

**INSPECTION DATA CHECKLIST**

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

Workorder: 65709/2-0 Sub:1 Op:140

Part: SE141-101 - 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	
*		<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	MEASURED AT 2.2 GIG AOHMS	840-G.M			A
(10)								06-23-06			
*		<u>T E S T 2</u> RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE JUMPERED BOLTS AND JUMPERED MID-PLANE CASTING AND WINDING FORM.	MULTIMETER	QA		J-1358	MEASURE AT 33 TO 40 MEGA OHMS	840-G.M			A
(20)								06-23-06			

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

Workorder: 65709/2-0 Sub:1 Op:130

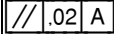
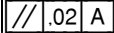
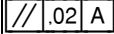
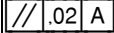

Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

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.	FEELER GAGES	MFG		J-1203	ACCEPT	242-M.G 06-26-06			A
* (15)		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"	FEELER GAGES	MFG		J-1203	ACCEPT	242-M.G 06-26-06			A
* (20)		ENSURE THAT THE CUMULATIVE GAPS AT ANY SINGLE CROSS SECTION OF THE POLOIDAL FLANGE ELEMENTS IS LESS THAN .005".	FEELER GAGES	MFG		J-1203	NO GAP	242-M.G 06-26-06			A
* (30)		THE MAX. GAP AT THE POLOIDAL BREAK PERIMETER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE.	FEELER GAGES	MFG		J-1203	ACCEPT	242-M.G 06-26-06			A
1* (40)	F2	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLIE	MFG		J-1240	DONE	825-B.JA 06-27-06			A


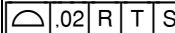

Quality Assurance Documentation for Part ID: SE141-114 - Item: 15

Workorder: 65709/2-0 Sub:1 Op:132

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		MTMFX3564	ACCEPT	339-E.RO 06-27-06			A
1* (20)	E8	FLANGE PROFILE +/- .25 IN THIS AREA	CMM	QA		00064	-.0027 TO -.0065	339-E.RO 06-27-06			A
1* (30)	D8		CMM	QA		00064	.006	339-E.RO 06-27-06			A
1* (40)	D8	54.20 ± .03	CMM	QA		00064	54.206	339-E.RO 06-27-06			A
1* (50)	C8	54.20 ± .03	CMM	QA		00064	54.205	339-E.RO 06-27-06			A
1* (60)	B8		CMM	QA		00064	.005	339-E.RO 06-27-06			A
1* (70)	D5		CMM	QA		00064	.002	339-E.RO 06-27-06			A
1* (80)	D5	48.50 ± .03	CMM	QA		00064	48.498	339-E.RO 06-27-06			A
1* (90)	C5	48.50 ± .03	CMM	QA		00064	48.494	339-E.RO 06-27-06			A
1* (100)	B5		CMM	QA		00064	.006	339-E.RO 06-27-06			A
1* (110)	D4	VERIFY PART MARKING: MAJOR TOOL SE141-114 A(casting number) (weight) LBS.		QA		VISUAL	ACCEPT	339-E.RO 06-27-06			A
1* (120)	D4	RECORD WEIGHT		QA			5180	242-M.G 06-21-06			A
1* (130)	D3	 OUTER AS CAST SURFACES	CMM	QA		00064	-.092 TO .553 [N/C: 20080-Doc:NC20080]	339-E.RO 06-27-06			R
2*	F8		CALIPER	QA		P-5075	.395 TO .435 ON DAT	533-B.CL			R

