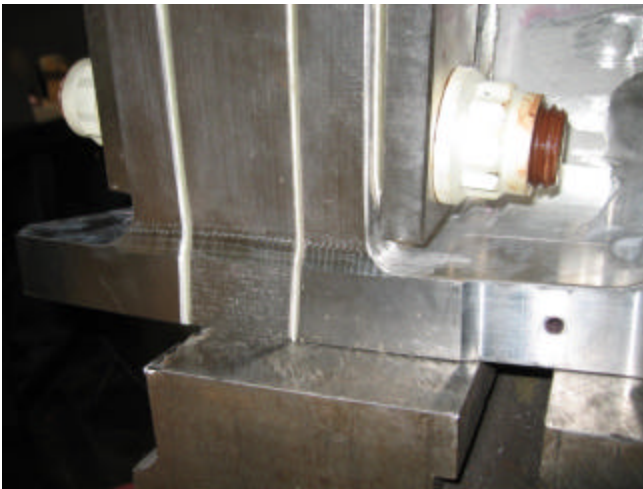
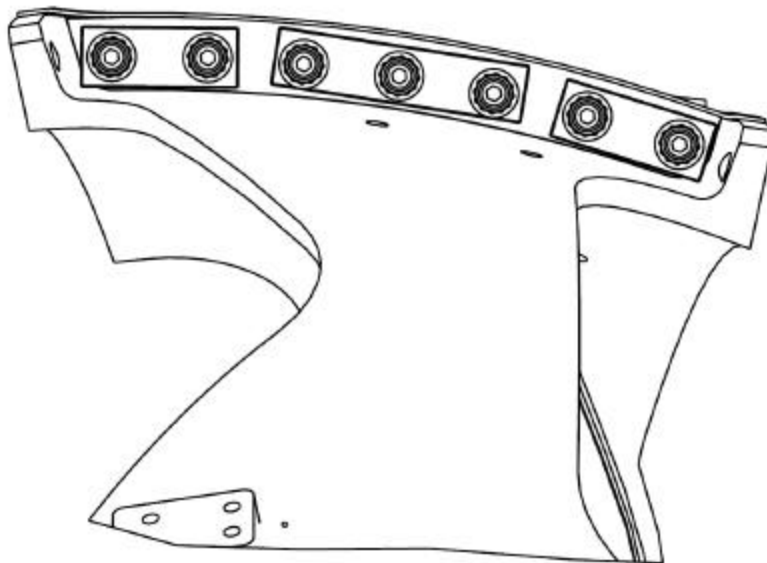


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1. G11 shim between break flanges and bearing plates.



G11 shim has a full radius on both ends. The drawing shown below shows only the radius toward the inside cast wall.

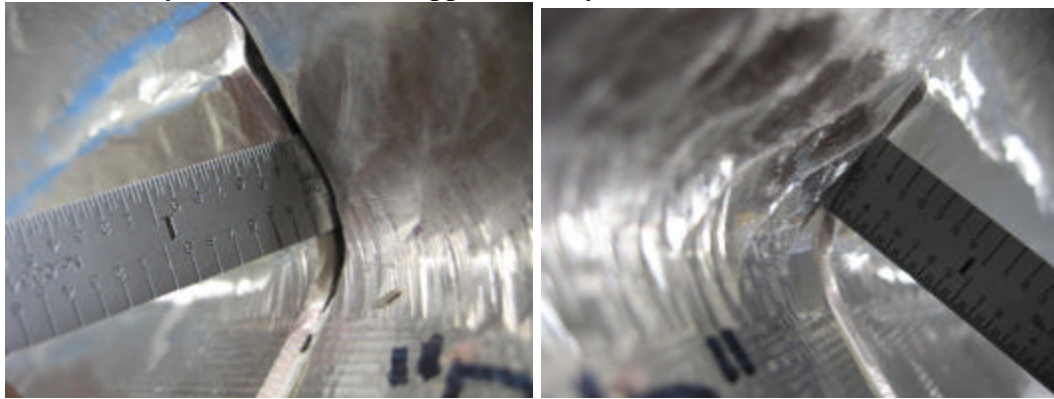


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2. Photo below shows areas where counterbore clearances were cut heavy into the casting wall. These areas will not accept the 3" diameter clearance gage. These areas and others were identified and reported on RFD 14-020.



