

INSPECTION DATA CHECKLIST

Workorder: 65709/4-0 Sub:1 Op:130

Revision:

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* (10)	D3	Ø.001 - Ø.002 CHECK CLEARANCE OF ITEM 5 TO ITEM 6.	FEELER GAGES	MFG		J-1144	LESS THAN .002	825-B.JA 11-08-06			A *
* (15)		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"	FEELER GAGES	MFG		J-1144	LESS THAN .002	825-B.JA 11-08-06			A *
* (20)		ENSURE THAT THE CUMULATIVE GAPS AT ANY SINGLE CROSS SECTION OF THE POLOIDAL FLANGE ELEMENTS IS LESS THAN .005".	FEELER GAGES	MFG		J-1144	LESS THAN .005	825-B.JA 11-08-06			A *
* (30)		THE MAX. GAP AT THE POLOIDAL BREAK PERIMETER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE.	FEELER GAGES	MFG		J-1144	ACCEPT	825-B.JA 11-08-06			A *
1* (40)	F2	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLIE	MFG		J-1240	1500#S	825-B.JA 11-08-06			A *

Workorder: 65709/4-0 Sub:1 Op:132

Revision: 11/13/06 14:54

Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

Drawing ID: SE141-114 Rev: 8			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		MTMFX-3564	ACCEPT	533-B.CL 11-10-06			A *
1*	E8		CMM	QA		00064	.008 [N/C:20759-Doc	339-E.RO			R

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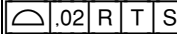

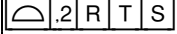
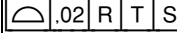
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INSPECTION DATA CHECKLIST

(20)		FLANGE PROFILE +0.0/-0.25 IN THIS AREA				:NC20759]	11-13-06		*
1* (30)	D8		CMM	QA	00064	.003	339-E.RO 11-13-06		A *
1* (40)	D8	54.20 ± .03	CMM	QA	00064	54.189	533-B.CL 11-10-06		A *
1* (50)	C8	54.20 ± .03	CMM	QA	00064	54.197	533-B.CL 11-10-06		A *
1* (60)	B8		CMM	QA	00064	.006	339-E.RO 11-13-06		A *
1* (70)	D5		CMM	QA	00064	.010	339-E.RO 11-13-06		A *
1* (80)	D5	48.50 ± .03	CMM	QA	00064	48.482	533-B.CL 11-10-06		A *
1* (90)	C5	48.50 ± .03	CMM	QA	00064	48.494	533-B.CL 11-10-06		A *
1* (100)	B5		CMM	QA	00064	.023 [N/C:20759-Doc :NC20759]	339-E.RO 11-13-06		R *
1* (110)	D4	VERIFY PART MARKING: MAJOR TOOL SE141-114 A(casting number) (weight) LBS.		QA		VISUAL ACCEPT	533-B.CL 11-10-06		A *
1* (120)	D4	RECORD WEIGHT		QA		VISUAL 5365	533-B.CL 11-10-06		A *
1* (130)	D3	 OUTER AS CAST SURFACES	CMM	QA	00064	-.0356 TO .3954 [N/ C:20759-Doc:NC20759]	339-E.RO 11-13-06		R *
2* (140)	F8	2 X .40	CALIPER	QA	J-707	E SIDE .40 TO .41 D SIDE .39 TO .41	533-B.CL 11-10-06		A *
2* (150)	F8	4 X .03 X 45	CALIPER	QA	J-707	.010 TO .060 [N/C:2 0759-Doc:NC20759]	533-B.CL 11-10-06		R *
2* (160)	G6	2 X R.187 +.025 / -.005	PIN GAGE	QA	J-652-1	.182 TO .212 BOTH S IDES	533-B.CL 11-10-06		A *

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2* (170)	G5	 P TO M	CMM	QA		00064	.0375 TO .1141 [N/C :20759-Doc:NC20759]	339-E.RO 11-13-06			R *
2* (180)	G5	DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	REJECTED LOC # 2-11 , 14-42, 75-77, 86- 95 [N/C:20759-Doc:N C20759]	533-B.CL 11-10-06			R *
2* (190)	F5	 M TO M1	CMM	QA		00064	-.0216 TO .0200 [N/ C:20759-Doc:NC20759]	339-E.RO 11-13-06			R *
2* (200)	E5	 M1 TO N1	CMM	QA		00064	-.0112 TO .0172	339-E.RO 11-13-06			A *
2* (210)	G3	 Q TO N	CMM	QA		00064	-.0196 TO .0879	339-E.RO 11-13-06			A *
2* (220)	F3	DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	REJECTED LOC# 47-55 , 79-81, 86-92 [N/C :20759-Doc:NC20759]	533-B.CL 11-10-06			R *
2* (230)	F3	 N TO N1	CMM	QA		00064	-.0164 TO .0265 [N/ C:20759-Doc:NC20759]	339-E.RO 11-13-06			R *
2* (240)	B4	2 X .06/.09 X 45		QA		VISUAL	ACCEPT	533-B.CL 11-10-06			A *
2* (250)	B5	Ø .375-16 UNC ▽ .750 +.1 -0 96 X	THREAD PLUG GAGE	QA	100%	A-275	ACCEPT	533-B.CL 11-10-06			A *
2* (250)	B5	└┘Ø.625 ▽ .188	CALIPER	QA		P-5075	.160 TO .201 REJEC T LOC # 35,37-43,45 ,49-52,55,60-70,73, 75,79,82,83,88-93 [N/C:20759-Doc:NC207	533-B.CL			R

