



INSPECTION DATA CHECKLIST

1458 E. 19th Street, Indianapolis, In 4621
TEL:(317)636-6433 FAX:(317)634-9420

B6

Workorder: 65708/6-0 Sub:1 Op:130

Revision: 05/18/07 13:28

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-1144	.000 -. 001	746 05-18-07			A *
* (15)		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"	FEELER GAGES	MFG		J-1144	ACCEPT	746 05-18-07			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	.004	746 05-18-07			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	746 05-18-07			A *
1* (40)	F3	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLIER TORQUE WRENCH	MFG		J-1086 J-512	ACCEPT	746 05-18-07			A *

Workorder: 65708/6-0 Sub:1 Op:132

Revision: 05/23/07 11:37

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	
1*	C3			QA		VISUAL	ACCEPT	242			A

* To Far Right Indicates Data Package Requirement

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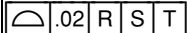


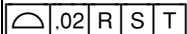
(10)		VERIFY PART MARKING: MAJOR TOOL SE141-115 B(casting number) (weight) LBS.						05-23-07	*
1* (20)	C3	RECORD FINAL PART WEIGHT		QA		VISUAL	5500	242 05-23-07	A *
1* (30)	F3	NOTE 14 BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.		QA		VISUAL	ACCPET	242 05-23-07	A *
1* (40)	E7	∕∕ .02 A	CMM	QA			00064 .0089	242 05-23-07	A *
1* (50)	E6	∕∕ .02 A	CMM	QA			00064 .011	242 05-23-07	A *
1* (60)	B6	∕∕ .02 A	CMM	QA			00064 .011	242 05-23-07	A *
1* (70)	B5	∕∕ .02 A	CMM	QA			00064 .0089	242 05-23-07	A *
1* (90)	D3	⌒ .5 A C B OUTER AS CAST SURFACES	CMM	QA			00064 -.082 TO .584 [N/C: 21872]	242 05-23-07	R *
2* (100)	G7	2X .03 X 45°	CALIPER	QA			J-707 ACCEPT	242 05-23-07	A *
2* (110)	G7	.40	CALIPER	QA			J-707 E SIDE .393 - .414 / D SIDE .395 - .48 7 [N/C:21872]	242 05-23-07	R *
2* (120)	G7	2X .03 X 45°		QA		VISUAL	ACCEPT	242 05-23-07	A *
2*	G8	*		QA			E SIDE HOLES 36-51,	242	R

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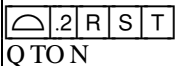
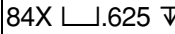
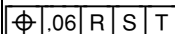
(130)		2X R.11				88-4 & D SIDE HOLES 3-5, 17-19, 41-46, 54-58 CHECKS .08" [N/C:21872]	05-23-07		*
2*	H7		CALIPER	QA	J-707	E SIDE .323 - .344 / D SIDE .270 - .34 0 [N/C:21872]	242		R
(140)		2X .31					05-23-07		*
2*	H6		CMM	QA	00064	-.023 TO .025 [N/C: 21872]	242		R
(150)		MACHINED SURFACES M TO M1					05-23-07		*
2*	F5			QA	MTMFX-3473	INTERFERENCE IN ARE A # 81 - 84, # 88 - 90 [N/C:21872]	242		R
(160)		DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473					05-23-07		*
2*	E6		CMM	QA	00064	.021 TO .140 [N/C:2 1872]	242		R
(170)		P TO M					05-23-07		*
2*	H4		CMM	QA	00064	-.005 TO .011	242		A
(180)		MACHINED SURFACES M1 TO N1					05-23-07		*
2*	G3		CMM	QA	00064	-.028 TO .018 [N/C: 21872]	242		R
(190)		MACHINED SURFACES N TO N1					05-23-07		*
2*	F3			QA	MTMFX-3473	INTERFERENCE AREAS #15 - 19, 33-45, 50	242		R

