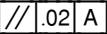
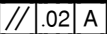



Workorder: 65707/3-0 Sub:1 Op:134

Revision: 02/27/06 8:12


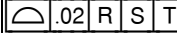
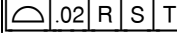

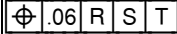


Part: SE141-116 - MODULAR COIL WINDING FORM TYPE-C - PRODUCTION MODULAR COIL WINDING FORM TYPE-C

Drawing ID: SE141-116 Rev: 8			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	47.25	339-E.RO 02-21-06			R *
1* (20)	B8	47.19 ± .03	CMM	QA		00064	47.26	339-E.RO 02-21-06			R *
1* (30)	D6	47.19 ± .03	CMM	QA		00064	47.06	339-E.RO 02-21-06			R *
1* (40)	C6	47.19 ± .03	CMM	QA		00064	47.07	339-E.RO 02-21-06			R *
1* (50)	E6		CMM	QA		00064	.028	339-E.RO 02-21-06			R *
1* (60)	B6		CMM	QA		00064	.012	339-E.RO 02-21-06			A *
2* (80)	H6	2X R.187 +.025 -.005	PIN GAGE	QA		J-652	ACCEPT	339-E.RO 02-21-06			A *
2* (90)	G8	2X .03 X 45°		QA		VISUAL	.03 X 45	339-E.RO 02-21-06			A *
2* (100)	G8	.40 ± .010	CALIPER	QA		J-707	0.32	339-E.RO 02-21-06			A *
2* (110)	G8	2X .030 X 45°		QA		VISUAL	.03 X 45	339-E.RO 02-21-06			A *
2* (120)	F7	2X .32	CALIPER	QA		J-707	0.32	339-E.RO 02-21-06			A *
2* (130)	F7	2X R.11	RADIUS GAGE	QA		R-25	.10 - .20	339-E.RO 02-21-06			R *
2* (140)	G6	 P TO M	CMM	QA		00064	-.300 TO .425 70 PTS / 54 OOT	242-M.G 02-27-06			R *
2*	G6	4.790 OR SHELL INTERSECT.	CMM	QA		00064	ACCEPT	242-M.G			A

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INSPECTION DATA CHECKLIST

(150)		VERIFY USING TEMPLATE PER DRAWING NOTE 16 (MTMFX-3473)						02-24-06		*	
2* (160)	G3	 Q TO N	CMM	QA		00064	-.015 TO .0785 53 PTS	242-M.G 02-27-06		A *	
2* (170)	G3	4.790 OR SHELL INTERSECT. VERIFY USING TEMPLATE PER DRAWING NOTE 16 (MTMFX-3473)		QA			ACCEPT	242-M.G 02-24-06		A *	
2* (180)	E6	 M TO MI	CMM	QA		00064	-.0465 TO .0425 981 PTS / 328 OOT	242-M.G 02-27-06		R *	
2* (182)	F3	 N TO NI	CMM	QA		00064	-.0456 TO .0485 977 PTS / 341 OOT	242-M.G 02-27-06		R *	
2* (185)	E5	 MI TO NI	CMM	QA		00064	-.0423 TO .0443 359 PTS	242-M.G 02-27-06		A *	
Drawing ID: NCSX-CSPEC-141-03 Rev: 11			INSPECTION INSTRUCTIONS			RESULTS			INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
4* (188)	3.1.1.4	¹²⁵ THE TWO "L" MACHINED SURFACES OF TEE.	PROFILOMETER	QA		J-1152	60	339-E.RO 02-21-06		A *	
Drawing ID: SE141-116 Rev: 8			INSPECTION INSTRUCTIONS			RESULTS			INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
2* (190)	B5	 96X .375-16 UNC .750 DEEP .625 C'BORE .188 DEEP	CMM	QA	50%	00064	.004 TO .098 48 PTS / 19 OOT	242-M.G 02-27-06		R *	
2* (195)	B5	.375-16 UNC .750 DEEP GAGE 100% OF THE HOLES AND VERIFY CLEANLINESS.	THREAD PLUG GAGE	QA	100%	A-443	ACCEPT	339-E.RO 02-21-06		A *	
2* (200)	B4	2X .06-.09 X 45°		QA		VISUAL	ACCEPT	339-E.RO 02-21-06		A *	
3* (210)	G7	 8X Ø1-8 UNC THRU	CMM	QA		00064	.022 TO .054	339-E.RO 02-21-06		R *	
3* (230)	H3	 DATUM -E- FLANGE	CMM	QA		00064	.020	242-M.G 02-27-06		R *	

