Major Tool & Machine, Inc.
1458 East 19th Street
Indianapolis, IN 46218-4289

MTM N/C: 20519

Date: 09/25/06
User ID: GRIFFITH

Customer: ENERGY INDUSTRIES OF OHIO
Contact: NANCY HORTON — Telephone: 216-496-2314
E-Mail: NKHFlowen@aol.com — Fax: 216-328-2001

Part: SE141-115 / MODULAR COIL, TYPE B — Customer P.O.: S005242-F/Ln:1
Drawing ID: SE141-102 — Revision: 3 — Serial No./Qty: B1
W/O Links: 1-Type:W: 65708/1.0 Sub: 0

Reported By: MIKE GRIFFITH — Telephone: 317-636-6433
E-Mail: mGriffith@MajorTool.com — Fax: 317-634-9420

Problem: Various issues were identified during the final review of the castings. See attachment for details.

Proposed Disposition:
Customer to review and provide remedial action.

Number of additional pages: 6 page attachment

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

The article to be dispositioned as follows, item numbers refer to the sections in the NC20519 attachment:
Item 1. Rework- Trim the bearing plate back to match the shape of the G-11CR insulator it's resting on
Item 2. Use As Is
Item 3. Use As Is
Item 4. Use As Is
Item 5. Use As Is
Item 6. Use As Is
Item 7. Use As Is
Item 8. Rework - The counterbores around the flange holes need to be enlarged to a 3" diameter cylinder by 3" high from the spot face surface. The blend-in corner radius at the upper extent of this machined area shall be 1/4".

The B1 casting may be released for shipment pending completion of item 8 of the corrective action of this NC.

Tech Rep Approval: Larry Dudek Digitally signed by Larry Dudek DN: cn=Larry Dudek, c=US Date: 2006.09.27 11:10:48 -04'00' Date: _____

RLM Approval: Brad Nelson Digitally signed by Brad Nelson DN: cn=Brad Nelson, c=US, o=ORNL, ou=FED, email=nelsonbe@ornl.gov Date: 2006.09.27 17:06:18 -04'00' Date: _____

