

INSPECTION DATA CHECKLIST

Workorder: 65709/1-0 Sub:1 Op:120

Revision: 03/22/06 7:44

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	854-R.UP			A
(10)								05-31-06			*
*		<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	854-R.UP			A
(20)								05-31-06			*

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

Revision: 03/22/06 6:07

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*	D3	∅.001 - ∅.002 CHECK CLEARANCE OF ITEM 5 TO ITEM 6.		QA			.004 TO.005	242-M.G			R
(10)								05-25-06			*
*		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"		QA			.001	242-M.G			A
(15)								05-25-06			*
2*	F2	ENSURE THAT THE CUMULATIVE GAPS AT ANY SINGLE CROSS SECTION OF THE POLOIDAL FLANGE ELEMENTS IS LESS THAN .005".		QA			LESS THAN .002	242-M.G			A
(20)								05-25-06			*
*		THE MAX. GAP AT THE POLOIDAL		QA			LESS THAN .002	242-M.G			A

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(30)	BREAK PERIMETER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE.							06-01-06		*
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Workorder: 65709/1-0 Sub:1 Op:132



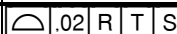


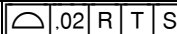
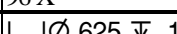
Revision: 05/31/06 10:28

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	
1* (10)	F3	NOTE 14 - BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.		QA			1 HOLE DID NOT CLEAN UP 100% (NC19933)	242-M.G 05-31-06			R *
1* (20)	E8	FLANGE PROFILE +/- .25 IN THIS AREA	CMM	QA		00064	.0104	339-E.RO 06-01-06			A *
1* (30)	D8	<input type="text" value="//.02 A"/>	CMM	QA		00064	.006	339-E.RO 05-31-06			A *
1* (40)	D8	54.20 ± .03	CMM	QA		00064	54.194	339-E.RO 05-31-06			A *
1* (50)	C8	54.20 ± .03	CMM	QA		00064	54.194	339-E.RO 05-31-06			A *
1* (60)	B8	<input type="text" value="//.02 A"/>	CMM	QA		00064	.006	339-E.RO 05-31-06			A *
1* (70)	D5	<input type="text" value="//.02 A"/>	CMM	QA		00064	.046	339-E.RO 05-31-06			R *
1* (80)	D5	48.50 ± .03	CMM	QA		00064	48.454	339-E.RO 05-31-06			R *
1* (90)	C5	48.50 ± .03	CMM	QA		00064	48.503	339-E.RO 05-31-06			A *
1* (100)	B5	<input type="text" value="//.02 A"/>	CMM	QA		00064	.003	339-E.RO 05-31-06			A *
1* (110)	D4	VERIFY PART MARKING: MAJOR TOOL SE141-114 A(casting number) (weight) LBS.		QA		VISUAL	ACCEPT	242-M.G 05-31-06			A *
1*	D4			QA		VISUAL	5280 LBS	242-M.G			A

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(120)		RECORD WEIGHT						05-31-06		*
1*	D3		CMM	QA	00064	-0.165 TO 0.288	339-E.RO			R
(130)		OUTER AS CAST SURFACES					05-31-06			*
2*	F8		CALIPER	QA	P-5075	.350 TO .420	533-B.CL			R
(140)		2 X .40					05-30-06			*
2*	F8		CALIPER	QA	P-5075	.010 TO .040	533-B.CL			R
(150)		4 X .03 X 45					05-30-06			*
2*	G6		PIN GAGE	QA	J-651-2	.184 TO .205	533-B.CL			A
(160)		2 X R.187 +.025 / -.005					05-30-06			*
2*	G5		CMM	QA	00064	POINTS NOT COLLECTE	339-E.RO			R
(170)		P TO M				D	05-31-06			*
2*	G5			QA	MTMFX-3473	5-10, 15 - 42, 84 - 94 OUT OF SPEC.	339-E.RO			R
(180)		DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473					06-01-06			*
2*	F5		CMM	QA	00064	-.0287 TO .268	339-E.RO			R
(190)		M TO M1					05-31-06			*
2*	E5		CMM	QA	00064	-.0223 TO .0294	339-E.RO			A
(200)		MI TO N1					05-31-06			*
2*	G3		CMM	QA	00064	POINTS NOT COLLECTE	339-E.RO			R
(210)		Q TO N				D	05-31-06			*
2*	F3			QA	MTMFX-3473	ACCEPT	339-E.RO			A
(220)		DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473					06-01-06			*
2*	F3		CMM	QA	00064	-.0297 TO .0321	339-E.RO			R
(230)		N TO N1					05-31-06			*
2*	B4		CALIPER	QA	P-5075	.030 TO .060	533-B.CL			R
(240)		2 X .06/.09 X 45					05-30-06			*
2*	B5	Ø .375-16 UNC ▽ .750 +.1 -0	THREAD PLUG GAGE	QA	100%	A-444	ACCEPT	242-M.G		A
(250)		96 X					05-31-06			*
2*	B5		CALIPER	QA	P-5075	.622 DEPT H .188 TO .310 (NC1 9783)	242-M.G			R
(260)							06-01-06			*