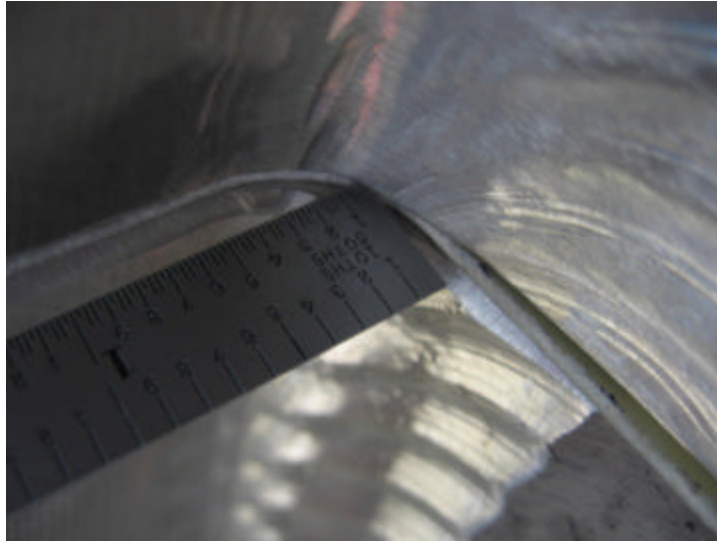
3. Poloidal Break, Datum D side. Casting radius between T section and inner wall extends beyond the G11 shim approximately .300" on each side.



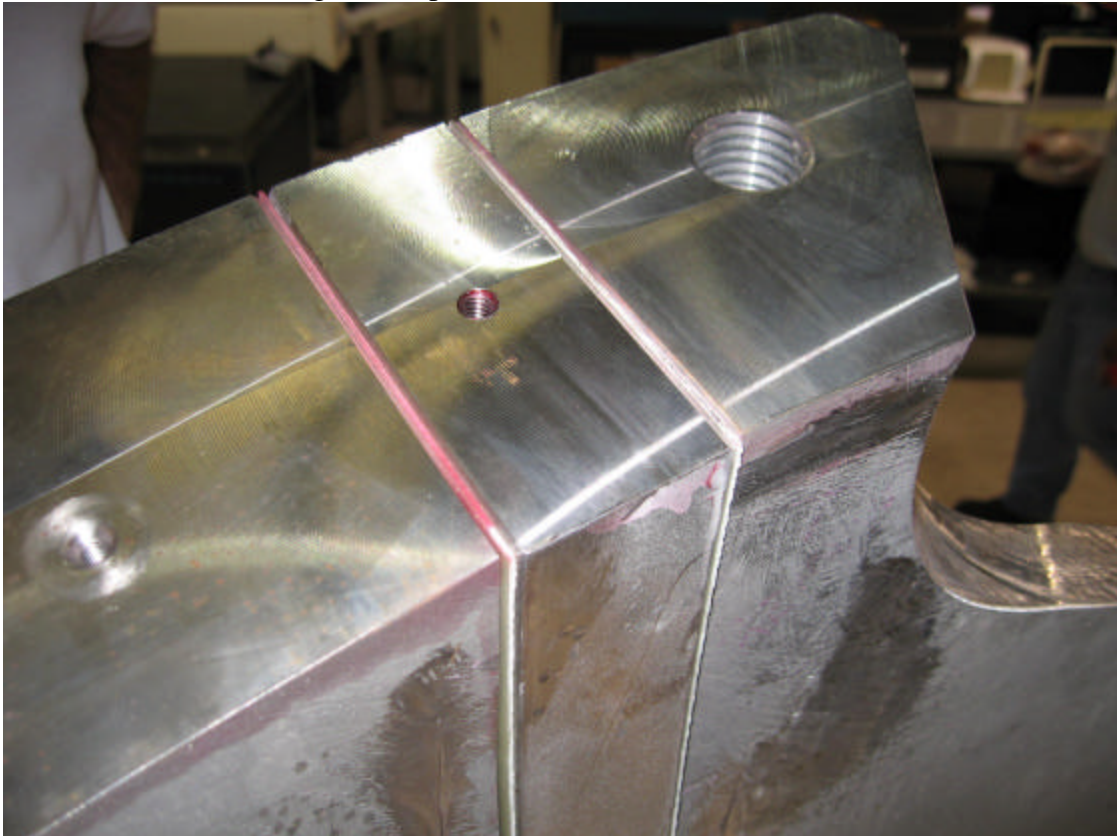
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4. Poloidal Break, Datum E side. Casting radius between T section and inner wall extends beyond the G11 shim .050" on each side.



