

**Customer: ENERGY INDUSTRIES OF OHIO**

Contact: NANCY HORTON  
E-Mail: NKHFlowen@aol.com

Telephone: 216-496-2314  
Fax: 216-328-2001

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

Drawing ID: SE141-114                      Revision: 6  
Links: 1-Type:W: 65709/1.0 Sub: 1 Op: 50

Customer P.O.: S005242-F/Ln:1  
Serial No./Qty: A1

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

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

Problem: Reference sheet 4, zone G7.

There is a tool gouge along the short leg of the T section on the Datum -D- side. The gouge is approximately 13.5" long, .900" wide and .200 deep. See attachments for clarification.

**Proposed Disposition:**

Propose to weld repair the tool gouge. Indicators would be applied on and around the T section to monitor any part movement caused by welding. The welding process would altered as needed to minimize movement. A local mag permeability and PT inspection would be performed. This gouge is located on the short leg in the area designated as "High Stress". During the RT of the High Stress area an additional shot would be taken of the repaired area. It is likely that this RT shot would prove inconclusive due to it's location.

Number of additional pages: \_\_\_\_\_

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

NCSX agrees with MTM's recommended disposition to weld repair, followed by local mag. perm. Inspection, PT inspection, and RT during the RT of the high stress area. MTM is requested to provide documentation after the repair is completed.

**Tech. Rep.:** \_\_\_\_\_                      **Title:** \_\_\_\_\_                      **Date:** \_\_\_\_\_

**RLM:** \_\_\_\_\_                      **Title:** \_\_\_\_\_                      **Date:** \_\_\_\_\_

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

**Root Cause 1: 816-PROGRAMMING ERROR**

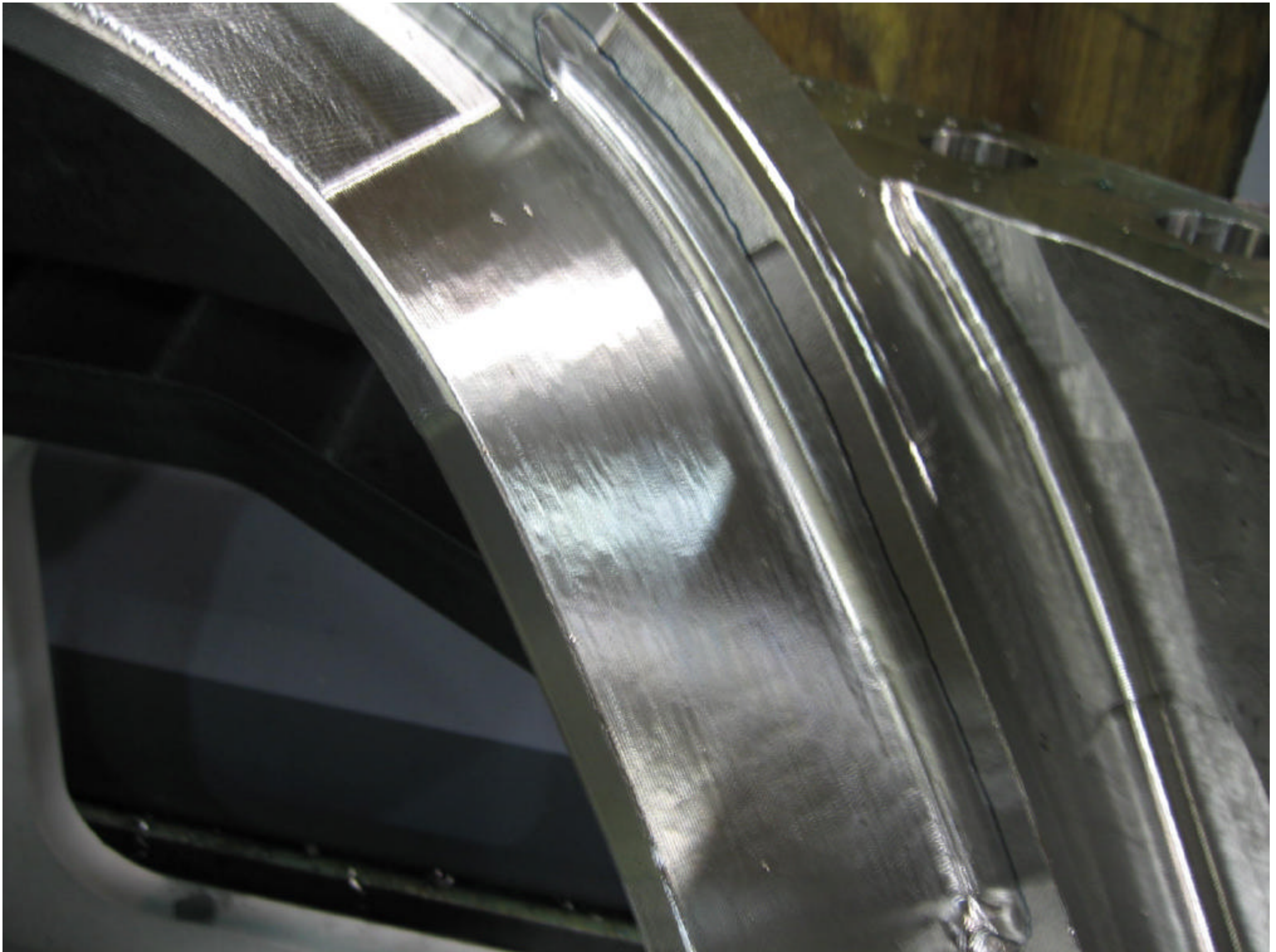
Resource: CAD/CAM - MEDIUM MILLING                      Equipment:

Description: There are 2 root causes here.

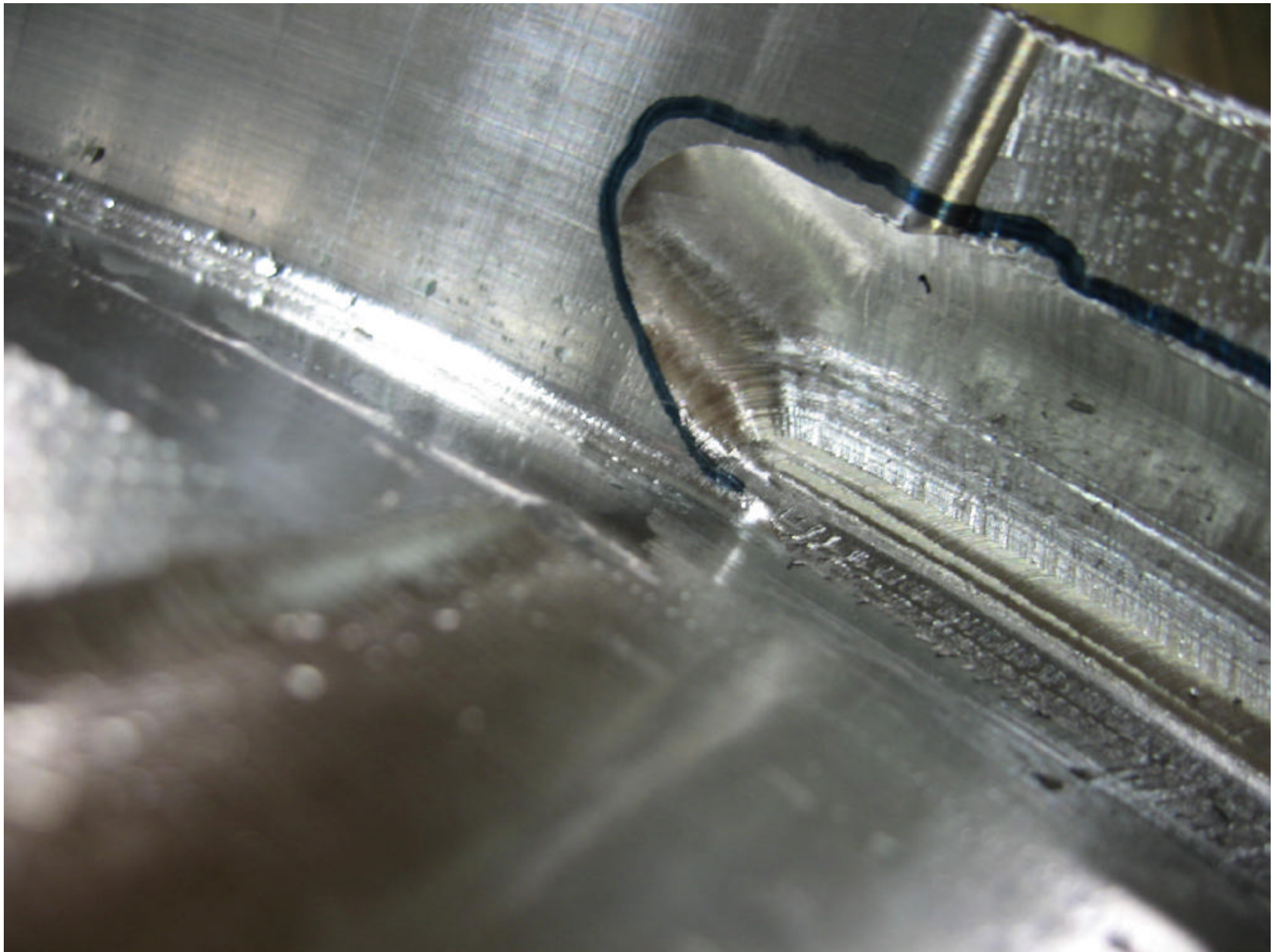
- 1) The tool gouged the wall because the toolpath was generated incorrectly. The check surface (back wall) was not selected and therefore the toolpath gouged the back wall.
- 2) The toolpath (n/c program 31501) was released as a good program because the verification did not show / flag an error of the toolpath violating the design model.