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INSPECTION DATA CHECKLIST

3* (240)	H4	$\sqrt{125}$ DATUM -E- FLANGE	PROFILOMETER	QA		J-1152	23 - 55	339-E.RO 02-21-06			A *
3* (250)	F3	\square .01 DATUM -D- FLANGE	CMM	QA		00064	.030	242-M.G 02-27-06			R *
3* (260)	F3	$\sqrt{125}$ DATUM -D- FLANGE	PROFILOMETER	QA		J-1152	28 - 106	339-E.RO 02-21-06			A *
3* (280)	E4	\varnothing .01 A B C 8X Ø1.13 THRU BACK SPOT FACE Ø2.38 MIN DEPTH FOR C'UP	CMM SCALE	QA		00064 J-922	.046 TO .056 / ACCE PT SPOTFACE	339-E.RO 02-24-06			R *
4* (290)	H8	\varnothing .060 D A N 3X Ø1.885 THRU	CMM	QA		00064	.0054 TO .016	339-E.RO 02-21-06			A *
4* (291)	H8	3X Ø1.885 +/- .003 Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP	CMM SCALE	QA		00064 J-922	1.885 - 1.890 / ACC EPT SPOTFACE	339-E.RO 02-21-06			R *
Drawing ID: SE141-116 Rev: 7			INSPECTION INSTRUCTIONS			RESULTS			INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
4* (300)	H7	\varnothing .01 D A N 3X SPH R.75 TO .75 DEEP	CMM	QA		00064	.0084 - .0986	339-E.RO 02-21-06			R *
Drawing ID: SE141-116 Rev: 8			INSPECTION INSTRUCTIONS			RESULTS			INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
4* (310)	H6	\varnothing .060 D A N 17X Ø1.885 THRU	CMM	QA		00064	.004 TO .104	339-E.RO 02-24-06			R *
4* (311)	H6	3X Ø1.885 +/- .003 THRU Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP	CMM SCALE	QA		00064 J-922	1.882 - 1.884 / ACC EPT	339-E.RO 02-21-06			A *
4* (320)	H5	\varnothing .060 D A N 3X Ø1.13	CMM	QA		00064	.0462 TO .0564	339-E.RO 02-21-06			A *
4* (321)	H5	3X Ø1.13 +/- .010 Ø2.38 BACK SPOTFACE VERIFY MIN CLEANUP	CMM SCALE	QA		00064 J-922	1.125 - 1.126 / ACC EPT SPOTFACE	242-M.G 02-24-06			R *

