

ENERGY INDUSTRIES OF OH

Purchase Order Number:

S005242-F

Part Number:

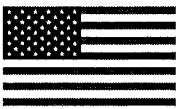
SE141-114

Part Name:

MCWF A-3

MTM Work Order Number:

65709/3.0



Major

Tool & Machine, Inc.

Customer: 8909 - ENERGY INDUSTRIES OF OHIO
Customer P.O.: S005242-F
Customer Part ID: SE141-114 - MCWF A-3

Item#	Document Description / Material Description / File Name / Heat Lot
1	CERTIFICATE OF CONFORMANCE
2	COMPLETED SHOP TRAVELERS: - 65709-3 completed shop travelers.pdf
3	NC20124 - OVER SIZED BORE: - NC20124Rev1.pdf
4	NC20166 - PT REJECTIONS: - NC20166 A-3 PT Indications.pdf
5	NC20201 - FINAL DIMENSIONAL AND VISUAL: - NC20201_2_A3IDC_Photos_072806.pdf

SE141-048 - POLOIDAL BREAK SHIM ASSEMBLY

Item#	Sub	Op	Pc	Document Description / Material Description / File Name / Heat Lot
6	2	30	20	Certificate of Conformance: FROM SUPPLIER / LOCTITE 411 - LOCKING COMPOUND - mc106438.TIF / CERTIFIED

SE141-048-03 - INSULATING SLEEVE

Item#	Sub	Op	Pc	Document Description / Material Description / File Name / Heat Lot
7	3	10	10	Certificate of Conformance: / G11CR_1 - ROUND, BAR, 1.75 DIA - mc108545.tif / CERTIFIED

SE141-101

Item#	Sub	Op	Pc	Document Description / Material Description / File Name / Heat Lot
8	1	140		Inspection Data Checklist: 2 steps

SE141-101-1 - MOD COIL WINDING FORM ASSEMBLY TYPE-A

Item#	Sub	Op	Pc	Document Description / Material Description / File Name / Heat Lot
9	0	10	10	Material Certification: Trace ID: 113686 / ER316MNNF_093_GTAW - WELD WIRE,GTAW .093 DIA - mc106164.pdf / W020132 / W020132
10	0	10	10	Material Certification: Trace ID: 116252 / ER316MNNF_093_GTAW - WELD WIRE,GTAW .093 DIA - mc106579.tif / W020132 / W020132

SE141-101-4 - INSULATING SHEET

Item#	Sub	Op	Pc	Document Description / Material Description / File Name / Heat Lot
11	7	10	10	Certificate of Conformance: G11CR / G11CR_3 - SHEET, FLAT - mc107081.tif / CERTIFIED

SE141-101-5 - INSULATING SLEEVE

Item#	Sub	Op	Pc	Document Description / Material Description / File Name / Heat Lot
12	5	10	10	Certificate of Conformance: / G11CR_1 - ROUND, BAR, 1.75 DIA - Same as Item #7 / CERTIFIED

SE141-114 - MODULAR COIL WINDING FORM TYPE-A

Item#	Sub	Op	Pc	Document Description / Material Description / File Name / Heat Lot
13	1	100		Nondestructive Liquid Penetrant Test Certification #17396
14	1	130		Inspection Data Checklist: 5 steps
15	1	132		Inspection Data Checklist: 79 steps
16	1	134		Map(s): RT MAP AND READER SHEET - mc120813.tif
17	1	136		Inspection Data Checklist: 2 steps
18	11	10	10	Material Certification: / DS141-036 - STUD - mc118607.tif / XFR/E3930
19	11	10	20	Material Certification: / DS141-060 - NUT - mc118688.tif / XFQ/5407813



Customer: 8909 - ENERGY INDUSTRIES OF OHIO
Customer P.O.: S005242-F
Customer Part ID: SE141-114 - MCWF A-3

SE141-141 - BEARING PLATE DETAIL TYPE "A" SHORT

Item#	Sub	Op	Pc	Document Description / Material Description / File Name / Heat Lot
20	13	30		Inspection Data Checklist: 1 steps

SE141-142 - BEARING PLATE DETAIL TYPE "A" LONG

Item#	Sub	Op	Pc	Document Description / Material Description / File Name / Heat Lot
21	14	30		Inspection Data Checklist: 1 steps



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COMPLETED SHOP TRAVELERS

SE141-114
MCWF A3

Activity	Visual Mfg Ref.	Op Status	Close Date	Emp ID
Manufacturing Planning- QA planning- Production Support PREPARE DOCUMENTATION TO PRESENT TO GOVERNMENT SOURCE INSPECTOR.	65709/3.0 -Sub:0 Op#:10	Closed	7/25/2006	840-G.Masood
REVIEW RESULTS FROM THE FOLLOWING INSECTIONS:--PENETRANT INSPECTION (PT)--RADIOGRAPHIC INSPECTION (RT)--FINAL DIMENSIONAL INSPECTION--MAG PERMEABILITY--ELECTRICAL RESISTANCE--	65709/3.0 -Sub:0 Op#:20	Closed	7/25/2006	840-G.Masood
ORIENT PART WITH DATUM E FLANGE DOWN.----ENSURE PART SURFACES ARE CLEAN AND FREE OF GRIT AND DEBRIS. THE PART IS NOT TO BE OILED.--THE ENTIRE PART IS TO BE WRAPPED IN PLASTIC.-- PLACE FOAM ON THE 4X6 BEAMS THAT THE FLANGE WILL BE SITTING ON. LOWER THE PAR	65709/3.0 -Sub:0 Op#:30	Closed	7/25/2006	840-G.Masood
Receive customer supplied material. ----Customer material data package will not be received with the part. This record will be obtained and linked later.----Part Number: SE141-114 Rev: 5--Part Description: PRODUCTION WINDING FORM TYPE-C	65709/3.0 -Sub:0 Op#:40	Closed	8/10/2006	131-W.Allen
SETUP 1 - MTMFX-3101 WITH DATUM E SIDE OF PART AGAINST FIXTURE.--SETUP 2 - MTMFX-3102 WITH DATUM D SIDE OF PART AGAINST FIXTURE.----SETUP AND MACHINE THE FLANGE FACES AND FLANGE PERIPHERY TO WITHIN .100- STOCK. --FINISH MACHINE THE WING SURFACES ABOVE EA	65709/3.0 -Sub:1 Op#:10	Closed	2/7/2006	437-J.Hiatt
WELD BRACES OVER THE PRE-CUT POLOIDAL BREAK IN THE -T-. SEE RON BACK FOR LOCATION OF BRACES.----MARK INSIDE EACH AREA TO BE REMOVED USING A METAL STAMP WITH THE SERIAL NUMBER FOR EACH PART AS APPLICABLE- A1- A2- A3- ETC...LOCATION OF STAMPING IS OPTIONAL.	65709/3.0 -Sub:1 Op#:18	Closed	3/31/2006	535-S.Lentz
SET CASTING ON RISERS WITH DATUM -E- FLANGE DOWN. TAB DATUM -E- FLANGE TO THE RISER ON EITHER SIDE OF THE BREAK TO PREVENT MOVEMENT AFTER MACHINING THE BREAK THROUGH. WELD CHANNEL BRACE ACROSS THE LARGE CUTOUT ADJACENT TO THE BREAK.--FINISH MACHINE THE PO	65709/3.0 -Sub:1 Op#:19	Closed	3/31/2006	170-D.Rothenberger
ROUGH MACHINE PER PROGRAM.	65709/3.0 -Sub:1 Op#:20	Closed	4/13/2006	535-S.Lentz
	65709/3.0 -Sub:1 Op#:25	Closed	6/9/2006	345-D.Sauser



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COMPLETED SHOP TRAVELERS

SE141-114
MCWF A3

Activity	Visual Mfg Ref.	Op Status	Close Date	Emp ID
SET UP FIXTURE PLATE MTFMX-3101 AND MACHINE LOCATING PADS AS NECESSARY.--SET UP CASTING WITH DATUM -E- AGAINST THE FIXTURE.--- FINISH MACHINE ALL AREAS BELOW THE T SECTION.--- MACHINE T SECTION TO WITHIN .030.--- FINISH MACHINE DATUM -D- FLANGE.--	65709/3.0 -Sub:1 Op#:30	Closed	6/28/2006	345-D.Sauser
SET UP FIXTURE PLATE MTFMX-3102 AND MACHINE LOCATING PADS AS NECESSARY.--SET UP CASTING WITH DATUM -D- AGAINST THE FIXTURE.--- FINISH MACHINE ALL AREAS BELOW THE T SECTION.--- MACHINE T SECTION TO WITHIN .030.--- FINISH MACHINE DATUM -E- FLANGE.--	65709/3.0 -Sub:1 Op#:35	Closed	7/7/2006	744-P.Schumacher
THIS OPERATION CONSISTS OF 3 SETUPS.--SETUP #1: ANGLE BASE AND FIXTURE MTFMX-3101-- DATUM -E- FLANGE DOWN.--SETUP #2: ANGLE BASE AND FIXTURE MTFMX-3102-- DATUM -D- FLANGE DOWN.-SETUP #3: RISERS AND FIXTURE MTFMX-3102-- DATUM -D- FLANGE DOWN.---MACHINE P	65709/3.0 -Sub:1 Op#:50	Closed	7/17/2006	445-J.Purkhiser
SETUP PART WITH DATUM E SIDE UP.--ALL GRINDING WHEELS AND DISKS MUST BE VIRGIN MATERIAL NOT PREVIOUSLY USED ON ANY OTHER MATERIAL TO AVOID MATERIAL CONTAMINATION.---- BLEND ACCESSIBLE AREAS OF THE T SECTION.--- DEBURR WING AREAS TO REMOVE ANY SHARPNESS F	65709/3.0 -Sub:1 Op#:88	Closed	7/19/2006	219-T.Laird
CAREFULLY REMOVE SHIM FROM PART. PRINT ROUTER FOR SUBID 15- OPERATION 10 AND MOVE TO THE PROCESSED WORK CENTER. DEBURR--ALL GRINDING WHEELS AND DISKS MUST BE VIRGIN MATERIAL NOT PREVIOUSLY USED ON ANY OTHER MATERIAL TO AVOID MATERIAL CONTAMINATION.---- TAP 96 3/8-16 HOLES USING TAP GUIDE. --- FINISH BLENDING T SECTION.--- HAND GRIND .06- -.09- CHAMFER ON ALL SPLI	65709/3.0 -Sub:1 Op#:89	Closed	7/19/2006	746-G.Davidson
INSTALL BREAK SHIM AND TEMPORARY ALUMINUM SHIM PLATES. USE TAPERED PINS TO ALIGN HOLES AND INSTALL THE FOUR SLAVE BOLTS. USE ANTI-SIEZE ON THE BOLTS TO PREVENT GAULDING. TORQUE THE ASSEMBLY TO PREVENT MOVEMENT. THIS IS ONLY TEMPORARY AND ALIGNMENT IS NOT	65709/3.0 -Sub:1 Op#:90	Closed	7/19/2006	219-T.Laird
	65709/3.0 -Sub:1 Op#:92	Closed	7/20/2006	219-T.Laird



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COMPLETED SHOP TRAVELERS

SE141-114
MCWF A3

Activity	Visual Mfg Ref.	Op Status	Close Date	Emp ID
PROTECT PART FROM METAL CONTAMINATION DUE TO CONTACT WITH IRON- SPECIFICALLY WHEN RIGGING PART FOR MOVEMENT.-- MOVE PART INTO WASH BOOTH. --THOROUGHLY CLEAN AND DRY ALL SURFACES AND HOLES PER SECTION 9 OF PS583. --PARTS TO BE WASHED USING HEATED- DE-MINERA PT 100% OF ALL MACHINED AND GROUND SURFACES. EXCLUDE THE PROCESSING OF ANY AS-CAST SURFACE.--SEE PS582 FOR PROCESSING INSTRUCTIONS. ----TAKE PHOTOS OF ALL REJECTIONS AND NUMBER THEM. IF THERE ARE SEVERAL INDICATIONS CLOSE TOGETHER- NUMBER THE GROUP AND RE	65709/3.0 -Sub:1 Op#:95	Closed	7/20/2006	219-T.Laird
SET PART ON RISERS WITH DATUM -D- FLANGE DOWN. PLACE A RISER ON EITHER SIDE OF THE POLOIDAL BREAK TO ENABLE CLAMPING TO ENSURE THAT THE DATUMS ARE COPLANER. LAY A STRAIGHT EDGE ACROSS THE DATUM -D- FLANGE TO VERIFY ALIGNMENT. ENSURE RADIAL ALIGNMENT BY LA	65709/3.0 -Sub:1 Op#:100	Closed	7/20/2006	667-J.Bannister
-CMM INSPECT DATUM E SIDE OF CASTING. --PERFORM ALL HARD GAGING OF THE DATUM E SIDE. ---CONDUCT PERMEABILITY CHECK OF DATUM E SIDE PER OPERATION 136.---CONSULT ENGINEERING ON ANY OUT OF TOLERANCE CONDITIONS PRIOR TO FLIPPING THE PART AND STARTING INSPECT	65709/3.0 -Sub:1 Op#:130	Closed	7/20/2006	825-B.Jarrett
THE -T- AREAS DEFINED AS -HIGH STRESS- ARE TO BE RT 100%. SEE PS581 FOR PROCESS INSTRUCTIONS.----HAND SKETCH A LAYOUT OF ALL FILM LOCATIONS ON ATTACHED RT MAP. ----ALL FILM IS TO BE DOUBLED UP IN ORDER TO SUPPLY THE CUSTOMER WITH A COMPLETE SET OF FILM.--	65709/3.0 -Sub:1 Op#:132	Closed	7/27/2006	339-E.Root
PERFORM A MAG PERMEABILITY CHECK OF THE MACHINED SURFACES USING A SEVERN PERMEABILITY INDICATOR GAGE. PERMEABILITY SHOULD BE NO GREATER THAN 1.02µ.----CHECK THE PERMEABILITY IN 3 PLACES ON EACH SIDE OF THE T SECTION AT LOCATIONS ADJACENT TO EVERY 5TH HOLE	65709/3.0 -Sub:1 Op#:134	Closed	7/26/2006	010-R.Contractor
THE RESISTANCE OF THE MID-PLANE ELECTRICAL INSULATION SHALL BE GREATER THAN 500 KOHMS WHEN TESTED AT 100 VDC.---- TEST 1:--THE INSULATION RESISTANCE BETWEEN THE MID-PLANE POLOIDAL BREAK SHIM AND WINDING FORM SHALL BE MEASURED. DURING THIS TEST- THE BOLTS S	65709/3.0 -Sub:1 Op#:136	Closed	7/26/2006	495-D.Coffman
	65709/3.0 -Sub:1 Op#:140	Closed	7/25/2006	503-B.Houk