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(140)		2 X .40					UM E SIDE, .355 TO .410 ON DATUM D SIDE [N/C:20080-Doc:NC20080]	06-23-06		
2*	F8		CALIPER	QA		P-5075	.035 ON DATUM E SIDE, .010 TO .035 ON DATUM D SIDE [N/C:20080-Doc:NC20080]	533-B.CL		R
(150)		4 X .03 X 45						06-23-06		
2*	G6		PIN GAGE	QA		J-651-2	.187 ON DATUM E SIDE, .183 TO .192 ON DATUM D SIDE	533-B.CL		A
(160)		2 X R.187 +.025 / -.005						06-23-06		
2*	G5		CMM	QA		00064	-.003 TO .081	339-E.RO		A
(170)		P TO M						06-27-06		
2*	G5			QA		MTMFX-3473	REJECT - MODEL DOES NOT ALLOW FOR CLEARANCE [N/C:20080-Doc:NC20080]	339-E.RO		R
(180)		DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473						06-27-06		
2*	F5		CMM	QA		00064	-.021 TO .012 [N/C:20080-Doc:NC20080]	339-E.RO		R
(190)		M TO M1						06-27-06		
2*	E5		CMM	QA		00064	-.015 TO .017	339-E.RO		A
(200)		M1 TO N1						06-27-06		
2*	G3		CMM	QA		00064	.015 TO .092	339-E.RO		A
(210)		Q TO N						06-27-06		
2*	F3			QA		MTMFX-3473	ACCEPT	339-E.RO		A
(220)		DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473						06-27-06		
2*	F3		CMM	QA		00064	-.017 TO .027 [N/C:20080-Doc:NC20080]	339-E.RO		R
(230)		N TO N1						06-27-06		
2*	B4		CALIPER	QA		P-5075	.025 TO .050 [N/C:20080-Doc:NC20080]	533-B.CL		R
(240)		2 X .06/.09 X 45						06-23-06		
2*	B5	Ø .375-16 UNC ▽ .750 +.1 -0 96 X	THREAD PLUG GAGE	QA	100%	A-151	ACCEPT	339-E.RO		A
(250)								06-27-06		
2*	B5	 Ø.625 ▽ .188	PIN GAGE	QA		J-652-3	.618 TO .627 DEP TH .165 TO .193 [N/	533-B.CL		R

### INSPECTION DATA CHECKLIST

(260)			DEPTH MICROMETE			J-520	C:20080-Doc:NC20080	06-23-06		
2* (270)	B5	$\Phi$ .06 R T S .375-16 HOLES	CMM	QA		00064	.005 TO .055	339-E.RO 06-27-06		A
3* (280)	H3	$\square$ .01 DATUM E FLANGE	CMM	QA		00064	.015 [N/C:20080-Doc :NC20080]	339-E.RO 06-27-06		R
3* (285)	H4	$\surd$ <sup>125</sup> DATUM E FLANGE	PROFILOMETER	QA		J-1109	25 TO 81	533-B.CL 06-23-06		A
3* (290)	F2	$\square$ .01 DATUM D FLANGE	CMM	QA		00064	.032 [N/C:20080-Doc :NC20080]	339-E.RO 06-27-06		R
3* (295)	F3	$\surd$ <sup>125</sup> DATUM D FLANGE	PROFILOMETER	QA		J-1109	32 TO 78	533-B.CL 06-23-06		A
3* (300)	E4	$\emptyset$ 2.50 THRU	DIAL BORE GAGE	QA		J-1401	2.495	533-B.CL 06-23-06		A
3* (310)	F4	$\Phi$ .060 A B C $\emptyset$ 2.50	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A
3* (320)	C7	8X $\emptyset$ 1-8UNC $\nabla$ 2	THREAD PLUG GAGE	QA		A-347	ACCEPT	533-B.CL 06-22-06		A
3* (330)	C7	$\Phi$ .010 A B C 8X $\emptyset$ 1-8 UNC	CMM	QA		00064	.016 TO .060 [N/C:2 0080-Doc:NC20080]	339-E.RO 06-27-06		R
3* (340)	D5	8X $\emptyset$ 1-8UNC THRU	THREAD PLUG GAGE	QA		A-347	ACCEPT	533-B.CL 06-22-06		A
3* (350)	D5	$\emptyset$ .010 A B C 8X $\emptyset$ 1-8 UNC	CMM	QA		00064	.016 TO .066 [N/C:2 0080-Doc:NC20080]	339-E.RO 06-27-06		R
3* (360)	D3	$\emptyset$ 2.50 THRU	DIAL BORE GAGE	QA		J-1401	2.491	533-B.CL 06-23-06		A
3* (370)	D3	$\Phi$ .060 A B C $\emptyset$ 2.5	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A
3* (380)	D1	40.90	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A
4* (390)	H6	$\square$ $\emptyset$ 2.000-2.001 $\nabla$ 0.990-1.000	DIAL BORE GAGE  CALIPER	QA		J-1401  P-5075	2.0005, 2.0007, 2.0 009 DEPTH .992 TO .996	533-B.CL 06-24-06		A
4* (400)	F4	$\emptyset$ 1.375-6UNC THRU	THREAD PLUG GAGE	QA		A-375	ACCEPT	533-B.CL 06-23-06		A
4* (410)	F4	$\Phi$ $\emptyset$ .06 M A D $\emptyset$ 1.375-6	CMM	QA		00064	.036	339-E.RO 06-27-06		A