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(260)						59]	11-10-06			*
2* (270)	B5	Φ .06 R T S 375-16 HOLES	CMM	QA	00064	.016 TO .081 [N/C:2 0759-Doc:NC20759]	339-E.RO 11-13-06			R *
3* (280)	H3	\square .01 DATUM E FLANGE	CMM	QA	00064	.028 [N/C:20759-Doc :NC20759]	339-E.RO 11-13-06			R *
3* (285)	H4	\surd ¹²⁵ DATUM E FLANGE	PROFILOMETER	QA	J-1152	22 TO 79	533-B.CL 11-10-06			A *
3* (290)	F2	\square .01 DATUM D FLANGE	CMM	QA	00064	.017 [N/C:20759-Doc :NC20759]	339-E.RO 11-13-06			R *
3* (295)	F3	\surd ¹²⁵ DATUM D FLANGE	PROFILOMETER	QA	J-1152	80 TO 136 [N/C:2075 9-Doc:NC20759]	533-B.CL 11-10-06			R *
3* (300)	E4	\varnothing 2.50 THRU	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
3* (310)	F4	Φ .060 A B C \varnothing 2.50	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
3* (320)	C7	8X \varnothing 1-8UNC ∇ 2	THREAD PLUG GAGE	QA	A-670	ACCEPT	533-B.CL 11-10-06			A *
3* (330)	C7	Φ .010 A B C 8X \varnothing 1-8 UNC	CMM	QA	00064	.012 TO .026 [N/C:2 0759-Doc:NC20759]	339-E.RO 11-13-06			R *
3* (340)	D5	8X \varnothing 1-8UNC THRU	THREAD PLUG GAGE	QA	A-670	ACCEPT	533-B.CL 11-10-06			A *
3* (350)	D5	\varnothing .010 A B C 8X \varnothing 1-8 UNC	CMM	QA	00064	.003 TO .068 [N/C:2 0759-Doc:NC20759]	339-E.RO 11-13-06			R *
3* (360)	D3	\varnothing 2.50 THRU	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
3* (370)	D3	Φ .060 A B C \varnothing 2.5	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
3* (380)	D1	40.90	CMM	QA	00064	SEE IGES DATA	339-E.RO 11-13-06			A *
4*	H6	\square \varnothing 2.000-2.001 ∇ 0.990-1.000	DIAL BORE GAGE		J-1401	1.9995 TO 1.9999 DEPTH .992 TO .994 [N/C:20759-Doc:NC20				R

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(390)						759]			*
4* (400)	F4	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA	A-375	ACCEPT	533-B.CL 11-13-06		A *
4* (410)	F4	Φ Ø.06 M A D Ø1.375-6	CMM	QA	00064	.007 TO .039	339-E.RO 11-13-06		A *
4* (420)	D4 &	Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA	J-1400	1.885 TO 1.8865	533-B.CL 11-10-06		A *
4* (430)	D4 &	Φ Ø.06 M A D Ø1.885	CMM	QA	00064	.002 TO .018	339-E.RO 11-13-06		A *
4* (440)	B6	3X Ø1.5	CALIPER	QA	J-1103	1.508 TO 1.510	533-B.CL 11-13-06		A *
4* (450)	B6	Φ .06 M A D 3X Ø1.5	CMM	QA	00064	.013 TO .024	339-E.RO 11-13-06		A *
4* (460)	A4	6X .25-20 UNC ▽ .5 .03" X 45° CHAMFER	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 11-10-06		A *
5* (470)	D8/D6	Ø1.885 ±.003	DIAL BORE GAGE	QA	J-1400	1.884 TO 1.8865	533-B.CL 11-10-06		A *
5* (480)	D8/D6	Φ Ø.06 N A E Ø1.885	CMM	QA	00064	.020 TO .034	339-E.RO 11-13-06		A *
5* (490)	F8	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA	A-375	ACCEPT	339-E.RO 11-13-06		A *
5* (500)	F8	Φ Ø.06 N A E Ø1.375-6 UNC	CMM	QA	00064	.007 TO .054	339-E.RO 11-13-06		A *
5* (510)	F6	8X 1/4 -20 UNC-2B	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 11-10-06		A *
5* (520)	D6	3X Ø1.5 ▽ 2.33	CALIPER CALIPER	QA	J-1103 J-1389	1.508 TO 1.509 DEP TH 2.325 TO 2.33	533-B.CL 11-13-06		A *
5* (530)	D6	Φ Ø.06 N A E 3X Ø1.5	CMM	QA	00064	.028 TO .040	339-E.RO 11-13-06		A *
5*	B3	6X .25 - 20 UNC ▽ .5 Ø.03" X 45° CHAMFER	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL		A