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COMPLETED SHOP TRAVELERS

SE141-114
MCWF A3

Activity	Visual Mfg Ref.	Op Status	Close Date	Emp ID
PERFORM FINAL COSMETICS AS REQUIRED.--THOROUGHLY CLEAN CASTING WITH ISOPROPYL ALCOHOL. VERIFY THAT ALL HOLES ARE CLEAN AND FREE OF CHIPS.	65709/3.0 -Sub:1 Op#:150	Closed	7/27/2006	578-S.Martinez
SAW MATERIAL TO LENGTH PER MATERIAL CARD.	65709/3.0 -Sub:10 Op#:10	Closed	3/15/2006	266-R.Keith
MACHINE SLAVE HARDWARE BUSHINGS TO THE FOLLOWING:---1.620 O.D.+0-.002--1.376 I.D. +.004/- .000--LENGTH 1.350 +/- .010----THESE BUSHINGS ARE FOR SLAVE HARDWARE SHIM MOUNTING. DELIVERY THESE PARTS TO RON BACK WHEN COMPLETE. THEY ARE TEMPORARY BUSHINGS THAT	65709/3.0 -Sub:10 Op#:20	Closed	3/29/2006	236-M.Jennings
MACHINE THICKNESS OF SHIM TO 2.125 +/- .001.--REMOVE AN EVEN AMOUNT OF STOCK FROM EACH FACE OF THE SHIM. THERE IS APPROXIMATELY 1/16- PER SIDE OF STOCK ON THE PART.--MACHINE	65709/3.0 -Sub:15 Op#:10	Closed	7/19/2006	234-E.Booher
3/8-16 LIFTING HOLES IN BOTH ENDS OF SHIM.	65709/3.0 -Sub:15 Op#:20	Closed		
HAND GRIND .06- .09- CHAMFER ON PERIMETER OF SHIM AND BOTH ENDS OF HOLES.--HAVE TOOL ROOM VERIFY THE SIZE OF THE HOLES IN ORDER TO SIZE THE BUSHINGS.	65709/3.0 -Sub:15 Op#:20	Closed		
RECEIVE CUSTOMER SUPPLIED CASTING	65709/3.0 -Sub:2 Op#:10	Closed	2/7/2006	437-J.Hiatt
MACHINE THE SHIM COMPLETE CNC PROGRAMS.--SHIM THICKNESS WILL FINISH AT 2.25- LEAVING 1/16- PER SIDE FOR A LATER MACHINING OPERATION.--MACHINE -T- SECTION OF SHIM LEAVING	65709/3.0 -Sub:2 Op#:20	Closed	3/30/2006	234-E.Booher
.25- STOCK.--INSIDE PROFILE OF SHIM (OTHER THAN T SECTION) WILL BE FINISHED.--TOP AND				
PRE FIT EACH BUSHING TO MAKE SURE THEY SLIP INTO THE				
POLOIDAL BREAK FLANGE HOLES.--APPLY LOCTITE 411 TO THE OD OF EACH BUSHING AND INSTALL FLUSH TO ONE SIDE OF THE BREAK SHIM. GRIND THE OPPOSITE SIDE OF THE BUSHINGS FLUSH TO THE SHIM.	65709/3.0 -Sub:2 Op#:30	Closed		
SAW OFF 16- AND MOVE TO NEXT WORK CENTER.	65709/3.0 -Sub:3 Op#:10	Closed	6/1/2005	227-D.Bockover
MACHINE OD OF BUSHING .001- .002- SMALLER THAN SIZE OF THE HOLES IN POLOIDAL BREAK SHIM. IF HOLE SIZES VARY- MARK THE SHIM AND BUSHINGS 1 THRU 7.--MACHINE THE ID OF THE BUSHING TO 1.380 +/- .001--MACHINE THE LENGTH TO 2.19-. BUSHINGS WILL BE GROUND FLUS				
RECEIVE MATERIAL--NOTIFY CFT AND FORWARD MATERIAL STORES.	65709/3.0 -Sub:4 Op#:10	Closed	6/1/2005	131-W.Allen



Major

Tool & Machine, Inc.

COMPLETED SHOP TRAVELERS

SE141-114

MCWF A3

Activity	Visual Mfg Ref.	Op Status	Close Date	Emp ID
SAW OFF 30- LENGTH AND MOVE TO NEXT WORK CENTER. MACHINE PER THE DRAWING FOR A .001- -.002- SLIP FIT WITH THE MATING DETAIL. --MEASURE THE HOLE SIZES IN THE TWO CASTING FLANGES AND SIZE THE BUSHINGS ACCORDINGLY. IF THE HOLE SIZES VARY- MARK EACH BUSHING I THRU 14 AND MAP OUT THE CORRESPONDING HOLE LOCA	65709/3.0 -Sub:5 Op#:10	Closed	6/1/2005	227-D.Bockover
SAW 13- LENGTH AND MOVE TO NEXT WORK CENTER. RECEIVE MATERIAL	65709/3.0 -Sub:5 Op#:20	Closed	7/19/2006	821-J.Leggins
MACHINE THE PROFILE LEAVING STOCK PER PROGRAM.	65709/3.0 -Sub:6 Op#:10	Closed	6/1/2005	227-D.Bockover
SAW PER MATERIAL CARD	65709/3.0 -Sub:7 Op#:10	Closed	4/5/2005	131-W.Allen
SAW PER MATERIAL CARD	65709/3.0 -Sub:7 Op#:20	Closed	6/1/2006	332-J.Bagwill
RECEIVE HARDWARE- SCAN CERTIFICATIONS AND COMPLETE IDC.-- MOVE TO STORES--	65709/3.0 -Sub:8 Op#:10	Closed	2/6/2006	266-R.Keith
PLACE THE FOLLOWING IN STORES:--7 PCS - DS141-036 STUD--14 PCS - DS141-060 NUT	65709/3.0 -Sub:9 Op#:10	Closed	2/6/2006	266-R.Keith
NO CERTIFICATIONS REQUIRED.--VERIFY QUANTITY AND FORWARD PARTS TO NEXT WORK CENTER.	65709/3.0 -Sub:11 Op#:10	Closed	5/26/2006	503-B.Houk
MACHINE COMPLETE PER PRINT	65709/3.0 -Sub:11 Op#:20	Closed	5/26/2006	419-J.Smith
PERFORM A MAGNETIC PERMEABILITY CHECK USING A SEVERN PERMEABILITY INDICATOR GAGE. PERMEABILITY SHOULD BE NO GREATER THAN 1.02µ.--Part Number: SE141-141--Part Description: BEARING PLATE TYPE -A- SHORT	65709/3.0 -Sub:13 Op#:10	Closed	5/12/2006	437-J.Hiatt
NO CERTIFICATIONS REQUIRED.--VERIFY QUANTITY AND FORWARD PARTS TO NEXT WORK CENTER.	65709/3.0 -Sub:13 Op#:20	Closed	6/21/2006	506-R.Liston
MACHINE COMPLETE PER PRINT	65709/3.0 -Sub:13 Op#:30	Closed	6/21/2006	533-B.Clevenger
PERFORM A MAGNETIC PERMEABILITY CHECK USING A SEVERN PERMEABILITY INDICATOR GAGE. PERMEABILITY SHOULD BE NO GREATER THAN 1.02µ.--Part Number: SE141-142--Part Description: BEARING PLATE TYPE -A- LONG	65709/3.0 -Sub:14 Op#:10	Closed	5/12/2006	437-J.Hiatt
TURN OD OF MATERIAL TO 2.0495- +.000 / -.002.--LENGTH TO BE 1.325- +/. 010.--BREAK SHARP EDGES .010 -.020.--	65709/3.0 -Sub:14 Op#:20	Closed	7/13/2006	506-R.Liston
FLIP PART AND CAREFULLY PLACE ON RISERS WITH THE DATUM E END UP.--GRIND RELIEF PER DIRECTION FROM ENGINEERING.--FLIP PART SO THAT DATUM E FLANGE IS DOWN.	65709/3.0 -Sub:16 Op#:20	Closed	7/19/2006	503-B.Houk
	65709/3.0 -Sub:17 Op#:10	Closed	7/25/2006	821-J.Leggins
	65709/3.0 -Sub:17 Op#:20	Closed	7/28/2006	705-B.Hill

Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
E-Mail: NKHFlowen@aol.com

Telephone: 216-496-2314
Fax: 216-328-2001

Part: SE141-114 / MODULAR COIL WINDING FORM TYPE
Drawing ID: SE141-114 Revision: 7

Customer P.O.: S005242-F/Ln:3
Serial No./Qty: A3

Reported By: MIKE GRIFFITH
E-Mail: mGriffith@MajorTool.com

Telephone: 317-636-6433
Fax: 317-634-9420

Problem: Sheet 5, Zone C7; 1.885 +/- .003" (hole 17).
Hole diameter measures 2.0515" (.1635" over the high limit of tolerance).

Rev. 1 - 2.057" changed to 2.0515 due to measurement error.

Proposed Disposition:

MTM proposes to accept the hole as is and increase the OD of the insulating bushing to compensate for the oversize condition.

Recommended bushing size to be 2.0495" +.000/-.002"

Number of additional pages: None

Customer Disposition: Use As Is Rework Repair Scrap Replace

Rework the bushing to 2.0495" +.000/-.002"

Approvals:

Larry Dudek

Digitally signed by Larry Dudek
DN: cn=Larry Dudek, c=US
Date: 2006.07.26 10:30:08
-04'00'

Procurement Technical Representative

Brad Nelson

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US, o=ORNL,
ou=FED, email=nelsonbe@ornl.gov
Date: 2006.07.26 14:08:18 -04'00'

Responsible Line Manager:

**Mike
Griffith**

Digitally signed by Mike Griffith
DN: cn=Mike Griffith, c=US, o=Major
Tool and Machine, ou=CFT - White,
email=mgriffith@majortool.com
Reason: I agree to the terms defined by
the placement of my signature on this
document
Date: 2006.08.18 15:14:52 -04'00'

Major Tool Implemented By: _____

Title: _____

Date: _____

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

MTM N/C: 20166

Page: 1
Date: 07/24/06
User ID: GRIFFITH

Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
E-Mail: NKHFlowen@aol.com

Telephone: 216-496-2314
Fax: 216-328-2001

Part: SE141-114 / MODULAR COIL WINDING FORM TYPE
Drawing ID: SE141-114 Revision: 7

Customer P.O.: S005242-F/Ln:3
Serial No./Qty: A3

Reported By: MIKE GRIFFITH
E-Mail: mGriffith@MajorTool.com

Telephone: 317-636-6433
Fax: 317-634-9420

Problem: PART IS REJECTED PER REQUIREMENTS OF ASTM A903/A903M LEVEL 1.
FIVE INDICATIONS WERE FOUND AT TIME OF INSPECTION.

Proposed Disposition:

PROPOSE TO ACCEPT INDICATIONS AS IS.

Number of additional pages: 5 page PT summary

Customer Disposition: Use As Is Rework Repair Scrap Replace

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

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Major Tool and Machine, Inc. 1458 East 19th Street, Indianapolis, IN 46218-4289 Tel: 317-636-6433 Fax: 317-634-9420

Nonconformance Report: NC20166 A-3 PT Indications

Project Disposition: Accept As Is

Approvals:

Larry Dudek

Digitally signed by Larry Dudek
DN: cn=Larry Dudek, c=US
Date: 2006.07.25 09:31:05 -04'00'

Procurement Technical Representative

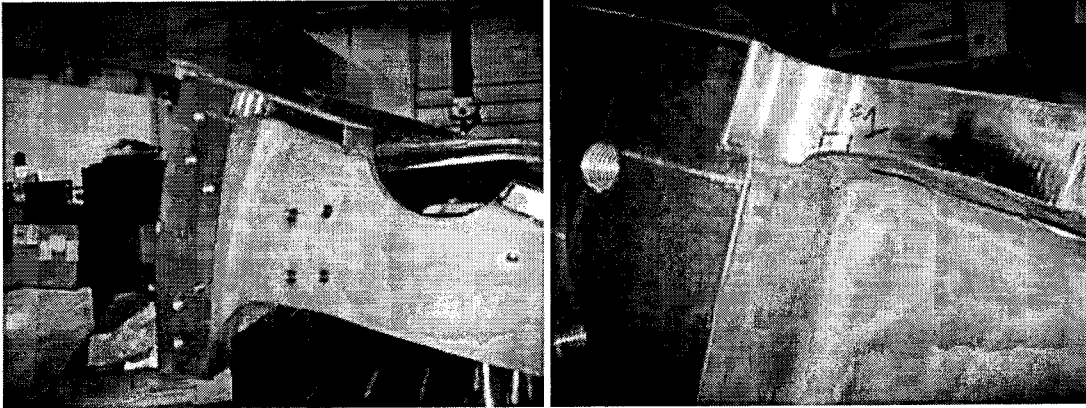
Brad Nelson

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US, o=ORNL,
ou=FED, email=nelsonbe@ornl.gov
Date: 2006.07.27 09:27:10 -04'00'

Responsible Line Manager:

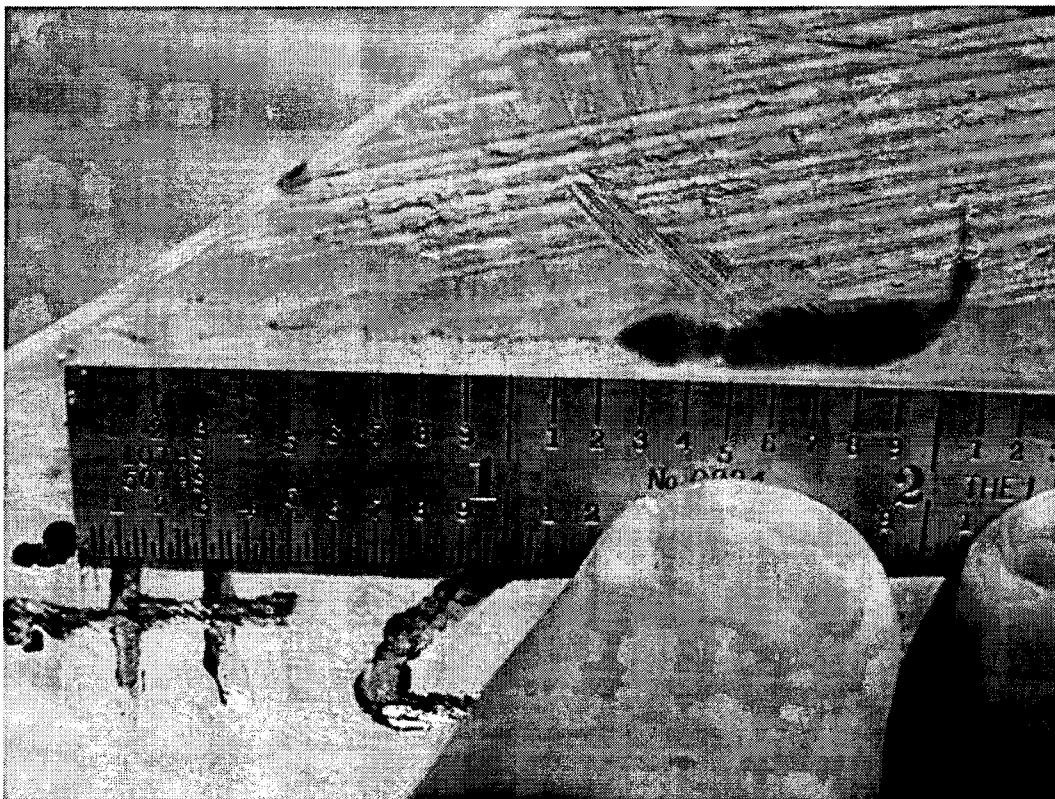
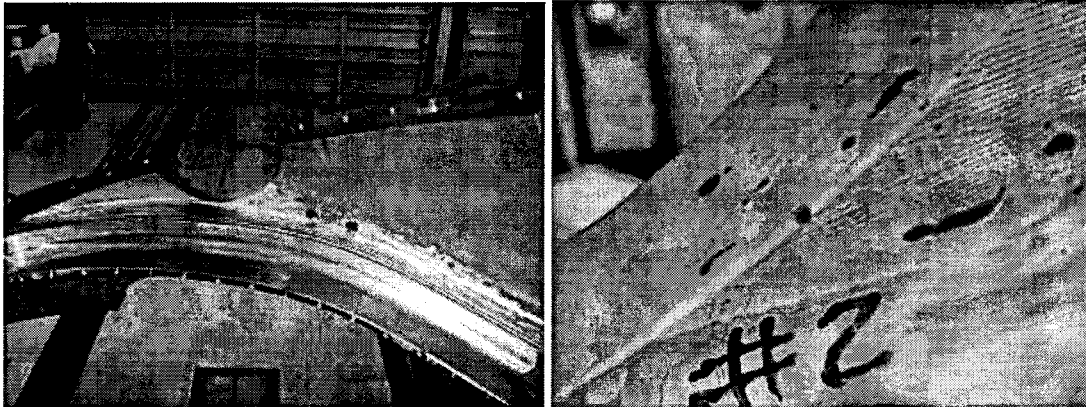
PT Inspection Results of A3 – NC20166

1. .600" linear indication on OD of datum –E- flange located adjacent to E-flange hole 19.



