

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-116 - Item: 13

Workorder: 65707/1-0 Sub:1 Op:90

Part: SE141-116 - MODULAR COIL WINDING FORM TYPE-C - PRODUCTION MODULAR COIL WINDING FORM TYPE-C

Drawing ID: SE141-116 Rev: 6			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		RECORD RANGE UPPER AND LOWER LIMITS OF MAG PERMEABILITY READI (Mu) FOR THE AS CAST SURFACES	MASTER GAGE	QA		J-1270	LESS THAN 1.01 (LESS THAN RANGE OF GAGE)	212-J.LE 09-20-05		
(10)										
*		RECORD RANGE UPPER AND LOWER LIMITS OF MAG PERMEABILITY READI (Mu) FOR THE MACHINED SURFACES	MASTER GAGE	QA		J-1270	LESS THAN 1.01 (LESS THAN RANGE OF GAGE)	212-J.LE 09-20-05		
(20)										

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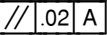
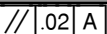


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INSPECTION DATA CHECKLIST









Quality Assurance Documentation for Part ID: SE141-116 - Item: 15

Workorder: 65707/1-0 Sub:1 Op:120

Part: SE141-116 - MODULAR COIL WINDING FORM TYPE-C - PRODUCTION MODULAR COIL WINDING FORM TYPE-C

Drawing ID: SE141-116 Rev: 6			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1* (10)	E8	47.19 ± .03	CMM	QA		00064	47.17 - 47.18	339-E.R 09-29-05		A
1* (11)	G8	R17.00 +.25 -.00	CMM	QA		00064	17.09	339-E.R 09-29-05		A
1* (20)	B8	47.19 ± .03	CMM	QA		00064	47.18 - 47.19	339-E.R 09-29-05		A
1* (30)	D6	47.19 ± .03	CMM	QA		00064	47.18 - 47.19	339-E.R 09-29-05		A
1* (40)	C6	47.19 ± .03	CMM	QA		00064	47.20	339-E.R 09-29-05		A
1* (50)		 .02 A	CMM	QA		00064	.0109	339-E.R 09-29-05		A
1* (60)	B6	 .02 A	CMM	QA		00064	.0045	339-E.R 09-29-05		A
1* (70)	F3	 .5 A B C	CMM	QA		00064	REFERENCE IGES INF RMATION	339-E.R 09-29-05		A
2* (80)	H6	2X R.187 +.025 -.005	INDICATOR	QA		J-651	.185 - .187	339-E.R 09-29-05		A
2* (90)	G8	2X .03 X 45°		QA		VISUAL	NOT PRESENT	339-E.R 09-29-05		R
2* (100)	G8	.40 ± .010	CALIPER	QA		J-707	.39 - .41	339-E.R 09-29-05		A
2* (110)	G8	2X .030 X 45°		QA		VISUAL	NOT PRESENT	339-E.R 09-29-05		R
2* (120)	F7	2X .32	CALIPER	QA		J-707	.31 - .33	339-E.R 09-29-05		A
2* (130)	F7	2X R.11	RADIUS GAGE	QA		R-25	.12	339-E.R 09-29-05		A
2* (140)	G6	 .1 R S T P TO M	CMM	QA		00064	REFERENCE IGES INF RMATION	339-E.R 09-29-05		R
2*	G6	4.790 ± .005		QA		VISUAL	ACCEPT	339-E.R		A