### INSPECTION DATA CHECKLIST

4* (420)	D4 &	Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA		J-1400	1.883 TO 1.887	533-B.CL 06-23-06		A
4* (430)	D4 &	⊕ Ø.06 M A D Ø1.885	CMM	QA		00064	.012 TO .059	339-E.RO 06-27-06		A
4* (440)	B6	3X Ø1.5	CALIPER	QA		J-1103	1.500 TO 1.502	533-B.CL 06-23-06		A
4* (450)	B6	⊕ .06 M A D 3X Ø1.5	CMM	QA		00064	.020 TO .058	339-E.RO 06-27-06		A
4* (460)	A4	6X .25-20 UNC ▽ .5 .5 X 82° CHAMFER	THREAD PLUG GAGE  CALIPER	QA		A-715  P-5075	THE THREADS ARE ACC EPTABLE BUT THE CHA MFER IS TOO BIG .5 00 [N/C:20080-Doc:N C20080]	533-B.CL  06-24-06		R
5* (470)	D8/D6	Ø1.885 ± .003	DIAL BORE GAGE	QA		J-1400	1.8835 TO 1.884	533-B.CL 06-22-06		A
5* (480)	D8/D6	⊕ Ø.06 N A E Ø1.885	CMM	QA		00064	.003 TO .074 [N/C:2 0080-Doc:NC20080]	339-E.RO 06-27-06		R
5* (490)	F8	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA		A-375	ACCEPT	533-B.CL 06-23-06		A
5* (500)	F8	⊕ Ø.06 N A E Ø1.375-6 UNC	CMM	QA		00064	.043	339-E.RO 06-27-06		A
5* (510)	F6	8X 1/4 -20 UNC-2B	THREAD PLUG GAGE	QA		A-715	ACCEPT	533-B.CL 06-23-06		A
5* (520)	D6	3X Ø1.5 ▽ 2.33	CALIPER  CALIPER	QA		J-1103  P-5075	1.498 TO 1.500 DEPTH 2.330 TO 2.34 0	533-B.CL  06-22-06		A
5* (530)	D6	⊕ Ø.06 N A E 3X Ø1.5	CMM	QA		00064	.024 TO .029	339-E.RO 06-27-06		A
5* (540)	B3	6X .25 - 20 UNC ▽ .6 Ø.5 X 82° CHAMFER	CALIPER	QA		P-5075	.375 DIA. CHAMFER [ N/C:20080-Doc:NC200 80]	533-B.CL  06-23-06		R
6* (550)	H7	6.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A
6* (560)	H7	1.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A
6* (570)	G8	6.70	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A