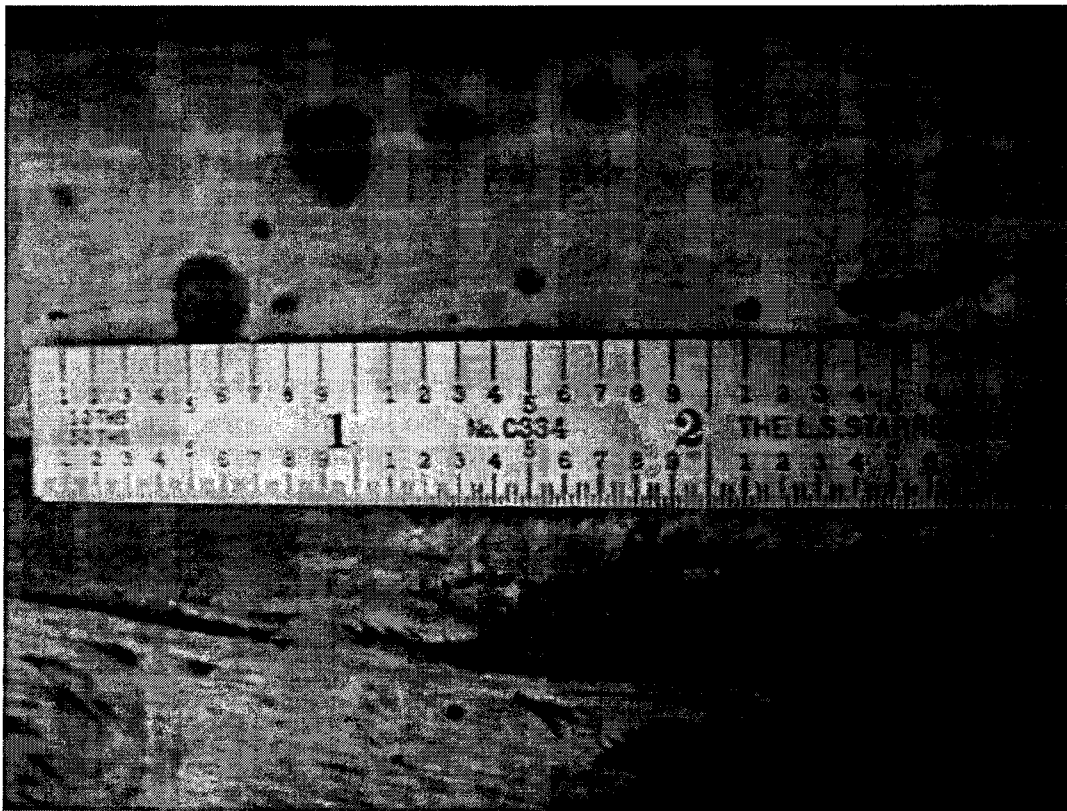
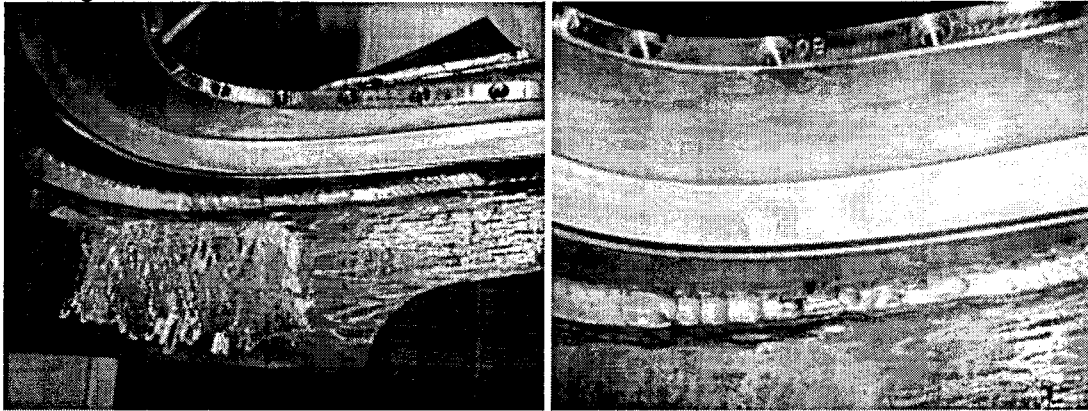
PT Inspection Results of A3 – NC20166

- Cluster of linear indications on E side of casting below VPI groove near T hole 86. The indications are on the inner casting wall and wrap around onto the surface of the 6" radial cutout. The longest indication is along the inner wall and is approximately 2".



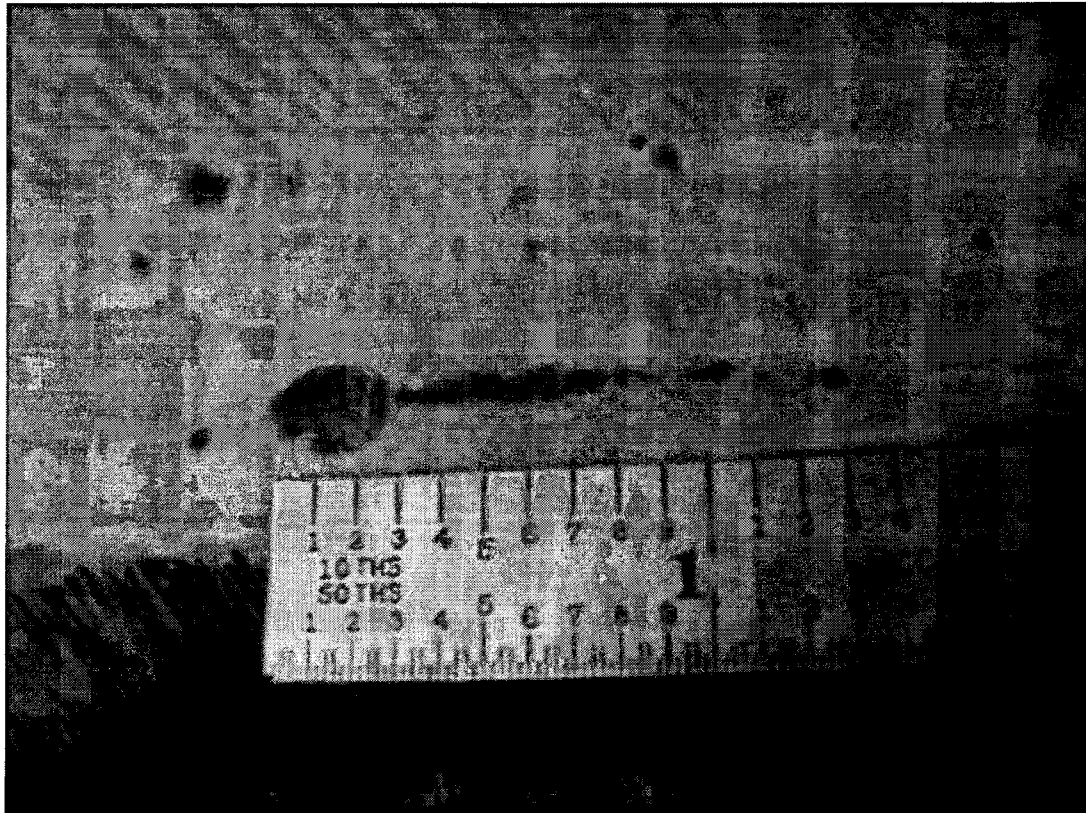
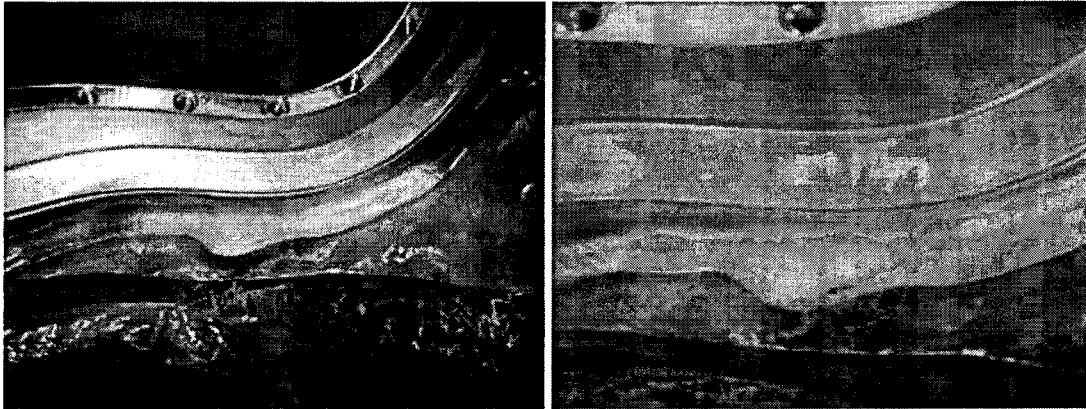
PT Inspection Results of A3 – NC20166

3. Cluster of linear indications on the datum –D- side beneath the VPI groove near T hole 80. The indication from 1.1" to 2.7" on the scale appears to be continuous for a total length of 1.6".



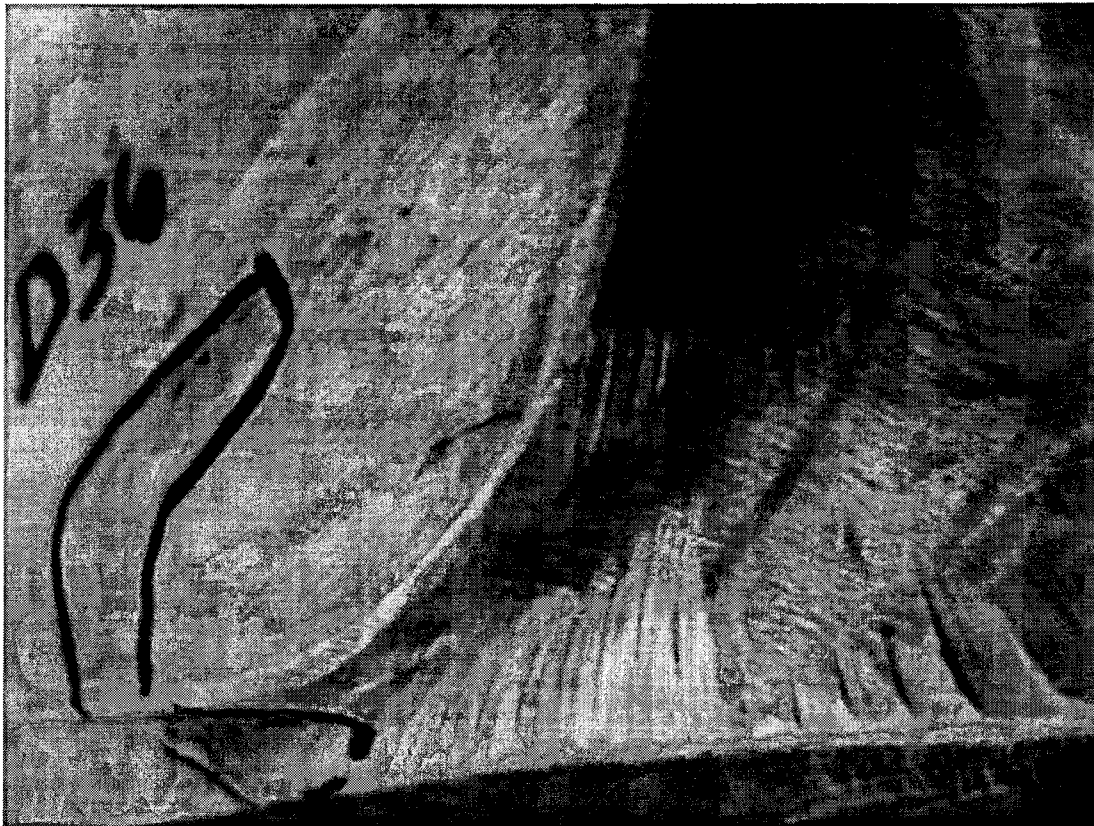
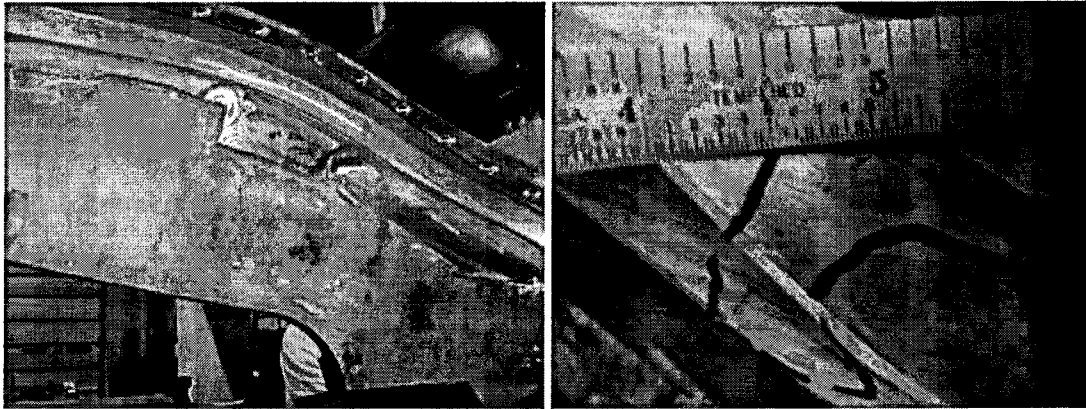
PT Inspection Results of A3 – NC20166

- 4. Linear indication approximately 1.3" located on datum D side of casting below the VPI groove near T hole 66.



