
Customer: ENERGY INDUSTRIES OF OHIO

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Part: SE141-116 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-116-1MTM Revision: 6A

Customer P.O.: S005242-F/Ln:5
Serial No./Qty: C5

Reported By: MIKE GRIFFITH
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Problem: THERE ARE MINOR AREAS OF TOOLING NONCLEANUP AND GOUGES ON THE T SECTION AND IN OTHER AREAS AROUND THE CASTING. SEE ATTACHMENT FOR CLARIFICATION.

Proposed Disposition:

Propose to Accept As Is.

Number of additional pages: 1 attachment

Customer Disposition: Use As Is Rework Repair Scrap Replace

The noncleanup and gouges shown in the attachment were reviewed and accepted as is. NCSX will evaluate each of these and may opt to fill those located in winding surface areas with cryogenic grade epoxy filler.

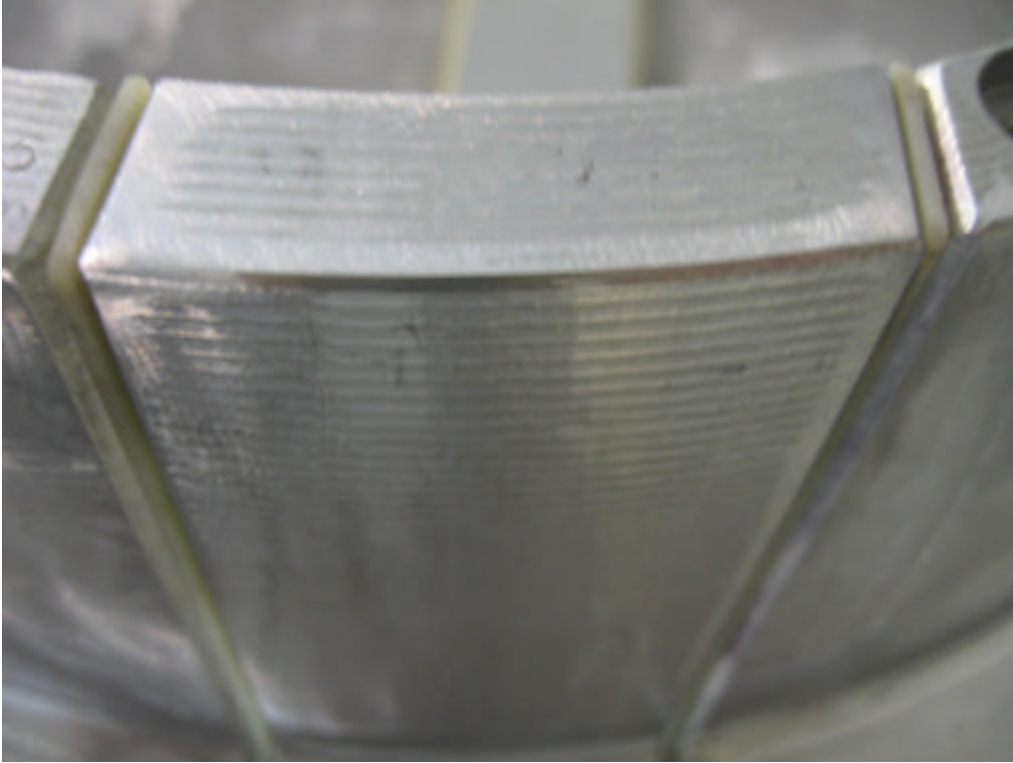
Approved by:

Tech. Rep.