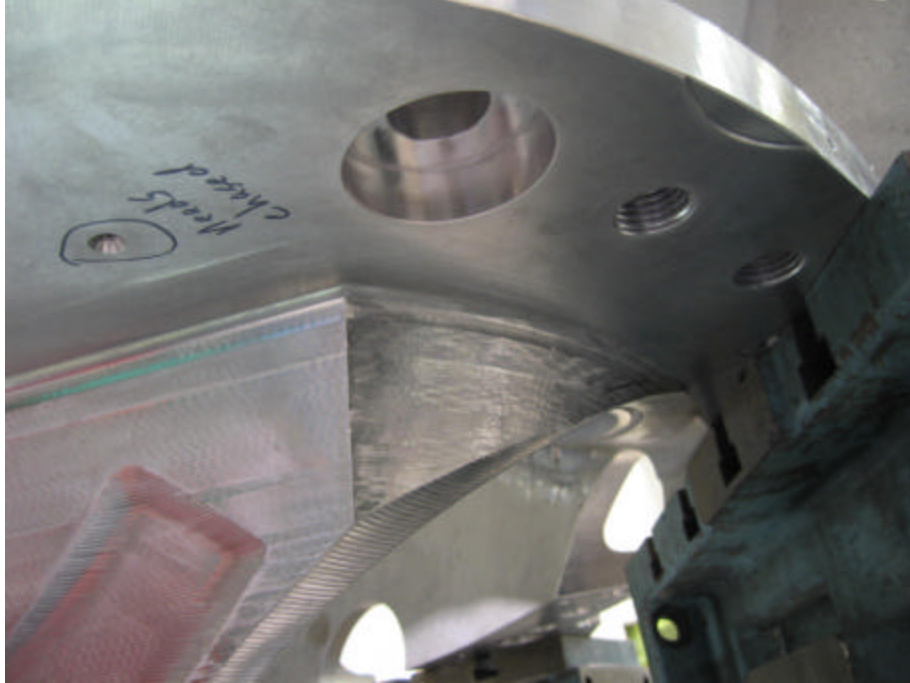
5. One of the G11 shims from the Datum D view is contaminated with the Liquid Penetrant used during the PT process.



