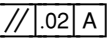
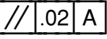
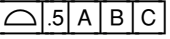


C2

Workorder: 65707/2-0 Sub:1 Op:134

Revision: 12/12/05 15:22

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

Drawing ID: SE141-116 Rev: 7			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1*	E8	47.19 ± .03	CMM	QA		00064	47.178 - 47.183	339-E.RO 12-07-05		A*
1*	G8	R17.00 +.25 -.00	CMM	QA		00064	17.035 - 17.070	339-E.RO 12-07-05		A*
1*	B8	47.19 ± .03	CMM	QA		00064	47.187 - 47.191	339-E.RO 12-07-05		A*
1*	D6	47.19 ± .03	CMM	QA		00064	47.192 - 47.195	339-E.RO 12-07-05		A*
1*	C6	47.19 ± .03	CMM	QA		00064	47.186 - 47.191	339-E.RO 12-07-05		A*
1*			CMM	QA		00064	.005	339-E.RO 12-07-05		A*
1*	B6		CMM	QA		00064	.006	339-E.RO 12-07-05		A*
1*	F3		CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-12-05		A*
2*	H6	2X R.187 +.025 -.005	INDICATOR	QA		J-651	.185 - .187	339-E.RO 12-07-05		A*
2*	G8	2X .03 X 45°		QA		VISUAL	ACCEPT	339-E.RO 12-12-05		A*
2*	G8	.40 ± .010	CALIPER	QA		J-707	0.40 - 0.41	339-E.RO 12-07-05		A*
2*	G8	2X .030 X 45°		QA		VISUAL	ACCEPT	339-E.RO 12-12-05		A*
2*	F7	2X .32	CALIPER	QA		J-707	.32 - .33	339-E.RO 12-07-05		A*
2*	F7	2X R.11	RADIUS GAGE	QA		R-25	.12	339-E.RO		A

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							12-07-05		*
2*	G6	 P TO M	CMM	QA	00064	REFERENCE IGES DATA	339-E.RO 12-12-05		R *
2*	G6	4.790 ± .005		QA	VISUAL	ACCEPT	339-E.RO 12-07-05		A *
2*	G3	 Q TO N	CMM	QA	00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
2*	G3	4.790 ± .005 RECORD NUMBER USED TO IDENTIFY POINT Q		QA	VISUAL	ACCEPT	339-E.RO 12-07-05		A *
2*	F5	 M TO N	CMM	QA	00064	REFERENCE IGES DATA	339-E.RO 12-12-05		R *
2*	F5	√125 RECORD SURFACE FINISH ON BOTH L SECTIONS OF THE T (SURFACE FINISH IS NOT ON DRAWING)	PROFILOMETER	QA	J-1152	25 - 125	339-E.RO 12-12-05		A *
2*	C5	  96X Ø.375-16 UNC .188 DEEP C'BORE Ø.625 AS SHOWN	CMM  THREAD PLUG GAGE	QA	00064  A-443	.077 POSITION / ACC EPT THREAD / .624 C BORE	339-E.RO 12-07-05		R *
2*	B4	2X .06 - .09 X 45°		QA	VISUAL	ACCEPT	339-E.RO 12-07-05		A *
3*	G7	 8X Ø1-8 UNC THRU	CMM	QA	00064	.038	339-E.RO 12-07-05		R *
3*	H3		CMM	QA	00064	0.020	339-E.RO 12-07-05		R *
3*	F3		CMM	QA	00064	0.016	339-E.RO 12-07-05		R *
3*	F5	R76.00	CMM	QA	00064	75.750 - 75.925	339-E.RO 12-07-05		R *
3*	E5	R73.70	CMM	QA	00064	73.723	339-E.RO 12-07-05		R *

