .027  
Inspection Test #: 240 rejected: 2 X .06/.09 X 45: : .025 TO .050  
Inspection Test #: 260 rejected: : bd.625 y .188: .618 TO .627 DEPTH .165 TO .193  
Inspection Test #: 280 rejected: DATUM E FLANGE: {f|,01}: .015  
Inspection Test #: 290 rejected: DATUM D FLANGE: {f|,01}: .032  
Inspection Test #: 330 rejected: 8X Ø1-8 UNC: {#|,010|A|B|C}: .016 TO .060  
Inspection Test #: 350 rejected: 8X Ø1-8 UNC: {d|,010|A|B|C}: .016 TO .066  
Inspection Test #: 460 rejected: : 6X .25-20 UNC y .5  
.5 X 82` CHAMFER: THE THREADS ARE ACCEPTABLE BUT THE CHAMFER IS TOO BIG .500  
Inspection Test #: 480 rejected: Ø1.885: {#|d,06|N|A|E}: .003 TO .074  
Inspection Test #: 540 rejected: : 6X .25 - 20 UNC y .6  
d.5 X 82` CHAMFER: .375 DIA. CHAMFER  
Inspection Test #: 780 rejected: INNER AS CAST SURFACES: {g|,5|A|B|C}: -.034 TO -.337 / -.341 TO .073  
Inspection Test #: 790 rejected: WING SURFACES: {g|-,12;;;,\,25|A|B|C}: -.164 TO -.197 / -.016 TO -.206

**Additional Items:**

- 1) Tool Gouge on top edge of T, datum D side. Gouge is approximately .300" long and .015" in depth. See pictures.
- 2) G11 shim is below flush on the outer surface of the datum D flange. G11 is approximately .08" below flange surface. See pictures.
- 3) Tool marks did not clean up on the short leg of the D flange from holes 16 to 19. Tool marks appear to be less than .005" in depth. See pictures.

**Proposed Disposition:**

Propose to accept deviations As-Is.

Number of additional pages: Dimensional IDC and Final Visual Pictures

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

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**Nonconformance Report: NC 20080**

A-2 dimensional deviations and surface discontinuities.

**Project Disposition:**

All deviations and discontinuities were evaluated and reviewed by NCSX in a teleconference on 6/28/06. All were determined to be acceptable as-is.

**Approvals:**

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Procurement Technical Representative

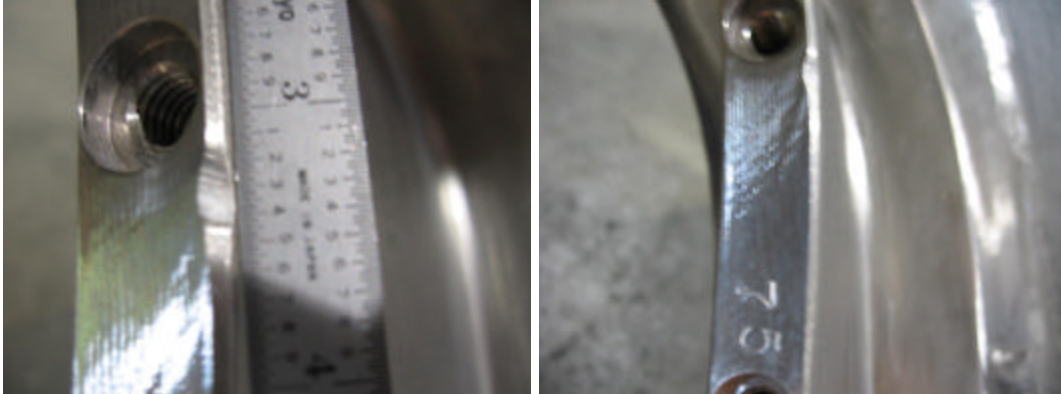
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Responsible Line Manager:

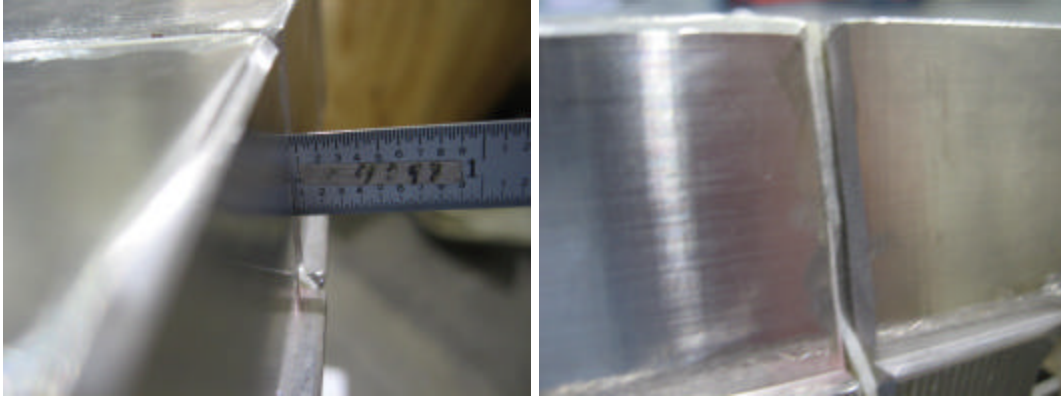
**Major Tool Implemented By:** \_\_\_\_\_ **Title:** \_\_\_\_\_ **Date:** \_\_\_\_\_

SE141-114 A2  
NC20080 attachment

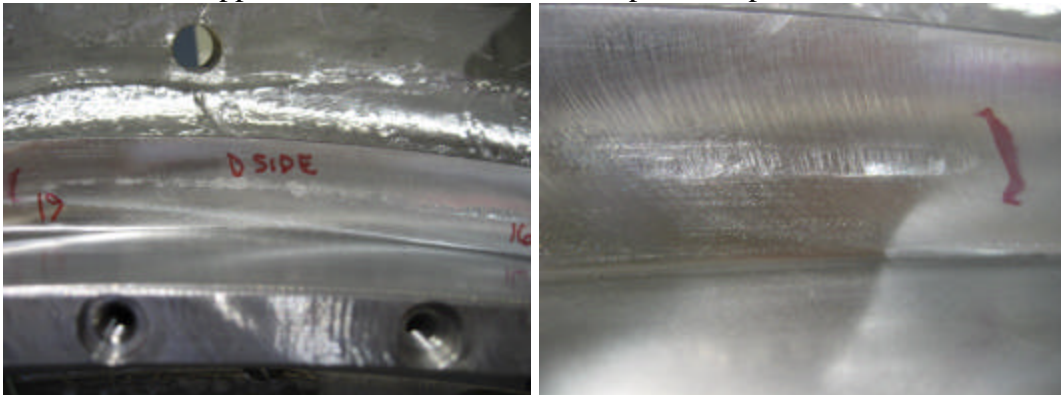
1. Tool gouge on top edge of T section on the datum D side of the part. Gouge is near hole 76.



2. G11 shim is below flush on the outer surface of the datum D flange. G11 is approximately .08" below flange surface.



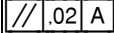
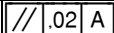
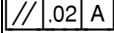
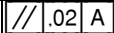

3. Tool marks did not clean up on the short leg of the D flange from holes 16 to 19. Tool marks appear to be less than .005" in depth. See pictures.



Workorder: 65709/2-0 Sub:1 Op:132

Revision: 06/24/06 0:03


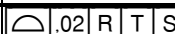


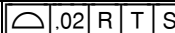
Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

Drawing ID: SE141-114 Rev: 7			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		MTMFX3564	ACCEPT	339-E.RO 06-27-06			A *
1* (20)	E8	FLANGE PROFILE +/- .25 IN THIS AREA	CMM	QA		00064	-.0027 TO -.0065	339-E.RO 06-27-06			A *
1* (30)	D8		CMM	QA		00064	.006	339-E.RO 06-27-06			A *
1* (40)	D8	54.20 ± .03	CMM	QA		00064	54.206	339-E.RO 06-27-06			A *
1* (50)	C8	54.20 ± .03	CMM	QA		00064	54.205	339-E.RO 06-27-06			A *
1* (60)	B8		CMM	QA		00064	.005	339-E.RO 06-27-06			A *
1* (70)	D5		CMM	QA		00064	.002	339-E.RO 06-27-06			A *
1* (80)	D5	48.50 ± .03	CMM	QA		00064	48.498	339-E.RO 06-27-06			A *
1* (90)	C5	48.50 ± .03	CMM	QA		00064	48.494	339-E.RO 06-27-06			A *
1* (100)	B5		CMM	QA		00064	.006	339-E.RO 06-27-06			A *
1* (110)	D4	VERIFY PART MARKING: MAJOR TOOL SE141-114 A(casting number) (weight) LBS.		QA		VISUAL	ACCEPT	339-E.RO 06-27-06			A *
1* (120)	D4	RECORD WEIGHT		QA			5180	242-M.G 06-21-06			A *
1*	D3		CMM	QA		00064	-.092 TO .553 [N/C:	339-E.RO			R