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INSPECTION DATA CHECKLIST

2* (270)	B5	Φ .06 R T S 375-16 HOLES	CMM	QA		00064	.002 TO .066	339-E.RO 05-31-06			R *
3* (280)	H3	\square .01 DATUM E FLANGE	CMM	QA		00064	.029	339-E.RO 05-31-06			R *
3* (285)	H4	\surd ¹²⁵ DATUM E FLANGE		QA		VISUAL	250	339-E.RO 06-01-06			R *
3* (290)	F2	\square .01 DATUM D FLANGE	CMM	QA		00064	.028	339-E.RO 05-31-06			R *
3* (295)	F3	\surd ¹²⁵ DATUM D FLANGE		QA		VISUAL	ACCEPT	339-E.RO 06-01-06			A *
3* (300)	E4	\varnothing 2.50 THRU	CALIPER	QA		P-5075	2.500	533-B.CL 05-31-06			A *
3* (310)	F4	Φ .060 A B C \varnothing 2.50	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
3* (320)	C7	8X \varnothing 1-8UNC ∇ 2	THREAD PLUG GAGE	QA		A-665	ACCEPT	533-B.CL 05-31-06			A *
3* (330)	C7	Φ .010 A B C 8X \varnothing 1-8 UNC	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
3* (340)	D5	8X \varnothing 1-8UNC THRU	THREAD PLUG GAGE	QA		A-665	ACCEPT	533-B.CL 05-31-06			A *
3* (350)	D5	\varnothing .010 A B C 8X \varnothing 1-8 UNC	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
3* (360)	D3	\varnothing 2.50 THRU	CALIPER	QA		P-5075	2.500	533-B.CL 05-31-06			A *
3* (370)	D3	Φ .060 A B C \varnothing 2.5	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
3* (380)	D1	40.90	CMM	QA		00064	SEE IGES DATA	339-E.RO 05-31-06			A *
4* (390)	H6	\square \varnothing 2.000-2.001 ∇ 0.990-1.000	DIAL BORE GAGE CALIPER			J-1401 P-5075	2.0000 TO 2.0002 DEPTH .991 T O .997	533-B.CL 05-30-06			A *
4* (400)	F4	\varnothing 1.375-6UNC THRU	THREAD PLUG GAGE	QA		A-375	ACCEPT	533-B.CL 05-31-06			A *
4* (400)	F4	Φ \varnothing .06 M A D	CMM	QA		00064	.062	339-E.RO			R

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INSPECTION DATA CHECKLIST

(410)		Ø1.375-6					05-31-06		*
4* (420)	D4 &	Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA	J-1400	1.884 TO 1.886	533-B.CL 05-31-06		A *
4* (430)	D4 &	Φ .06 M A D Ø1.885	CMM	QA	00064	.012 TO .060	339-E.RO 05-31-06		A *
4* (440)	B6	3X Ø1.5	CALIPER	QA	J-1103	1.500	533-B.CL 05-31-06		A *
4* (450)	B6	Φ .06 M A D 3X Ø1.5	CMM	QA	00064	.030 TO .040	339-E.RO 05-31-06		A *
4* (460)	A4	6X .25-20 UNC ∇ .5 .5 X 82° CHAMFER	THREAD PLUG GAGE	QA	A-235	ACCEPT	533-B.CL 05-30-06		A *
5* (470)	D8/D6	Ø1.885 ± .003	DIAL BORE GAGE	QA	J-1400	1.884 TO 1.886	533-B.CL 05-31-06		A *
5* (480)	D8/D6	Φ .06 N A E Ø1.885	CMM	QA	00064	.007 TO .076	339-E.RO 05-31-06		R *
5* (490)	F8	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA	A-375	ACCEPT	533-B.CL 05-31-06		A *
5* (500)	F8	Φ .06 N A E Ø1.375-6 UNC	CMM	QA	00064	.044	339-E.RO 05-31-06		A *
5* (510)	F6	8X 1/4 -20 UNC-2B	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 05-31-06		A *
5* (520)	D6	3X Ø1.5 ∇ 2.33	CALIPER	QA	J-1103	1.500 DEPTH 2.335 TO 2.340	533-B.CL 05-31-06		A *
5* (530)	D6	Φ .06 N A E 3X Ø1.5	CMM	QA	00064	.004 TO .034	339-E.RO 05-31-06		A *
5* (540)	B3	6X .25 - 20 UNC ∇ .6 Ø.5 X 82° CHAMFER	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 05-31-06		A *
6* (550)	H7	6.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
6* (560)	H7	1.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
6*	G8		CMM	QA	00064	SEE IGES DATA	339-E.RO		A

