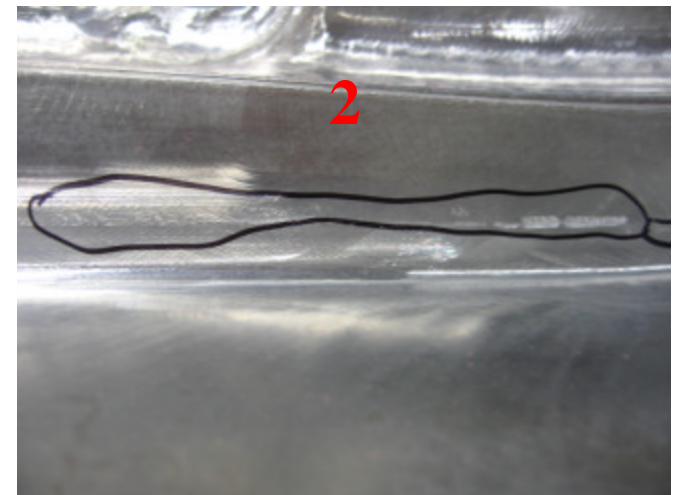
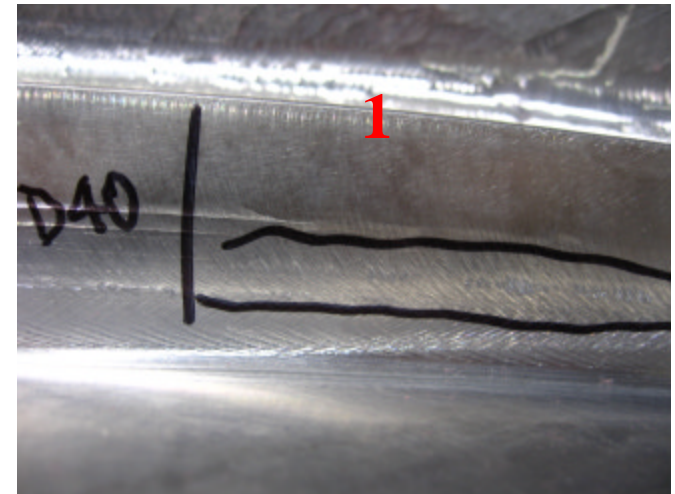
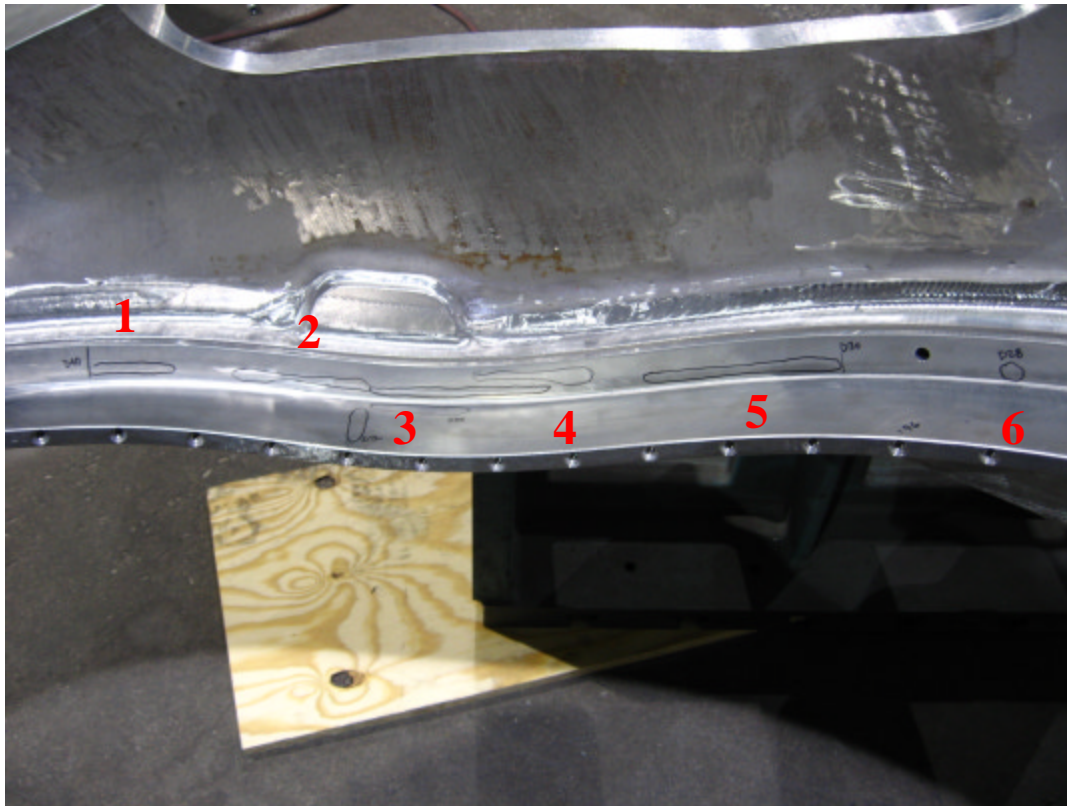
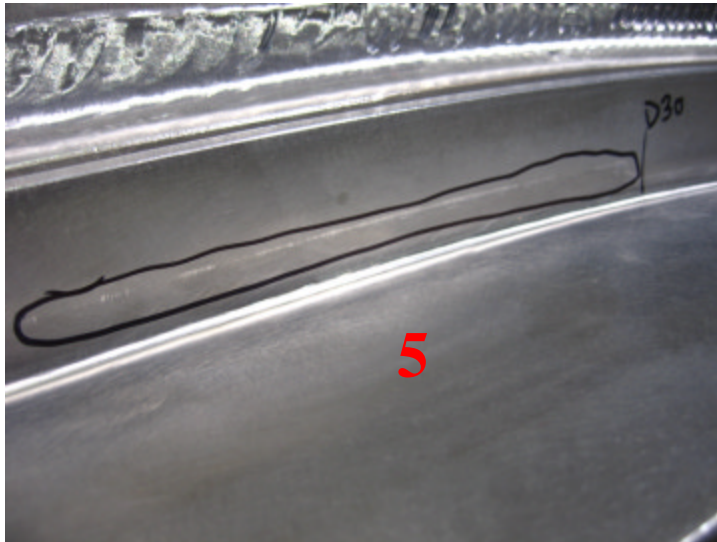