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### INSPECTION DATA CHECKLIST

(130)		OUTER AS CAST SURFACES				20080-Doc:NC20080]	06-27-06			*
2*	F8		CALIPER	QA	P-5075	.395 TO .435 ON DATUM E SIDE, .355 TO .410 ON DATUM D SIDE [N/C:20080-Doc:NC20080]	533-B.CL			R
(140)		2 X .40					06-23-06			*
2*	F8		CALIPER	QA	P-5075	.035 ON DATUM E SIDE, .010 TO .035 ON DATUM D SIDE [N/C:20080-Doc:NC20080]	533-B.CL			R
(150)		4 X .03 X 45					06-23-06			*
2*	G6		PIN GAGE	QA	J-651-2	.187 ON DATUM E SIDE, .183 TO .192 ON DATUM D SIDE	533-B.CL			A
(160)		2 X R.187 +.025 / -.005					06-23-06			*
2*	G5		CMM	QA	00064	-.003 TO .081	339-E.RO			A
(170)		P TO M					06-27-06			*
2*	G5			QA	MTMFX-3473	REJECT - MODEL DOES NOT ALLOW FOR CLEARANCE [N/C:20080-Doc:NC20080]	339-E.RO			R
(180)		DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473					06-27-06			*
2*	F5		CMM	QA	00064	-.021 TO .012 [N/C:20080-Doc:NC20080]	339-E.RO			R
(190)		M TO M1					06-27-06			*
2*	E5		CMM	QA	00064	-.015 TO .017	339-E.RO			A
(200)		M1 TO N1					06-27-06			*
2*	G3		CMM	QA	00064	.015 TO .092	339-E.RO			A
(210)		Q TO N					06-27-06			*
2*	F3			QA	MTMFX-3473	ACCEPT	339-E.RO			A
(220)		DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473					06-27-06			*
2*	F3		CMM	QA	00064	-.017 TO .027 [N/C:20080-Doc:NC20080]	339-E.RO			R
(230)		N TO N1					06-27-06			*
2*	B4		CALIPER	QA	P-5075	.025 TO .050 [N/C:20080-Doc:NC20080]	533-B.CL			R
										*

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### INSPECTION DATA CHECKLIST

(240)		2 X .06/.09 X 45					0080-Doc:NC20080]	06-23-06		
2* (250)	B5	Ø .375-16 UNC ▽ .750 +.1 -0 96 X	THREAD PLUG GAGE	QA	100%	A-151	ACCEPT	339-E.RO 06-27-06		A *
2* (260)	B5	└┐Ø.625 ▽ .188	PIN GAGE	QA		J-652-3	.618 TO .627 DEP TH .165 TO .193 [N/ C:20080-Doc:NC20080	533-B.CL 06-23-06		R *
2* (270)	B5	⊕ .06 R T S 375-16 HOLES	CMM	QA		00064	.005 TO .055	339-E.RO 06-27-06		A *
3* (280)	H3	▱ .01 DATUM E FLANGE	CMM	QA		00064	.015 [N/C:20080-Doc :NC20080]	339-E.RO 06-27-06		R *
3* (285)	H4	√ <sup>125</sup> DATUM E FLANGE	PROFILOMETER	QA		J-1109	25 TO 81	533-B.CL 06-23-06		A *
3* (290)	F2	▱ .01 DATUM D FLANGE	CMM	QA		00064	.032 [N/C:20080-Doc :NC20080]	339-E.RO 06-27-06		R *
3* (295)	F3	√ <sup>125</sup> DATUM D FLANGE	PROFILOMETER	QA		J-1109	32 TO 78	533-B.CL 06-23-06		A *
3* (300)	E4	Ø2.50 THRU	DIAL BORE GAGE	QA		J-1401	2.495	533-B.CL 06-23-06		A *
3* (310)	F4	⊕ .060 A B C Ø2.50	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A *
3* (320)	C7	8X Ø1-8UNC ▽ 2	THREAD PLUG GAGE	QA		A-347	ACCEPT	533-B.CL 06-22-06		A *
3* (330)	C7	⊕ .010 A B C 8X Ø1-8 UNC	CMM	QA		00064	.016 TO .060 [N/C:2 0080-Doc:NC20080]	339-E.RO 06-27-06		R *
3* (340)	D5	8X Ø1-8UNC THRU	THREAD PLUG GAGE	QA		A-347	ACCEPT	533-B.CL 06-22-06		A *
3* (350)	D5	Ø .010 A B C 8X Ø1-8 UNC	CMM	QA		00064	.016 TO .066 [N/C:2 0080-Doc:NC20080]	339-E.RO 06-27-06		R *
3* (360)	D3	Ø2.50 THRU	DIAL BORE GAGE	QA		J-1401	2.491	533-B.CL 06-23-06		A *
3* (370)	D3	⊕ .060 A B C Ø2.5	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A *
3* (370)	D1		CMM	QA		00064	SEE IGES DATA	339-E.RO		A

