

Workorder: 65708/1-0 Sub:1 Op:130

Revision: 06/13/06 10:13

Part: SE141-115 - MODULAR COIL, TYPE B -

Drawing ID: SE141-102 Rev: 3			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
2* (10)	D2	Ø.001 - Ø.002 CHECK CLEARANCE OF ITEM 5 TO ITEM 6.	FEELER GAGES	MFG		J-1203	LESS THAN .002	825-B.JA 09-18-06			A *
*		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"		MFG			LES THAN .002	825-B.JA 09-19-06			A *
*		ENSURE THAT THE CUMULATIVE GAPS AT ANY SINGLE CROSS SECTION OF THE POLOIDAL FLANGE ELEMENTS IS LESS THAN .005".		MFG		FEELER STOCK	ONE AREA WILL ACCEP T A .005" SHIM [N/C :20487-Doc:NC20487]	242-M.G 09-18-06			R *
*		THE MAX. GAP AT THE POLOIDAL BREAK PERIMITER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE.		MFG		FEELER STOCK	ONE AREA EXCEEDS TH E ALLOWABLE GAP (.0 32" WILL START) [N/ C:20487-Doc:NC20487]	242-M.G 09-18-06			R *
1* (40)	F3	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLIE	MFG		J-1240	1500	825-B.JA 09-18-06			A *

Workorder: 65708/1-0 Sub:1 Op:132

Revision: 09/20/06 14:20

Part: SE141-115 - MODULAR COIL, TYPE B -

Drawing ID: SE141-115 Rev: 9			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT

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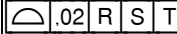

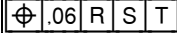
INSPECTION DATA CHECKLIST

1* (10)	C3	VERIFY PART MARKING: MAJOR TOOL SE141-114 A(casting number) (weight) LBS.		QA		VISUAL	ACCEPT	339-E.RO 09-26-06			A *
1* (20)	C3	RECORD FINAL PART WEIGHT		QA			5460	339-E.RO 09-26-06			A *
1* (30)	F3	NOTE 14 BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.		QA		VISUAL	ACCEPT	339-E.RO 09-26-06			A *
1* (40)	E7		CMM	QA		00064	.001	339-E.RO 09-26-06			A *
1* (50)	E6		CMM	QA		00064	.003	339-E.RO 09-26-06			A *
1* (60)	B6		CMM	QA		00064	.003	339-E.RO 09-26-06			A *
1* (70)	B5		CMM	QA		00064	.001	339-E.RO 09-26-06			A *
1* (80)	C8	 WING SURFACES	CMM	QA		00064	-.033 TO .038 [N/C: 20528]	339-E.RO 09-26-06			R *
1* (90)	D3	 OUTER AS CAST SURFACES	CMM	QA		00064	-.166 TO .275 [N/C: 20528]	339-E.RO 09-26-06			R *
2* (100)	G7	2X .03 X 45°		QA		VISUAL	ACCEPT	503-B.HO 09-26-06			A *
2* (110)	G7	.40	CALIPER	QA		P-2056	.391/.405	503-B.HO 09-26-06			A *
2* (120)	G7	2X .03 X 45°		QA		VISUAL	ACCEPT	503-B.HO 09-26-06			A *
2* (130)	G8	2X R.11	RADIUS GAGE	QA		R-25	.110	503-B.HO 09-26-06			A *
2* (140)	H7	2X .31	CALIPER	QA		P-2056	.305/.350 [N/C:2052 8]	503-B.HO 09-26-06			R *
2*	H6		CMM	QA		00064	-.025 TO .022 [N/C:	339-E.RO			R