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INSPECTION DATA CHECKLIST

4* (340)	E6	Φ Ø.060 D A N 3X Ø1.375-6 UNC THRU	CMM	QA		00064	.0096 TO .0316	339-E.RO 02-24-06			A *
4* (350)	E6	Φ Ø.060 D A N 5X Ø1.885 THRU	CMM	QA		00064	.0352 TO .0550	339-E.RO 02-24-06			A *
4* (351)	E6	5X Ø1.885 +/- .003 THRU Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP	SCALE	QA		J-922	ACCEPT	339-E.RO 02-21-06			A *
4* (360)	D4	Φ Ø.060 D A N Ø1.885 THRU	CMM	QA		00064	0.1088	339-E.RO 02-21-06			R *
4* (361)	D4	Ø1.885 +/- .003 THRU Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP	SCALE	QA		J-922	ACCEPT	339-E.RO 02-21-06			A *
4* (370)	B5	Φ Ø.060 D A N 3X Ø1.13	CMM	QA		00064	.046 TO 0.1008	339-E.RO 02-24-06			R *
4* (371)	B5	3X Ø1.13 +/- .010 Ø2.38 BACK SPOTFACE VERIFY MIN CLEANUP	CMM SCALE	QA		00064 J-922	1.125 - 1.126 / ACC EPT SPOTFACE	339-E.RO 02-21-06			A *
4* (375)	D1	12X .25-20 UNC -2B	THREAD PLUG GAGE	QA		A-67	ACCEPT	339-E.RO 02-21-06			A *
5* (380)	E8	Φ Ø.060 E A J Ø1.885 THRU	CMM	QA		00064	.034	339-E.RO 02-24-06			A *
5* (381)	E8	Ø1.885 +/- .003 THRU Ø3.00 BACK SPOTFACE VERIFY MIN CLEANUP	SCALE	QA		J-922	ACCEPT	339-E.RO 02-21-06			A *
5* (400)	F6	Φ Ø.060 E A J 3X Ø1.375-6 UNC THRU	CMM	QA		00064	.033, .036, .037	339-E.RO 02-24-06			A *
Drawing ID: SE141-116 Rev: 7			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
5* (410)	F6	Φ Ø.01 E A J 3X SPH R.75 TO .75 DEEP	CMM	QA		00064	.022, .023, .026	339-E.RO 02-24-06			R *
Drawing ID: SE141-116 Rev: 8			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			

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INSPECTION DATA CHECKLIST

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
5* (420)	F7	7X .25-20 UNC -2B	THREAD PLUG GAGE	QA		A-67	ACCEPT	339-E.RO 02-21-06			A *
5* (430)	E7	$\varnothing \varnothing .060$ E A J 24X $\varnothing 1.885$ THRU	CMM	QA		00064	.0072 TO .039	339-E.RO 02-24-06			A *
5* (431)	E7	24X $\varnothing 1.885 \pm .003$ THRU $\varnothing 3.00$ BACK SPOTFACE VERIFY MIN CLEANUP	SCALE	QA		J-922	ACCEPT	339-E.RO 02-21-06			A *
5* (440)	E7	$\varnothing \varnothing .060$ E A J 3X $\varnothing 1.5$ TO 2.00 DEEP $\varnothing 3.00$ TO 1.00 DEEP	CMM	QA		00064	.015, .016, .017	339-E.RO 02-24-06			A *
5* (450)	D7	3X $\varnothing 1.885 \pm .003$ THRU $\varnothing 3.00$ BACK SPOTFACE VERIFY MIN CLEANUP	CMM	QA		00064	ACCEPT	242-M.G 02-24-06			A *
Drawing ID: SE141-116 Rev: 7			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
5* (460)	G2	SPH R.75 TO .75 DEEP	CMM	QA		00064	.745 - .750	339-E.RO 02-21-06			A *
Drawing ID: SE141-116 Rev: 8			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
6* (470)	E3	4X $\varnothing 1.00$ THRU	CALIPER	QA		J-707	0.98 - 0.99	339-E.RO 02-21-06			A *
8* (650)	G7	4.00 \pm .010	SCALE	QA		J-922	4.0	339-E.RO 02-21-06			A *
8* (750)	D7	6X $\varnothing .375-16$ UNC TO .75 DEEP .03 X 45° CHAMFER	THREAD PLUG GAGE	QA		A-443	ACCEPT	339-E.RO 02-21-06			A *
8* (760)	D7	13.6 °	CMM	QA		00064	12.93	339-E.RO 02-21-06			R *
8*	D7	5.88 VERIFY THAT PAD MEETS THE	SCALE	QA		J-922	> 5.88	339-E.RO			A

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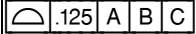

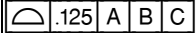
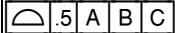
INSPECTION DATA CHECKLIST