INSPECTION DATA CHECKLIST

(150)								09-29-05		
2* (160)	G3	 .1 R S T Q TO N	CMM	QA		00064	REFERENCE IGES INFORMATION	339-E.R 09-29-05		R
2* (170)	G3	4.790 ± .005 RECORD NUMBER USED TO IDENTIFY POINT Q		QA		VISUAL	ACCEPT	339-E.R 09-29-05		A
2* (180)	F5	 .02 R S T M TO N	CMM	QA		00064	REFERENCE IGES INFORMATION	339-E.R 09-29-05		R
2* (190)	C5	 .01 R S T 96X Ø.375-16 UNC .188 DEEP C'BORE Ø.625 AS SHOWN	CMM THREAD PLUG GA	QA		00064 A-46	.0043 - .1657 , .62 3 - .626	339-E.R 09-29-05		R
2* (200)	B4	2X .03 X 45°		QA		VISUAL	ACCEPT	339-E.R 09-29-05		A
3* (210)	G7	 .01 A B C 8X Ø1-8 UNC THRU	CMM	QA		00064	.010 - .043	339-E.R 09-29-05		R
3* (220)	H4	.25 ± .01	CMM	QA		00064	SET	339-E.R 09-29-05		A
3* (230)	H3	 .01	CMM	QA		00064	.015	339-E.R 09-29-05		R
3* (240)	F3	.25 ± .01	CMM	QA		00064	SET	339-E.R 09-29-05		A
3* (250)	F3	 .01	CMM	QA		00064	.032	339-E.R 09-29-05		R
3* (260)	F5	R76.00	CMM	QA		00064	REFERENCE IGES INFORMATION	339-E.R 09-29-05		R
3* (270)	E5	R73.70	CMM	QA		00064	REFERENCE IGES INFORMATION	339-E.R 09-29-05		R
3* (280)	E4	 .01 A B C 8X Ø1.13 THRU BACK SPOT FACE Ø2.38 MIN DEPTH FOR C'UP	CMM	QA		00064	.010 - .031	339-E.R 09-29-05		R
4* (290)	H8	 .010 D A N 3X Ø1.88 THRU Ø3.00 BACK SPOTFACE	CMM	QA		00064	.0304 - .0442 , >3. 00 SPOT, 1.87 - 1.8 8 DIA.	339-E.R		R

INSPECTION DATA CHECKLIST

(290)		MIN TO CLEANUP	SCALE			J-922		09-29-05		
4* (300)	H7	Φ .01 D A N 3X SPH R.75 TO .75 DEEP	CMM	QA		00064	.019 - .020 , R .7 4 - .745	339-E.R 09-29-05		R
4* (310)	H6	Φ .01 D A N 17X Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP	CMM	QA		00064	0.009 - 0.059, >3.0 0 SPOT, 1.87 - 1.88	295-C.W		R
4* (320)	H5	Φ .01 D A N 3X Ø1.13 Ø2.38 BACK SPOTFACE MIN TO CLEANUP	CMM	QA		00064	0.001 - 0.007, >2.3 8 SPOT	295-C.W 10-01-05		A
4* (340)	E6	Φ .01 D A N 3X Ø1.375-6 UNC THRU	CMM	QA		00064	.022 - .039	339-E.R 09-29-05		R
4* (350)	E6	Φ .01 D A N 5X Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP	CMM	QA		00064	.0019 - .0182, >3. 00 SPOT	339-E.R 09-29-05		R
4* (360)	D4	Φ .01 D A N Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP	CMM	QA		00064	.018, >3.00 SPOT, 1.879 DIA.	339-E.R 09-29-05		R
4* (370)	B5	Φ .01 D A N 3X Ø1.13 Ø2.38 BACK SPOTFACE MIN TO CLEANUP	CMM	QA		00064	.047 - .054, 1.126 - 1.127	295-C.W 10-01-05		R
5* (380)	E8	Φ .01 E A J Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP	CMM	QA		00064	0.77, >3.00 SPOT.	339-E.R 09-29-05		R
5* (400)	F6	3X Ø1.375-6 UNC THRU	THREAD PLUG GA	QA		A-375	ACCEPT	339-E.R 09-29-05		A
5* (410)	F6	Φ .01 E A J 3X SPH R.75 TO .75 DEEP	CMM	QA		00064	.020 - .021	339-E.R 09-29-05		R
5* (420)	F7	7X .25-20 UNC -2B	THREAD PLUG GA	QA		A-67	ACCEPT	339-E.R 09-29-05		A
5*	E7	Φ .01 E A J 24X Ø1.88 THRU Ø3.00 BACK SPOTFACE	CMM	QA		00064	.008 - .040, >3.00 SPOT.	339-E.R		R