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INSPECTION DATA CHECKLIST

(150)		MACHINED SURFACES M TO M1				20528]	09-26-06		*
2* (160)	F5	DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA	MTMFX-3473	GAGE DOES NOT GO - T82 [N/C:20528]	339-E.RO 09-26-06		R *
2* (170)	E6	 P TO M	CMM	QA	00064	.018 TO .110 [N/C:2 0528]	339-E.RO 09-26-06		R *
2* (180)	H4	 MACHINED SURFACES M1 TO N1	CMM	QA	00064	-.016 TO .023	339-E.RO 09-26-06		A *
2* (190)	G3	 MACHINED SURFACES N TO N1	CMM	QA	00064	-.026 TO .032 [N/C: 20528]	339-E.RO 09-26-06		R *
2* (200)	F3	DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA	MTMFX-3473	WILL NOT ACCEPT GAG E: T32-T37, T6-T11, T86-T92, T56-T49 [N/C:20528]	339-E.RO 09-26-06		R *
2* (210)	F3	 Q TO N	CMM	QA	00064	.009 TO .130 [N/C:2 0528]	339-E.RO 09-26-06		R *
2* (220)	D6	$\perp .625 \sqrt{.188}$ HOLE 63 THRU 73	CALIPER	QA	P-3761	#70-.635 #71-.647 # 72-.636 #73-.633 .178/.184 [N/C:2052 8]	503-B.HO 09-26-06		R *
2* (230)	C5	2X .06-.09 X 45°	CALIPER	QA	P-2056	ACCEPT	503-B.HO 09-26-06		A *
2* (240)	C4	84X .375-16 UNC $\sqrt{.75}$	THREAD PLUG GAGE	QA	A-46	ACCEPT	339-E.RO 09-26-06		A *
2* (250)	C4	84X $\perp .625 \sqrt{.188}$	CALIPER	QA	P-3761	.620/.630 .174/.1 84	503-B.HO 09-26-06		A *
2* (260)	C4		CMM	QA	00064	.004 TO .078 [N/C:2 0528]	339-E.RO 09-26-06		R *
3*	G7		CMM	QA	00064	SEE IGES DATA	339-E.RO		A

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INSPECTION DATA CHECKLIST

(270)		9.00					09-26-06		*
3* (280)	G7	4.50	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
3* (290)	G6	3.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
3* (300)	F7	1.50	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
3* (310)	F7	4X Ø1.0-8UNC ▽2.1	THREAD PLUG GAGE	QA	A-71	ACCEPT	503-B.HO 09-26-06		A *
3* (320)	G5	17.00 AT MOUNTING AREA	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
3* (330)	H2	¹²⁵ / DATUM E	PROFILOMETER	QA	J-1152	LESS THAN 100	503-B.HO 09-26-06		A *
3* (340)	G1	 DATUM E	CMM	QA	00064	.019 [N/C:20528]	339-E.RO 09-26-06		R *
3* (350)	G3	.25± .01 DATUM E	CMM	QA	00064	.236 TO .256 [N/C:2 0528]	339-E.RO 09-26-06		R *
3* (360)		 DATUM D	CMM	QA	00064	.014 [N/C:20528]	339-E.RO 09-26-06		R *
3* (370)	E2	.25± .01 DATUM D	CMM	QA	00064	.237 TO .254 [N/C:2 0528]	339-E.RO 09-26-06		R *
3* (380)	E2	 DATUM D	PROFILOMETER	QA	J-1152	26 TO 71	339-E.RO 09-26-06		A *
3* (390)	F4	2X Ø2.50	CALIPER	QA	P-2056	2.25	503-B.HO 09-26-06		A *
3* (400)	F4	4X Ø1.0 -8UNC ▽2.5	THREAD PLUG GAGE	QA	A-71	ACCEPT	503-B.HO 09-26-06		A *
3* (410)	F4	1.72	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
3* (420)	D5	8X Ø1-8UNC ▽ 1.5	THREAD PLUG GAGE	QA	A-71	ACCEPT	503-B.HO 09-26-06		A *
3* (430)	B7	4X 1-8UNC ▽ 2.5	THREAD PLUG GAGE	QA	A-71	ACCEPT	503-B.HO 09-26-06		A *