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### INSPECTION DATA CHECKLIST

(380)		40.90						06-27-06		*
4*	H6	$\square \text{ } \varnothing 2.000-2.001 \text{ } \nabla 0.990-1.000$	DIAL BORE GAGE	QA		J-1401	2.0005, 2.0007, 2.0009 DEPTH .992 TO .996	533-B.CL		A
(390)			CALIPER			P-5075		06-24-06		*
4*	F4	$\varnothing 1.375-6\text{UNC THRU}$	THREAD PLUG GAGE	QA		A-375	ACCEPT	533-B.CL		A
(400)								06-23-06		*
4*	F4	$\varnothing \varnothing .06 \text{ M A D}$	CMM	QA		00064	.036	339-E.RO		A
(410)		$\varnothing 1.375-6$						06-27-06		*
4*	D4 &	$\varnothing 1.885 \pm .003 \text{ THRU}$	DIAL BORE GAGE	QA		J-1400	1.883 TO 1.887	533-B.CL		A
(420)								06-23-06		*
4*	D4 &	$\varnothing \varnothing .06 \text{ M A D}$	CMM	QA		00064	.012 TO .059	339-E.RO		A
(430)		$\varnothing 1.885$						06-27-06		*
4*	B6	3X $\varnothing 1.5$	CALIPER	QA		J-1103	1.500 TO 1.502	533-B.CL		A
(440)								06-23-06		*
4*	B6	$\varnothing .06 \text{ M A D}$	CMM	QA		00064	.020 TO .058	339-E.RO		A
(450)		3X $\varnothing 1.5$						06-27-06		*
4*	A4	6X .25-20 UNC $\nabla .5$ .5 X 82° CHAMFER	THREAD PLUG GAGE	QA		A-715	THE THREADS ARE ACCEPTABLE BUT THE CHAMFER IS TOO BIG .500 [N/C:20080-Doc:N	533-B.CL		R
(460)			CALIPER			P-5075	C20080]	06-24-06		*
5*	D8/D6	$\varnothing 1.885 \pm .003$	DIAL BORE GAGE	QA		J-1400	1.8835 TO 1.884	533-B.CL		A
(470)								06-22-06		*
5*	D8/D6	$\varnothing \varnothing .06 \text{ N A E}$	CMM	QA		00064	.003 TO .074 [N/C:20080-Doc:NC20080]	339-E.RO		R
(480)		$\varnothing 1.885$						06-27-06		*
5*	F8	$\varnothing 1.375-6\text{UNC THRU}$	THREAD PLUG GAGE	QA		A-375	ACCEPT	533-B.CL		A
(490)								06-23-06		*
5*	F8	$\varnothing \varnothing .06 \text{ N A E}$	CMM	QA		00064	.043	339-E.RO		A
(500)		$\varnothing 1.375-6 \text{ UNC}$						06-27-06		*
5*	F6	8X 1/4 -20 UNC-2B	THREAD PLUG GAGE	QA		A-715	ACCEPT	533-B.CL		A
(510)								06-23-06		*
5*	D6	3X $\varnothing 1.5 \text{ } \nabla 2.33$	CALIPER	QA		J-1103	1.498 TO 1.500	533-B.CL		A
(520)			CALIPER			P-5075	DEPTH 2.330 TO 2.340	06-22-06		*

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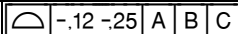
### INSPECTION DATA CHECKLIST