PT Inspection Results of A3 – NC20166

5. Cluster of linear indications on and around the machined pad on the D side inner wall located near T hole 36. The longest indication appears to be continuous and is over 2”.



Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
E-Mail: NKHFlowen@aol.com

Telephone: 216-496-2314
Fax: 216-328-2001

Part: SE141-114 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-114

Revision: 7

Customer P.O.: S005242-F/Ln:3
Serial No./Qty: A3

Reported By: MIKE GRIFFITH
E-Mail: mGriffith@MajorTool.com

Telephone: 317-636-6433
Fax: 317-634-9420

- Problem: Inspection Test #: 130 rejected: OUTER AS CAST SURFACES: {g|,5|A|B|C}: -.056 TO .457
- Inspection Test #: 150 rejected: 4 X .03 X 45: : .010 TO .040
- Inspection Test #: 190 rejected: M TO M1: {g|,02|R|T|S}: -.020 TO .017
- Inspection Test #: 230 rejected: N TO N1: {g|,02|R|T|S}: -.024 TO .015
- Inspection Test #: 240 rejected: 2 X .06/.09 X 45: : 030 TO .068
- Inspection Test #: 270 rejected: .375-16 HOLES: {#|,06|R|T|S}: .0052 TO .072
- Inspection Test #: 280 rejected: DATUM E FLANGE: {f|,01}: .011
- Inspection Test #: 330 rejected: 8X Ø1-8 UNC: {#|,010|A|B|C}: .001 TO .025
- Inspection Test #: 350 rejected: 8X Ø1-8 UNC: {d|,010|A|B|C}: .007 TO .048
- Inspection Test #: 470 rejected: : d1.885 ~.003: 1.8855 ,1.8858, 1 HOLE 2.0515"
- Inspection Test #: 780 rejected: INNER AS CAST SURFACES: {g|,5|A|B|C}: -.444 TO .053

Also 3 additional items on NC attachment.

Proposed Disposition:

Based on previous submittal history, MTM proposes to accept deviations as is.

Number of additional pages: IDC attachment and NC attachment

Customer Disposition: Use As Is Rework Repair Scrap Replace

The rejections listed above and the attached IDC list and photos were reviewed during a telecom on 7/27 attended by D. Williamson, T. Brown, F. Malinowski, P. Heitzenroeder, and H. Neilson, M. Griffith, and N. Horton. All were accepted as is with the exception of the "as cast" surface indicated in the attached Excel file and Tom Brown's PPT slides which summarize his review of this area. He determined that the cast surface in the concave surface area exceed tolerances by approximately 3/4". EIO/MTM agreed that this surface will be ground to the specified dimension.

Phil
Heitzenroeder

Digitally signed by Phil Heitzenroeder
DN: cn=Phil Heitzenroeder, c=US, o=PPPL, ou=Mech. Eng. Division
Date: 2006.07.28 10:10:19 -04'00'

Brad
Nelson

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US, o=ORNL, ou=FED, email=nelsonbe@ornl.gov
Date: 2006.07.28 18:22:35 -04'00'

Mike
Griffith

Digitally signed by Mike Griffith
DN: cn=Mike Griffith, c=US, o=Major Tool and Machine, ou=CFT - White, email=mgriffith@majortool.com
Reason: I agree to the terms defined by the placement of my signature on this document
Date: 2006.08.18 15:16:56 -04'00'

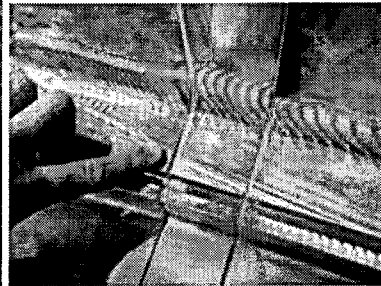
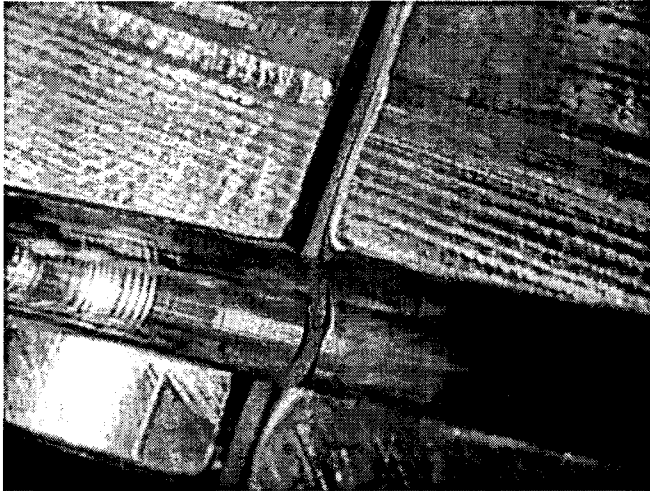
Major Tool Implemented By: _____

Title: _____

Date: _____

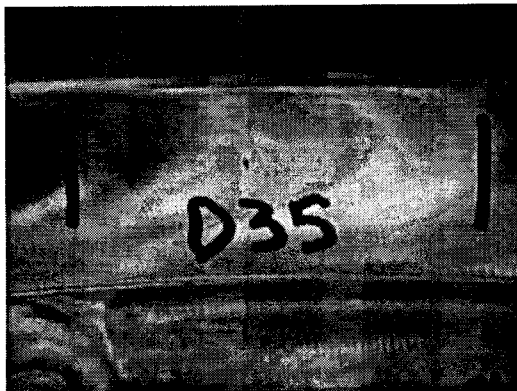
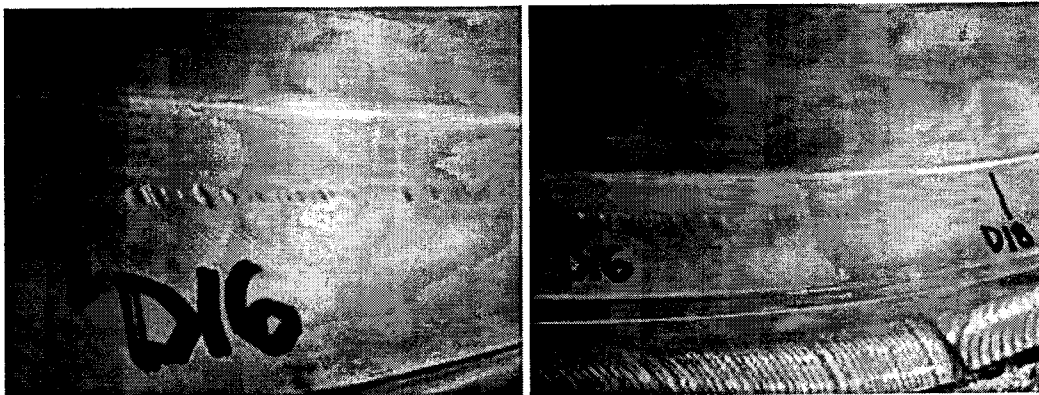
SE141-114 A3
NC20201 attachment

1. The pictures below show examples of the G11 insulating material below the surface of the finished part. The top two are on the E side of the casting below the VPI groove. The bottom two pictures were taken at the perimeter of the datum D flange. The maximum amount the G11 is below the surface is .060”.

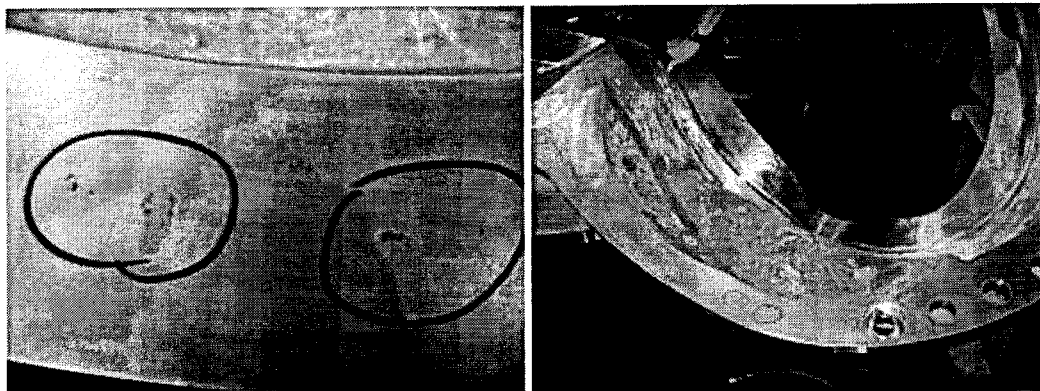


SE141-114 A3
NC20201 attachment

2. The pictures below are of tooling marks on the short leg of the T section (datum D side). The numbers represent the corresponding T hole locations. The maximum depth of these marks is approximately .005”.



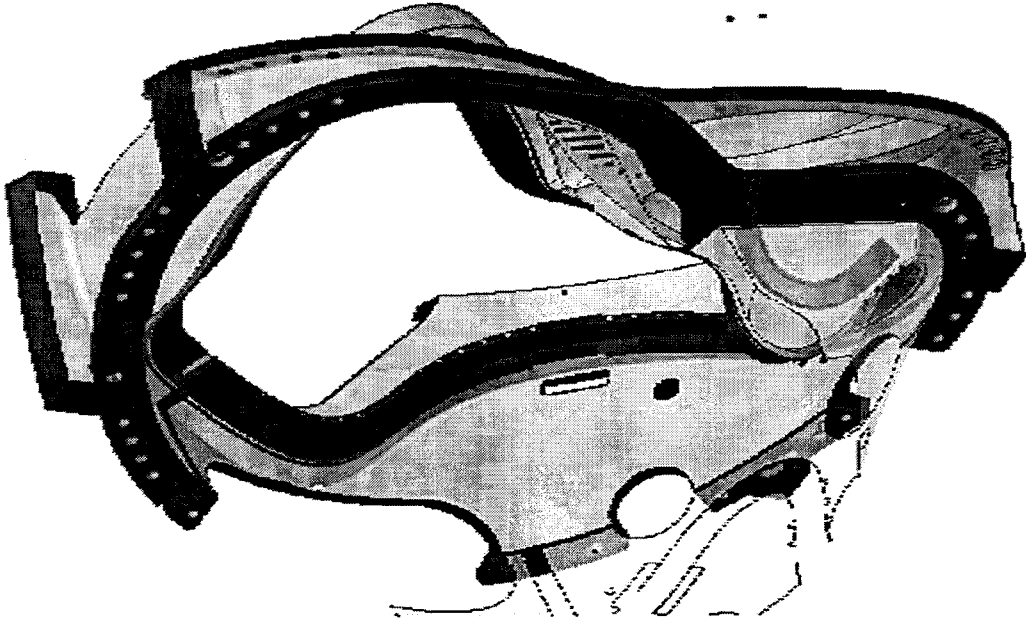
3. There were two areas of casting porosity on the D flange that were not rejectable during the PT process but are worth noting due to their visibility.