(770)		MINIMUM OF 5.88						02-21-06		*
8* (780)	D7	2.19 ± .010	CALIPER	QA		J-707	2.19	339-E.RO 02-21-06		A *
8* (790)	D7	2.19 ± .010	CALIPER	QA		J-707	2.19	339-E.RO 02-21-06		A *
8* (830)	C8	2X 1.56 ± .010 THRU	CALIPER	QA		J-707	1.56 / 1.55	339-E.RO 02-21-06		A *
8* (850)	C8	2X 7.50 ± .010 THRU	CMM	QA		00064	7.50 / 7.499	339-E.RO 02-21-06		A *
8* (860)	C8	8X R.25	RADIUS GAGE	QA		R-25	8X 0.26	339-E.RO 02-21-06		A *
8* (870)	C8	2X 2.52 ± .010	CALIPER	QA		J-707	2.52	339-E.RO 02-21-06		A *
9* (900)	E7	2.54 ± .010	CALIPER	QA		J-707	2.54	339-E.RO 02-21-06		A *
9* (910)	E7	5.08 ± .010	CALIPER	QA		J-707	5.08	339-E.RO 02-21-06		A *
9* (920)	F3	4X Ø1.0 THRU VERIFY THAT HOLES BREAK COMPLETELY THROUGH INSIDE OF CASTING	CALIPER	QA		J-707	.99 - .100	339-E.RO 02-21-06		A *
9* (930)	F3	2X Ø .50 ± .010 THRU	CALIPER	QA		J-707	.49 - .50	339-E.RO 02-21-06		A *
9* (940)	E3	2.44 ± .010	CALIPER	QA		J-707	2.44	339-E.RO 02-21-06		A *
9* (950)	E3	1.22 ± .010	CALIPER	QA		J-707	1.22	339-E.RO 02-21-06		A *
9* (960)	C7	4X Ø1.0 THRU VERIFY THAT HOLES BREAK COMPLETELY THROUGH INSIDE OF CASTING	CALIPER	QA		J-707	.99 - .100	339-E.RO 02-21-06		A *
9* (970)	C6	2X Ø .25 T.C. HOLE TO 2.5 DEEP	CALIPER	QA		J-707	.250 / 2.5	339-E.RO 02-21-06		A *

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INSPECTION DATA CHECKLIST

Drawing ID: SE141-116 Rev: 7			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
10* (980)	C8	 .125 A B C	CMM	QA		00064	-.278 / .492 75 PTS / 5 OOT	242-M.G 02-27-06			R *
Drawing ID: SE141-116 Rev: 8			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
10* (990)	D5	 .5 A B C DATUM -D- SIDE INNER CAST	CMM	QA		00064	-.989 TO .733 90 PTS / 17 OOT	242-M.G 02-27-06			R *
Drawing ID: SE141-116 Rev: 7			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
10* (1010)	C4	 .125 A B C DATUM -E- SIDE LARGE WING		QA			.048 TO .1062 35 PTS / 9 OOT	242-M.G 02-27-06			R *
Drawing ID: SE141-116 Rev: 8			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
10* (1030)	D1	 .5 A B C DATUM -E- SIDE INNER CAST	CMM	QA		00064	-.339 / .656 69 PTS / 18 OOT	242-M.G 02-27-06			R *
Drawing ID: SE141-116 Rev: 7			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
10* (1035)	E1	MACHINE / GRIND THIS AREA TO PROFILE OF +.05/.10	CMM	QA		00064	-.114 TO -.160 ACT UAL DEVIATION FROM NOMINAL	242-M.G 02-24-06			R *
Drawing ID: NCSX-CSPEC-141-03 Rev: 10			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
4* (1040)	3.1.1.4	UOS ALL MACHINED SURFACES TO BE 250 RMS SURFACE FINISH RECORD RANGE	PROFILOMETER	QA		J-1152	31 - 125	339-E.RO 02-21-06			A *
Drawing ID: SE141-116 Rev: 8			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1* (1040)		NOTE 9 RECORD THE WEIGHT OF THE PART		QA			VISUAL 5640	339-E.RO			A