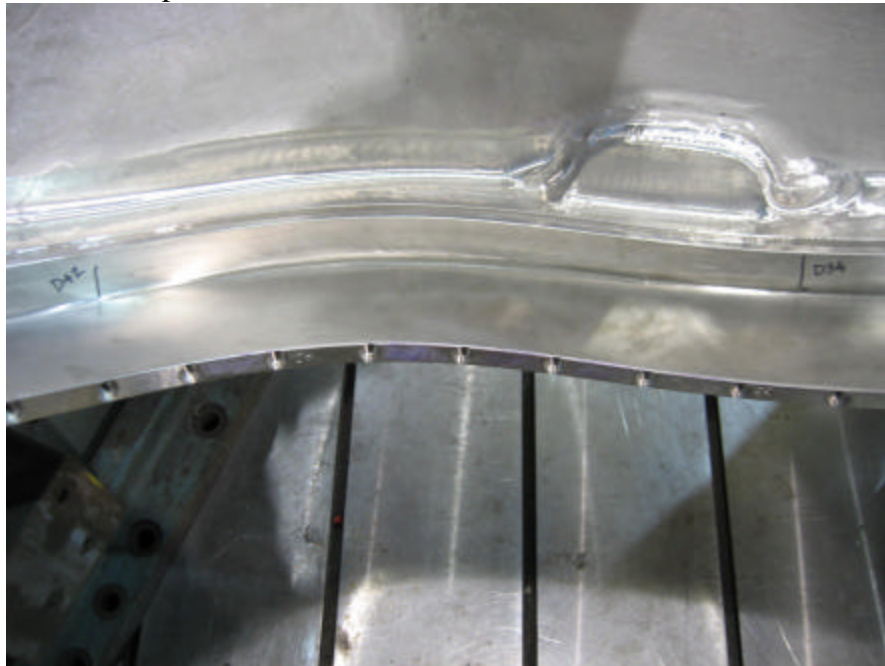
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6. Tool gouge on datum E flange. Gouge measures .038" deep by 3.25" long by .50" at its widest point. Radial gouge from 6" face. The gouge is located on the datum E flange in section C5 on sheet 5 of the drawing.

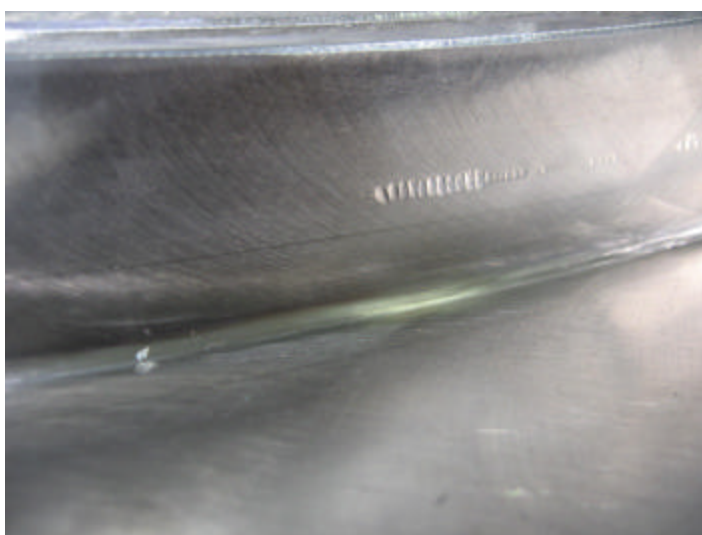
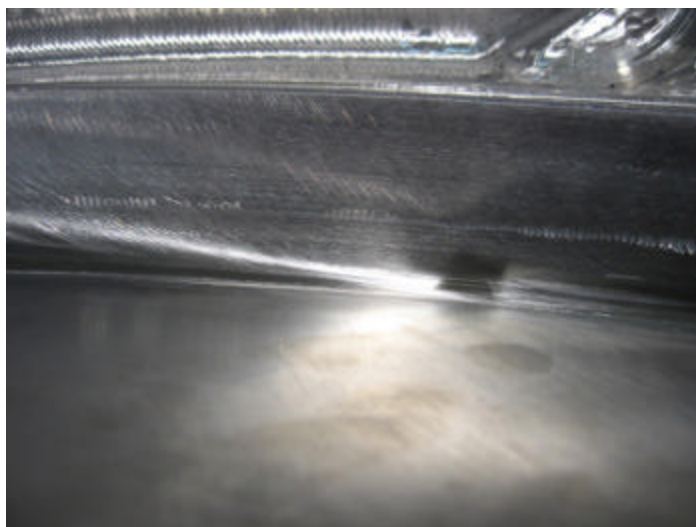
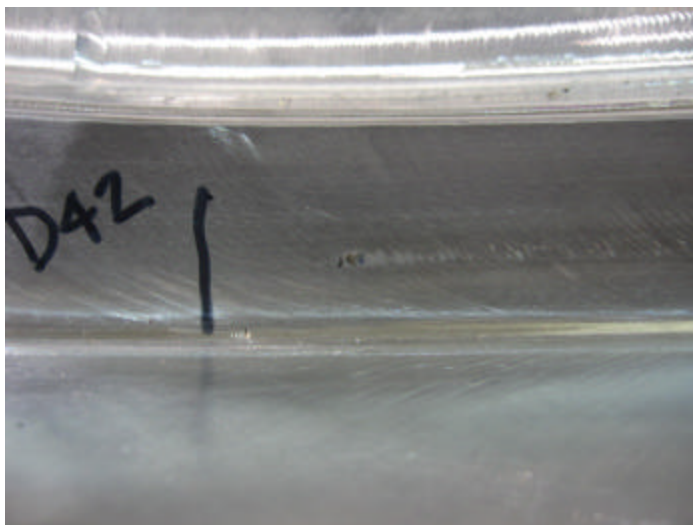