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3*	E4	⊕ .01 A B C 8X Ø1.13 THRU BACK SPOT FACE Ø2.38 MIN DEPTH FOR C'UP	CMM  SCALE	QA	00064  J-922	.027 / 1.12 - 1.13 / ACCEPT SPOT	339-E.RO  12-07-05	R  *
4*	H8	⊕ .010 D A N 3X Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP	CMM  SCALE	QA	00064  J-922	.027 / 1.87 - 1.88 / ACCEPT CLEAN UP	339-E.RO  12-07-05	R  *
4	H7	3 X SPHERICAL R.750 +.002 / -.003 TOLERANCE CHANGE PER RFD 14-009 ITEM 5. DATUM -D- FLANGE.	CMM	QA	00064	.753 / .764 / .763	339-E.RO  12-12-05	R
4*	H7	⊕ Ø.01 D A N 3X SPH R.75 TO .75 DEEP	CMM DEPTH MICROMETE	QA	00064 J-1024	TP .020 / .74 DEEP	339-E.RO 12-12-05	R *
4*	H6	⊕ Ø.01 D A N 17X Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP	CMM	QA	00064	0.102 / 1.87 - 1.88 / 3.00 CLEAN UP	339-E.RO  12-07-05	R  *
4*	H5	⊕ Ø.01 D A N 3X Ø1.13 Ø2.38 BACK SPOTFACE MIN TO CLEANUP	CMM	QA	00064	0.041 / 1.12 - 1.13 / 3.2 CLEAN UP	339-E.RO  12-07-05	R  *
4*	E6	⊕ Ø.01 D A N 3X Ø1.375-6 UNC THRU	CMM THREAD PLUG GAGE	QA	00064 A-375	.038 / ACCEPT THREA DS	339-E.RO 12-07-05	R *
4*	E6	⊕ Ø.01 D A N 5X Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP	CMM  CALIPER	QA	00064  J-707	.0182 / 1.87 - 1.88 / 2.98 - 2.99	339-E.RO  12-07-05	R  *
4*	D4	⊕ Ø.01 D A N Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP	CMM  CALIPER	QA	00064  J-707	.0184 / 1.88 / 2.99	339-E.RO  12-07-05	R  *

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4*	B5	$\Phi$ .01 D A N 3X Ø1.13 Ø2.38 BACK SPOTFACE MIN TO CLEANUP	CMM  SCALE	QA	00064  J-922	.028 / 1.13 - 1.27 / 3.2 CLEAN UP	339-E.RO  12-07-05		R  *
5*	E8	$\Phi$ .01 E A J Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP	CMM	QA	00064	.015	339-E.RO  12-07-05		R  *
5*	F6	3X Ø1.375-6 UNC $\nabla$ 1.25	THREAD PLUG GAGE	QA	A-375	ACCEPT	339-E.RO 12-07-05		A *
5*	F6	3 X SPHERICAL R.750 +.002 / -.003 TOLERANCE CHANGE PER RFD 14-009 ITEM 5. DATUM -E- FLANGE.	CMM	QA	00064	.758 / .752 / .750	339-E.RO  12-12-05		A  *
5*	F6	$\Phi$ .01 E A J 3X SPH R.75 TO .75 DEEP	CMM	QA	00064	TP .0172	339-E.RO 12-12-05		R *
5*	F7	7X .25-20 UNC -2B	THREAD PLUG GAGE	QA	A-236	ACCEPT	339-E.RO 12-07-05		A *
5*	E7	$\Phi$ .01 E A J 24X Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP	CMM	QA	00064	.070 / 3.00 CLEANUP	339-E.RO  12-07-05		R  *
5*	E7	$\Phi$ .01 E A J 3X Ø1.5 TO 2.00 DEEP Ø3.00 TO 1.00 DEEP	CMM  CALIPER	QA	00064  J-707	.051 / 2.99 / 1.00 DEEP	339-E.RO  12-07-05		R  *
5*	D7	3X Ø1.88 THRU Ø3.00 BACK SPOTFACE MIN TO CLEANUP	CMM  CALIPER	QA	00064  J-707	1.879 - 1.881 / 3.0  0 CLEAN UP	339-E.RO  12-07-05		A  *
5*	G2	SPH R.75 TO .75 DEEP	CMM  DEPTH MICROMETE	QA	00064  J-1024	R .75 / .74 DEEP	339-E.RO  12-07-05		A  *

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7*	G2	R7.00	CMM	QA		00064	6.99	339-E.RO 12-07-05		A *
7*	F2	2X R1.50	CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
7*	E2	2.52 ± .010	CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
7*	E2	90°	CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
7*	E1	2.0°	CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
7*	E2	2.64 ± .010	CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
7*	E2	6.50 ± .010	CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
7*	E2	3.06 ± .010	CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
7*	D2	R4.00 ± .010	CMM	QA		00064	3.90	339-E.RO 12-12-05		R *
7*	D3	2.10 ± .010	CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
8*	G7	4.00 ± .010	CMM	QA		00064	3.97	339-E.RO 12-12-05		R *
8*	G7	R4.00 ± .010	CMM	QA		00064	3.98	339-E.RO 12-12-05		R *
8*	F7	2.00 ± .010	CMM	QA		00064	2.00	339-E.RO 12-07-05		A *
8*	E3	9.38 ± .010	CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
8*	E2	6.0°	CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
8*	C2	Ø8.00 ± .010	CMM	QA		00064	7.990-8.265 (0.275 OOR)	212-J.LE 12-07-05		R *