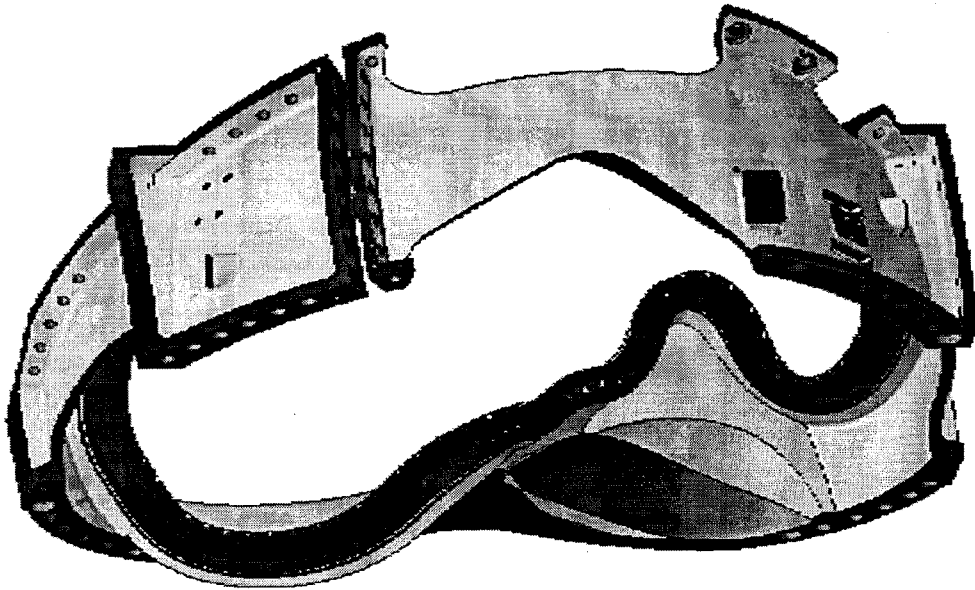
MC A3 Wing Inspection

Mtm_mc_a3_check.asm

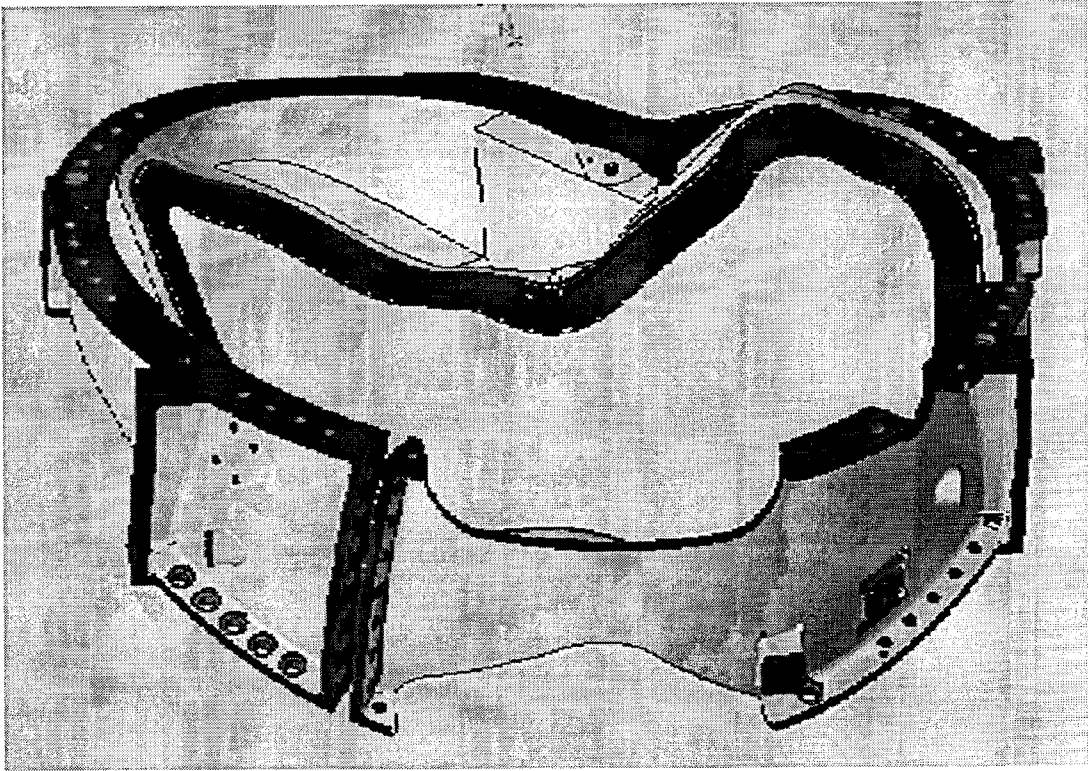
T. Brown
7/27/06



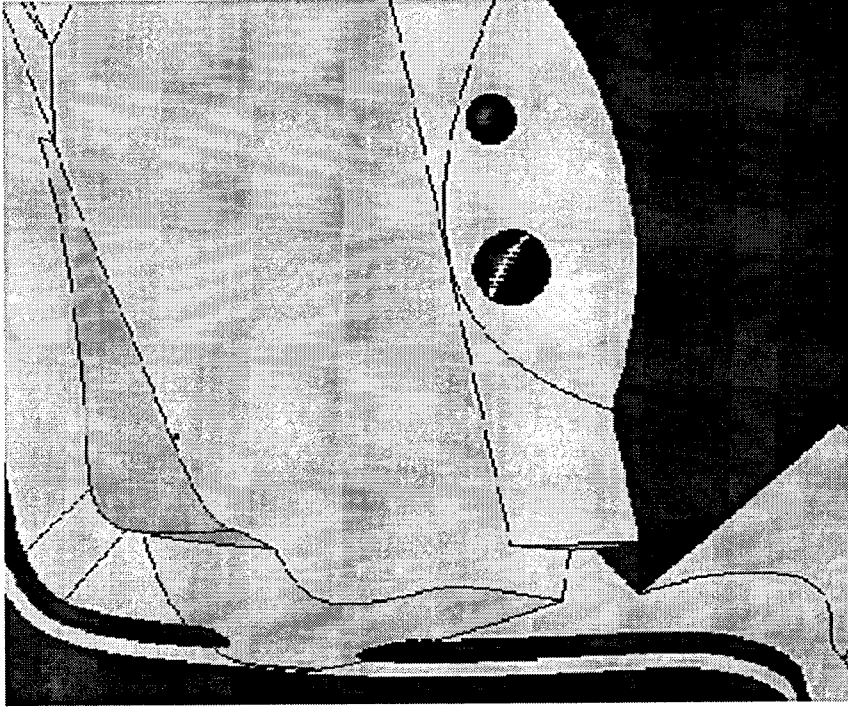
A to B Side

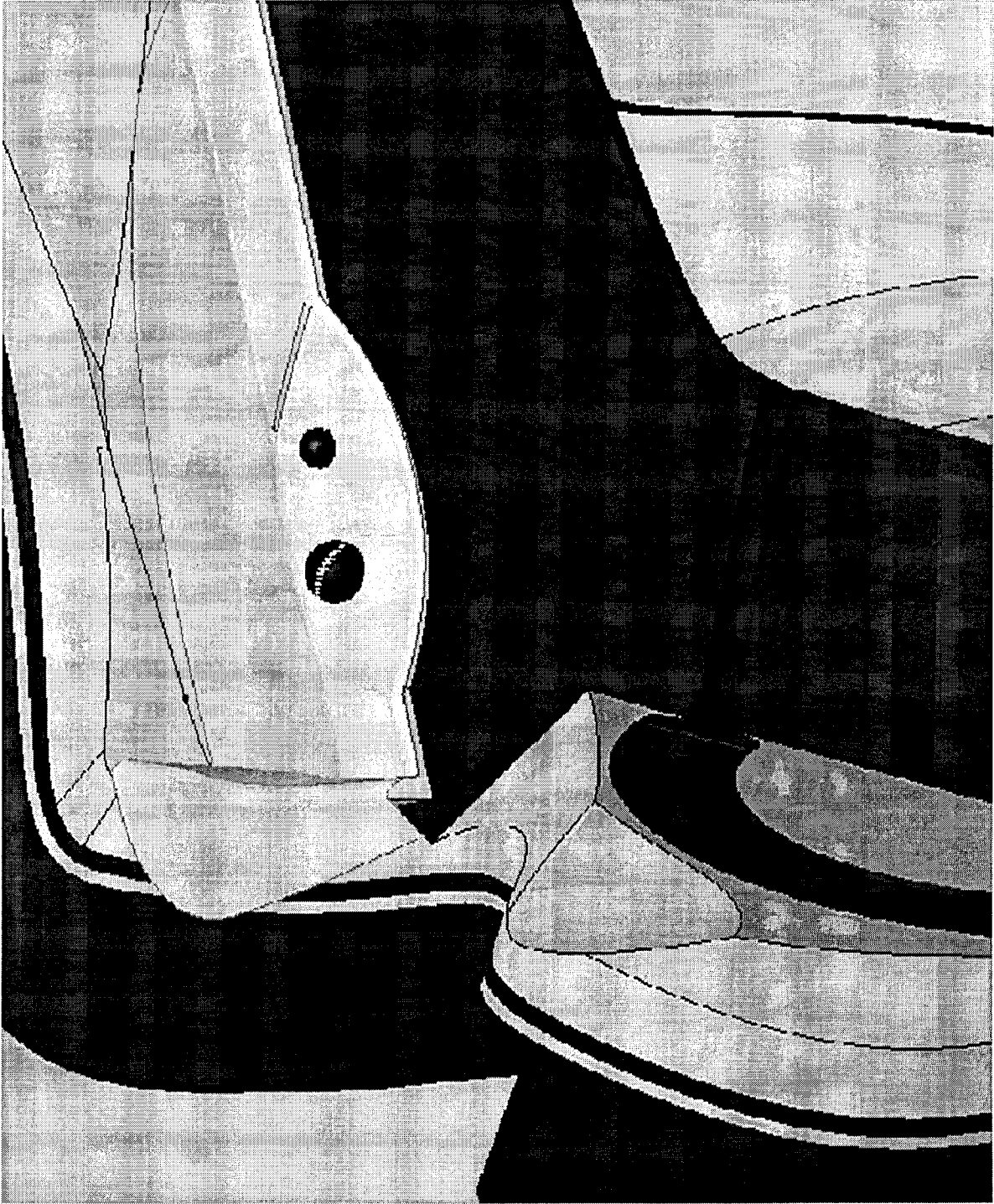


A to A Side

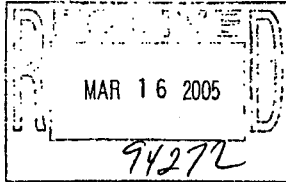


A to B Side





MAJOR TOOL & MACHINE INC 1458 E 19TH ST INDIANAPOLIS IN 46218		YOUR PURCHASE ORDER NUMBER P05-01332		MCMaster-CARR 600 COUNTY LINE ROAD ELMHURST IL 60126-2081 IF THERE ARE ANY QUESTIONS ABOUT THIS SHIPMENT CONTACT OUR SALES DEPARTMENT (630)833-0300		PAGE 1 MCM NUMBER 6241663-03				
Warehouse Location		McMaster Carr Part Number		Fill Quantity		Item Description		Your Line	Your Order	This Shipment
PACKING LIST EXTRA		74765 A86		1 EA		LOCTITE PRISM SUPER GLUE HZ-N TOUGHENED,NUMBER 411,1-POUND BOTTLE,CLEAR 1		9	1 EA	1
		74765 A86		1 EA		LOCTITE PRISM SUPER GLUE HZ-N TOUGHENED,NUMBER 411,1-POUND BOTTLE,CLEAR 1		10	1 EA	1
		74765 A86		1 EA		LOCTITE PRISM SUPER GLUE HZ-N TOUGHENED,NUMBER 411,1-POUND BOTTLE,CLEAR 1		11	1 EA	1
		74765 A86		1 EA		LOCTITE PRISM SUPER GLUE HZ-N TOUGHENED,NUMBER 411,1-POUND BOTTLE,CLEAR 1		12	1 EA	1



3/16/05
B.J.

REFER TO: 6241663-03
MAJOR TOOL & MACHINE INC

3/16/05

TAG
CCP

PACER	NUMBER OF CARTONS	FILLER

LNS: 4

CYCLE

WEIGHT 4

MCM NO. 6241663-03 04

PURCHASE ORDER
P05-01332

FROM:
MCMaster-CARR
600 COUNTY LINE ROAD
ELMHURST IL 60126-2081 USA

SHIP TO:

MAJOR TOOL & MACHINE INC
1458 E 19TH ST
INDIANAPOLIS IN 46218

CCP

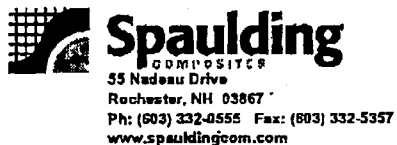
CERTIFICATION OF COMPLIANCE

This is to certify that, according to our records, the above item(s) furnished on your purchase order was supplied in accordance with the description and as illustrated in our catalog.

Sincerely,

Brian Hedstrom
Quality Manager

x



Shipping List 072435

Customer No 101193
Sales Order Shipper

Sold to : STANDARD GRINDING & MFG CO
3721 W. CHASE AVENUE
SKOKIE, IL 60076
United States

Ship to : STANDARD GRINDING & MFG CO
3721 W. CHASE AVENUE
SKOKIE, IL 60076
United States

Ship Date	Customer PO	Sales Order	# of Boxes	Weight	Ship VIA	Bill of Lading	FOB
05/17/2005	80624	065171-00	1	0	YELLOW	072435	DE
Item	Part / Description / Details				Order Quantity	Ship Qty	
000001	39G1CNT73125NMWLF U/M SHT SO Item 4				1.00000		
	G-11 CR 48" ±untrimmed X 36" ±untrimmed Thickness: 3.125" ±.110" PLEASE NOTE THAT THERE IS NO NEMA STANDARD FOR G-11 CR SHEET SPAULDING C OF C TO G-11 CR SHEET NO TESTING REQUIRED AT TIME OF ORDER <i>Sheet len 3.55076</i>					1.00000	

CERTIFICATE of CONFORMANCE

WE HEREBY CERTIFY THAT THE MATERIAL SUPPLIED ON THIS ORDER WAS MADE IN ACCORDANCE WITH THE STANDARDS AND PROCESSES ESTABLISHED BY SPAULDING COMPOSITES COMPANY FOR THE REQUIREMENTS OF MATERIAL DESCRIBED ABOVE.

LOT # _____ DOML
 Authorized By: Mark L. Caudillo Date: 05/17/2005

Customer Copy

Page # 1

Form: SCSHIP Rev: 8/99

000/2002

ATLAS FIBRE CO.

05/26/05 13:00 9447 674 1723



Spaulding
COMPOSITES

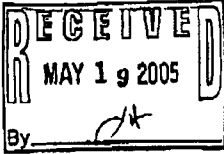

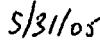

55 Nadeau Drive
Rochester, NH 03867
Ph: (603) 332-0555 Fax: (603) 332-5357
www.spauldingcom.com

Shipping List 072434

Customer No 101193
Sales Order Shipper

Sold to : STANDARD GRINDING & MFG CO
3721 W. CHASE AVENUE
SKOKIE, IL 60076
United States

Ship to : STANDARD GRINDING & MFG CO
3721 W. CHASE AVENUE
SKOKIE, IL 60076
United States

Ship Date	Customer PO	Sales Order	# of Boxes	Weight	Ship VIA	Bill of Lading	FOB
05/17/2005	60624	065169-00	1	716	YELLOW	072434	DE
Item	Part / Description / Details				Order Quantity	Ship Qty	
000001	39G1CNT71850NMWLF U/M SHY SO Item 5 G-11-CR 48" *UNTRIMMED X 36" *UNTRIMMED THK: 1.050" +/- .070" PLEASE NOTE THAT THERE IS NO NEMA STANDARD FOR G-11 CR SHEET SPAULDING C OF C TO G-11 CR SHEET NO TESTING REQUIRED AT TIME OF ORDER				1.00000	1.00000	
							
							
							
							

CERTIFICATE of CONFORMANCE

WE HEREBY CERTIFY THAT THE MATERIAL SUPPLIED ON THIS ORDER WAS MADE IN ACCORDANCE WITH THE STANDARDS AND PROCESSES ESTABLISHED BY SPAULDING COMPOSITES COMPANY FOR THE REQUIREMENTS OF MATERIAL DESCRIBED ABOVE.

LOT #

DOM.

Authorized By:

Mark Li

Date 05/17/2005

Customer Copy

Page # 1

Form: SCSHIP Rev: 8/99

000/C002

ATLAS FIBRE CO.

847 674 1723

05/26/05 13:00

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-101 - Item: 8

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

Part: SE141-101 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

SHEET ZONE	CHARACTERISTIC	INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
		GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
* (10)	T E S T 1 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 OHMS	503-B.H		A
* (20)	T E S T 2 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 OHMS	503-B.H	07-27-06	A

METRODE PRODUCTS LIMITED
HANWORTH LANE, CHERTSEY

SURREY, UK, KT16 9LL

Tel: +44 (0) 1832 586721

Fax: +44 (0) 1832 585188

Email: info@metrode.com

Website: www.metrode.com

CERTIFIED MATERIAL TEST REPORT

THIS PRODUCT HAS BEEN MANUFACTURED
AND SUPPLIED THROUGH A SYSTEM
APPROVED TO ISO 9001 & 2 OR EQUIVALENT



TEST CERTIFICATE NUMBER

183695

INVOICE TO
EUROWELD LTD
255 ROLLING HILLS ROAD
MOORESVILLE
NC 28117
USA

DESPATCHED TO
EUROWELD LTD
255 ROLLING HILLS ROAD
MOORESVILLE
NC 28117
USA

CUSTOMER ORDER NUMBER	N.05-34
DELIVERY NOTE DOCUMENT NUMBER	DN0105859
QUANTITY (KG)	15.0000
OUR ORDER REFERENCE	SO1787730 / 1
DATE	02/03/05

METRODE WELDING CONSUMABLE	ER316MNNF TIG 2.4mm
FORM	TIG WIRE
BATCH NUMBER	WO20132
SPECIFICATION	BS EN 12072:2000 W 20 16 3 Mn L

Chemical Analysis (Weight %)										Type: BS EN 10204: 3.1.B / ASME SFA-5.01: Sch. H	
C	Mn	Si	S	P	Cr	Ni	Mo	N	Cu		
0.015	7.43	0.42	0.008	0.014	19.9	15.4	2.62	0.14	0.20		

Mechanical Tests

Type: BS EN 10204: 2.2 / ASME SFA-5.01: Sch. G

Tensile Tests						Impact Energies		
Condition	Test Temperature	R _{p0.2} (MPa)	R _m (MPa)	A4 (%)	Z (%)	Temperature (°C)	Impact Energy (J)	Lateral Expansion (mm)
AS-WELDED	ROOM	>400	>600	40	-	-196	70	-

Metrode Products Limited certifies that the above material conforms to the indicated specifications.