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(430)		MIN TO CLEANUP	SCALE			J-922		09-29-05		
5*	E7	Φ .01 E A J 3X Ø1.5 TO 2.00 DEEP Ø3.00 TO 1.00 DEEP	CMM	QA		00064	.013 - .037	339-E.R		R
(440)								09-29-05		
5*	D7	3X Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP	CMM	QA		00064	1.87 - 1.88, >3.00	339-E.R		A
(450)			SCALE			J-922		09-29-05		
5*	G2	SPH R.75 TO .75 DEEP	CMM	QA		00064	.736 - .74	339-E.R		A
(460)								09-29-05		
6*	F2	\square .02	05	QA			CANNOT CHECK DUE ASSY	295-C.W 10-01-05		A
(510)										
6*	F2	1.125 ± .010	05	QA			CANNOT CHECK DUE ASSY	295-C.W 10-01-05		A
(520)										
6*	F2	2.250 ± .010	05	QA			CANNOT CHECK DUE ASSY	295-C.W 10-01-05		A
(530)										
6*	E2	Φ .01 F P V 7X Ø1.625 THRU BOTH SIDES 14X Ø3.00 TO .500 BOTH SIDES	05	QA			CANNOT CHECK DUE ASSY	295-C.W 10-01-05		A
(540)										
7*	G2	R7.00	05	QA			REFERENCE IGES INF RMATION	339-E.R 09-29-05		R
(550)										
7*	F2	2X R1.50	05	QA			REFERENCE IGES INF RMATION	339-E.R 09-29-05		R
(560)										
7*	E2	2.52 ± .010	CMM	QA		00064	2.51	339-E.R 09-29-05		A
(570)										
7*	E2	90°	CMM	QA		00064	87.92	339-E.R 09-29-05		R
(580)										
7*	E1	2.0°	CMM	QA		00064	2.04	339-E.R 09-29-05		A
(590)										
7*	E2	2.64 ± .010	DEPTH MICROMET	QA		J-851	2.64	339-E.R 09-29-05		A
(600)										
7*	E2	6.50 ± .010	CMM	QA		00064	6.486	339-E.R 09-29-05		R
(610)										
7*	E2	3.06 ± .010	CMM	QA		00064	REFERENCE IGES INF RMATION	339-E.R 09-29-05		R
(620)										

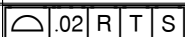


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7* (630)	D2	R4.00 ± .010	CMM	QA		00064	REFERENCE IGES INFORMATION	339-E.R 09-29-05			R
7* (640)	D3	2.10 ± .010	CMM	QA		00064	REFERENCE IGES INFORMATION	339-E.R 09-29-05			R
8* (650)	G7	4.00 ± .010	CMM	QA		00064	3.98	339-E.R 09-29-05			R
8* (660)	G7	.25 ± .010	CMM	QA		00064	SET	339-E.R 09-29-05			A
8* (670)	G7	R4.00 ± .010	CMM	QA		00064	REFERENCE IGES INFORMATION	339-E.R 09-29-05			R
8* (680)	F7	2.00 ± .010	CMM	QA		00064	1.99	339-E.R 09-29-05			A
8* (690)	E3	9.38 ± .010	CMM	QA		00064	REFERENCE IGES INFORMATION	339-E.R 09-29-05			R
8* (700)	E2	6.0°	CMM	QA		00064	REFERENCE IGES INFORMATION	339-E.R 09-29-05			R
8* (710)	C2	Ø8.00 ± .010	CMM	QA		00064	REFERENCE IGES INFORMATION	339-E.R 09-29-05			R
8* (720)	B3	5.9°	CMM	QA		00064	REFERENCE IGES INFORMATION	339-E.R 09-29-05			R
8* (730)	B3	7.81 ± .010	CMM	QA		00064	REFERENCE IGES INFORMATION	339-E.R 09-29-05			R
8* (740)	C6	7.25 ± .010	CMM	QA		00064	REFERENCE IGES INFORMATION	339-E.R 09-29-05			R
8* (750)	D7	6X Ø.375-16 UNC TO .75 DEEP .03 X 45° CHAMFER	THREAD PLUG GA CALIPER	MFG		A-46 J-707	ACCEPT THREAD/CHAMFER, .53 - 1.32 DEPT H	339-E.R 09-29-05			R
8* (760)	D7	13.6 °	CMM	MFG		00064	13.16	339-E.R 09-29-05			A
8* (770)	D7	5.88 ± .010	CALIPER	QA		J-707	5.89	339-E.R 09-29-05			A
8* (780)	D7	2.19 ± .010	CMM	QA		00064	2.172 - 2.198	339-E.R 09-29-05			R
8* (790)	D7	2.19 ± .010	CMM	QA		00064	2.176 - 2.191	339-E.R 09-29-05			R
8* (800)	B7	4X R.50	RADIUS GAGE	QA		R-25	.50	339-E.R 09-29-05			A