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

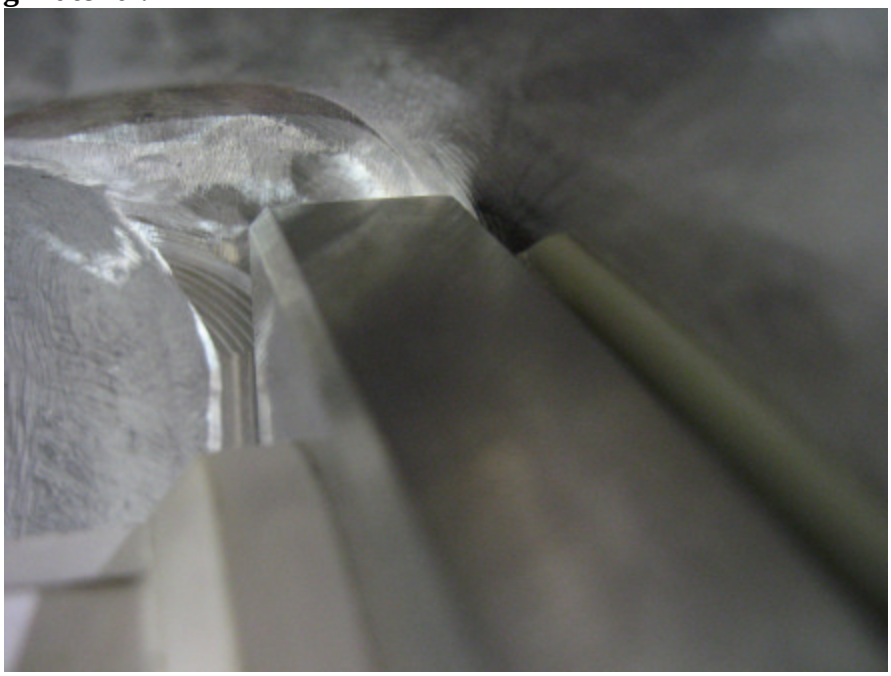
n:\mtmapps\Mtnonc14.qrp

SE141-115 B1

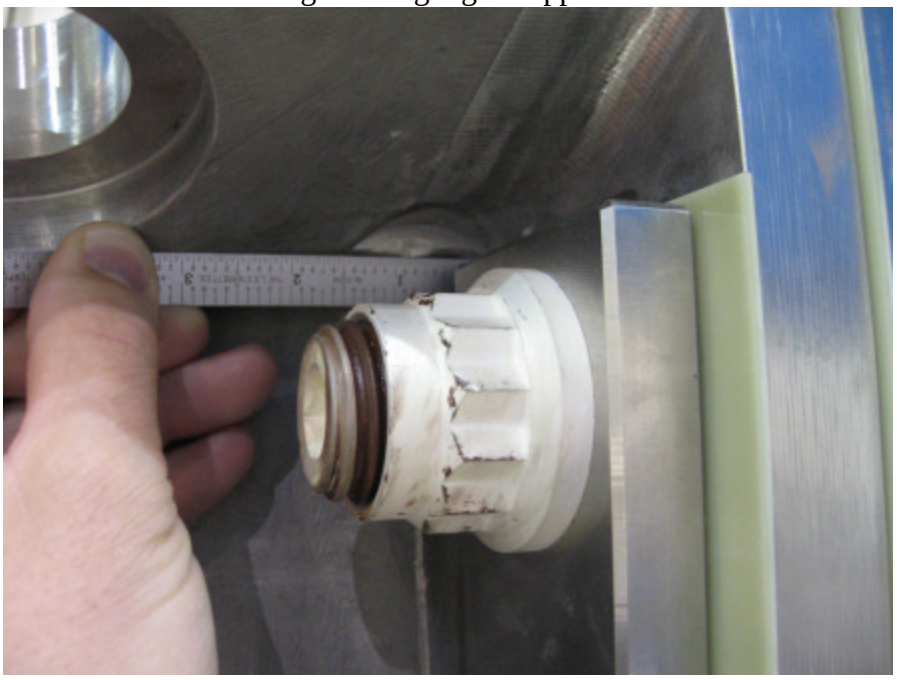
NC20519 attachment

1. Insulating material does not extend beyond bearing plate in one place nearest the datum D flange. The area is approximately .5” x .5” along the corner of the plate.

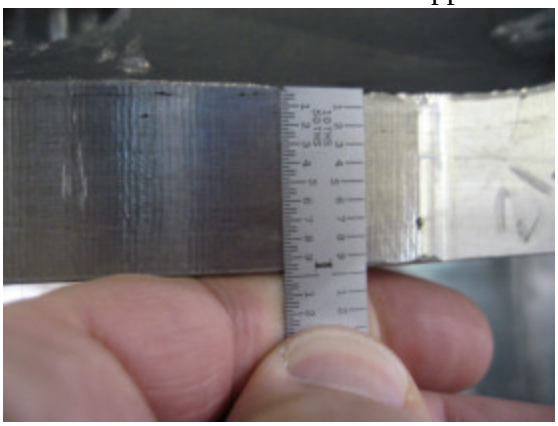
Proposed Action: Remove material from corner of bearing plate to match insulating material.



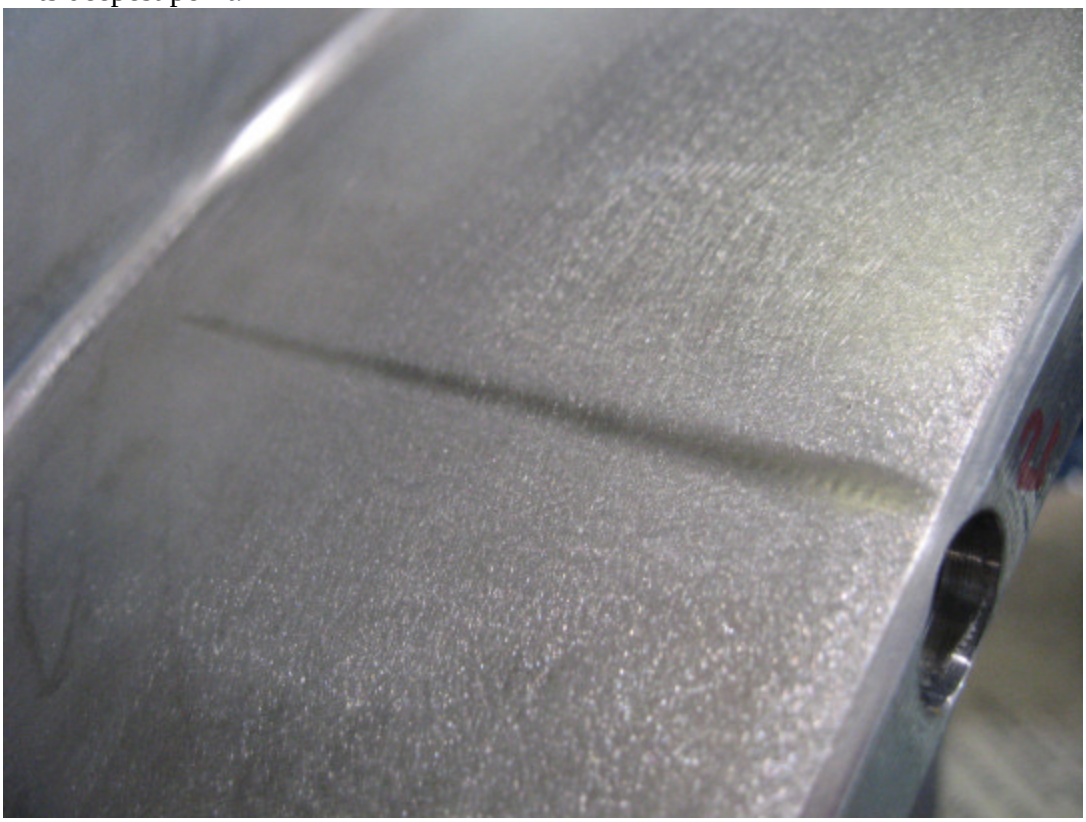
2. There is a tool gouge (eyebrow shape) near the poloidal break flange just underneath the datum D flange. The gouge is approx. 1.4” across.