This document is produced electronically and is valid without signature.

IMPORTANT: Any liability arising from other reference on this certificate, or use of our products, is strictly limited and governed by our conditions of business.

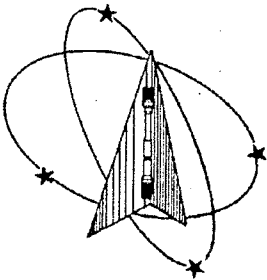
Barrie Kyles - Q.A. Manager

ASME SFA-5.01; Lot classification: S4

3/3/05
93911
Linc 1 B.1

Notes:
1. All includes incidental Co unless otherwise specified.
2. All (Co) includes incidental Fe unless otherwise specified.
3. Parts is given as FN (Part Number) and measured on all-weld gas using instrument calibrated against NBS-related secondary standards (See AWS A4 2-07) unless otherwise specified.

MTH 09
3/3/05



Westmoreland Mechanical Testing & Research, Inc.
 P.O. Box 388
 Westmoreland Drive
 Youngstown, Pa. 15696-0388 U.S.A.
 Telephone: 724-537-3131 Fax: 724-537-3151
 Website: www.wmtr.com
WMTR is a technical leader in the material testing industry.



621-01 & 621-02

April 22, 2005

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

CERTIFICATION

Page IM1 of 1

WMT&R Report No. 5-25008
 P.O. No. P05-01764
 PQR No. 434
 Welder Jason Bever #465

Corrected Date
 May 4, 2005

Attention: Josh Mayne

Subject: All processes performed upon the material as received, were conducted at WMT&R, Inc. in accordance with the WMT&R Quality Assurance Manual, Rev. 9, dated 4/1/2000.
 The following tests were performed on this order: IMPACT and TENSILE

IMPACT RESULTS: ASME Section IX and AWS B2.1, ASTM E23-02

No Requirements

MATERIAL: Metatek CF8MNMN MOD

SAMPLE TYPE: Charpy V-Notch

DISPOSITION: Report

Specimen ID	TestLog Number	Sample Size	Temp. °F/C	Energy ft-lbs	Energy joules	Mils Lat Exp	AUIR
Weld-1	B65835	Standard	68±20	173	234.6	84	Report
Weld-2	B65836	Standard	68±20	160	216.9	68	Report
Weld-3	B65837	Standard	68±20	157	212.9	81	Report

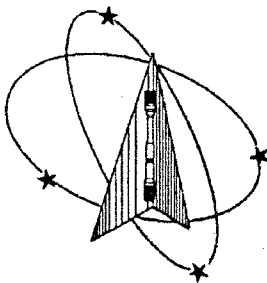
AUIR: A=ACCEPTABLE, U=UNACCEPTABLE, R=REPORT

KNOWINGLY OR WILLFULLY FALSIFYING OR CONCEALING A MATERIAL FACT ON THIS FORM OR MAKING FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS OR REPRESENTATIONS HEREIN COULD CONSTITUTE A FELONY PUNISHABLE UNDER FEDERAL STATUTES. THIS CERTIFICATE OR REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF WMT&R, INC.

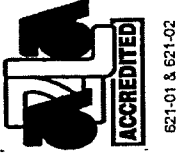
Richard G. Parks
 Richard G. Parks
 Project Manager/Industrial Technology Engineer

5/4/05
 May 4, 2005

Testing Specialists for Aerospace, Automotive, and Material Testing Fields
 Locations in Youngstown, PA U.S.A. ~ Tel. (724) 537-3131 and
 Banbury U.K. ~ Tel. +44 (0) 1295 261211



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 Youngstown, Pa. 15696-0388 U.S.A.
 Telephone: 724-537-3131 Fax: 724-537-3151
 Website: www.wmtr.com
 WMT&R is a technical leader in the material testing industry.



April 20, 2005

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

CERTIFICATION

Section 1 of 2
 WMT&R Report No. 5-25008
 P.O. No. P05-01764
 PQR No. 434
 Welder Jason Bever #465

Attention: Josh Mayne

Subject: All processes, performed upon the material as received, were conducted at WMT&R, Inc. in accordance with the WMT&R Quality Assurance Manual, Rev. 9, dated 4/1/2000.
 The following tests were performed on this order: IMPACT and TENSILE

TENSILE RESULTS: ASME Section IX and AWS B2.1, ASTM E21-03a

SOAK TIME: 5 Minutes

SPEED OF TESTING: 0.0050 in./in./min., 0.0500 in./min./in.

MATERIAL: Metrode ER316Mnrf

DISPOSITION: Report

Specimen ID	TestLog Number	Temp. °F/°C	UTS KSI/MPA	0.2% YS KSI/MPA	Elong %	RA %	Modulus MSI/GPA	Ult. Load LBS/NEWTONS	0.2% YLD. LBS/NEWTONS
T1	B65833	-320/-196	191.8/1320	148.7/1030	27	39	28.7/198	2630/11699	2039/9071

AU/R: A=ACCEPTABLE, U=UNACCEPTABLE, R=REPORT

DISPOSITION: Report

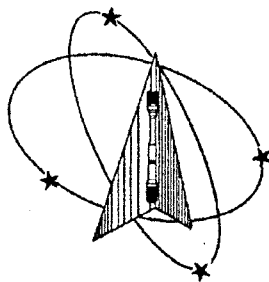
Specimen ID	TestLog Number	Orig. Width (in./mm)	Final Width (in./mm)	Orig. Thick (in./mm)	Final Thick (in./mm)	Orig. Dia. (in./mm)	4D Orig GL (in./mm)	4D Final GL (in./mm)	Orig. Area (Sq. In./Sq. mm)	Failure Location/Type	Machine Number	A/U/R
T1	B65833	0.1802/4.57708	0.1437/3.650	0.0761/1.933	0.0582/1.478	0.2511/6.378	0.70/17.78	0.89/22.61	0.04183816/26.992307	WELD/DUCTILE	M9	R

AU/R: A=ACCEPTABLE, U=UNACCEPTABLE, R=REPORT

Roy E. Starr/Matt Wojton
 Technical Services Manager/ Tensile Supervisor
 April 20, 2005

Testing Specialists for Aerospace, Automotive, and Material Testing Fields
 Locations in Youngstown, PA U.S.A. ~ Tel. (724) 537-3131 and
 Banbury U.K. ~ Tel. +44 (0) 1295 261211

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Westmoreland Mechanical Testing & Research, Inc.
 P.O. Box 388
 Westmoreland Drive
 Youngstown, Pa. 15696-0388 U.S.A.
 Telephone: 724-537-3131 Fax: 724-537-3151
 Website: www.wmtr.com

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April 20, 2005

Major Tool & Machine Inc.

CERTIFICATION

TENSILE RESULTS: ASME Section IX and AWS B2.1, ASTM E21-03a

SOAK TIME: 5 Minutes

SPEED OF TESTING: 0.0050 in./in./min., 0.0500 in./min./in.

MATERIAL: Metrode ER316Mnrf

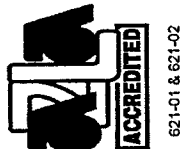
Specimen ID	TestLog Number	Temp. °F/C	UTS KSI/MPA	UTS KSI/MPA	0.2% YS KSI/MPA	Elong %	RA %	Modulus MSI/GPA	DISPOSITION: Report	
									Ult. Load LBS/NEWTONS	0.2% YLD. LBS/NEWTONS
T2	B65834	-320/-196	204.7/1410	156.5/1080	29	34	29.9/206	5095/22664	3894/17323	

AUJR: A=ACCEPTABLE, U=UNACCEPTABLE, R=REPORT

DISPOSITION: Report

Specimen ID	TestLog Number	Orig. Dia. (in./mm)	Final Dia. (in./mm)	4D Orig GL (in./mm)	4D Final GL (in./mm)	Orig. Area (Sq. In./Sq. mm)	DISPOSITION: Report	
							Failure Location/Type	Machine Number
T2	B65834	0.1780/4.521	0.1444/3.668	0.70/17.78	0.90/22.86	0.02488456/16.054520	WELD/DUCTILE M9	R

AUJR: A=ACCEPTABLE, U=UNACCEPTABLE, R=REPORT



621-01 & 621-02

Section 2 of 2

WMT&R Report No. 5-25008

P.O. No. P05-01764

Matthew J. Wojton
 Roy E. Slarr/Matt Wojton
 Technical Services Manager
 4-20-05
 April 20, 2005

Testing Specialists for Aerospace, Automotive, and Material Testing Fields
 Locations in Youngstown, PA U.S.A. ~ Tel. (724) 537-3131 and
 Banbury U.K. ~ Tel. +44 (0) 1295 261211

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WESTMORELAND MECHANICAL TESTING & RESEARCH, Inc

Phone: (724)537-3131

P.O. No.: P05-01764

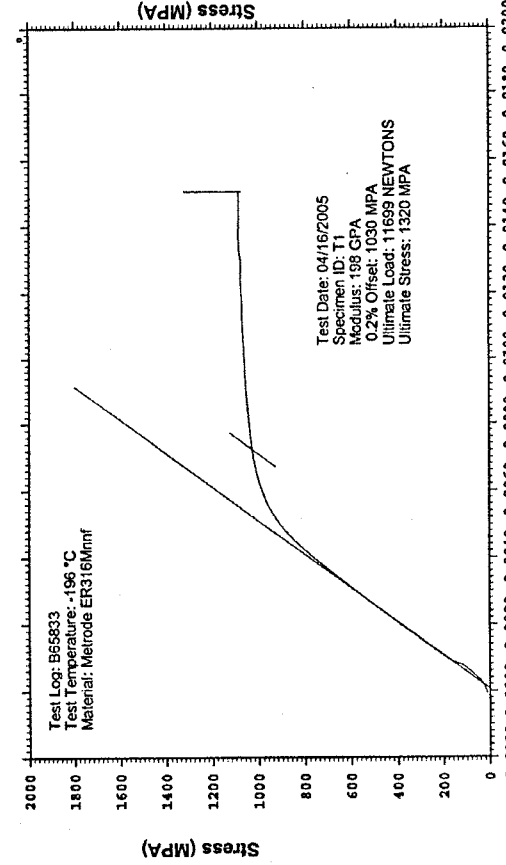
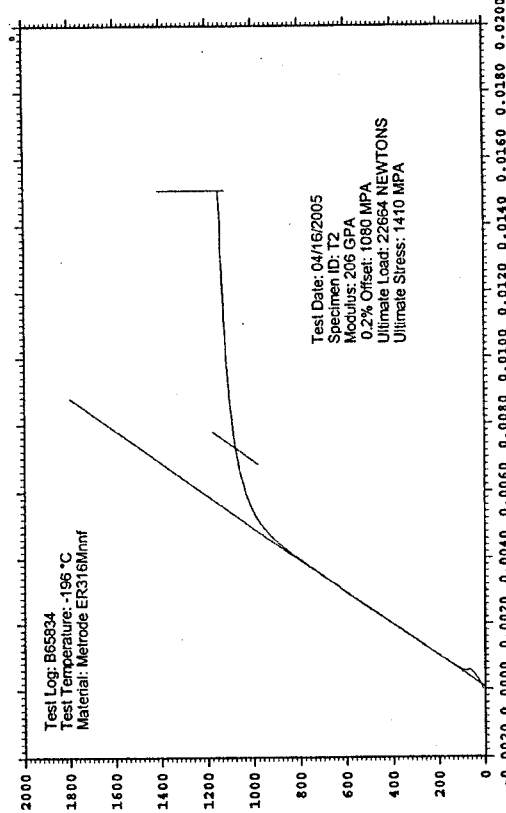
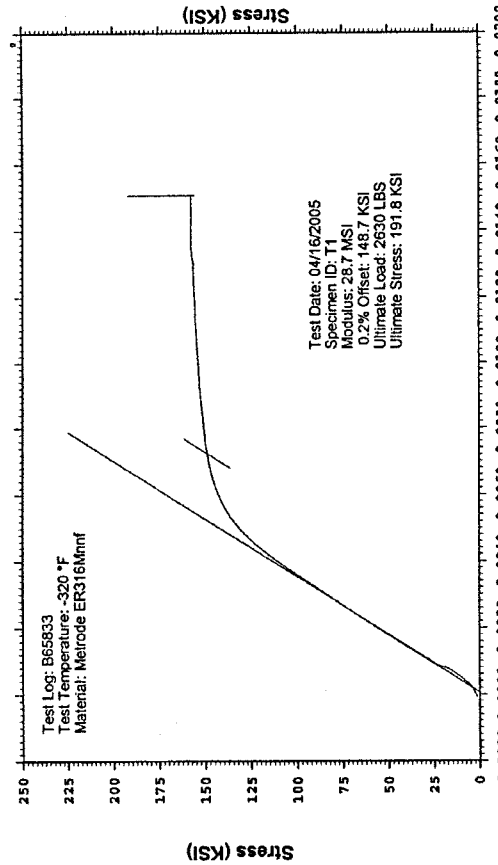
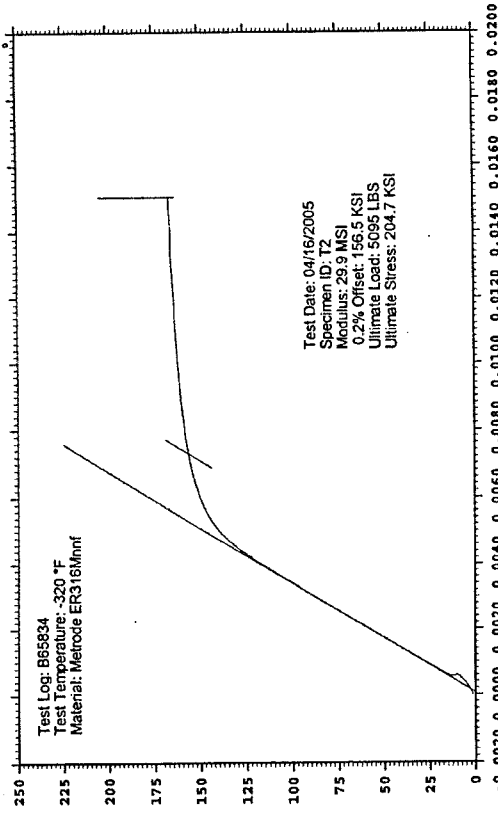
PQR No.: 434

Welder: Jason Bever #465

Stress vs. Strain

Customer: Major Tool & Machine Inc.