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8*	B3	5.9°	CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
8*	B3	7.81 ± .010	CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
8*	C6	7.25 ± .010	CMM	QA		00064	REFERENCE IGES DATA	339-E.RO 12-07-05		A *
8*	D7	6X Ø.375-16 UNC TO .75 DEEP .03 X 45° CHAMFER	THREAD PLUG GAGE	MFG		A-275	ACCEPT / 0.75 / .03	339-E.RO		A
			CALIPER			J-707	X 45	12-07-05		*
8*	D7	13.6 °	CMM	MFG		00064	13.20	339-E.RO 12-07-05		R *
8*	D7	5.88 ± .010		QA		VISUAL	PAD BLENDS INTO CAS T SUFACE	339-E.RO 12-12-05		R *
8*	D7	2.19 ± .010	CMM	QA		00064	2.1	339-E.RO 12-12-05		R *
8*	D7	2.19 ± .010	CMM	QA		00064	2.17	339-E.RO 12-12-05		R *
8*	B7	4X R.50	RADIUS GAGE	QA		R-25	BOTTOM RADII BLEND INTO CAST SURFACE	339-E.RO 12-12-05		R *
8*	B7	3.50 ± .010	CMM	QA		00064	ACCEPT	212-J.LE 12-07-05		A *
8*	B7	1.75 ± .010	CMM	QA		00064	ACCEPT	212-J.LE 12-07-05		A *
8*	C8	2X 1.56 ± .010 THRU	CALIPER	QA		J-707	1.558	212-J.LE 12-07-05		A *
8*	C8	3.75 ± .010	CMM	QA		00064	ACCEPT	212-J.LE 12-07-05		A *
8*	C8	2X 7.50 ± .010 THRU	CMM	QA		00064	ACCEPT	212-J.LE 12-07-05		A *
8*	C8	8X R.25	RADIUS GAGE	QA		R-25	0.260	212-J.LE 12-07-05		A *
8*	C8	2X 2.52 ± .010	CMM	QA		00064	ACCEPT	212-J.LE		A

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8*	E2	Ø8.00 ± .010	CALIPER	QA	J-707	7.980-8.265 0.075 O OR	212-J.LE 12-07-05			*
9*	E7	2.54 ± .010	CALIPER	QA	J-707	2.54	212-J.LE 12-07-05			A*
9*	E7	5.08 ± .010	CALIPER	QA	J-707	5.08	212-J.LE 12-07-05			A*
9*	F3	4X Ø1.0 THRU	CALIPER	QA	J-707	.999 - 1.004	212-J.LE 12-07-05			A*
9*	F3	2X Ø .50 ± .010 THRU	CALIPER	MFG	J-707	.500 - .502	321-C.LO 12-07-05			A*
9*	E3	2.44 ± .010	CALIPER	QA	J-707	2.450	212-J.LE 12-07-05			A*
9*	E3	1.22 ± .010	CALIPER	QA	J-707	1.22	212-J.LE 12-07-05			A*
9*	C7	4X Ø1.0 THRU	CALIPER	QA	J-707	1.003-1.016	339-E.RO 12-12-05			A*
9*	C6	2X Ø.25 T.C. HOLE TO 2.5 DEEP	CALIPER	QA	J-707	0.25	339-E.RO 12-12-05			A*
10*	C8		CMM	QA	00064	REFERENCE IGES DATA	339-E.RO 12-12-05			A*
10*	D6		CMM	QA	00064	REFERENCE IGES DATA	339-E.RO 12-12-05			R*
10*	C5		CMM	QA	00064	REFERENCE IGES DATA	339-E.RO 12-12-05			R*
10*	C4		CMM	QA	00064	REFERENCE IGES DATA	339-E.RO 12-12-05			A*
10*	G1		CMM	QA	00064	REFERENCE IGES DATA	339-E.RO 12-12-05			R*
10*	E1		CMM	QA	00064	REFERENCE IGES DATA	339-E.RO 12-12-05			R*
<b>Drawing ID: NCSX-CSPEC-141-03 Rev: 10</b>			<b>INSPECTION INSTRUCTIONS</b>			<b>RESULTS</b>		<b>INSPECTED BY</b>		

