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**Customer: ENERGY INDUSTRIES OF OHIO**

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

Drawing ID: SE141-114

Revision: 6

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

Reported By: MIKE GRIFFITH

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Problem: Sheet 2, Zone B5; 96X .625 diameter counterbore, .188" +/- .005 deep.  
31 counterbores plus the 1 hole in poloidal break (total of 32) check from .210" to .310".  
34 counterbores are under the low limit of the tolerance.  
(see attachment for details)

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**Proposed Disposition:**

Propose to machine all of the discrepant deep holes (32 places) to a depth of .310". The holes that are currently shallow will be machined to meet the drawing requirements.

Major Tool will provide PPPL with 14 bushings to compensate for the machining error in the holes that require clamps.

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Number of additional pages: 1 attachment

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

NCSX agrees with MTM's proposed disposition. The bushings shall be made per dwg. SE 142C-294. It is recommended that MTM consider increasing the quantity of bushings being made as contingency if needed in the future..

Approved by:

Tech. Rep.

RLM

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

# SE141-114 TYPE A1

## NC19783 Attachment

Holes are numbered from center of Lead Block Slot toward the Poloidal Break.

Hole #	Depth
1	0.242
2	0.242
3	0.242
4	0.244 C
5	0.247
6	0.26 C
7	0.27
8	0.275 C
9	0.29
10	0.295 C
11	0.3
12	0.31 C
13	0.31
14	0.31 C
15	0.31
16	0.298 C
17	0.295
18	0.295 C
19	0.286
20	ACCEPT
21	ACCEPT
22	ACCEPT
23	ACCEPT
24	ACCEPT
25	ACCEPT
26	ACCEPT
27	ACCEPT
28	ACCEPT
29	ACCEPT
30	ACCEPT
31	ACCEPT
32	ACCEPT
33	ACCEPT

Hole #	Depth
34	ACCEPT
35	S
36	S
37	N/M
38	N/M
39	N/M
40	N/M
41	N/M
42	N/M
43	N/M
44	S
45	S
46	S
47	S
48	S
49	S
50	S
51	S
52	S
53	S
54	S
55	S
56	S
57	S
58	ACCEPT
59	0.215 C
60	ACCEPT
61	ACCEPT
62	ACCEPT
63	0.21 C
64	0.225
65	S
66	S

Hole #	Depth
67	S
68	S
69	N/M
70	N/M
71	N/M
72	N/M
73	N/M
74	S
75	S
76	S
77	S
78	S
79	S
80	S
81	S
82	S
83	S
84	S
85	S
86	S
87	S
88	0.26 C
89	0.262
90	0.258 C
91	0.253
92	0.25 C
93	0.25
94	0.246 C
95	0.245
96	0.245
Break	0.282

S = Shallow

N/M = Not Machined

ACCEPT = Within Tolerance

C = designates clamp hole which will require special bushing per DWG SE142C-294 Rev. 0