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8* (810)	B7	3.50 ± .010	CALIPER	QA		J-707	3.60	339-E.R 09-29-05		A
8* (820)	B7	1.75 ± .010	SCALE	QA		J-922	1.75	339-E.R 09-29-05		A
8* (830)	C8	2X 1.56 ± .010 THRU	CMM	QA		00064	1.) 1.56 2.) 1.79	339-E.R 09-29-05		R
8* (840)	C8	3.75 ± .010	CMM	QA		00064	3.90	339-E.R 09-29-05		R
8* (850)	C8	2X 7.50 ± .010 THRU	CMM	QA		00064	1.) 7.53 2.) 7.63	339-E.R 09-29-05		R
8* (860)	C8	8X R.25	RADIUS GAGE	QA		R-25	.25 - .28	339-E.R 09-29-05		R
8* (870)	C8	2X 2.52 ± .010	CMM	QA		00064	2.04 - 2.08 , 2.65 - 2.66	339-E.R 09-29-05		R
8* (880)	E2	Ø8.00 ± .010	CMM	QA		00064	7.992	339-E.R 09-29-05		A
9* (890)	F7	4X Ø.63 ± .010 THRU	PIN GAGE	QA		J-652	.62	339-E.R 09-29-05		A
9* (900)	E7	2.54 ± .010	CMM	QA		00064	REFERENCE IGES INF RMATION	339-E.R 09-29-05		R
9* (910)	E7	5.08 ± .010	CMM	QA		00064	REFERENCE IGES INF RMATION	339-E.R 09-29-05		R
9* (920)	F3	4X Ø.63 ± .010 THRU	PIN GAGE	QA		J-652	SEE #890	339-E.R 09-29-05		A
9* (930)	F3	2X Ø .50 ± .010 THRU	PIN GAGE	MFG		J-652	.498	339-E.R 09-29-05		A
9* (940)	E3	2.44 ± .010	CMM	QA		00064	REFERENCE IGES INF RMATION	339-E.R 09-29-05		R
9* (950)	E3	1.22 ± .010	CMM	QA		00064	REFERENCE IGES INF RMATION	339-E.R 09-29-05		R
9* (960)	C7	4X Ø.63 ± .010 THRU	PIN GAGE	QA		J-652	.622 - .624	339-E.R 09-29-05		A
9* (970)	C6	2X Ø.25 T.C. HOLE TO 2.5 DEEP	PIN GAGE	QA		J-652	.24	339-E.R 09-29-05		A
10* (980)	C8	 .125 A B C	CMM	QA		00064	REFERENCE IGES INF RMATION	339-E.R 09-29-05		R
10*	C8	 .5 A B C	CMM	QA		00064	REFERENCE IGES INF	339-E.R		R

INSPECTION DATA CHECKLIST

(990)							RMATION	09-29-05		
10* (1000)	C5		CMM	QA		00064	REFERENCE IGES INF RMATION	339-E.R 09-29-05		R
10* (1010)	C4		CMM	QA		00064	REFERENCE IGES INF RMATION	339-E.R 09-29-05		R
10* (1020)	G1		CMM	QA		00064	REFERENCE IGES INF RMATION	339-E.R 09-29-05		R
10* (1030)	E1		CMM	QA		00064	REFERENCE IGES INF RMATION	339-E.R 09-29-05		R
* (1040)		UOS ALL MACHINED SURFACES TO BE 250 RMS SURFACE FINISH RECORD RANGE	PROFILOMETER	QA		J-1152	31 - 500	339-E.R 09-29-05		R
1* (1050)		RECORD THE WEIGHT OF THE PART 6000LBS MAX		QA		SCALE	5080LBS	339-E.R 09-29-05		A
4* (1060)	H7	22.13 ± .010	CMM	QA		00064	TAP	339-E.R 09-29-05		R
4* (1070)	H7	47.79 ± .010	CMM	QA		00064	47.76	339-E.R 09-29-05		R
4* (1080)	H6	59.18 ± .010	CMM	QA		00064	59.16	339-E.R 09-29-05		R
4* (1090)	H6	73.27 ± .010	CMM	QA		00064	TAP	339-E.R 09-29-05		R
4* (1100)	H5	80.49	CMM	QA		00064	80.46	339-E.R 09-29-05		R
4* (1110)	H5	87.87 ± .010	CMM	QA		00064	87.84	339-E.R 09-29-05		R
4* (1120)	H5	89.64 ± .010	CMM	QA		00064	89.64	339-E.R 09-29-05		A
4* (1130)	G4	31.83 ± .010	CMM	QA		00064	TAP	339-E.R 09-29-05		R
4* (1140)	F4	24.10 ± .010	CMM	QA		00064	24.08	339-E.R 09-29-05		A
4* (1150)	F4	11.48 ± .010	CMM	QA		00064	11.46	339-E.R 09-29-05		R