5* (530)	D6	$\varnothing .06$ N A E 3X $\varnothing 1.5$	CMM	QA		00064	.024 TO .029	339-E.RO 06-27-06			A *
5* (540)	B3	6X .25 - 20 UNC $\nabla$ .6 $\varnothing .5$ X 82° CHAMFER	CALIPER	QA		P-5075	.375 DIA. CHAMFER [ N/C:20080-Doc:NC200 80]	533-B.CL 06-23-06			R *
6* (550)	H7	6.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06			A *
6* (560)	H7	1.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06			A *
6* (570)	G8	6.70	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06			A *
6* (600)	F8	6.70	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06			A *
6* (610)	E7	5.75	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06			A *
6* (620)	E7	1.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06			A *
6* (630)	E6	4X $\varnothing 1.00$	PIN GAGE	QA		J-921	.995	533-B.CL 06-23-06			A *
6* (640)	G5	2X .88 - 1.13	CALIPER	QA		P-5075	1.115 TO 1.130	533-B.CL 06-23-06			A *
6* (650)	F5	.06-.09 X 45° TYP	CALIPER	QA		P-5075	.065	533-B.CL 06-22-06			A *
7* (660)	G2	19.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06			A *
7* (670)	F2	2.00	CALIPER	QA		P-5075	2.00	533-B.CL 06-22-06			A *
7* (680)	F2	6.75	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06			A *
7* (690)	F2	3.75	CALIPER	QA		P-5075	3.745 TO 3.750	533-B.CL 06-22-06			A *
7* (700)	F1	4X $\varnothing .75$ -10 UNC $\nabla$ 1.50	THREAD PLUG GAGE	QA		A-167	ACCEPT	533-B.CL 06-22-06			A *
7*	D1		CALIPER	QA		P-5075	1.560	533-B.CL			A

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### INSPECTION DATA CHECKLIST

(710)		2X 1.56 OPEN THRU						06-22-06		*	
7*	C1	.375-16 UNC-2B TAP▽ .75 .03 X 45° CHAMFER	THREAD PLUG GAGE	QA		A-444	ACCEPT CHAMFE	533-B.CL		A	
(720)		6X	CALIPER			P-5075	R .035	06-22-06		*	
7*	C4	VERIFY THAT HOLE LOCATIONS ARE SCRIBED ON THE PART.		QA		VISUAL	ACCEPT	533-B.CL		A	
(730)								06-22-06		*	
7*	B3	8.50 DISTANCE BETWEEN SCRIBE MARKINGS.	CALIPER	QA		J-1389	ACCEPT	533-B.CL		A	
(740)								06-22-06		*	
9*	H1	2X Ø.50	PIN GAGE	QA		J-652-3	.500	533-B.CL		A	
(750)								06-23-06		*	
9*	B7	TC2 HOLE TO BE .625" IN DIAMETER APPROX. 2.52" DEEP AND .25" IN DIAMETER AT LEAST 1" DEEP.	PIN GAGE	QA		J-652-3	2.570 DEEP .623 D IA. 1 DEEP . 252 DIA.	533-B.CL		A	
(760)			CALIPER			P-5075		06-23-06		*	
*		TC1 LOCATION AND CONFIGURATION MODIFIED. HOLE TO HAVE .625 CLEARANCE AND AT LEAST 1" OF DEPTH AT THE .25" DIA	PIN GAGE	QA		J-652-3	.623 DIA. 1.150 D EEP .252 DIA.	533-B.CL		A	
(770)			CALIPER			P-5075		06-23-06		*	
10*	F5		CMM	QA		00064	-.034 TO -.337 / -. 341 TO .073 [N/C:20 080-Doc:NC20080]	339-E.RO		R	
(780)		INNER AS CAST SURFACES						06-27-06		*	
10*	D5		CMM	QA		00064	-.164 TO -.197 / -. 016 TO -.206 [N/C:2 0080-Doc:NC20080]	339-E.RO		R	
(790)		WING SURFACES						06-27-06		*	
<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*	3.1.1.4	<sup>125</sup> THE TWO "L" MACHINED SURFACES OF	PROFILOMETER	QA		J-1109	15 TO 30	533-B.CL		A	

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# INSPECTION DATA CHECKLIST

(800)	TEE MUST HAVE A RMS OF 125.							06-23-06		*
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Employees: 242-M.Griffith / 339-E.Root / 533-B.Clevenger

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