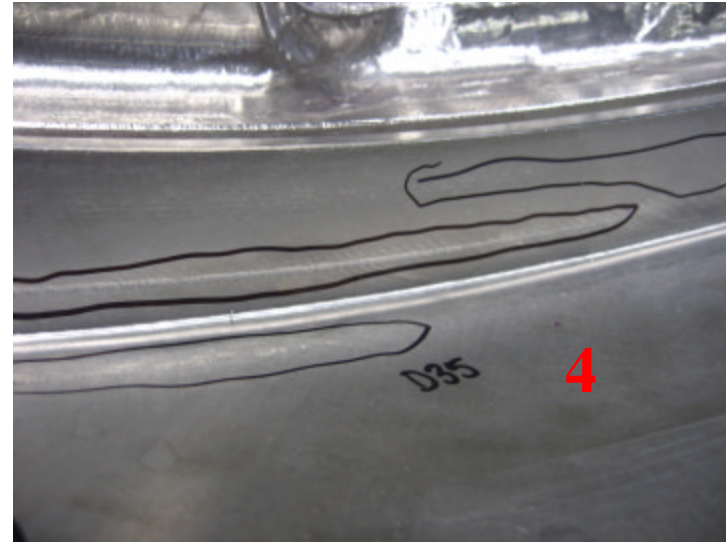
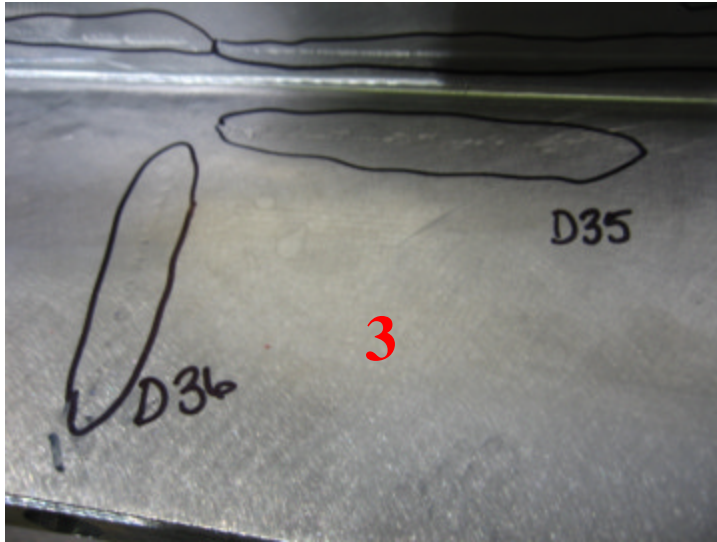
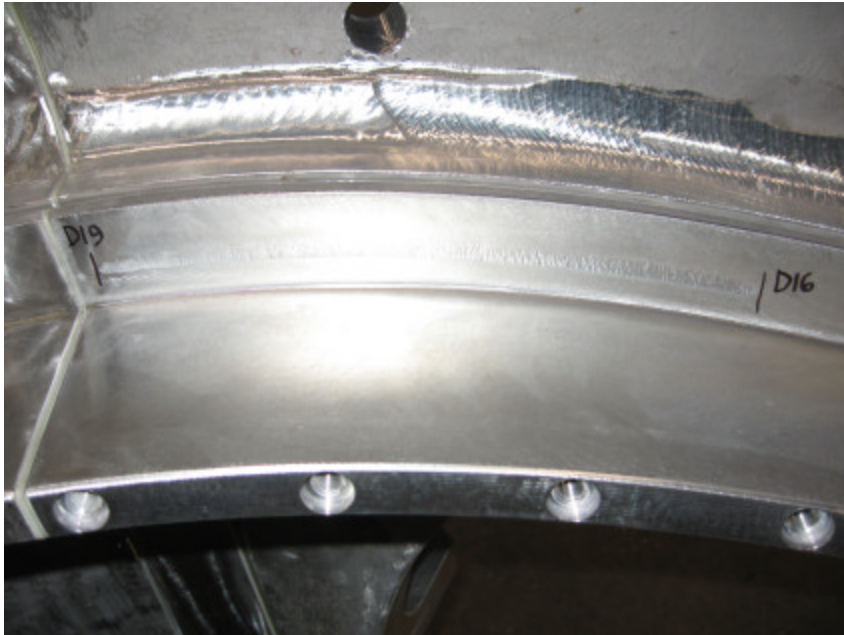