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INSPECTION DATA CHECKLIST

(1050)		6000LBS MAX						02-24-06		*
4* (1060)	H7	22.13 ± .010	CMM	QA		00064	22.12	339-E.RO 02-21-06		A *
4* (1070)	H7	47.79 ± .010	CMM	QA		00064	47.91	339-E.RO 02-21-06		A *
4* (1080)	H6	59.18 ± .010	CMM	QA		00064	59.17	339-E.RO 02-21-06		A *
4* (1090)	H6	73.27 ± .010	CMM	QA		00064	73.27	339-E.RO 02-21-06		A *
4* (1100)	H5	80.49	CMM	QA		00064	80.50	339-E.RO 02-21-06		A *
4* (1110)	H5	87.87 ± .010	CMM	QA		00064	87.89	339-E.RO 02-21-06		R *
4* (1120)	H5	89.64 ± .010	CMM	QA		00064	89.64	339-E.RO 02-21-06		A *
4* (1130)	G4	31.83 ± .010	CMM	QA		00064	31.85	339-E.RO 02-21-06		R *
4* (1140)	F4	24.10 ± .010	CMM	QA		00064	24.10	339-E.RO 02-21-06		A *
4* (1150)	F4	11.48 ± .010	CMM	QA		00064	11.52	339-E.RO 02-21-06		R *
4* (1160)	E4	5.20 ± .010	CMM	QA		00064	5.24	339-E.RO 02-21-06		R *
4* (1170)	D4	18.31 ± .010	CMM	QA		00064	18.26	339-E.RO 02-21-06		R *
4* (1180)	D4	32.50 ± .010	CMM	QA		00064	32.45	339-E.RO 02-21-06		R *
4* (1190)	C5	77.13 ± .010	CMM	QA		00064	77.12	339-E.RO 02-21-06		A *
4* (1200)	C6	55.56 ± .010	CMM	QA		00064	55.55	339-E.RO 02-21-06		A *
4* (1210)	B7	23.74 ± .010	CMM	QA		00064	23.72	339-E.RO 02-21-06		R *
4*	C7	37.09 ± .010	CMM	QA		00064	37.06	339-E.RO		R

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INSPECTION DATA CHECKLIST

(1220)								02-21-06		*
4*	D8	17.22 ± .010	CMM	QA		00064	17.21	339-E.RO		A
(1230)								02-21-06		*
4*	F8	28.17 ± .010	CMM	QA		00064	28.18	339-E.RO		A
(1240)								02-21-06		*
4*	G8	40.75 ± .010	CMM	QA		00064	40.76	339-E.RO		A
(1260)								02-21-06		*
4*	G8	43.42 ± .010	CMM	QA		00064	43.42	339-E.RO		A
(1270)								02-21-06		*
5*	H8	88.39 ± .010	CMM	QA		00064	88.41	339-E.RO		R
(1290)								02-21-06		*
5*	H7	86.42 ± .010	CMM	QA		00064	86.42	339-E.RO		A
(1300)								02-21-06		*
5*	H6	59.08 ± .010	CMM	QA		00064	59.08	339-E.RO		A
(1310)								02-21-06		*
5*	H5	28.71 ± .010	CMM	QA		00064	28.70	339-E.RO		A
(1320)								02-21-06		*
5*	G5	32.42 ± .010	CMM	QA		00064	32.44	339-E.RO		R
(1330)								02-21-06		*
5*	D4	22.117 ± .005	CMM	QA		00064	22.100	339-E.RO		R
(1340)								02-21-06		*
5*	D4	38.14 ± .010	CMM	QA		00064	38.12	339-E.RO		R
(1350)								02-21-06		*
5*	D5	21.33 ± .010	CMM	QA		00064	21.32	339-E.RO		A
(1360)								02-21-06		*
5*	D7	87.62 ± .010	CMM	QA		00064	87.58	339-E.RO		R
(1370)								02-21-06		*
5*	E8	7.53 ± .010	CMM	QA		00064	7.50	339-E.RO		R
(1380)								02-21-06		*
5*	E8	4.91 ± .010	CMM	QA		00064	4.89	339-E.RO		R
(1390)								02-21-06		*
5*	G8	36.13 ± .010	CMM	QA		00064	36.13	339-E.RO		A
(1400)								02-21-06		*
8*	D8	2.63 ± .010	CMM	QA		00064	2.62	339-E.RO		A

* To Far Right Indicates Data Package Requirement

NOTE: the recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, title 18, chapter 47.



INSPECTION DATA CHECKLIST

(1420)									02-21-06		*
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Employees: 242-M.Griffith / 339-E.Root

* To Far Right Indicates Data Package Requirement

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