

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

MTM N/C: 19209

Page: 1
Date: 02/09/06
User ID: GRIFFITH

Customer: ENERGY INDUSTRIES OF OHIO

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

Telephone: 216-496-2314
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Part: SE141-116 / MODULAR COIL WINDING FORM TYPE
Drawing ID: SE141-116 Revision: 7
Links: I-Type:W: 65707/4.0 Sub: 1 Op: 35

Customer P.O.: S005242-F/Ln:4
Serial No./Qty: C4

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

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

Problem: TOOL GOUGE APPROXIMATELY 1.5" LONG X .5" WIDE AND .250" DEEP ON THE CORNER OF THE T.
GOUGE IS LOCATED ON THE DATUM -D- SIDE (SEE PICTURES).

Proposed Disposition:

RECOMMEND WELD REPAIR OF DEFECTIVE AREA PRIOR TO FINISH MACHINING.
ALSO RECOMMEND REPAIR TO BE INSPECTED USING PT AND MAG PERMEABILITY CHECK WITH
WAIVER OF THE X-RAY REQUIREMENT.

Number of additional pages: 2 attached pictures

Customer Disposition: Use As Is Rework Repair Scrap Replace

PPPL concurs with Major Tools recommended disposition.

Phil
Heitzenroeder

Digitally signed by Phil Heitzenroeder
DN: CN = Phil Heitzenroeder, C = US,
O = PPPL, OU = Mech. Eng. Division
Reason: I am approving this
document
Date: 2006.02.10 16:31:49 -05'00'

Technical Contact Approval: _____

Title: _____ Date: _____

Brad
Nelson

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US,
o=ORNL, ou=FED,
email=nelsonbe@ornl.gov
Date: 2006.02.10 17:50:02
-05'00'

RLM: _____

Title: _____ Date: _____

Major Tool Implemented By: Mike Griffith Title: QFT. ENGINEER Date: 2-10-06

Root Cause1: 803-INEFFECTIVE TRAINING

Resource: CAD/CAM - LARGE MILLING Equipment:
Description: THE TOOL-GOUGE OCCURRED AS A RESULT OF A PROGRAMMING ERROR. PROGRAMS HAD BEEN MODIFIED TO HELP REDUCE MACHINING CYCLE. THE NEW PROGRAM WAS VERIFIED USING VERICUT PRIOR TO RELEASING TO THE MACHINE. THE PROGRAMMER AGAIN VERIFIED THE PROGRAM AFTER THE GOUGE OCCURRED AND DISCOVERED THAT THE ERROR HAD BEEN DETECTED BY VERICUT. THE PROGRAMMER WAS NOT CORRECTLY INTERPRETING THE RESULTS FROM THE VERIFICATION PROCESS.

Corrective Action 1:

Action: 02/09/06 By: 242-M.GRIFFITH

Description: THE PROGRAMMER HAS BEEN GIVEN ADDITIONAL TRAINING ON THE USE OF VERICUT AND FULLY UNDERSTANDS HOW THE ERROR WAS MISSED.