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INSPECTION DATA CHECKLIST

3* (440)	C1	1.50	CMM	QA		00064	SEE IGES DATA	339-E.RO 09-26-06			A *
3* (450)	C1	3.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 09-26-06			A *
3* (460)	C1	4X Ø 1-8UNC ▽ 2.1	THREAD PLUG GAGE	QA		A-71	ACCEPT	503-B.HO 09-26-06			A *
3* (470)	C1	4.50	CMM	QA		00064	SEE IGES DATA	339-E.RO 09-26-06			A *
3* (480)	B1	9.00	CMM	QA		00064	SEE IGES DATA	339-E.RO 09-26-06			A *
4* (500)	H6	Ø1.375-6UNC THRU OR Ø1.375-6UNC X ▽1.5 MIN FOR FLANGE THK GREATER THAN 1.5	THREAD PLUG GAGE	QA		A-375	ACCEPT	339-E.RO 09-26-06			A *
4* (510)	E6	14X Ø1.885 ± .003 THRU	CMM	QA		00064	1.882 TO 1.887	339-E.RO 09-26-06			A *
4* (520)	E6	14X ┌┐Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP	SCALE	QA		J-922	ACCEPT	339-E.RO 09-26-06			A *
4* (530)	E6	⊕.06 M A D 14 X Ø1.885	CMM	QA		00064	.026 TO .056	339-E.RO 09-26-06			A *
4* (540)	D6	10X Ø1.885 ± .003 THRU	CMM	QA		00064	1.882 TO 1.887	339-E.RO 09-26-06			A *
4* (550)	D6	10X ┌┐Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP	SCALE	QA		J-922	ACCEPT	339-E.RO 09-26-06			A *
4* (560)	D6	⊕.06 M A D 10 X Ø1.885	CMM	QA		00064	.030 TO .038	339-E.RO 09-26-06			A *
4*	C7	3X ┌┐Ø2.000 - 2.001 ▽ .990 - 1.000	DIAL BORE GAGE	QA		J-1401	1.9992 DIA. X .998	890-M.VI			R

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INSPECTION DATA CHECKLIST

(580)			DEPTH MICROMETE			P-5018	DEEP [N/C:20528]	09-26-06		*
4* (590)	C7	$\text{⌀} \begin{matrix} \text{.06} \\ \text{M} \\ \text{A} \\ \text{D} \end{matrix}$ 3X $\text{⌀}1.130$	CMM	QA		00064	.026 TO .042	339-E.RO 09-26-06		A *
4* (600)	D4	$\text{⌀}1.375\text{-}6\text{UNC}$ THRU OR $\text{⌀}1.375\text{-}6\text{UNC}$ X 1.5 MIN FOR FLANGE THK GREATER 1.5	THREAD PLUG GAGE	QA		A-375	ACCEPT	339-E.RO 09-26-06		A *
4* (610)	D4	$\text{⌀} \begin{matrix} \text{.06} \\ \text{M} \\ \text{A} \\ \text{D} \end{matrix}$ $\text{⌀}1.375\text{-}6\text{UNC}$	CMM	QA		00064	.028	339-E.RO 09-26-06		A *
4* (620)	E2	10X .25-20UNC-2B	THREAD PLUG GAGE	QA		A-726	ACCEPT	503-B.HO 09-26-06		A *
4* (630)	E2	$\text{⌀}0.03$ X 45° CHAMFER		QA		VISUAL	ACCEPT	503-B.HO 09-26-06		A *
5* (640)	F7	12X .25-20UNC-2B	THREAD PLUG GAGE	QA		A-726	ACCEPT	503-B.HO 09-26-06		A *
5* (650)	F7	$\text{⌀}0.03$ X 45° CHAMFER		QA		VISUAL	ACCEPT	503-B.HO 09-26-06		A *
5* (660)	G6	3X 1.0	CMM	QA		00064	1.0	339-E.RO 09-26-06		A *
5* (670)	G6	3X $\text{⌀}3.00$	CMM	QA		00064	3.00	339-E.RO 09-26-06		A *
5* (680)	G6	3X $\text{⌀}1.50$	CMM	QA		00064	1.51	339-E.RO 09-26-06		A *
5* (690)	E3	12X $\text{⌀}1.375\text{-}6\text{UNC}$ THRU OR $\text{⌀}1.375\text{-}6\text{UNC}$ X ∇ 1.5 MIN FOR FLANGE THK GREATER THAN 1.5	THREAD PLUG GAGE	QA		A-375	ACCEPT	339-E.RO 09-26-06		A *
5* (700)	E3	$\text{⌀} \begin{matrix} \text{.06} \\ \text{N} \\ \text{A} \\ \text{E} \end{matrix}$ 12X $\text{⌀}1.375\text{-}6$	CMM	QA		00064	.015 TO .055	339-E.RO 09-26-06		A *
5* (710)	D4	14X $\text{⌀}1.375\text{-}6\text{UNC}$ THRU OR $\text{⌀}1.375\text{-}6\text{UNC}$ X ∇ 1.5 MIN FOR FLANGE THK GREATER THAN 1.5	THREAD PLUG GAGE	QA		A-375	ACCEPT	339-E.RO 09-26-06		A *
5*	D4	$\text{⌀} \begin{matrix} \text{.06} \\ \text{N} \\ \text{A} \\ \text{E} \end{matrix}$	CMM	QA		00064	.013 TO .065	339-E.RO		A

