

Workorder: 65709/3-0 Sub:1 Op:130

Revision:

**Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A**

Drawing ID: SE141-101 Rev: 3			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
2* (10)	D3	Ø.001 - Ø.002 CHECK CLEARANCE OF ITEM 5 TO ITEM 6.		MFG			LESS THAN .002	825-B.JA 07-21-06			A *
*		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"		MFG			LESS THAN .002	825-B.JA 07-21-06			A *
*		ENSURE THAT THE CUMULATIVE GAPS AT ANY SINGLE CROSS SECTION OF THE POLOIDAL FLANGE ELEMENTS IS LESS THAN .005".		MFG			LESS THAN .002	825-B.JA 07-21-06			A *
*		THE MAX. GAP AT THE POLOIDAL BREAK PERIMETER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE.		MFG			LESS THAN .002	825-B.JA 07-21-06			A *
1* (40)	F2	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLIE	MFG		J-1240	1500	825-B.JA 07-21-06			A *

Workorder: 65709/3-0 Sub:1 Op:132

Revision: 07/27/06 8:45

**Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A**

Drawing ID: SE141-114 Rev: 7			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1* (10)	F3	NOTE 14 - BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.		QA		VISUAL	ACCEPT	339-E.RO 07-27-06			A *
1*	E8		CMM	QA		00064	.0045	339-E.RO			A *

\* To Far Right Indicates Data Package Requirement

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(20)		FLANGE PROFILE +/- .25 IN THIS AREA						07-27-06		
1* (30)	D8		CMM	QA	00064	.004	339-E.RO	07-27-06		A*
1* (40)	D8	54.20 ± .03	CMM	QA	00064	54.200	339-E.RO	07-27-06		A*
1* (50)	C8	54.20 ± .03	CMM	QA	00064	54.199	339-E.RO	07-27-06		A*
1* (60)	B8		CMM	QA	00064	.002	339-E.RO	07-27-06		A*
1* (70)	D5		CMM	QA	00064	.004	339-E.RO	07-27-06		A*
1* (80)	D5	48.50 ± .03	CMM	QA	00064	48.480	339-E.RO	07-27-06		A*
1* (90)	C5	48.50 ± .03	CMM	QA	00064	48.508	339-E.RO	07-27-06		A*
1* (100)	B5		CMM	QA	00064	.009	339-E.RO	07-27-06		A*
1* (110)	D4	VERIFY PART MARKING: MAJOR TOOL SE141-114 A(casting number) (weight) LBS.	CMM	QA	00064	ACCEPT	339-E.RO	07-27-06		A*
1* (120)	D4	RECORD WEIGHT	CMM	QA	00064	5440	339-E.RO	07-27-06		A*
1* (130)	D3	 OUTER AS CAST SURFACES	CMM	QA	00064	-.056 TO .457 [N/C: 20201-Doc:NC20201]	339-E.RO	07-27-06		R*
2* (140)	F8	2 X .40	CMM	QA	00064	0.39 TO 0.41	339-E.RO	07-27-06		A*
2* (150)	F8	4 X .03 X 45	CALIPER	QA	J-707	.010 TO .040 [N/C:2 0201-Doc:NC20201]	533-B.CL	07-26-06		R*
2* (160)	G6	2 X R.187 +.025 / -.005	PIN GAGE	QA	J-651-2	.184 TO .207	533-B.CL	07-26-06		A*
2* (170)	G5	 P TO M	CMM	QA	00064	.0149 TO .076	339-E.RO	07-27-06		A*

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### INSPECTION DATA CHECKLIST