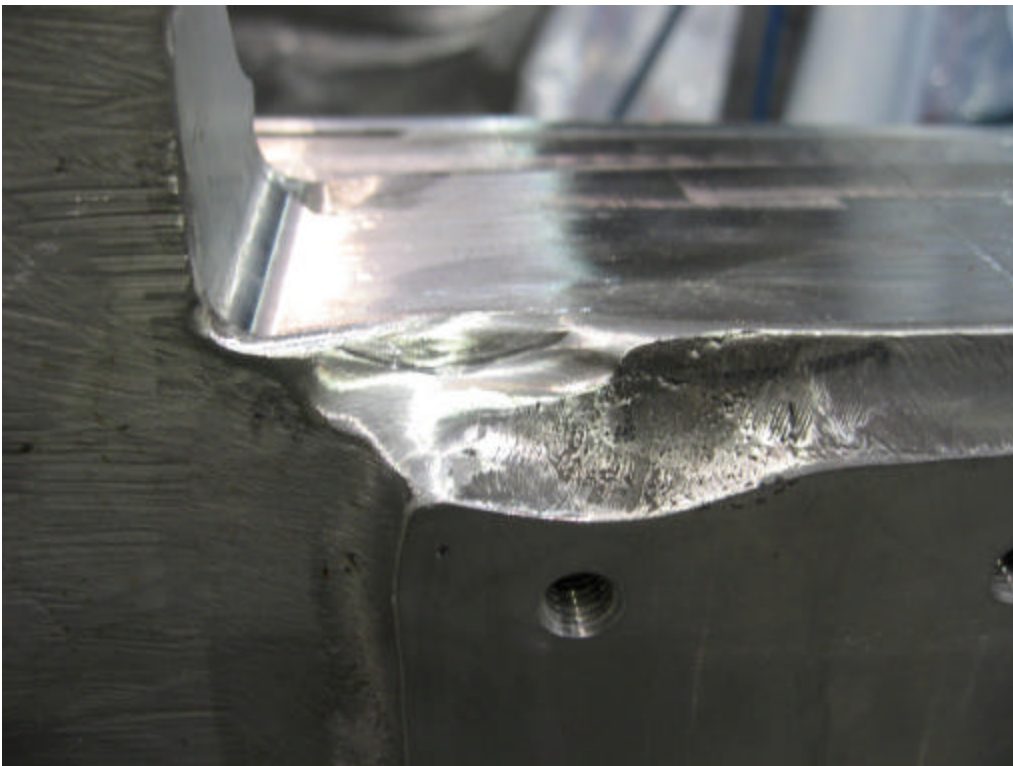
RLM

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

SE141-116 C5
NC19718 attachment.



Poloidal Break view – Chamfer on casting (.09”) is larger than chamfer on shim (.06”).