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INSPECTION DATA CHECKLIST

(720)		14X Ø1.375-6					09-26-06		*
5* (730)	E3	3X Ø1.885 ±.003 THRU	CMM	QA	00064	1.884 TO 1.885	339-E.RO 09-26-06		A *
5* (740)	E3	3X \perp Ø3.00 SPOTFACE BACKSIDE MINIMUM CLEAN UP	SCALE	QA	J-922	ACCEPT	339-E.RO 09-26-06		A *
5* (750)	E3	\varnothing .06 N A E 3X Ø1.885	CMM	QA	00064	.031 TO .033	339-E.RO 09-26-06		A *
6* (760)	G7	5.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
6* (770)	H7	5.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
6* (780)	H6	5.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
6* (790)	C6	6.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
6* (800)	C6	5.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
6* (810)	F6	4X Ø1.00	CALIPER	QA	P-2056	1.005	503-B.HO 09-26-06		A *
6* (820)	F7	6.50	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
6* (830)	F6	2.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
6* (840)	H5	2X .88/1.13		QA	VISUAL	NOT MEASURED AT TH S OP	339-E.RO 09-26-06		A *
6* (850)	C5	2.250 ± .010		QA	VISUAL	NOT MEASURED AT TH S OP	339-E.RO 09-26-06		A *
6* (860)	F4	.06 - .09 × 45°		QA	VISUAL	ACCEPT	503-B.HO 09-26-06		A *
7* (870)	E6	CONFIRM THAT SCRIBE MARKS ARE PARALLEL AND PERPENDICULAR TO THE WINDING AXIS.		QA	VISUAL	NOT PAR. / PERP. [N /C:20528]	339-E.RO 09-26-06		R *

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INSPECTION DATA CHECKLIST

7* (880)	C4	2X 1.56	INDICATOR	QA	J-1387	1.76 TO 1.77 [N/C:2 0528]	339-E.RO 09-26-06		R *
7* (890)	C4	5.190	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
7* (900)	C3	6X .375-16UNC-2B TAP ∇ .75 .03 X 45° CHAMFER	THREAD PLUG GAGE	QA	A-52	ACCEPT	503-B.HO 09-26-06		A *
7* (910)	B3	3.75	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
7* (920)	B3	7.50	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
8* (930)	C5	4 X \varnothing 1.0 T H R U	CALIPER	QA	P-2056	1.005	503-B.HO 09-26-06		A *
9* (940)	C7	2X \varnothing .50 THRU	CALIPER	QA	P-2056	.498	503-B.HO 09-26-06		A *
9* (950)	F4	10.15	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
9* (960)	F4	1.63	CMM	QA	00064	SEE IGES DATA	339-E.RO 09-26-06		A *
9* (970)	D4	\varnothing .25 ∇ 5.0 \perp \varnothing .625 ∇ 3.0	CALIPER	QA	P-2056	.247/.630	503-B.HO 09-26-06		A *
9* (980)	E2	\varnothing .25 \perp \varnothing .625 DETAIL D	CALIPER	QA	P-2056	.247/.630	503-B.HO 09-26-06		A *
9* (990)	F2	4X \varnothing 1.0 THRU	CALIPER	QA	P-2056	1.005	503-B.HO 09-26-06		A *
11* (1000)	C5	$\frac{\Delta}{\square}$.02 A B C MACHINED SURFACES	CMM	QA	00064	-.026 TO .032 [N/C: 20528]	339-E.RO 09-26-06		R *
11* (1010)	E5	$\frac{\Delta}{\square}$.5 A B C AS CAST SURFACES	CMM	QA	00064	-.312 TO .494 [N/C: 20528]	339-E.RO 09-26-06		R *
11*	C8	$\frac{\Delta}{\square}$ -.12 -.25 A B C	CMM	QA	00064	-.698 TO .115 [N/C:	339-E.RO		R