### INSPECTION DATA CHECKLIST

6* (600)	F8	6.70	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A
6* (610)	E7	5.75	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A
6* (620)	E7	1.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A
6* (630)	E6	4X Ø1.00	PIN GAGE	QA		J-921	.995	533-B.CL 06-23-06		A
6* (640)	G5	2X .88 - 1.13	CALIPER	QA		P-5075	1.115 TO 1.130	533-B.CL 06-23-06		A
6* (650)	F5	.06-.09 X 45° TYP	CALIPER	QA		P-5075	.065	533-B.CL 06-22-06		A
7* (660)	G2	19.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A
7* (670)	F2	2.00	CALIPER	QA		P-5075	2.00	533-B.CL 06-22-06		A
7* (680)	F2	6.75	CMM	QA		00064	SEE IGES DATA	339-E.RO 06-27-06		A
7* (690)	F2	3.75	CALIPER	QA		P-5075	3.745 TO 3.750	533-B.CL 06-22-06		A
7* (700)	F1	4X Ø.75-10 UNC ▽ 1.50	THREAD PLUG GAGE	QA		A-167	ACCEPT	533-B.CL 06-22-06		A
7* (710)	D1	2X 1.56 OPEN THRU	CALIPER	QA		P-5075	1.560	533-B.CL 06-22-06		A
7* (720)	C1	.375-16 UNC-2B TAP ▽ .75 .03 X 45° CHAMFER 6X	THREAD PLUG GAGE CALIPER	QA		A-444 P-5075	ACCEPT CHAMFE R .035	533-B.CL 06-22-06		A
7* (730)	C4	VERIFY THAT HOLE LOCATIONS ARE SCRIBED ON THE PART.		QA		VISUAL	ACCEPT	533-B.CL 06-22-06		A
7* (740)	B3	8.50 DISTANCE BETWEEN SCRIBE MARKINGS.	CALIPER	QA		J-1389	ACCEPT	533-B.CL 06-22-06		A
9* (750)	H1	2X Ø.50	PIN GAGE	QA		J-652-3	.500	533-B.CL 06-23-06		A
9*	B7		PIN GAGE	QA		J-652-3	2.570 DEEP .623 D	533-B.CL		A



**Major**

Tool & Machine, Inc.

**INSPECTION DATA CHECKLIST**

(760)		TC2 HOLE TO BE .625" IN DIAMETER APPROX. 2.52" DEEP AND .25" IN DIAMETER AT LEAST 1" DEEP.	CALIPER			P-5075	1A. 1 DEEP . 252 DIA.	06-23-06		
*		TC1 LOCATION AND CONFIGURATION MODIFIED. HOLE TO HAVE .625 CLEARANCE AND AT LEAST 1" OF DEPTH AT THE .25" DIA	PIN GAGE	QA		J-652-3	.623 DIA. 1.150 D EEP .252 DIA.	533-B.CL		A
(770)			CALIPER			P-5075		06-23-06		
10*	F5		CMM	QA		00064	-.034 TO -.337 / -. 341 TO .073 [N/C:20 080-Doc:NC20080]	339-E.RO		R
(780)		INNER AS CAST SURFACES						06-27-06		
10*	D5		CMM	QA		00064	-.164 TO -.197 / -. 016 TO -.206 [N/C:2 0080-Doc:NC20080]	339-E.RO		R
(790)		WING SURFACES						06-27-06		
<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*	3.1.1.4	<sup>125</sup> THE TWO "L" MACHINED SURFACES OF TEE MUST HAVE A RMS OF 125.	PROFILOMETER	QA		J-1109	15 TO 30	533-B.CL		A
(800)								06-23-06		



**INSPECTION DATA CHECKLIST**

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

Workorder: 65709/2-0 Sub:1 Op:136

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

Drawing ID: SE141-114 Rev: 6			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		<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	LESS THAN 1.02	667-J.BA			A
(10)								06-26-06			
*		<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	LESS THAN 1.02	667-J.BA			A
(20)								06-26-06			



**INSPECTION DATA CHECKLIST**

Quality Assurance Documentation for Part ID: SE141-141 - Item: 19

Workorder: 65709/2-0 Sub:14 Op:30

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-1270	LESS THAN 1.02	503-B.HO		
(10)								06-20-06		

A



**INSPECTION DATA CHECKLIST**

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

Workorder: 65709/2-0 Sub:15 Op:30

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-1270	LESS THAN 1.02	503-B.HO		
(10)								06-20-06		

A

Employees: 242-M.Griffith / 339-E.Root / 503-B.Houk / 533-B.Clevenger / 667-J.Bannister / 825-B.Jarrett / 840-G.Masood