7. Various tool cutter marks on the D side short leg between holes 34 and 42. Cutter marks are no deeper than .010".



Cont. on next page.

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8. Various cutter marks on the E side of the T section. Cutter marks are no more than .010" deep.

Short leg of T near hole 79.



In radius between long and short legs near hole 89.

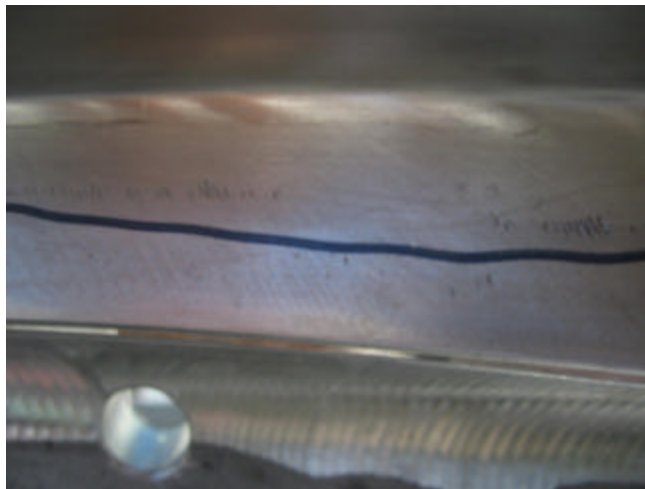
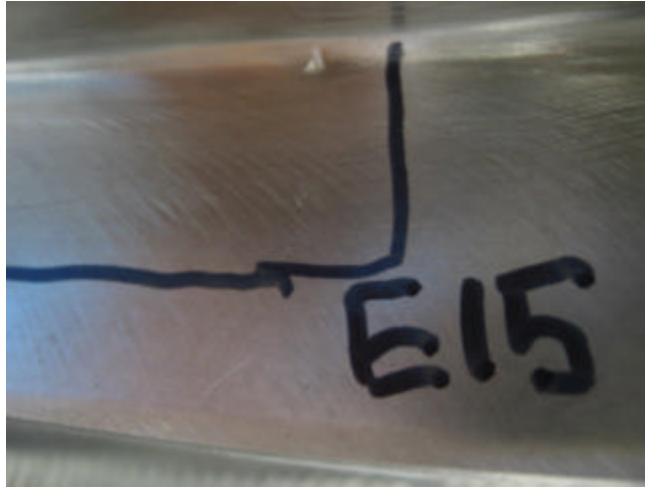


In radius between long and short legs near hole 87.



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The following photos are of the short leg of T between holes 15 and 19.