2* (190)	F5	 M TO M1	CMM	QA		00064	-.020 TO .017 [N/C: 20201-Doc:NC20201]	339-E.RO 07-27-06			R *
2* (200)	E5	 M1 TO N1	CMM	QA		00064	-.011 TO .022	339-E.RO 07-27-06			A *
2* (210)	G3	 Q TO N	CMM	QA		00064	-.007 TO .094	339-E.RO 07-27-06			A *
2* (220)	F3	DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	ACCEPT	533-B.CL  07-26-06			A *
2* (230)	F3	 N TO N1	CMM	QA		00064	-.024 TO .015 [N/C: 20201-Doc:NC20201]	339-E.RO 07-27-06			R *
2* (240)	B4	2 X .06/.09 X 45	CALIPER	QA		J-707	030 TO .068 [N/C:20 201-Doc:NC20201]	533-B.CL 07-26-06			R *
2* (250)	B5	Ø .375-16 UNC ▽ .750 +.1 -0 96 X	THREAD PLUG GAGE	QA	100%	A-444	ACCEPT [N/C:20201-D oc:NC20201]	242-M.G 07-27-06			A *
2* (260)	B5		DEPTH MICROMETE  PIN GAGE	QA		J-1024  J-652-3	.620 TO .621 DIA. DEPTH .183 TO .191 [N/C:20201-Doc:NC20 201]	242-M.G  07-27-06			A *
2* (270)	B5	 .375-16 HOLES	CMM	QA		00064	.0052 TO .072 [N/C: 20201-Doc:NC20201]	339-E.RO 07-27-06			R *
3* (280)	H3	 DATUM E FLANGE	CMM	QA		00064	.011 [N/C:20201-Doc :NC20201]	339-E.RO 07-27-06			R *
3* (285)	H4	$\sqrt{125}$ DATUM E FLANGE	PROFILOMETER	QA		J-1109	20 TO 100	533-B.CL 07-26-06			A *
3* (290)	F2	 DATUM D FLANGE	CMM	QA		00064	.007	339-E.RO 07-27-06			A *
3* (295)	F3	$\sqrt{125}$ DATUM D FLANGE	PROFILOMETER	QA		J-1109	40 TO 125 [N/C:2020 1-Doc:NC20201]	242-M.G 07-27-06			A *
3* (300)	E4	Ø2.50 THRU	CALIPER	QA		J-707	2.497	533-B.CL 07-26-06			A *
3* (310)	F4	 Ø2.50	CMM	QA		00064	SEE IGES	339-E.RO 07-27-06			A *

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### INSPECTION DATA CHECKLIST

3* (320)	C7	8X Ø1-8UNC ∇ 2	THREAD PLUG GAGE	QA		A-71	ACCEPT	533-B.CL 07-26-06			A *
3* (330)	C7	$\Phi$ .010   A   B   C 8X Ø1-8 UNC	CMM	QA		00064	.001 TO .025 [N/C:2 0201-Doc:NC20201]	339-E.RO 07-27-06			R *
3* (340)	D5	8X Ø1-8UNC THRU	THREAD PLUG GAGE	QA		A-71	ACCEPT	533-B.CL 07-26-06			A *
3* (350)	D5	$\Phi$ .010   A   B   C 8X Ø1-8 UNC	CMM	QA		00064	.007 TO .048 [N/C:2 0201-Doc:NC20201]	339-E.RO 07-27-06			R *
3* (360)	D3	Ø2.50 THRU	CALIPER	QA		J-707	2.499	533-B.CL 07-26-06			A *
3* (370)	D3	$\Phi$ .060   A   B   C Ø2.5	CMM	QA		00064	SEE IGES	339-E.RO 07-27-06			A *
3* (380)	D1	40.90	CMM	QA		00064	SEE IGES	339-E.RO 07-27-06			A *
4* (390)	H6	$\square$ Ø2.000-2.001 ∇0.990-1.000	DIAL BORE GAGE DEPTH MICROMETE	QA		J-1400 J-1024	2.000 DEPTH .998	339-E.RO 07-27-06			A *
4* (400)	F4	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA		A-375	ACCEPT	533-B.CL 07-26-06			A *
4* (410)	F4	$\Phi$ Ø.06   M   A   D Ø1.375-6	CMM	QA		00064	SEE IGES	339-E.RO 07-27-06			A *
4* (420)	D4 &	Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA		J-1400	1.883 TO 1.886	533-B.CL 07-26-06			A *
4* (430)	D4 &	$\Phi$ Ø.06   M   A   D Ø1.885	CMM	QA		00064	.0036 TO .044	339-E.RO 07-27-06			A *
4* (440)	B6	3X Ø1.5	CALIPER	QA		J-1103	1.503 TO 1.505	533-B.CL 07-26-06			A *
4* (450)	B6	$\Phi$ .06   M   A   D 3X Ø1.5	CMM	QA		00064	.004 TO .018	339-E.RO 07-27-06			A *
4* (460)	A4	6X .25-20 UNC ∇ .5 .5 X 82° CHAMFER	THREAD PLUG GAGE	QA		A-726	ACCEPT	533-B.CL 07-26-06			A *
5* (470)	D8/D6	Ø1.885 ± .003	CMM	QA		00064	1.8855 ,1.8858, 1 H OLE 2.0515" [N/C:20 124-Doc:NC20124]	242-M.G 07-27-06			R *

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### INSPECTION DATA CHECKLIST