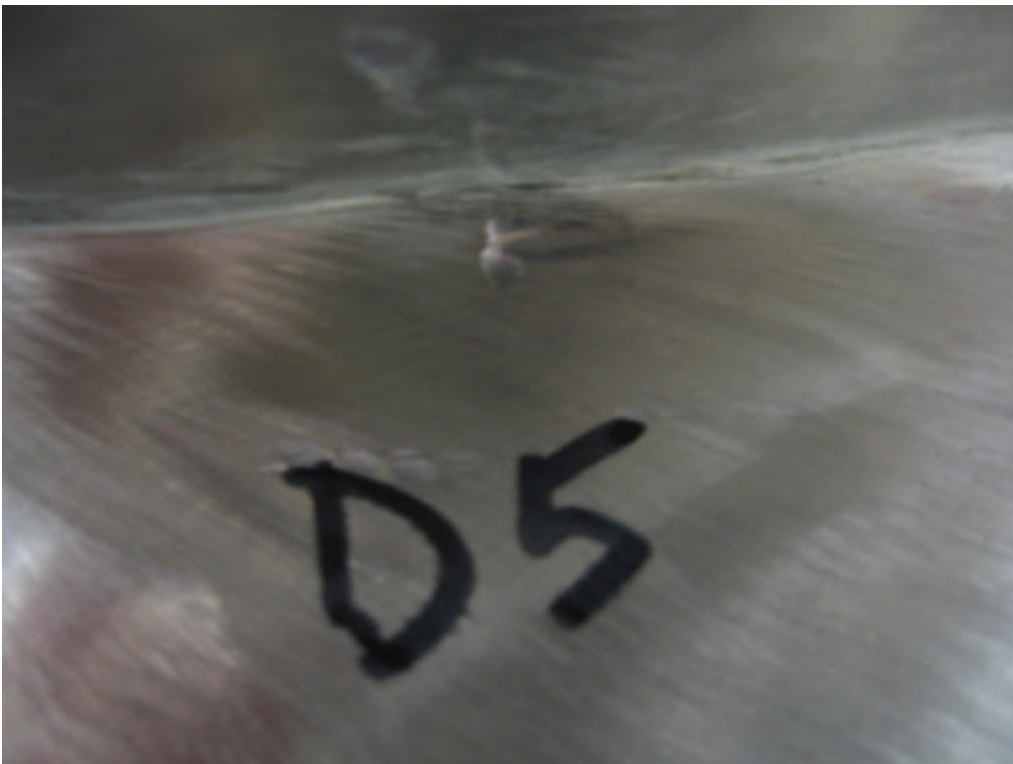


Tool Gouge blended out between pad and lead block slot.

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Excavated areas of high permeability beneath VPI groove in radius at casting wall.

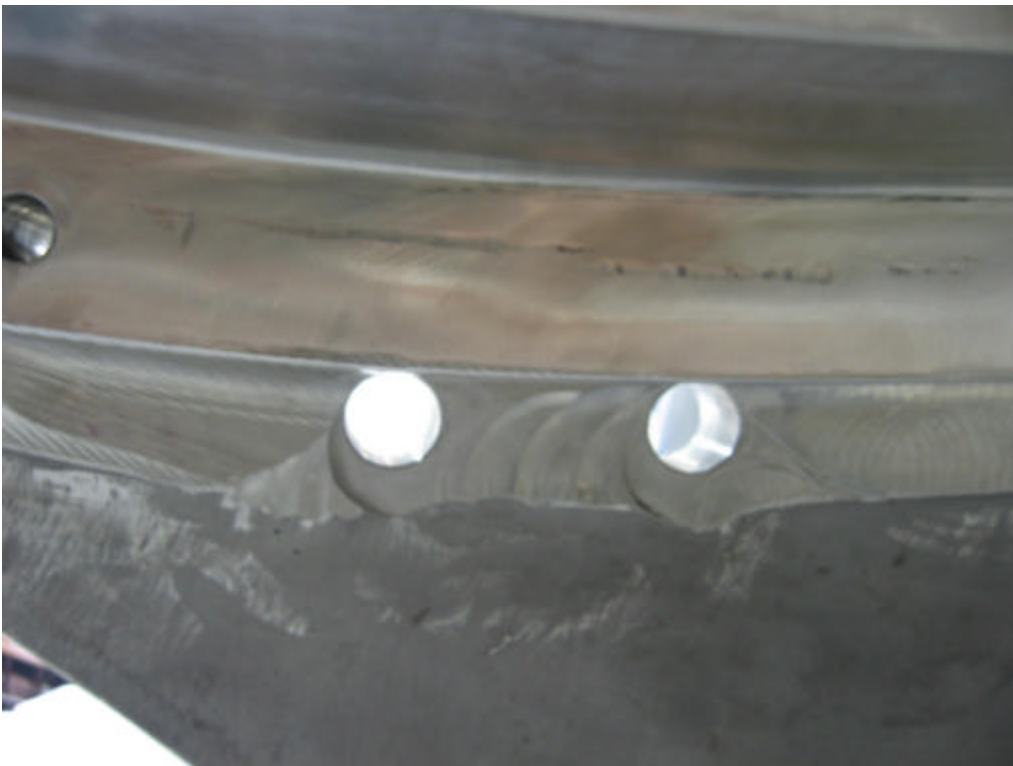


Small cutter noncleanup between long and short legs (.120", .005" deep)

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NC19718 attachment.



Wide view of cutter noncleanup on short leg between holes 26 and 29 on E side.



Close up view. Noncleanup is approx. .008" at the max depth and max. of .100" wide.

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NC19718 attachment.



Area of cutter noncleanup near radius between D33 and D35. Approx. .008" max depth.