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(200)		DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473					-56 [N/C:21872]		05-23-07	*
2* (210)	F3		CMM	QA		00064	.013 TO .085	242	05-23-07	A*
2* (230)	C5	2X .06-.09 X 45°		QA		VISUAL	ACCEPT	242	05-23-07	A*
2* (240)	C4	84X .375-16 UNC ∇ .75	*THREAD PLUG GAGE	QA		A-444	ACCEPT	242	05-23-07	A*
2* (250)	C4	84X  ∇ .188	*CALIPER	QA		J-707	.620 - .625 / .183 - .192	242	05-23-07	A*
2* (260)	C4		CMM	QA		00064	UP TO .054"	242	05-23-07	A*
3* (270)	G7	9.00	CMM	QA		00064	REFER TO IGES	242	05-23-07	A*
3* (280)	G7	4.50	CMM	QA		00064	REFER TO IGES	242	05-23-07	A*
3* (290)	G6	3.00	CMM	QA		00064	REFER TO IGES	242	05-23-07	A*
3* (300)	F7	1.50	CMM	QA		00064	REFER TO IGES	242	05-23-07	A*
3* (310)	F7	4X \varnothing 1.0-8UNC ∇ 2.1	*THREAD PLUG GAGE CALIPER	QA		A-670 J-707	ACCEPT THREADS AND DEPTH	242	05-23-07	A*
3* (320)	G5	17.00 AT MOUNTING AREA	CMM	QA		00064	REFER TO IGES	242	05-23-07	A*
3* (330)	H2	$\sqrt[125]{}$ DATUM E	*PROFILOMETER	QA		J-1308	11 TO 38	242	05-23-07	A*

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3* (340)	G1	 DATUM E	CMM	QA		00064	.025 [N/C:21872]	242 05-23-07			R *
3* (350)	G3	.25± .01 DATUM E	CMM	QA		00064	0.264 - .239 [N/C:21872]	242 05-23-07			R *
3* (360)		 DATUM D	CMM	QA		00064	.018 [N/C:21872]	242 05-23-07			R *
3* (370)	E2	.25± .01 DATUM D	CMM	QA		00064	.227 [N/C:21872]	242 05-23-07			R *
3* (380)	E2	$\sqrt{125}$ DATUM D	*PROFILOMETER	QA		J-1308	16 TO 35	242 05-23-07			A *
3* (390)	F4	2X Ø2.50	CALIPER	QA		J-707	2.506 - 2.508	242 05-23-07			A *
3* (400)	F4	4X Ø1.0 -8UNC ∇ 2.5	*THREAD PLUG GAGE	QA		A-670	ACCEPT THREADS	242 05-23-07			A *
3* (410)	F4	1.72	CALIPER	QA		J-707	1.72	242 05-23-07			A *
3* (420)	D5	8X Ø1-8UNC ∇ 1.5	*THREAD PLUG GAGE	QA		A-666	ACCEPT	242 05-23-07			A *
3* (430)	B7	4X 1-8UNC ∇ 2.5	*THREAD PLUG GAGE	QA		A-375	ACCEPT	242 05-23-07			A *
3* (440)	C1	1.50	CMM	QA		00064	REFER TO IGES	242 05-23-07			A *
3* (450)	C1	3.00	CMM	QA		00064	REFER TO IGES	242 05-23-07			A *
3* (460)	C1	4X Ø 1-8UNC ∇ 2.1	*THREAD PLUG GAGE	QA		A-666	ACCEPT THREADS	242 05-23-07			A *
3* (470)	C1	4.50	CMM	QA		00064	REFER TO IGES	242 05-23-07			A *
3*	B1		CMM	QA		00064	REFER TO IGES	242			A

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(480)		9.00						05-23-07		*
4*	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	242		A
(500)								05-23-07		*
4*	E6	14X Ø1.885 ± .003 THRU	*CMM	QA		00064	1.885 - 1.887	242		A
(510)								05-23-07		*
4*	E6	14X └┘Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP		QA		MTMFX-3564	ACCEPT	242		
(520)								05-23-07		*
4*	E6	Φ .06 M A D 14 X Ø1.885	CMM	QA		00064	.010 TO .023	242		A
(530)								05-23-07		*
4*	D6	10X Ø1.885 ± .003 THRU	*CMM	QA		00064	1.885 - 1.887	242		A
(540)								05-23-07		*
4*	D6	10X └┘Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP		QA		MTMFX-3564	ACCEPT	242		A
(550)								05-23-07		*
4*	D6	Φ .06 M A D 10 X Ø1.885	CMM	QA		00064	.012 TO .043	242		A
(560)								05-23-07		*
4*	C7	3X └┘Ø2.000 - 2.001 √ .990 - 1.000	DIAL BORE GAGE	QA		J-1401	2.000 / 1.999	242		A
(580)								05-23-07		*
4*	C7	Φ .06 M A D 3X Ø1.130		QA			.041 TO .042	242		A
(590)								05-23-07		*
4*	D4	Ø1.375-6UNC THRU OR Ø1.375-6UNC X 1.5 MIN	*THREAD PLUG GAGE	QA		A-375	ACCEPT	242		A