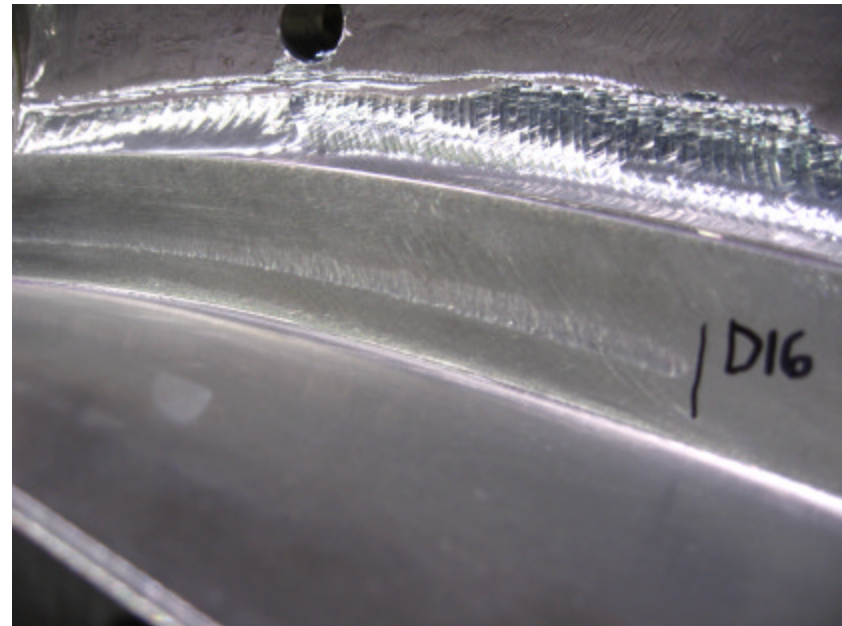
There are several shallow tool marks (<.010”) on the datum D side between T holes 28 and 40. These are shown on slides 1 and 2.