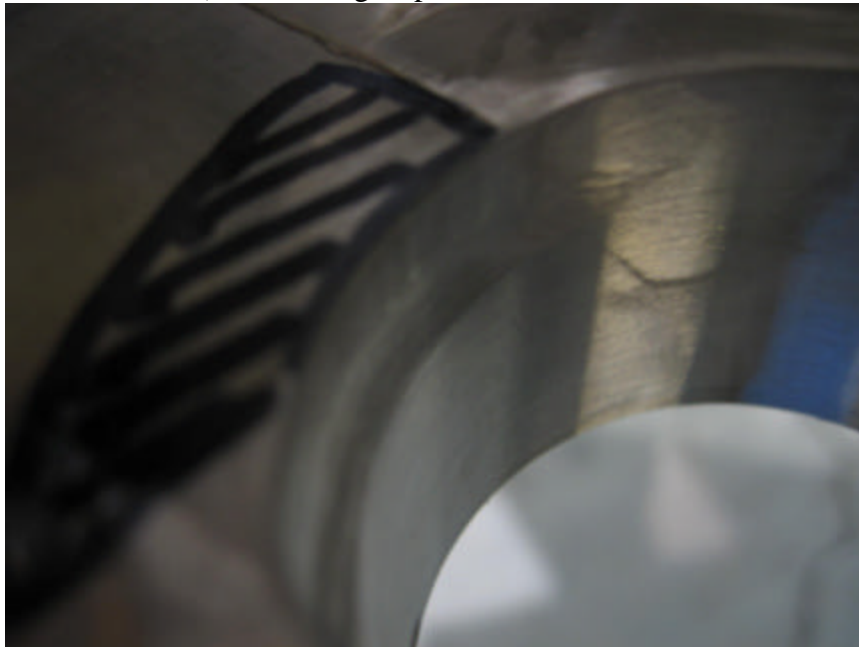
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9. Approx. 20% of counterbore did not clean up to 100%. Hole is located on the datum E flange next to the poloidal break. (area shaded in photo below).

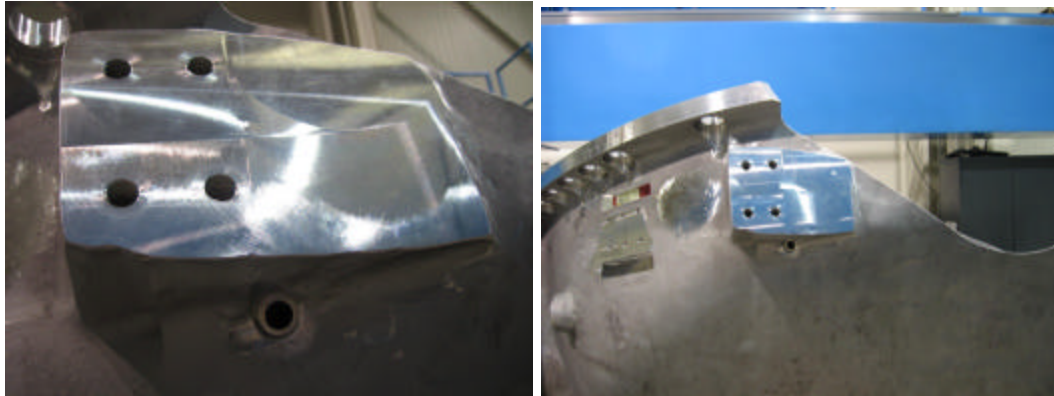


10. There is also an oversized area in this same 1.885 hole. The hole checks $\varnothing 1.884$ " from the datum E face to a depth of .950". The oversized area extends approximately 1/3 around the diameter (the oversized area is offset to the centerline of the bore). At its largest point, the bore checks $\varnothing 1.948$ ".