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4* (1160)	E4	5.20 ± .010	CMM	QA		00064	5.19	339-E.R 09-29-05			A
4* (1170)	D4	18.31 ± .010	CMM	QA		00064	18.32	339-E.R 09-29-05			A
4* (1180)	D4	32.50 ± .010	CMM	QA		00064	32.50	339-E.R 09-29-05			A
4* (1190)	C5	77.13 ± .010	CMM	QA		00064	77.13	339-E.R 09-29-05			A
4* (1200)	C6	55.56 ± .010	CMM	QA		00064	55.55	339-E.R 09-29-05			A
4* (1210)	B7	23.74 ± .010	CMM	QA		00064	23.73	339-E.R 09-29-05			A
4* (1220)	C7	37.09 ± .010	CMM	QA		00064	37.08	339-E.R 09-29-05			A
4* (1230)	D8	17.22 ± .010	CMM	QA		00064	17.23	339-E.R 09-29-05			A
4* (1240)	F8	28.17 ± .010	CMM	QA		00064	TAP	339-E.R 09-29-05			R
4* (1250)	G8	12X .250-20 UNC-2B	THREAD PLUG GA	QA		A-517 VISUAL	ACCEPT	339-E.R 09-29-05			A
4* (1260)	G8	40.75 ± .010	CMM	QA		00064	40.74	339-E.R 09-29-05			A
4* (1270)	G8	43.42 ± .010	CMM	QA		00064	TAP	339-E.R 09-29-05			R
4* (1280)	D1	12X .25-20 UNC Ø.5 X 82° INCL. CHAMFER	THREAD PLUG GA	QA		A-517 VISUAL	ACCEPT	339-E.R 09-29-05			A
5* (1290)	H8	88.39 ± .010	CMM	QA		00064	88.39	339-E.R 09-29-05			A
5* (1300)	H7	86.42 ± .010	CMM	QA		00064	86.40	339-E.R 09-29-05			R
5* (1310)	H6	59.08 ± .010	CMM	QA		00064	59.06	339-E.R 09-29-05			A
5* (1320)	H5	28.71 ± .010	CMM	QA		00064	28.69	339-E.R 09-29-05			R
5* (1330)	G5	32.42 ± .010	CMM	QA		00064	32.41	339-E.R 09-29-05			A

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5* (1340)	D4	22.117 ± .005	CMM	QA		00064	22.118	339-E.R 09-29-05			A
5* (1350)	D4	38.14 ± .010	CMM	QA		00064	38.14	339-E.R 09-29-05			A
5* (1360)	D5	21.33 ± .010	CMM	QA		00064	21.32	339-E.R 09-29-05			A
5* (1370)	D7	87.62 ± .010	CMM	QA		00064	87.63	339-E.R 09-29-05			A
5* (1380)	E8	7.53 ± .010	CMM	QA		00064	7.53	339-E.R 09-29-05			A
5* (1390)	E8	4.91 ± .010	CMM	QA		00064	4.88	339-E.R 09-29-05			R
5* (1400)	G8	36.13 ± .010	CMM	QA		00064	36.12	339-E.R 09-29-05			A
7* (1410)	D4	2.1°	CMM	QA		00064	REFERENCE IGES INF RMATION	339-E.R 09-29-05			R
8* (1420)	D8	2.63 ± .010	CMM	QA		00064	2.63 - 2.65	339-E.R 09-29-05			R

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-116 - Item: 16

Workorder: 65707/1-0 Sub:1 Op:140

Part: SE141-116 - MODULAR COIL WINDING FORM TYPE-C - PRODUCTION MODULAR COIL WINDING FORM TYPE-C

Drawing ID: SE141-103 Rev: 2			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		INSPECT AND RECORD RESISTANCE ACROSS BOLT INSUL. VALUE TO BE >500 KOHM'S		QA			HOLE 2 > 35,000 K-O HMS; ALL OTHERS AP . INFINITY	295-C.W		
(10)								10-01-05		
*		INSPECT AND RECORD RANGE OF RESISTANCE ACROSS POLOIDAL BREAK MIDPLANE AND BOLTS VALUE TO BE >500 KOHM'S		QA			HOLE 2 > 100,000 K- OHMS; ALL OTHERS A P. INFINITY	295-C.W		
(20)								10-01-05		

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Employees: 212-J.Lehr / 295-C.Weaver / 339-E.Root