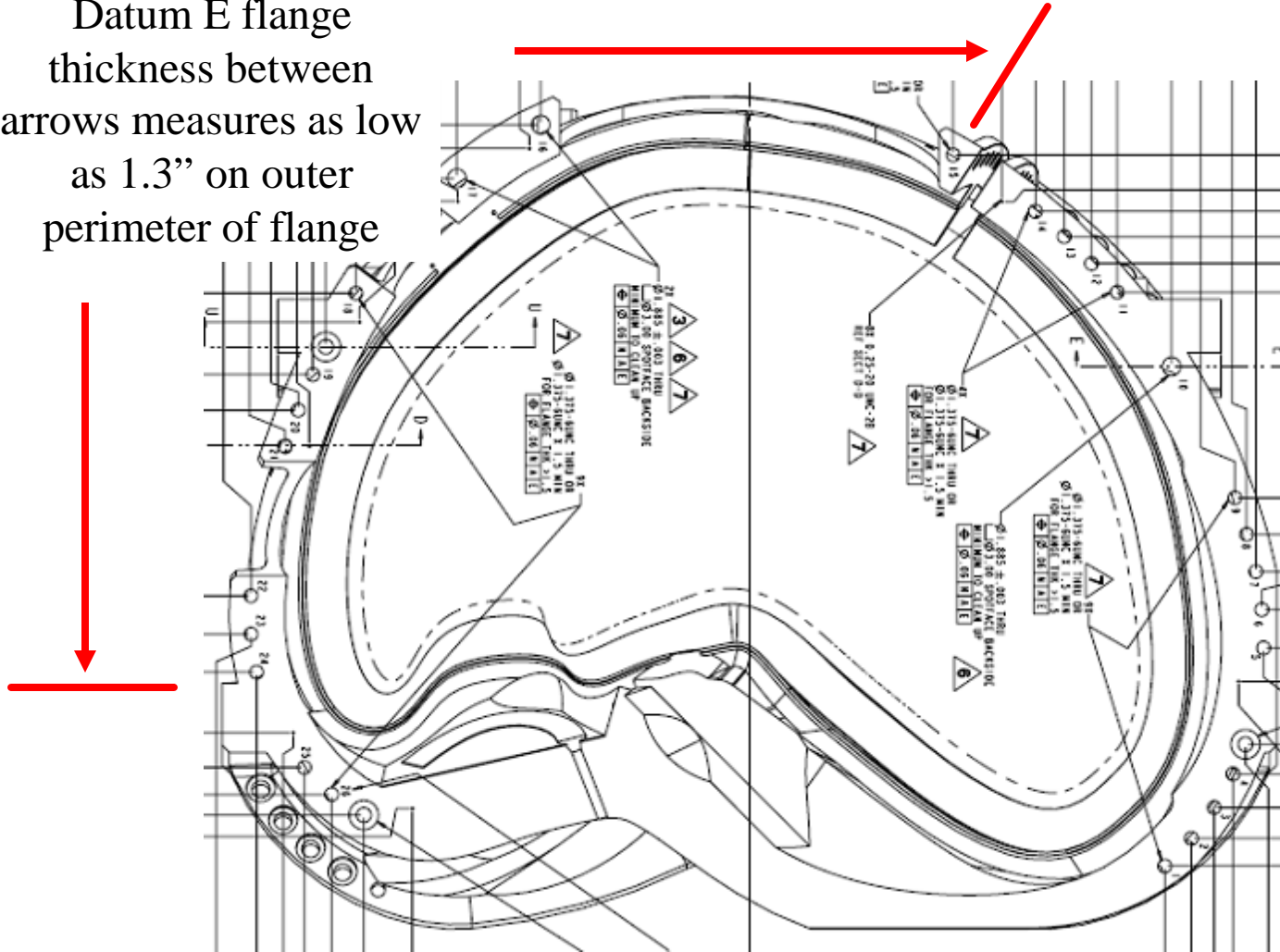


Shallow tool mark on D side short leg, between T holes D16 and D19.
Tool mark is $<.005$ " deep.