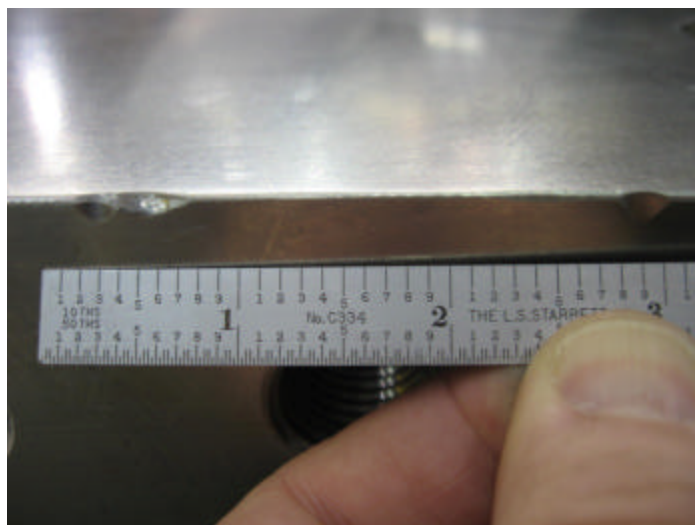
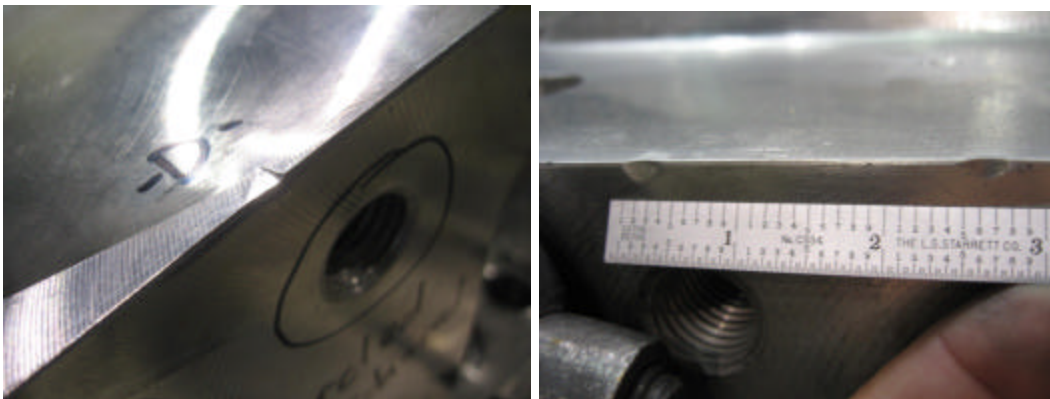


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11. The pad shown below has excess casting stock which was machined flush with the pad face. See detail J in section F2 on sheet 7.



12. Various dings on the datum flange edges. Dings are being caused by swivel hoist rings when lifting the parts. Any raised metal around the areas have been polished flush to the surrounding surfaces.



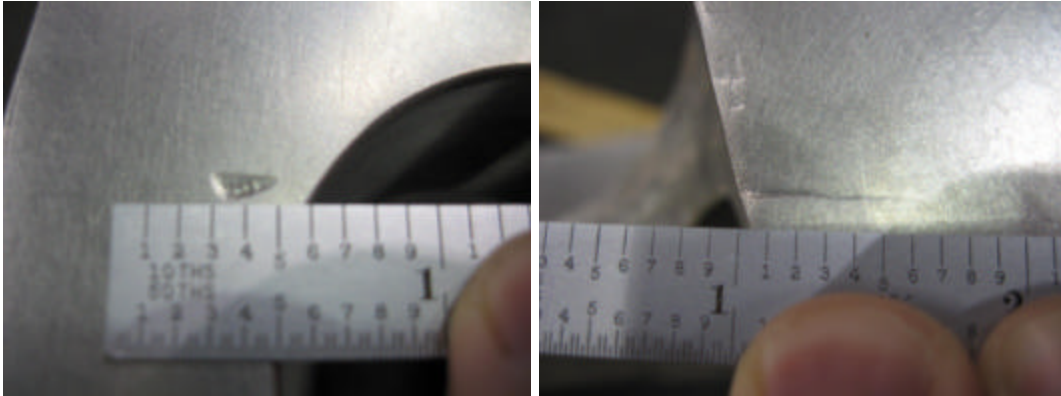
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13. There are two impressions on the datum E flange face that were caused by handling damage. Any raised metal around the areas have been polished flush to the surrounding surfaces.



14. The area shown below on the datum E flange exceeds the v^{125} surface finish requirement. Area checks approximately v^{250} . This area is located on sheet 5, zone D5.