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(600)		FOR FLANGE THK GREATER 1.5						05-23-07		*
4* (610)	D4	Φ .06 M A D Ø1.375-6UNC	CMM	QA		00064	.030	242 05-23-07		A *
4* (620)	E2	10X .25-20UNC-2B	THREAD PLUG GAGE	QA		A-729	ACCEPT	242 05-23-07		A *
4* (630)	E2	Ø.03 X 45° CHAMFER		QA		VISUAL	ACCEPT	242 05-23-07		A *
5* (640)	F7	12X .25-20UNC-2B	*THREAD PLUG GAGE	QA		A-729	ACCEPT	242 05-23-07		A *
5* (650)	F7	Ø.03 X 45° CHAMFER		QA		VISUAL	ACCEPT	242 05-23-07		A *
5* (660)	G6	3X 1.0	CALIPER	QA		J-707	.999 - 1.005	242 05-23-07		A *
5* (670)	G6	3X Ø3.00	CMM	QA		00064	2.99 - 3.0	242 05-23-07		A *
5* (680)	G6	3X Ø1.50	CALIPER	QA		J-707	1.496	242 05-23-07		A *
5* (690)	E3	12XØ1.375-6UNC THRU OR Ø1.375-6UNC X ∇ 1.5 MIN FOR FLANGE THK GREATER THAN 1.5	*THREAD PLUG GAGE	QA		A-375	ACCEPT	242 05-23-07		A *
5* (700)	E3	Φ .06 N A E 12X Ø1.375-6	CMM	QA		00064	.010 TO .031	242 05-23-07		A *
5* (710)	D4	14XØ1.375-6UNC THRU OR Ø1.375-6UNC X ∇ 1.5 MIN FOR FLANGE THK GREATER THAN 1.5	THREAD PLUG GAGE	QA		A-375	ACCEPT	242 05-23-07		A *
5* (720)	D4	Φ .06 N A E 14X Ø1.375-6	CMM	QA		00064	.006 TO .053	242 05-23-07		A *

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5* (730)	E3	3X Ø1.885 ±.003 THRU	CMM	QA		00064	1.882	242 05-23-07			A *
5* (740)	E3	3X L┘Ø3.00 SPOTFACE BACKSIDE MINIMUM CLEAN UP		QA		MTMZ-3564	ACCEPT	242 05-23-07			A *
5* (750)	E3	Φ.06 N A E 3X Ø1.885	CMM	QA		00064	.024 TO .025	242 05-23-07			A *
6* (760)	G7	5.00		QA			REFER TO IGES	242 05-23-07			A *
6* (770)	H7	5.00		QA			REFER TO IGES	242 05-23-07			A *
6* (780)	H6	5.00		QA			REFER TO IGES	242 05-23-07			A *
6* (790)	C6	6.00		QA			REFER TO IGES	242 05-23-07			A *
6* (800)	C6	5.00		QA			REFER TO IGES	242 05-23-07			A *
6* (810)	F6	4X Ø1.00	PIN GAGE	QA		J-921	.995	242 05-23-07			A *
6* (820)	F7	6.50	CMM	QA		00064	REFER TO IGES	242 05-23-07			A *
6* (830)	F6	2.00	CMM	QA		00064	REFER TO IGES	242 05-23-07			A *
6* (840)	H5	2X .88/1.13	CALIPER	QA		J-707	1.130	242 05-23-07			A *
6* (850)	C5	2.250 ± .010	CALIPER	QA		J-707	2.251	242 05-23-07			A *
6* (860)	F4	.06 - .09 × 45°	CALIPER	QA		J-707	ACCEPT	242 05-23-07			A *
7*	C4		CMM	QA		00064	REFER TO IGES	242			A *