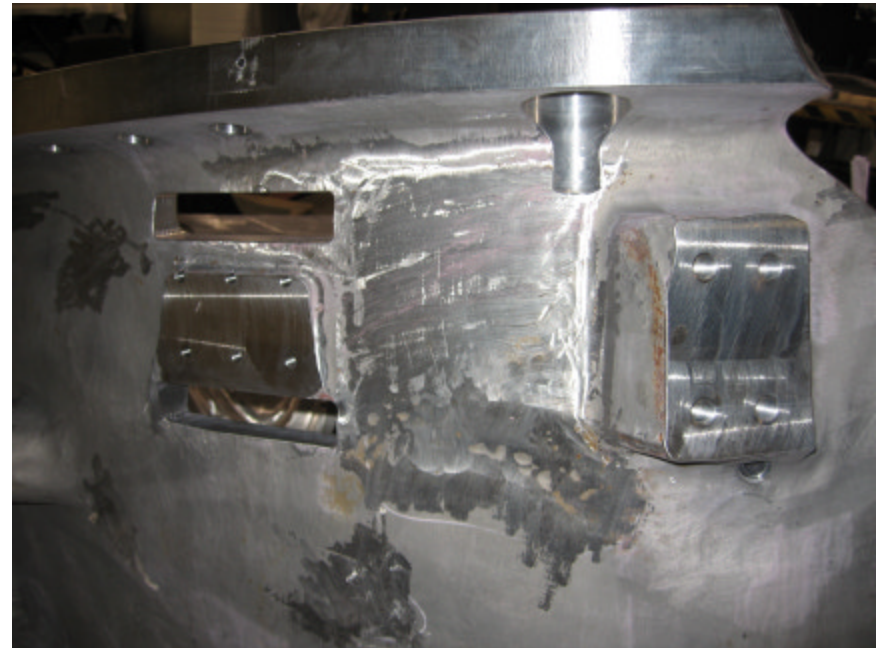
Datum E flange thickness between arrows measures as low as 1.3” on outer perimeter of flange

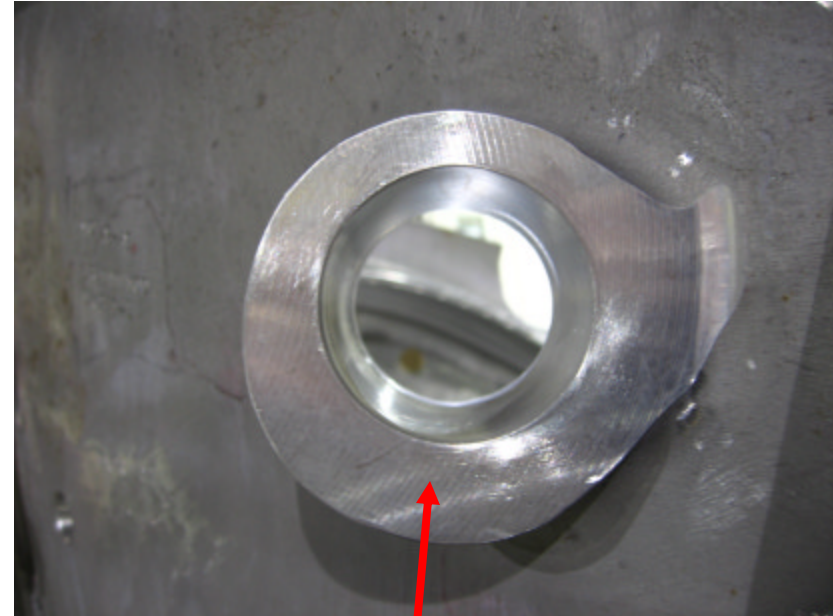




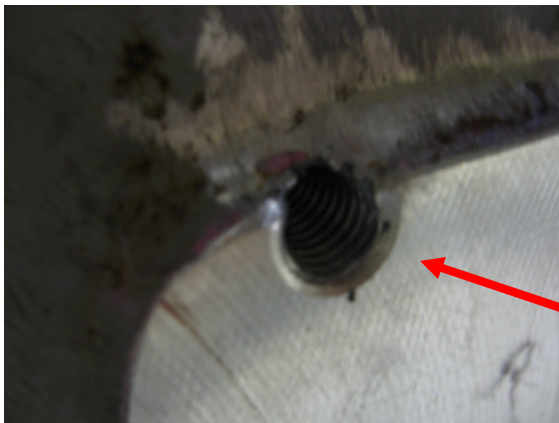
NC21265 – A5 Visual Review

It appears that the casting stock was not balanced as well as it could have been when the casting was qualified on the 1st roughing operation at MTM. A rotation of approximately .400" near the lead block area would have improved this condition. This resulted in a thicker flange on datum D and a thinner condition on datum E (as reported in previous slide). This also affected the lead pad and the cast stock around the 2.5" holes (see next slide).