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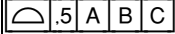
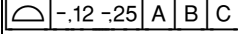
INSPECTION DATA CHECKLIST

(540)								11-10-06		*
6* (550)	H7	6.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (560)	H7	1.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (570)	G8	6.70		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (600)	F8	6.70		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (610)	E7	5.75		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (620)	E7	1.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
6* (630)	E6	4X Ø1.00	PIN GAGE	QA		J-921	.993 TO .996	533-B.CL 11-10-06		A *
6* (640)	G5	2X .88 - 1.13	CALIPER	QA		P-5075	1.110 TO 1.140 [N/C :20759-Doc:NC20759]	533-B.CL 11-10-06		R *
6* (650)	F5	.06-.09 X 45° TYP		QA		VISUAL	ACCEPT	533-B.CL 11-10-06		A *
7* (660)	G2	19.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
7* (670)	F2	2.00		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
7* (680)	F2	6.75		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
7* (690)	F2	3.75		QA		VISUAL	SEE IGES DATA	533-B.CL 11-10-06		A *
7* (700)	F1	4X Ø.75-10 UNC ▽ 1.50	THREAD PLUG GAGE	QA		A-167	ACCEPT	533-B.CL 11-10-06		A *
7* (710)	D1	2X 1.56 OPEN THRU	CALIPER	QA		J-707	1.55	533-B.CL 11-10-06		A *

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INSPECTION DATA CHECKLIST

7* (720)	C1	.375-16 UNC-2B TAP ∇ .75 .03 X 45° CHAMFER 6X	THREAD PLUG GAGE	QA		A-233	ACCEPT	533-B.CL	11-10-06	A *	
7* (730)	C4	VERIFY THAT HOLE LOCATIONS ARE SCRIBED ON THE PART.		QA		VISUAL	ACCEPT	533-B.CL	11-10-06	A *	
7* (740)	B3	8.50 DISTANCE BETWEEN SCRIBE MARKINGS.		QA		VISUAL	ACCEPT	533-B.CL	11-10-06	A *	
9* (750)	H1	2X \varnothing .50	PIN GAGE	QA		J-652-3	.501	533-B.CL	11-13-06	A *	
9* (760)	B7	TC2 HOLE TO BE .625" IN DIAMETER APPROX. 2.52" DEEP AND .25" IN DIAMETER AT LEAST 1" DEEP.	PIN GAGE CALIPER	QA		J-652-3 J-1389	\varnothing .625 DEPT 2.567 \varnothing .250 DEPTH 1.017	533-B.CL	11-13-06	A *	
* (770)		TC1 LOCATION AND CONFIGURATION MODIFIED. HOLE TO HAVE .625 CLEARANCE AND AT LEAST 1" OF DEPTH AT THE .25" DIA	PIN GAGE CALIPER	QA		J-652-3 J-1389	\varnothing .622 \varnothing .250 DE PTH 1.125	533-B.CL	11-13-06	A *	
10* (780)	F5	 INNER AS CAST SURFACES	CMM	QA		00064	-.3301 TO .3954 [N/ C:20759-Doc:NC20759]	339-E.RO	11-13-06	R *	
10* (790)	D5	 WING SURFACES	CMM	QA		00064	-.0005 TO -.1940, - .1387 TO -.1942 [N/ C:20759-Doc:NC20759]	339-E.RO	11-13-06	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.	PROFILOMETER	QA		J-1152	20 TO 100	533-B.CL	11-10-06	A *	

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Workorder: 65709/4-0 Sub:1 Op:136

Revision:

Part: SE141-114 - MODULAR COIL WINDING FORM TYPE-A - PRODUCTION MODULAR COIL WINDING FORM TYPE-A

Drawing ID: SE141-114 Rev: 8			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	503-B.HO			A
(10)								11-10-06			*
*		<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	503-B.HO			A
(20)								11-10-06			*

Workorder: 65709/4-0 Sub:1 Op:140

Revision:

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	
*		<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	2.2 GOHMS	503-B.HO			A
(10)								11-09-06			*
*		<u>T E S T 2</u> RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE JUMPERED BOLTS AND JUMPERED MID-PLANE CASTING AND WINDING FORM.	MULTIMETER	QA		J-1358	2.2 GOHMS	503-B.HO			A
(20)								11-09-06			*

Workorder: 65709/4-0 Sub:13 Op:30

Revision:

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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* (10)	G2	RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	503-B.HO 06-29-06			A *

Workorder: 65709/4-0 Sub:14 Op:30

Revision:

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* (10)	G2	RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	503-B.HO 07-19-06			A *

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