5* (480)	D8/D6	$\Phi$ $\emptyset$ .06 N A E $\emptyset$ 1.885	CMM	QA		00064	.013 TO .053	339-E.RO 07-27-06			A *
5* (490)	F8	$\emptyset$ 1.375-6UNC THRU	THREAD PLUG GAGE	QA		A-375	ACCEPT	495-D.CO 07-26-06			A *
5* (500)	F8	$\Phi$ $\emptyset$ .06 N A E $\emptyset$ 1.375-6 UNC	CMM	QA		00064	.048	339-E.RO 07-27-06			A *
5* (510)	F6	8X 1/4 -20 UNC-2B	THREAD PLUG GAGE	QA		A-375	ACCEPT 23 PLACES	495-D.CO 07-26-06			A *
5* (520)	D6	3X $\emptyset$ 1.5 $\nabla$ 2.33	CALIPER DEPTH MICROMETE	QA		J-1103 J-1024	1.503 TO 1.505 D EPTH 2.337	533-B.CL 07-26-06			A *
5* (530)	D6	$\Phi$ $\emptyset$ .06 N A E 3X $\emptyset$ 1.5	CMM	QA		00064	.002 TO .032	339-E.RO 07-27-06			A *
5* (540)	B3	6X .25 - 20 UNC $\nabla$ .6 $\emptyset$ .5 X 82° CHAMFER	THREAD PLUG GAGE	QA		A-726	ACCEPT	533-B.CL 07-26-06			A *
6* (550)	H7	6.00	CMM	QA		00064	SEE IGES	339-E.RO 07-27-06			A *
6* (560)	H7	1.00	CMM	QA		00064	SEE IGES	339-E.RO 07-27-06			A *
6* (570)	G8	6.70	CMM	QA		00064	SEE IGES	339-E.RO 07-27-06			A *
6* (600)	F8	6.70	CMM	QA		00064	SEE IGES	339-E.RO 07-27-06			A *
6* (610)	E7	5.75	CMM	QA		00064	SEE IGES	339-E.RO 07-27-06			A *
6* (620)	E7	1.00	CMM	QA		00064	SEE IGES	339-E.RO 07-27-06			A *
6* (630)	E6	4X $\emptyset$ 1.00	PIN GAGE	QA		J-921	.993 TO 1.00	533-B.CL 07-26-06			A *
6* (640)	G5	2X .88 - 1.13	CALIPER	QA		J-707	1.120 TO 1.130	533-B.CL 07-26-06			A *
6* (650)	F5	.06-.09 X 45° TYP	CALIPER	QA		J-707	.080	533-B.CL 07-26-06			A *
7* (660)	G2		CMM	QA		00064	SEE IGES	339-E.RO			A *

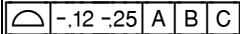
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(660)		19.00						07-27-06		*
7*	F2		CMM	QA		00064	SEE IGES	339-E.RO		A
(670)		2.00						07-27-06		*
7*	F2		CMM	QA		00064	SEE IGES	339-E.RO		A
(680)		6.75						07-27-06		*
7*	F2		CMM	QA		00064	SEE IGES	339-E.RO		A
(690)		3.75						07-27-06		*
7*	F1	4X Ø.75-10 UNC ▽ 1.50	THREAD PLUG GAGE	QA		A-681	THREAD AND DEPTH A	495-D.CO		A
(700)							CEPT	07-26-06		*
7*	D1		CALIPER	QA		J-707	1.56 / 1.56	339-E.RO		A
(710)		2X 1.56 OPEN THRU						07-27-06		*
7*	C1	.375-16 UNC-2B TAP ▽ .75 .03 X 45° CHAMFER 6X	THREAD PLUG GAGE	QA		A-444	ACCEPT	339-E.RO		A
(720)								07-27-06		*
7*	C4	VERIFY THAT HOLE LOCATIONS ARE SCRIBED ON THE PART.		QA		VISUAL	ACCEPT	533-B.CL		A
(730)								07-26-06		*
7*	B3	8.50 DISTANCE BETWEEN SCRIBE MARKINGS.	CALIPER	QA		J-1389	8.51	495-D.CO		A
(740)								07-26-06		*
9*	H1	2X Ø.50	PIN GAGE	QA		J-651-2	.500	533-B.CL		A
(750)								07-26-06		*
9*	B7	TC2 HOLE TO BE .625" IN DIAMETER APPROX. 2.52" DEEP AND .25" IN DIAMETER AT LEAST 1" DEEP.	DEPTH MICROMETE	QA		J-1024	.628 DIA. DEPTH 2. 639 AND 3.640	533-B.CL		A
(760)			CALIPER			J-707		07-26-06		*
*		TC1 LOCATION AND CONFIGURATION MODIFIED. HOLE TO HAVE .625 CLEARANCE AND AT LEAST 1" OF DEPTH AT THE .25" DIA	DEPTH MICROMETE	QA		J-1024	.625 DIA. DEPTH 1.060	533-B.CL		A
(770)			CALIPER			J-707		07-26-06		*
10*	F5		CMM	QA		00064	-.444 TO .053 [N/C:	339-E.RO		R

