

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

MTM N/C: 17746

Page: 1
Date: 08/19/05
User ID: BOWLING

Customer: ENERGY INDUSTRIES OF OHIO

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

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

Part: SE141-116 / MODULAR COIL WINDING FORM TYPE
Drawing ID: SE141-116 Revision: 5

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: C-1

Reported By: KEVIN BOWLING
E-Mail: kBowling@MajorTool.com

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

Problem: Part has multiple gouges from tools and one dent. See attached sketches describing the non-conformances.

Proposed Disposition:

SUBMIT TO CUSTOMER FOR DISPOSITION.

Number of additional pages: 1

Customer Disposition: Use As Is Rework Repair Scrap Replace

NCSX reviewed the descriptions of the three tool gouges and one dent shown in the attached sketches. The gouges need to be blended to avoid sharp edges. The dent defect needs to be worked as necessary so the tapped hole can be used.

Phil Heitzenroeder
2005.08.25 16:13:48 -04'00'
Technical Representative: _____

RLM: Brad Nelson
Digitally signed by Brad Nelson
DN: cn=Brad Nelson, ou=US, o=ORNL,
ou=PEO, email=nelsonbr@ornl.gov
Date: 2005.08.25 17:22:21 -04'00'

Major Tool Implemented By: Kevin Bowling

Title: PROGRAM MANAGER

Date: 25-OCT-05

Major Tool &
Machine, Inc.

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1458 East 19th Street
Indianapolis, IN
46218-4289

MTM N/C: 17399

Date: 05/24/05

User ID: BOWLINK

ENERGY INDUSTRIES OF OHIO Customer:

Contact: NANCY HORTON Telephone: 216-496-2314
NKHFloewen@aol.com E-Mail: 216-328-2001 Fax:

SE141-116 / MODULAR COIL WINDING FORM TYPE Part:

S005242-F/Ln:1 Customer P.O.: SE141-116 Drawing ID: 3 Revision: C1 Serial
No./Qty: Links: 1-Type:W: 65707/1.0 Sub: 1 Op: 20

KEVIN BOWLING Reported By: 317-636-6433 Telephone: E-Mail:
kBowling@MajorTool.com Fax: 317-634-9420

Problem: Part was gouged by an errant tool path.

Gouge is approximately 2" wide by 10" long and at worst case 1/2" deep.

Proposed Disposition:

SUBMIT TO CUSTOMER REQUESTING WELD
REPAIR.

Number of additional pages:

Customer Disposition: Use As Is Rework Repair Scrap Replace

Princeton Dist.
MTM is authorized to proceed with repair as soon as MTM's weld repair procedure which was submitted by e-mail on 5/12/05 is formally approved by PPPL. Weld repair procedures are currently being reviewed at PPPL.
on Casting Cut based on the

Submitted weld qualification procedures which lack some of the test results required in ASTM A488. Full qualification and re-submittal are required before ASAP and prior to weld repair on any subsequent castings. *B.N. concurs*

Technical Contact Approval: *Phil Heitzenroeder*
2005/05.25.08:10:42 -04'00'

PPPL Tech. Rep. *Michelle PA 5/26/05*
Date: *5/26/05*

Buyer Approval: *Larry J. Sutton*

Title: *SE & ADMIN* Date: *5/26/05*

Major Tool Implemented By: *Kevin Bowling* Title: *PROGRAM MANAGER* Date: *27-MAY-2005*

816-PROGRAMMING ERROR Root Cause 1:

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

MTM N/C: 18236

Page: 1
Date: 09/21/05
User ID: BOWLINK

Customer: ENERGY INDUSTRIES OF OHIO

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

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

Part: SE141-116 / MODULAR COIL WINDING FORM TYPE
Drawing ID: SE141-116 Revision: 6

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: C1

Reported By: KEVIN BOWLING
E-Mail: kBowling@MajorTool.com

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

Problem: AFTER MACHINING SEVERAL MACHINING DEFECTS WERE DETECTED UPON VISUAL EXAMINATION. SEE ADDITIONAL DOCUMENTS FOR MAPS AND LISTS OF (16) SEPARATE NON-CONFORMING FEATURES.

Proposed Disposition:

SUBMIT TO CUSTOMER CONTINUE PROCESSING THE PART.

Customer Disposition: Use As Is Rework Repair Scrap Replace

PAPL WILL PATCH IMPERFECTIONS WITH
FILLED EPOXY MIXTURE

Technical Contact Approval:

P. Ritzman

Title: Tech Rep.

Date: 9/22/05

RLM ~~Buyer~~ Approval:

[Signature]

Title: RLM

Date: 9/22/05

Major Tool Implemented By:

K. Bowling

Title: PROG. MGR

Date: 23-SEP-05

Major Tool & Machine, Inc.
1458 East 19th Street
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MTM N/C: 18237

Page: 1
Date: 09/21/05
User ID: BOWLINK

Customer: ENERGY INDUSTRIES OF OHIO
Contact: NANCY HORTON
E-Mail: NKHFlowen@aol.com

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

Part: SE141-116 / MODULAR COIL WINDING FORM TYPE
Drawing ID: SE141-116 Revision: 6

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: C1

Reported By: KEVIN BOWLING
E-Mail: kBowling@MajorTool.com

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

Problem: AFTER MACHINING SEVERAL MACHINING DEFECTS ON THE OUTSIDE OF THE PART WERE DETECTED UPON VISUAL EXAMINATION. SEE ADDITIONAL DOCUMENTS FOR MAPS AND LISTS OF (9) SEPARATE NON-CONFORMING FEATURES.

Proposed Disposition:
SUBMIT TO CUSTOMER CONTINUE MANUFACTURING.

Customer Disposition: Use As Is Rework Repair Scrap Replace

ITEM 3 - BLEND TROUGH SMOOTHLY
ITEMS 1, 2, 4, 5, 6, 7, 8, 9 - REMOVE SHARP EDGES, GRIND FLUSH

Technical Contact Approval: [Signature]
RLM Buyer Approval: [Signature]

Title: Tech. Rep Date: 9/22/05
Title: RLM Date: 9/22/05

Major Tool Implemented By: [Signature]

Title: Prod. Mgr. Date: 26-SEP-05

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Customer: ENERGY INDUSTRIES OF OHIO

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

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

Part: SE141-116 / MODULAR COIL WINDING FORM TYPE
Drawing ID: SE141-116 Revision: 6

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: C1

Reported By: KEVIN BOWLING
E-Mail: kBowling@MajorTool.com

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

Problem: VIEWING PART FROM THE OUTSIDE LOOKING TOWARD THE POLOIDAL BREAK WITH DATUM E
SIDE FACING UP THE (2) LEADBLOCK POCKETS ARE MACHINED OVERSIZE.

THE LEFT POCKET CHECKS 1.754
THE RIGHT POCKET CHECKS 1.625

PRINT DIMENSION IS 1.56" +/- .01

Proposed Disposition:

SUBMIT TO CUSTOMER CONTINUE MANUFACTURING.

Customer Disposition: Use As Is Rework Repair Scrap Replace

PPPL WILL FIT APPROPRIATE G-11 CR STIMS
TO FILL GAPS WITH LEAD BLOCKS

Technical Contact Approval:

Rup Ditzon
RLM Buyer Approval: *RLM*

Title:

Tech. Rep.
RLM

Date:

9/22/05
9/22/05

Major Tool Implemented By:

K. Bowling

Title:

PROG. MGR.

Date:

23-SEP-05