WMT&R Report: 5-25008



KNOWINGLY OR WILLFULLY FALSIFYING OR CONCEALING A MATERIAL FACT ON THIS FORM OR MAKING FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS OR REPRESENTATIONS HEREIN COULD CONSTITUTE A FELONY PUNISHABLE UNDER FEDERAL STATUTES.



TEST CERTIFICATE
THIS PRODUCT HAS BEEN MANUFACTURED
AND SUPPLIED THROUGH A SYSTEM APPROVED
TO ISO 9001 & 2 OR EQUIVALENT

METRODE PRODUCTS LTD
HAINWORTH LANE
CHERTSEY SURREY
ENGLAND KT16 9LL
Tel +44 (0)1932 566721
Fax +44 (0)1932 565168
Email info@metrode.com
Internet http://www.metrode.com



TEST CERTIFICATE NUMBER 194277

DESPATCHED TO:
EUROWELD LTD
255 ROLLING HILLS ROAD
MOORESVILLE
NC 28117
USA

INVOICE TO:
EUROWELD LTD
255 ROLLING HILLS ROAD
MOORESVILLE
NC 28117
USA

IMPORTANT: Any liability arising from either reliance on this certificate, or use of our products, is strictly limited and governed by our conditions of business.

CUSTOMER ORDER No.
N. 05-39

DELIVERY NOTE DOCUMENT No.
DNO106163

PATCH No.	WP20102
OUR ORDER REF.	S01788013 / 1
DATE	09/03/05
PRODUCT	ER91GMNF-TIG
FORM	2-4MM
SPECIFICATION	TIG-MIRE
BS EN 12072:2000 W 20 16 3 Mn L	

QUANTITY (Kg)	17.5000
---------------	---------

CHEMICAL ANALYSIS (WEIGHT %)		CERTIFIED MATERIAL TEST REPORT: BS EN 10204: 3.1, B	
C	TYPE	Mo	N
0.015	Si	15.4	0.14
7.43	P	19.9	0.20
0.006	S		
	Cr		
	Fe		
	Cu		

TYPICAL ALL-WELD METAL MECH. PROPERTIES, AS WELDED:-
TS: >600 N/mm²; 0.2%PS: >400 N/mm²; EL. ON 4T: 40 %;
CVN @ -196 DEG.C: 70 J.

3/23/05
3/23/05
44534
CIVEI
B.2

3/23/05
MTM
09

Metrode Products Ltd. certifies that the above material conforms to the indicated specifications

B. KYIET
Q.A. MANAGER

All Test certificates issued by METRODE will contain this embossed seal
Any recipient of a copy of METRODE Test Certificate without the seal should
measure from the supplier that it is a true and accurate reproduction
of the original



GE Advanced Materials, Polymershapes

Certificate of Conformance

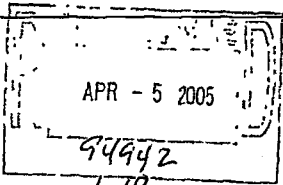
Date:

Attn: Receiving Inspection
 To: Major Tool + Machine
 Address: 1458 E. 19th St.
Indianapolis, IN 46218

Customer P.O. Number: PO5-01288
 Sales Order No: 2790834

It is hereby certified that the product information provided below conforms to the corresponding information in the possession of GE Advanced Materials, Polymershapes with respect to such products. This certification and the sale of products are subject to GE Advanced Materials, Polymershapes' standard conditions of sale. This document shall not be reproduced, except in full, without prior written approval.

Quantity	Description	Lot/Specification/Standard Number
<u>36</u>	<u>Glick Plexidac sheet .062" THX 16" x 38"</u>	<u>NO SPEC / N38.009023</u>



GE Advanced Materials, Polymershapes

By: Ernest Evans
 Title: Warehouse Worker

MTM 09
 4/5/05

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Nondestructive Test

Certification for Liquid Penetrant Examination

Quality Assurance Documentation for Part ID: SE141-114 - Item: 13

1458 E. 19th Street, Indianapolis, In 46218
 TEL:(317)636-6433 FAX:(317)634-9420

Date of Inspection: 07/20/2006 **Type of Material:** CAST STAINLESS **NDT#:** 17396

Stage of Inspection: <input type="checkbox"/> Incoming Inspection <input type="checkbox"/> In-Process Inspection <input type="checkbox"/> After Repair <input checked="" type="checkbox"/> Final Inspection	Manufacturing Process: <input type="checkbox"/> Weldment <input checked="" type="checkbox"/> Casting <input type="checkbox"/> Bar Stock <input type="checkbox"/> Plate <input type="checkbox"/> Forging <input type="checkbox"/> Other	Surface Condition: <input checked="" type="checkbox"/> Machined <input type="checkbox"/> Rough <input type="checkbox"/> Other FINAL MACHINED	Test Being Run to: <input checked="" type="checkbox"/> Router Instructions <input checked="" type="checkbox"/> Drawing <input type="checkbox"/> Test Plan <input type="checkbox"/> Technique Card SEE NOTES	Heat Treated: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No
--	--	---	---	--

Part Information: MTM Job Number: 65709/3.0 -Sub:1 -Op:100 Resource ID: 810-LIQUID PENETRANT INSPE Part ID: SE141-114 Part Name: MODULAR COIL WINDING FOR Serial Number: Customer P.O.: S005242-F Customer Unit/Plant:	Test Results: Quantity Inspected: 1 Quantity Accepted: 0 Quantity Rejected: 1 Run Hours: 0.0	Inspection Results: Customer N/C #: <input type="checkbox"/> Accepted <input checked="" type="checkbox"/> Rejected <input type="checkbox"/> N/C-Report <input type="checkbox"/> Rework MTM N/C #: 20166
--	---	--

Customer Inspection Plan: SEE NOTES Test Step: Revision: Material Test Number:	Inspection Criteria: Customer Specification: ASTM A903/A903M MTM Spec Number: PS582 (REF NDT-WI-09) Acceptance Standard: ASTM A903 (SEE NOTES)
---	---

Inspection Materials Used: Manufacturer: SHERWIN Type of Penetrant: DP-51 Batch Number: 69-E47 Developer: D-100 Batch Number: 65-C6	Penetrant Examination Processes: Type: II (Visible) / Dwell Time: 20 Minutes Method: A (Water Wash) Method of Drying: Forced Air Fan Form: e (nonaqueous for Type II visible dye) / Dwell Time: 20 Min
--	---

Inspection Requirements:

100 % of all accessible surfaces Joint Preps Root Pass Back Gouge Cover Pass Other

Notes:
 INSPECT 100% OF SURFACES ON PRODUCTION MODULAR COIL WINDING FORM TYPE-A.
 SPECIFICATION: ASTM A903/A903M
 METHOD: ASTM E165

ACCEPTANCE CRITERIA: ASTM A903/A903M LEVEL I FOR MACHINED SURFACES INCLUDING THE ENTIRE "T" SECTION (HIGH STRESS AREAS)

PART HAS 17 REJECTABLE INDICATIONS PER CUSTOMER REQUIREMENTS ON MACHINED SURFACES. SEE NCR-20044 AND PHOTOS FOR MORE DETAILED INFO.

This is to certify that the pieces specified have been inspected in accordance with the specifications shown.

Inspector: 674-S.WILLIAMS

Date: 07/20/2006

Sylvester Williams Level II MIN P.1



Major
Tool & Machine, Inc.

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-114 - Item: 14

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

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

SHEET	ZONE	CHARACTERISTIC	INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY				
			GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT		
2*	D3	Ø.001 - Ø.002	MFG				LESS THAN .002	825-B.J			A	
(10)		CHECK CLEARANCE OF ITEM 5 TO ITEM 6.						07-21-06				
*		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"	MFG				LESS THAN .002	825-B.J				A
(15)								07-21-06				
*		ENSURE THAT THE CUMULATIVE GAP AT ANY SINGLE CROSS SECTION OF THE POLOIDAL FLANGE ELEMENTS IS LESS THAN .005".	MFG				LESS THAN .002	825-B.J				A
(20)								07-21-06				
*		THE MAX. GAP AT THE POLOIDAL BREAK PERIMETER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE	MFG				LESS THAN .002	825-B.J				A
(30)								07-21-06				
1*	F2	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLI	MFG			1500	825-B.J				A
(40)								07-21-06				



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-114 - Item: 15

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

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

SHEET	ZONE	CHARACTERISTIC	INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
			GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1*	F3			QA		VISUAL	ACCEPT	339-E.R			A
(10)		NOTE 14 - BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.									
1*	E8		CMM	QA		00064	.0045	339-E.R			A
(20)		FLANGE PROFILE +/- .25 IN THIS AREA									
1*	D8	// .02 A	CMM	QA		00064	.004	339-E.R			A
(30)											
1*	D8	54.20 ± .03	CMM	QA		00064	54.200	339-E.R			A
(40)											
1*	C8	54.20 ± .03	CMM	QA		00064	54.199	339-E.R			A
(50)											
1*	B8	// .02 A	CMM	QA		00064	.002	339-E.R			A
(60)											
1*	D5	// .02 A	CMM	QA		00064	.004	339-E.R			A
(70)											
1*	D5	48.50 ± .03	CMM	QA		00064	48.480	339-E.R			A
(80)											
1*	C5	48.50 ± .03	CMM	QA		00064	48.508	339-E.R			A
(90)											
1*	B5	// .02 A	CMM	QA		00064	.009	339-E.R			A
(100)											
1*	D4	VERIFY PART MARKING: MAJOR TOOL SE141-114 A (casting number) (weight) LBS.	CMM	QA		00064	ACCEPT	339-E.R			A
(110)											
1*	D4	RECORD WEIGHT	CMM	QA		00064	5440	339-E.R			A
(120)											
1*	D3	OUTER AS CAST SURFACES	CMM	QA		00064	-056 TO .457 [N/C: 20201-Doc:NC20201]	339-E.R			R
(130)											
2*	F8		CMM	QA		00064	0.39 TO 0.41	339-E.R			A



Major
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INSPECTION DATA CHECKLIST

Item #	Description	Tool / Gage	Inspection Method	Inspection Point	Inspection Date	Inspection Result	Inspection Operator
(140)	2 X .40				07-27-06		
2* (150)	F8 4 X .03 X 45	CALIPER		QA	J-707	.010 TO .040 [N/C:2 0201-Doc:NC20201]	R
2* (160)	G6 2 X R.187 + .025 / -.005	PIN GAGE		QA	J-651-2	.184 TO .207	A
2* (170)	G5 $\square \begin{matrix} .2 \\ R \\ T \\ S \end{matrix}$ P TO M	CMM		QA	00064	.0149 TO .076	A
2* (190)	F5 $\square \begin{matrix} .02 \\ R \\ T \\ S \end{matrix}$ M TO M1	CMM		QA	00064	-.020 TO .017 [N/C: 20201-Doc:NC20201]	R
2* (200)	E5 $\square \begin{matrix} .1 \\ R \\ T \\ S \end{matrix}$ M1 TO N1	CMM		QA	00064	-.011 TO .022	A
2* (210)	G3 $\square \begin{matrix} .2 \\ R \\ T \\ S \end{matrix}$ Q TO N	CMM		QA	00064	-.007 TO .094	A
2* (220)	F3 DATUM E SIDE VERIFY SHELL INTERSECT CLEARANC USING GAGE MTMFX-3473			QA	MTMFX-3473	ACCEPT	A
2* (230)	F3 $\square \begin{matrix} .02 \\ R \\ T \\ S \end{matrix}$ N TO N1	CMM		QA	00064	-.024 TO .015 [N/C: 20201-Doc:NC20201]	R
2* (240)	B4 2 X .06/.09 X 45	CALIPER		QA	J-707	.030 TO .068 [N/C:20 201-Doc:NC20201]	R
2* (250)	B5 \varnothing .375-16 UNC ∇ .750 +.1 -0 96 X	THREAD PLUG GA		QA	A-444	ACCEPT [N/C:20201-D oc:NC20201]	A
2* (260)	B5 $\perp \varnothing$.625 ∇ .188	DEPTH MICROMET		QA	J-1024	.620 TO .621 DIA. DEPTH .183 TO .191 [N/C:20201-Doc:NC20 201]	A
2* (270)	B5 $\varnothing \begin{matrix} .06 \\ R \\ T \\ S \end{matrix}$.375-16 HOLES	PIN GAGE		QA	J-652-3	.0052 TO .072 [N/C: 20201-Doc:NC20201]	R
3* (280)	H3 $\square \begin{matrix} .01 \\ R \\ T \\ S \end{matrix}$ DATUM E FLANGE	CMM		QA	00064	.011 [N/C:20201-Doc :NC20201]	R
3* (285)	H4 $\sqrt{125}$ DATUM E FLANGE	PROFILOMETER		QA	J-1109	20 TO 100	A
3* (290)	F2 $\square \begin{matrix} .01 \\ R \\ T \\ S \end{matrix}$ DATUM D FLANGE	CMM		QA	00064	.007	A
3* (295)	F3 $\sqrt{125}$ DATUM D FLANGE	PROFILOMETER		QA	J-1109	40 TO 125 [N/C:2020 1-Doc:NC20201]	A



Major
Tool & Machine, Inc.

INSPECTION DATA CHECKLIST

Page: 5
Date: 08/18/06
User ID: GRIFFIT#

3* (300)	E4	Ø2.50 THRU	CALIPER	QA	J-707	2.497	533-B.C 07-26-06	A
3* (310)	F4	Φ .060 A B C Ø2.50	CMM	QA	00064	SEE IGES	339-E.R 07-27-06	A
3* (320)	C7	8X Ø1-8UNC √ 2	THREAD PLUG GA	QA	A-71	ACCEPT	533-B.C 07-26-06	A
3* (330)	C7	Φ .010 A B C 8X Ø1-8 UNC	CMM	QA	00064	.001 TO .025 [N/C:2 0201-Doc:NC20201]	339-E.R 07-27-06	R
3* (340)	D5	8X Ø1-8UNC THRU	THREAD PLUG GA	QA	A-71	ACCEPT	533-B.C 07-26-06	A
3* (350)	D5	Ø .010 A B C 8X Ø1-8 UNC	CMM	QA	00064	.007 TO .048 [N/C:2 0201-Doc:NC20201]	339-E.R 07-27-06	R
3* (360)	D3	Ø2.50 THRU	CALIPER	QA	J-707	2.499	533-B.C 07-26-06	A
3* (370)	D3	Φ .060 A B C Ø2.5	CMM	QA	00064	SEE IGES	339-E.R 07-27-06	A
3* (380)	D1	40.90	CMM	QA	00064	SEE IGES	339-E.R 07-27-06	A
4* (390)	H6	└┘Ø2.000-2.001 √0.990-1.000	DIAL BORE GAGE DEPTH MICROMET	QA	J-1400 J-1024	2.000 DEPTH .998	339-E.R 07-27-06	A
4* (400)	F4	Ø1.375-6UNC THRU	THREAD PLUG GA	QA	A-375	ACCEPT	533-B.C 07-26-06	A
4* (410)	F4	Φ Ø .06 M A D Ø1.375-6	CMM	QA	00064	SEE IGES	339-E.R 07-27-06	A
4* (420)	D4 &	Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA	J-1400	1.883 TO 1.886	533-B.C 07-26-06	A
4* (430)	D4 &	Φ Ø .06 M A D Ø1.885	CMM	QA	00064	.0036 TO .044	339-E.R 07-27-06	A
4* (440)	B6	3X Ø1.5	CALIPER	QA	J-1103	1.503 TO 1.505	533-B.C 07-26-06	A
4* (450)	B6	Φ .06 M A D 3X Ø1.5	CMM	QA	00064	.004 TO .018	339-E.R 07-27-06	A
4* (460)	A4	6X .25-20 UNC √ .5 .5 X 82° CHAMFER	THREAD PLUG GA	QA	A-726	ACCEPT	533-B.C	A
5*	D8/D6	Ø1.885 ± .003	CMM	QA	00064	1.8855 , 1.8858, 1 H OLE 2.0515" [N/C:20]	07-26-06 242-M.G	R



Major
Tool & Machine, Inc.