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(780)		INNER AS CAST SURFACES					20201-Doc:NC20201]	07-27-06			*
10* (790)	D5	 WING SURFACES	CMM	QA		00064	-.122 TO -.209	339-E.RO 07-27-06			A *
<b>Drawing ID: NCSX-CSPEC-141-03 Rev: 11</b>			<b>INSPECTION INSTRUCTIONS</b>			<b>RESULTS</b>		<b>INSPECTED BY</b>			
<b>SHEET</b>	<b>ZONE</b>	<b>CHARACTERISTIC</b>	<b>GAGE/EQUIP</b>	<b>BY</b>	<b>SAMPLE</b>	<b>SER#</b>	<b>DATA/REMARKS</b>	<b>INSP</b>	<b>VERFD</b>	<b>AUDIT</b>	
4* (800)	3.1.1.4	<sup>125</sup> THE TWO "L" MACHINED SURFACES OF TEE MUST HAVE A RMS OF 125.	PROFILOMETER	QA		J-1109	8 TO 30	533-B.CL 07-26-06			A *

Workorder: 65709/3-0 Sub:1 Op:136

Revision:

**Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A**

<b>Drawing ID: SE141-114 Rev: 7</b>			<b>INSPECTION INSTRUCTIONS</b>			<b>RESULTS</b>		<b>INSPECTED BY</b>			
<b>SHEET</b>	<b>ZONE</b>	<b>CHARACTERISTIC</b>	<b>GAGE/EQUIP</b>	<b>BY</b>	<b>SAMPLE</b>	<b>SER#</b>	<b>DATA/REMARKS</b>	<b>INSP</b>	<b>VERFD</b>	<b>AUDIT</b>	
* (10)		<u>D A T U M - E - S I D E</u> MAG PERMEABILITY TO BE NO GREATER THAN 1.02μ. CHECK 3 PLACES ADJACENT TO EVERY 5TH HOLE IN T SECTION.	MASTER GAGE	QA		J-1165	< 1.02	495-D.CO 07-26-06			A *
* (20)		<u>D A T U M - D - S I D E</u> MAG PERMEABILITY TO BE NO GREATER THAN 1.02μ. CHECK 3 PLACES ADJACENT TO EVERY 5TH HOLE IN T SECTION.	MASTER GAGE	QA		J-1165	<1.02	495-D.CO 07-26-06			A *

Workorder: 65709/3-0 Sub:1 Op:140

Revision:

**Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A**

<b>Drawing ID: SE141-101 Rev: 3</b>			<b>INSPECTION INSTRUCTIONS</b>			<b>RESULTS</b>		<b>INSPECTED BY</b>			
<b>SHEET</b>	<b>ZONE</b>	<b>CHARACTERISTIC</b>	<b>GAGE/EQUIP</b>	<b>BY</b>	<b>SAMPLE</b>	<b>SER#</b>	<b>DATA/REMARKS</b>	<b>INSP</b>	<b>VERFD</b>	<b>AUDIT</b>	
* (10)		<u>T E S T 1</u> RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE MID-PLANE POLOIDAL BREAK SHIM AND THE WINDING FORM.	MULTIMETER	QA		J-1358	2.2 G KOHMS	503-B.HO 07-25-06			A *

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### INSPECTION DATA CHECKLIST

*		<b>TEST 2</b> RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE JUMPERED BOLTS AND JUMPERED MID-PLANE CASTING AND WINDING FORM.	MULTIMETER	QA		J-1358	655 M KOHMS	503-B.HO			A
(20)								07-25-06			*

Workorder: 65709/3-0 Sub:13 Op:30

Revision:

**Part: SE141-141 - BEARING PLATE DETAIL TYPE "A" SHORT -**

Drawing ID: SE141-141 Rev: 1			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1*	G2	RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1165	ACCEPT	533-B.CL			A
(10)								06-21-06			*

Workorder: 65709/3-0 Sub:14 Op:30

Revision:

**Part: SE141-142 - BEARING PLATE DETAIL TYPE "A" LONG -**

Drawing ID: SE141-142 Rev: 1			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1*	G2	RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	503-B.HO			A
(10)								07-19-06			*

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