3. There is an area of the datum E flange that is 1.00 thick on the outer edge. The area under the 1.25” minimum is approx. 20” long in the area circled below.

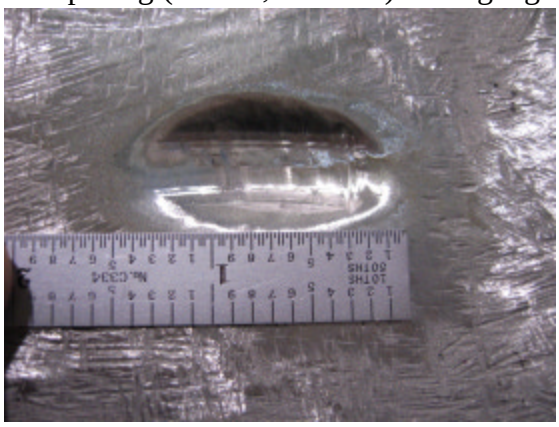
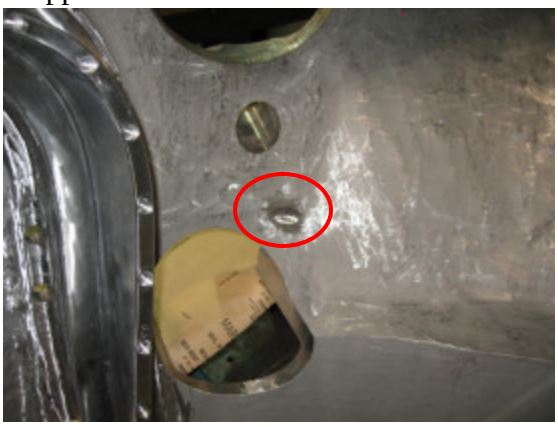


4. There is a cutter mark on the datum D side of the long leg of the T section near T hole 21. The cross section thickness of the T at this point checks .733”. When compared to the surfaces adjacent to the mark, it measures approximately .011” at its deepest point.

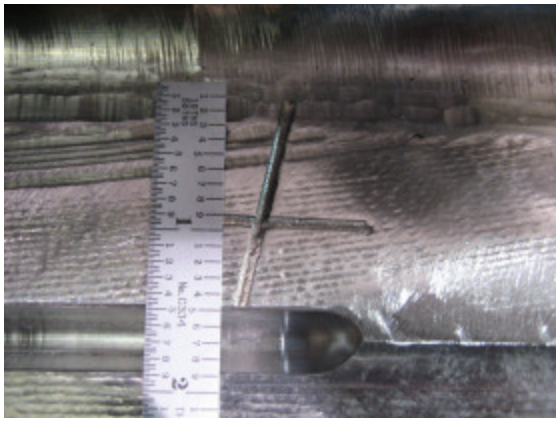


5. There are several tooling marks on the long and short legs of the T section on the datum E side near T hole 90. The cross section thickness of the T at this point checks .737". When compared to the surfaces adjacent to the mark, it measures approximately .013" at its deepest point.
   The deepest tool mark is shown next to the scale in the bottom-left photo. This gouge checks approx. .03" in depth.

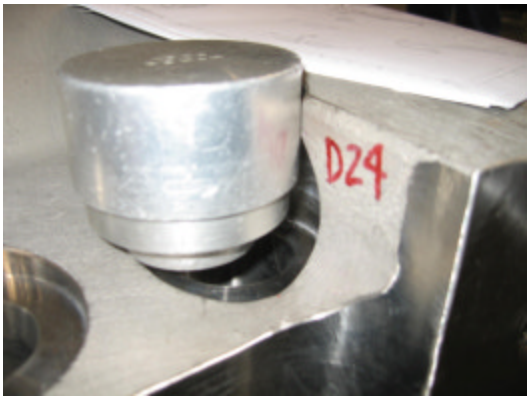
6. There is a tool gouge on the inner wall on the datum D side near the 8” port opening (sheet 8, zone B6). The gouge is approx. 1.5” wide.

7. The scribe marks do not match the drawing requirements as described on sheet 7, zone E6. The scribing was performed prior to notification of the revision 9 changes. The scribing is to be aligned with sections U2 and U3 of the drawing (perpendicular and parallel to the base of the T). The scale in the below pictures show what would be the correct orientation (This conditions exists on both the D and E sides.




8. There are six counterbores that will not accept the 3” diameter gage. The holes are designated by the flange side (E or D) and flange hole number.



SE141-115 B1

NC20519 attachment