INSPECTION DATA CHECKLIST

Page: 7
Date: 08/18/06
User ID: GRIFFIT#

(670)	2.00																		07-27-06		
7*	F2		CMM	QA			00064	SEE IGES											339-E.R	A	
(680)	6.75																		07-27-06		
7*	F2		CMM	QA			00064	SEE IGES											339-E.R	A	
(690)	3.75																		07-27-06		
7*	F1	4X Ø.75-10 UNC ▽ 1.50	THREAD PLUG GA	QA			A-681	THREAD AND DEPTH CEPT											495-D.C	A	
(700)																			07-26-06		
7*	D1	2X 1.56 OPEN THRU	CALIPER	QA			J-707	1.56 / 1.56											339-E.R	A	
(710)																			07-27-06		
7*	C1	.375-16 UNC-2B TAP ▽ .75 .03 X 45° CHAMFER 6X	THREAD PLUG GA	QA			A-444	ACCEPT											339-E.R	A	
(720)																			07-27-06		
7*	C4	VERIFY THAT HOLE LOCATIONS ARE SCRIBED ON THE PART.		QA			VISUAL	ACCEPT											533-B.C	A	
(730)																			07-26-06		
7*	B3	8.50 DISTANCE BETWEEN SCRIBE MARKINGS.	CALIPER	QA			J-1389	8.51											495-D.C	A	
(740)																			07-26-06		
9*	H1	2X Ø.50	PIN GAGE	QA			J-651-2	.500											533-B.C	A	
(750)																			07-26-06		
9*	B7	TC2 HOLE TO BE .625" IN DIAMETER APPRO 2.52" DEEP AND .25" IN DIAMETER AT LEAST 1" DEEP.	DEPTH MICROMET	QA			J-1024	.628 DIA. DEPTH 2. 639 AND 3.640											533-B.C	A	
(760)																			07-26-06		
*																			533-B.C	A	
(770)																			07-26-06		
10*	F5	TC1 LOCATION AND CONFIGURATION MODIFIED. HOLE TO HAVE .625 CLEARANCE AND AT LEAST 1" OF DEPTH AT THE .25" DI CALIPER	DEPTH MICROMET	QA			J-1024	.625 DIA. DEPTH 1.060											07-26-06		
(780)																			339-E.R	R	
10*	D5	INNER AS CAST SURFACES	CMM	QA			00064	-.444 TO .053 [N/C; 20201-Doc:NC20201]											07-27-06		
(790)																			339-E.R	A	
																			07-27-06		
SHEET ZONE		CHARACTERISTIC		INSPECTION INSTRUCTIONS		GAGE/EQUIP		BY		SAMPLE		SER#		DATA/REMARKS		INSP		VERFD		AUDIT	
		Drawing ID: NCSX-CSPEC-141-03 Rev: 11																			



Major
Tool & Machine, Inc.

INSPECTION DATA CHECKLIST

4*	3.1.1.1. ✓/125	PROFILOMETER	QA	J-1109	8 TO 30	533-B.C	A
(800)	THE TWO "L" MACHINED SURFACES OF TEE MUST HAVE A RMS OF 125.					07-26-06	

RT Map of High Stress Region

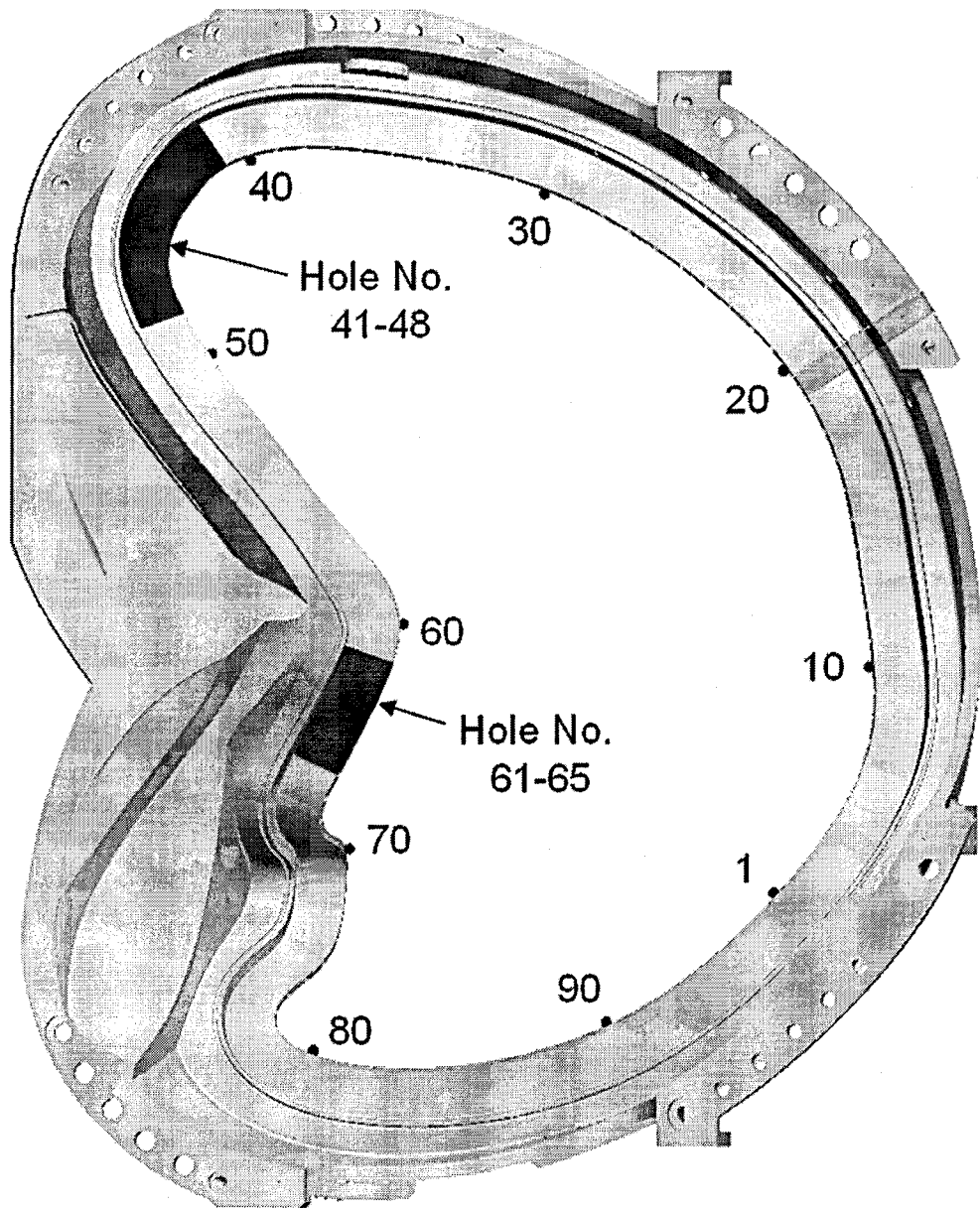


Figure 1 High Stress Region Identification for Type-A MCWF

TEAM[®] Industrial Services, Inc.

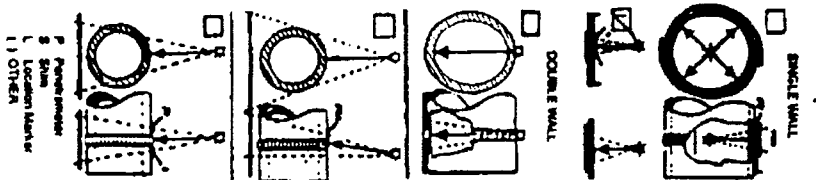
TCM Division

10540 Chester Road
Cincinnati, Ohio 45215
(513) 771-3292 Phone

RADIOGRAPHY READER SHEET
Form # 20.3A Rev. 3

4347

Client Major Tool & Machine		Interpreter/Level Robert Weaver/II		Radiographer Robert Weaver		Job No. 13810001	P.O. No. N/A	Cal Date 7/26/66																				
Isotope X-Ray IR152	Dia X Len/KV .118" x .094"	Curtis/MA 32	Focal Spot Size .151"	SFD 15"	SOD 14.25"	Time 2:00	Film Processing Auto	Film Type / 1 or 2 2	PB Screens .010"	Film Technique Double																		
Weld Process / Heat Number N/A	Material Spec 316 SST	Material Diameter N/A	Material Thickness .75"	Penetrant ASTM 1B	Shim N/A	Acceptance Standard NO Defect > .080"	MFG/Speed Kodak AA	Date 7/26/66																				
Description 85209/30/1/134/818		Density Readings through Collis & Area of Interest 2.0-4.0		Remarks: Refer to Film Identification for Special Requirement for ASME Sec XI																								
SE141-114 rev. 7 page 1 of 2																												
FITTING SEAM OR FITTING	FILM INTERVAL NUMBER	WELDER IDENTIFICATION	SIZE	QUALITY LEVEL	SLAG	POROSITY	POROSITY WITH TAIL	CRACK	LACK OF PEN	LACK FUSION	INTERNAL CONVEXITY	INTERNAL CONCAVITY	LUNGSTEN	MELT-THROUGH	BURN-THROUGH	CRATER-PIT	OXIDATION	INTERNAL UNDERCUT	EXTERNAL UNDERCUT	ALIGNED INDICATIONS	WELD CONTOUR	MIS-MATCH	FILM ARTIFACT	VISUAL CONCERNS	FILM DENSITY	SEE REMARKS	ACCEPT	REJECT
	41-45	N/A	1B	.016"																								
	45-48																											
	44-45																											



Robert Weaver
TEAM Technician Signature

Robert D. Allward
Customer Representative Signature

7/26/66
Date



INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-114 - Item: 17

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

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


SHEET ZONE	CHARACTERISTIC	INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
		GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	D A T U M - E - S I D E 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.C		A
(10)							07-26-06		
*	D A T U M - D - S I D E 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.C		A
(20)							07-26-06		

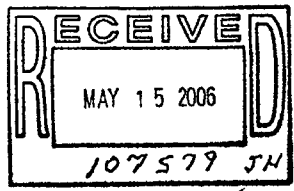
SOUTH TEXAS BOLT & FITTING, INC 4845 HOMESTEAD RD #500 HOUSTON TEXAS 77028 PH # 713 673 5376 FAX# 713 673 5379	* MATERIAL TEST REPORT * Date 05 17 2006
---	--

SOLD TO Major Tool & Machine INC 1458 East 19th Street Indianapolis IN 46218	Customer P/O # P06 01393 STBF Order # 81140
---	--

ITEM	QTY	DESCRIPTION	LOT / HEAT				
1	50	1 3 8 6 x 9 1 2 660B Broached Tapend Stud Silver Plated per AMS 2410	XFR / E3930				
Chemical Properties							
C 046	Mn 26	P 015	S 001	Si 28	Ni 25 60	Cr 14 10	Mo 1 21
Cu 13	Co 08	V 22	Al 24	Ti 2 18	B 0054		
Mechanical Properties							
Tensile 163310	Yield 11090	Elong 23 10	RA 49 90	Hardness 290hb	Temperature 1325 f	Macro Pass	
Remarks ASTM A453 03							

Certificate of Conformance
 This is to certify that the material purchased on this order was made in accordance with and to conform to the specifications and descriptions required by the American Society for Testing Materials (ASTM) and the American Society of Mechanical Engineers (ASME)

SOUTH TEXAS BOLT & FITTING

 Lance Byrns
 Quality Coordinator



Line 1.5



SOUTH TEXAS BOLT & FITTING, INC.
 4845 HOMESTEAD RD, #500
 HOUSTON, TEXAS 77028
 PH # 713-673-5376
 FAX# 713-673-5379

*** MATERIAL TEST REPORT ***
 Date: 05-22-2006

SOLD TO: Major Tool & Machine, Inc.
 1458 East 19th Street
 Indianapolis, IN 46218

Customer P/O # P06-01394
STBF Order # 81140-1A

ITEM	QTY	DESCRIPTION	LOT / HEAT
1	40	1 3/8-6 660B 12-Point Hex Nut Silver Plated Per AMS 2410	xfq / 5407813

Chemical Properties

C	Mn	P	S	Si	Ni	Cr	Mo
.034	1.50	.007	.0016	.54	25.00	14.70	1.22
Cu	Co	V	Al	Ti	B	Pb	
.06	.05	.26	.27	2.25	.0074	.0001	

Mechanical Properties

Tensile	Yield	Elong	RA	Hardness	Temperature	Macro
160000	109000	27.60	43.10	319hr	720°C	Pass

Remarks: ASTM A453

Certificate of Conformance

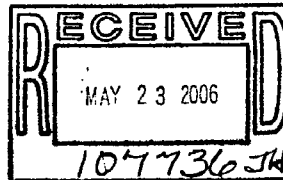
This is to certify that the material purchased on this order was made in accordance with, and to conform to, the specifications and descriptions required by the American Society for Testing Materials (ASTM) and the American Society of Mechanical Engineers (ASME).

SOUTH TEXAS BOLT & FITTING

Lance Byrns
 Quality Coordinator



MAY 23 2006



lines 2-4



Major
Tool & Machine, Inc.

INSPECTION DATA CHECKLIST

Page: 10
Date: 08/18/06
User ID: GRIFFIT#

Quality Assurance Documentation for Part ID: SE141-141 - Item: 20

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

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

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



Major
Tool & Machine, Inc.

INSPECTION DATA CHECKLIST

Quality Assurance Documentation for Part ID: SE141-142 - Item: 21

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

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

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

Employees: 242-M.Griffith / 339-E.Root / 495-D.Coffman / 503-B.Houk / 533-B.Clevenger / 825-B.Jarrett