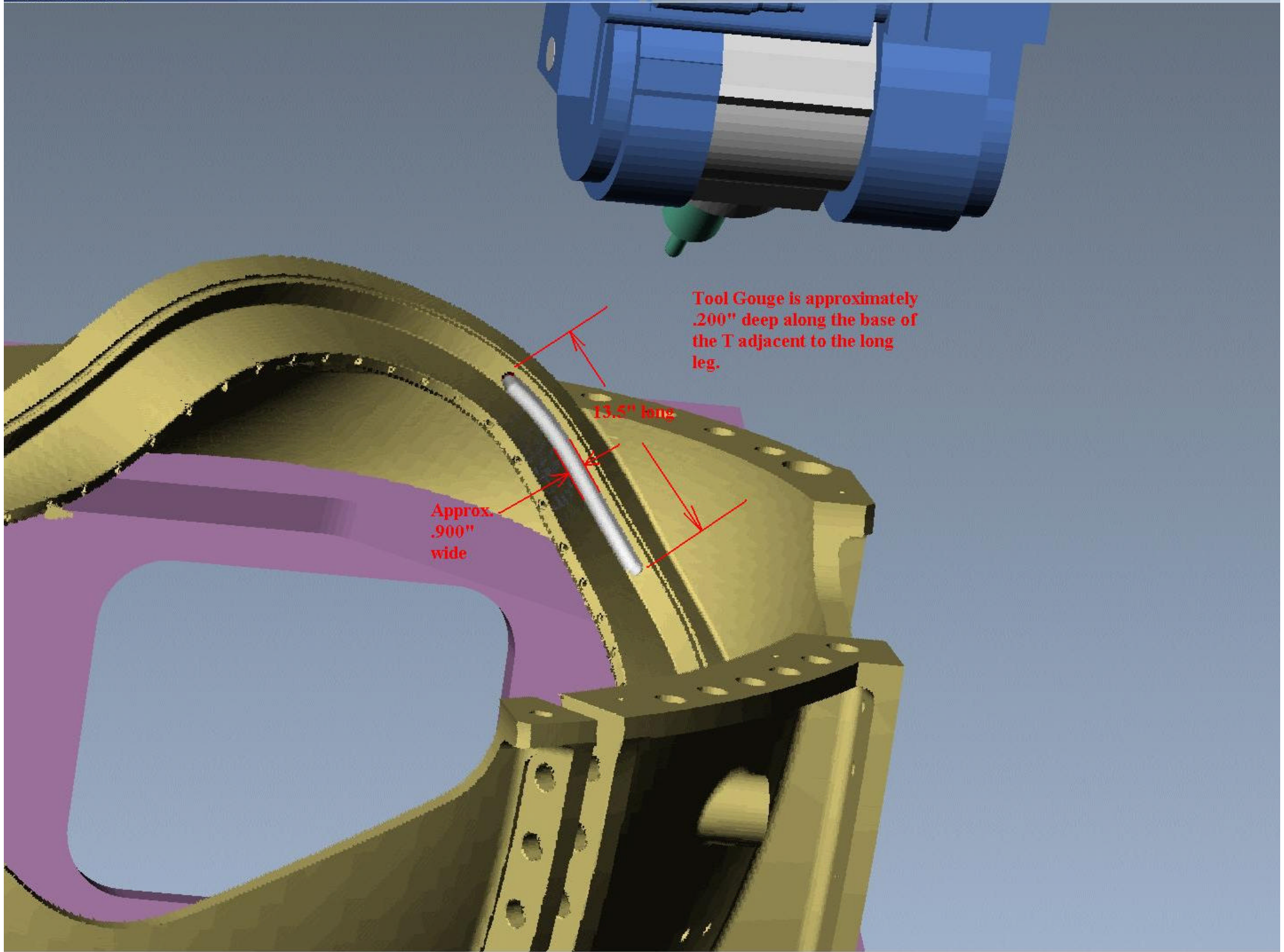
**Corr Actn: 1:** \_\_\_\_\_                      Action:    By:

Description:









Tool Gouge is approximately  
.200" deep along the base of  
the T adjacent to the long  
leg.

13.5" long

Approx.  
.900"  
wide