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INSPECTION DATA CHECKLIST

(1020)		WING SURFACES				20528]	09-26-06]	*
11*	DI	+0.0 -.12 A B C	CMM	QA	00064	-.173 TO .124 [N/C: 20528]	339-E.RO 09-26-06	R *
(1030)		WING POCKET						

Workorder: 65708/1-0 Sub:1 Op:136

Revision: 06/14/06 6:55

Part: SE141-115 - MODULAR COIL, TYPE B -

Drawing ID: SE141-115 Rev: 8			INSPECTION INSTRUCTIONS				RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		D A T U M - E - S I D E	MASTER GAGE	QA		J-1165	ACCEPTABLE PER CUST OMER REQUIREMENTS	053-M.D			A
(10)		MAG PERMEABILITY TO BE NO GREATER THAN 1.02µ. CHECK 3 PLACES ADJACENT TO EVERY 5TH HOLE IN T SECTION.						09-14-06			*
*		D A T U M - D - S I D E	MASTER GAGE	QA		J-1165	ACCEPTABLE PER CUST OMER REQUIREMENTS	053-M.D			A
(20)		MAG PERMEABILITY TO BE NO GREATER THAN 1.02µ. CHECK 3 PLACES ADJACENT TO EVERY 5TH HOLE IN T SECTION.						09-14-06			*

Workorder: 65708/1-0 Sub:1 Op:140

Revision: 06/13/06 17:05

Part: SE141-115 - MODULAR COIL, TYPE B -

Drawing ID: SE141-102 Rev: 3			INSPECTION INSTRUCTIONS				RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		T E S T 1	MULTIMETER	QA		J-1358	.8 GOHMS	503-B.HO			A
(10)		RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE MID-PLANE POLOIDAL BREAK SHIM AND THE WINDING FORM.						09-18-06			*
*		T E S T 2	MULTIMETER	QA		J-1358	.7 GOHMS	503-B.HO			A
(20)		RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE JUMPERED BOLTS AND JUMPERED MID-PLANE CASTING AND WINDING FORM.						09-18-06			*

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INSPECTION DATA CHECKLIST

Workorder: 65708/1-0 Sub:1 Op:170

Revision: 09/25/06 6:19

Part: SE141-115 - MODULAR COIL, TYPE B -

Drawing ID: SE141-115 Rev: 8			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		NC20475 MAG PERMEABILITY TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	503-B.HO			A
(10)								09-25-06			*

Workorder: 65708/1-0 Sub:12 Op:30

Revision: 05/08/06 16:15

Part: SE141-139 - SHORT BEARING PLATE TYPE "B" -

Drawing ID: SE141-139 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	854-R.UP			A
(10)								07-09-06			*

Workorder: 65708/1-0 Sub:13 Op:30

Revision: 05/08/06 16:16

Part: SE141-140 - LONG BEARING PLATE TYPE "B" -

Drawing ID: SE141-140 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-1165	LESS THAN 1.02	854-R.UP			A
(10)								07-16-06			*

* 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.