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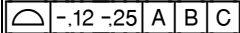
INSPECTION DATA CHECKLIST

(570)		6.70					05-31-06		*
6* (600)	F8	6.70	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
6* (610)	E7	5.75	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
6* (620)	E7	1.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
6* (630)	E6	4X Ø1.00	PIN GAGE	QA	J-921	.999	533-B.CL 05-30-06		A *
6* (640)	G5	2X .88 - 1.13	CALIPER	QA	J-1389	1.13 TO 1.14	533-B.CL 05-30-06		R *
6* (650)	F5	.06-.09 X 45° TYP	CALIPER	QA	P-5075	ACCEPT	533-B.CL 05-31-06		A *
7* (660)	G2	19.00	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
7* (670)	F2	2.00	CALIPER	QA	P-5075	2.001	533-B.CL 05-31-06		A *
7* (680)	F2	6.75	CMM	QA	00064	SEE IGES DATA	339-E.RO 05-31-06		A *
7* (690)	F2	3.75	CALIPER	QA	P-5075	3.752	533-B.CL 05-31-06		A *
7* (700)	F1	4X Ø.75-10 UNC ▽ 1.50	THREAD PLUG GAGE	QA	A-232	ACCEPT	533-B.CL 05-30-06		A *
7* (710)	D1	2X 1.56 OPEN THRU	CALIPER	QA	P-5075	1.558 TO 1.560	533-B.CL 05-30-06		A *
7* (720)	C1	.375-16 UNC-2B TAP ▽ .75 .03 X 45° CHAMFER 6X	THREAD PLUG GAGE	QA	A-52	ACCEPT	533-B.CL 05-30-06		A *
7* (730)	C4	VERIFY THAT HOLE LOCATIONS ARE SCRIBED ON THE PART.		QA	VISUAL	ACCEPT	533-B.CL 05-31-06		A *
7*	B3	8.50 DISTANCE BETWEEN SCRIBE	CALIPER	QA	P-5075	8.500	533-B.CL		A

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INSPECTION DATA CHECKLIST

(740)		MARKINGS.						05-31-06		*	
9* (750)	H1	2X Ø.50	CALIPER	QA		P-5075	.502	533-B.CL 05-31-06		A *	
9* (760)	B7	TC2 HOLE TO BE .625" IN DIAMETER APPROX. 2.52" DEEP AND .25" IN DIAMETER AT LEAST 1" DEEP.	CALIPER	QA		P-5075	.625 DEPTH 2.5 30	533-B.CL 05-31-06		A *	
* (770)		TC1 LOCATION AND CONFIGURATION MODIFIED. HOLE TO HAVE .625 CLEARANCE AND AT LEAST 1" OF DEPTH AT THE .25" DIA	CALIPER	QA		P-5075	.625	533-B.CL 05-31-06		A *	
10* (780)	F5	 INNER AS CAST SURFACES	CMM	QA		00064	-.321 TO .149	339-E.RO 05-31-06		R *	
10* (790)	D5	 WING SURFACES	CMM	QA		00064	.009 TO -.150	339-E.RO 05-31-06		R *	
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* (800)	3.1.1.4 ¹²⁵	THE TWO "L" MACHINED SURFACES OF TEE MUST HAVE A RMS OF 125.		QA		VISUAL	ACCEPT	533-B.CL 05-31-06		A *	

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

Revision: 03/22/06 7:50

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	
* (10)		<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	218 TO 225 MEGA OHM S	840-G.M 06-01-06		A *	
*		<u>T E S T 2</u>	MULTIMETER	QA		J-1358	280 TO 330 MEGA OHM	840-G.M		A	

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(20)	RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE JUMPERED BOLTS AND JUMPERED MID-PLANE CASTING AND WINDING FORM.					S				06-01-06	*
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Workorder: 65709/1-0 Sub:17 Op:50

Revision: 04/25/06 16:37

Part: REWORK - REWORK / REPAIR PER N/C - N/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	
*		N C 19709	MASTER GAGE	QA		J-1165	NO PERMEABILITY RES PONSE EQUAL TO OR G REATER THAN 1.02μ (ORSTEADS)	840-G.M			A
(10)		RECORD PERMEABILITY READINGS OF THE REPAIRED AREA. MAG PERMEABILITY TO BE NO GREATER THAN 1.02μ.						06-01-06			*

Workorder: 65709/1-0 Sub:18 Op:30

Revision: 05/08/06 9:52

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-1271	LESS THAN 1.02	261-T.DU			A
(10)								05-16-06			*

Workorder: 65709/1-0 Sub:19 Op:30

Revision: 05/08/06 9:51

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.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	503-B.HO			A

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(10)	RESULTS TO BE NO GREATER THAN 1.02μ.						05-18-06		*
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