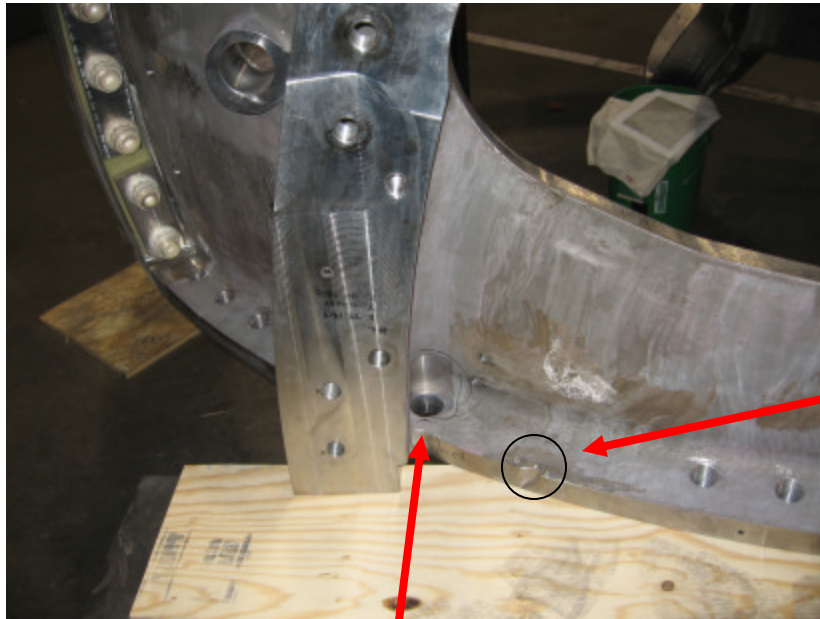
The picture above and the one in the previous slide show how the hole is shifted relative to the cast stock.



The 1st 2 ½ threads break out the edge of the hole. This hole (and the other five) checks good with a thread gage.



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Tool Gouge on perimeter of Datum E flange, approximately 1" wide by .50" deep.



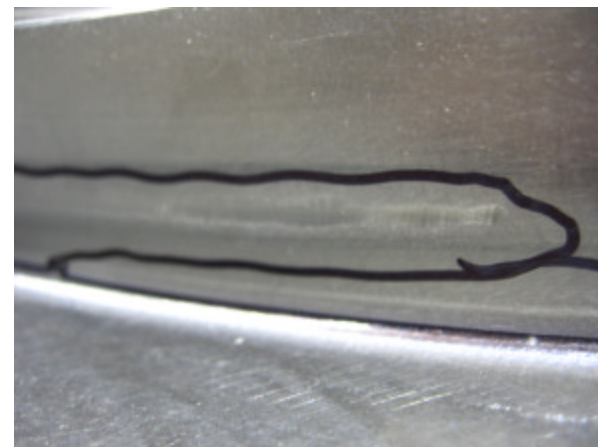
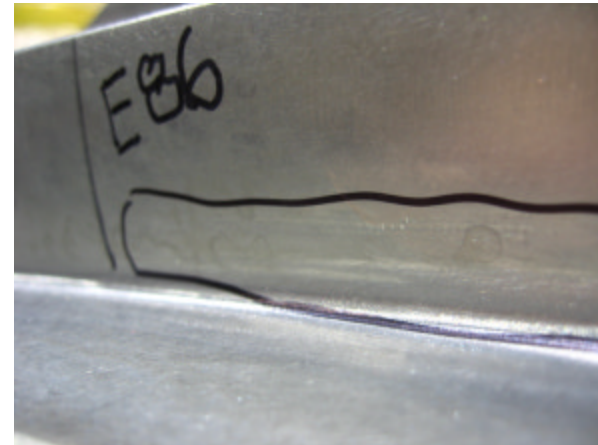
Picture to the left is of the 3" counterbore in the datum E flange as reported on NC21252 step 810. Area shows heavy stock around hole (too much to grind).





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Shallow tool marks on short leg of E side from T hole E86 to E1 thru E12. Marks are less than .005” but in too big of an area to try to blend out. Pictures to the right are close-up of the tool marks but even in the picture they are hard to see





Another area of tool marks between holes 78 and 81 on the E side short leg. Again, very shallow (<.005”).