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SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
4*	3.1.1.4	UOS ALL MACHINED SURFACES TO BE 250 RMS SURFACE FINISH RECORD RANGE	PROFILOMETER	QA		J-1152	85 - 230	339-E.RO 12-07-05			A *
<b>Drawing ID: SE141-116 Rev: 7</b>			<b>INSPECTION INSTRUCTIONS</b>			<b>RESULTS</b>		<b>INSPECTED BY</b>			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1*		RECORD THE WEIGHT OF THE PART 6000LBS MAX		QA							*
4*	H7	22.13 ± .010	CMM	QA		00064	22.12	212-J.LE 12-07-05			A *
4*	H7	47.79 ± .010	CMM	QA		00064	47.776	212-J.LE 12-07-05			R *
4*	H6	59.18 ± .010	CMM	QA		00064	59.176	212-J.LE 12-07-05			A *
4*	H6	73.27 ± .010	CMM	QA		00064	73.265	212-J.LE 12-07-05			A *
4*	H5	80.49	CMM	QA		00064	80.469	212-J.LE 12-07-05			R *
4*	H5	87.87 ± .010	CMM	QA		00064	87.838	212-J.LE 12-07-05			R *
4*	H5	89.64 ± .010	CMM	QA		00064	89.584	339-E.RO 12-12-05			R *
4*	G4	31.83 ± .010	CMM	QA		00064	31.827	212-J.LE 12-07-05			A *
4*	F4	24.10 ± .010	CMM	QA		00064	24.097	212-J.LE 12-07-05			A *
4*	F4	11.48 ± .010	CMM	QA		00064	11.463	339-E.RO 12-12-05			R *
4*	E4	5.20 ± .010	CMM	QA		00064	5.201	212-J.LE 12-07-05			A *

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4*	D4	18.31 ± .010	CMM	QA		00064	18.307	212-J.LE 12-07-05		A *
4*	D4	32.50 ± .010	CMM	QA		00064	32.493	212-J.LE 12-07-05		A *
4*	C5	77.13 ± .010	CMM	QA		00064	77.128	212-J.LE 12-07-05		A *
4*	C6	55.56 ± .010	CMM	QA		00064	55.556	212-J.LE 12-07-05		A *
4*	B7	23.74 ± .010	CMM	QA		00064	23.742	212-J.LE 12-07-05		A *
4*	C7	37.09 ± .010	CMM	QA		00064	37.087	212-J.LE 12-07-05		A *
4*	D8	17.22 ± .010	CMM	QA		00064	17.220	212-J.LE 12-07-05		A *
4*	F8	28.17 ± .010	CMM	QA		00064	28.171	212-J.LE 12-07-05		A *
4*	G8	12X .250-20 UNC-2B	THREAD PLUG GAGE	QA		A-375	ACCEPT	212-J.LE 12-07-05		A *
4*	G8	40.75 ± .010	CMM	QA		00064	40.753	212-J.LE 12-07-05		A *
4*	G8	43.42 ± .010	CMM	QA		00064	43.422	212-J.LE 12-07-05		A *
4*	D1	12X .25-20 UNC Ø.5 X 82° INCL. CHAMFER	THREAD PLUG GAGE	QA		A-236	ACCEPT SEE STEP 125 0	212-J.LE 12-07-05		A *
5*	H8	88.39 ± .010	CMM	QA		00064	88.371	212-J.LE 12-07-05		R *
5*	H7	86.42 ± .010	CMM	QA		00064	86.422	212-J.LE 12-07-05		A *
5*	H6	59.08 ± .010	CMM	QA		00064	59.088	212-J.LE 12-07-05		A *
5*	H5	28.71 ± .010	CMM	QA		00064	28.721	212-J.LE		R

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								12-07-05		*
5*	G5	32.42 ± .010	CMM	QA		00064	32.424	212-J.LE 12-07-05		A *
5*	D4	22.117 ± .005	CMM	QA		00064	22.109	212-J.LE 12-07-05		R *
5*	D4	38.14 ± .010	CMM	QA		00064	38.152	212-J.LE 12-07-05		R *
5*	D5	21.33 ± .010	CMM	QA		00064	21.338	212-J.LE 12-07-05		A *
5*	D7	87.62 ± .010	CMM	QA		00064	87.617	212-J.LE 12-07-05		A *
5*	E8	7.53 ± .010	CMM	QA		00064	7.555	212-J.LE 12-07-05		R *
5*	E8	4.91 ± .010	CMM	QA		00064	4.879	212-J.LE 12-07-05		R *
5*	G8	36.13 ± .010	CMM	QA		00064	36.120	212-J.LE 12-07-05		A *
7*	D4	2.1°	CMM	QA		00064	ACCEPT	212-J.LE 12-07-05		A *
8*	D8	2.63 ± .010	CMM	QA		00064	ACCEPT	212-J.LE 12-07-05		A *

Employees: 212-J.Lehr / 321-C.Lonaker / 339-E.Root

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