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(880)		2X 1.56					05-23-07		
7* (890)	C4	5.190	CMM	QA	00064	REFER TO IGES	242 05-23-07		A *
7* (900)	C3	6X .375-16UNC-2B TAP ∇ .75 .03 X 45° CHAMFER	THREAD PLUG GAGE	QA	A-444	ACCEPT	242 05-23-07		A *
7* (910)	B3	3.75	CMM	QA	00064	REFER TO IGES	242 05-23-07		A *
7* (920)	B3	7.50	CMM	QA	00064	REFER TO IGES	242 05-23-07		A *
8* (930)	C5	<u>4 X \varnothing1.0 THRU</u>	PIN GAGE	QA	J-921	.995	242 05-23-07		A *
9* (940)	C7	2X \varnothing .50 THRU	CALIPER	QA	J-707	.501	242 05-23-07		A *
9* (950)	F4	10.15		QA		REFER TO IGES	242 05-23-07		A *
9* (960)	F4	1.63	CMM	QA	00064	REFER TO IGES	242 05-23-07		A *
9* (970)	D4	\varnothing .25 ∇ 5.0 \perp \varnothing .625 ∇ 3.0	CALIPER CALIPER	QA	J-707	.249 / 4.99 / .624 / 2.99	242 05-23-07		A *
9* (980)	E2	\varnothing .25 \perp \varnothing .625 DETAIL D	CALIPER	QA	J-707	.253 / .626	242 05-23-07		A *
9* (990)	F2	4X \varnothing 1.0 THRU	PIN GAGE	QA	J-921	.995	242 05-23-07		A *
11*	E5		CMM	QA	00064	OUTSIDE -.082 TO .5 85 / INSIDE -.159 T	242		R

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(1010)		AS CAST SURFACES					O .201 [N/C:21872]	05-23-07		*	
11*	C8	-0.12 -0.25 A B C	CMM	QA		00064	D WING -.093 TO -.3	242		R	
(1020)		WING SURFACES					05 [N/C:21872]	05-23-07		*	
11*	D1	+0.0 -0.12 A B C	CMM	QA		00064	-.04 TO -.1715 [N/C	242		R	
(1030)		WING POCKET					:21872]	05-23-07		*	
Drawing ID: ECN-5185 Rev: NONE			INSPECTION INSTRUCTIONS			RESULTS			INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
2*		VERIFY 9.00" +/- .05" CLEARANCE	SCALE	QA		J-922	9.0	242		A	
(1040)								05-23-07		*	
*		VERIFY CLEARANCE ABOVE SPOTFACE		QA		MTMFX3564	ACCEPT	242		A	
(1050)		3" DIAMTER CYLINDER 3" HIGH						05-23-07		*	
		1/4" BLEND IN RADIUS WERE	SCALE								
		APPLICABLE.									

Workorder: 65708/6-0 Sub:1 Op:136

Revision: 05/21/07 7:45

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	
*		D A T U M - E - S I D E	MASTER GAGE	QA		J-1270	LESS THAN 1.02	503		A	
(10)		MAG PERMEABILITY TO BE NO						05-21-07		*	
		GREATER THAN 1.02μ.									
		CHECK 3 PLACES ADJACENT TO									
		EVERY 5TH HOLE IN T SECTION.									
*		D A T U M - D - S I D E	MASTER GAGE	QA		J-1270	LESS THAN 1.02	503		A	
		MAG PERMEABILITY TO BE NO									
		GREATER THAN 1.02μ.									
		CHECK 3 PLACES ADJACENT TO									

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(20)	EVERY 5TH HOLE IN T SECTION.							05-21-07		
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Workorder: 65708/6-0 Sub:1 Op:140

Revision: 05/21/07 7:46

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

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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	110 M OHMS	503			A
(10)								05-21-07			*
*		<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	110 M OHMS	503			A
(20)								05-21-07			*

Workorder: 65708/6-0 Sub:11 Op:30

Revision:

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			A
(10)								07-09-06			*

Workorder: 65708/6-0 Sub:12 Op:30

Revision: 07/09/06 15:49

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

* 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.



Major

Tool & Machine, Inc.

INSPECTION DATA CHECKLIST

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Date: 05/23/07
User ID: GRIFFITH

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TEL:(317)636-6433 FAX:(317)634-9420

B6

1*	G2	RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	854			A
(10)								07-16-06			*

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