

**INSPECTION DATA CHECKLIST**

A5

Workorder: 65709/5-0 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*	D3	Ø.001 - Ø.002  CHECK CLEARANCE OF ITEM 5 TO ITEM 6.	FEELER GAGES	MFG		J-1144	LESS THAN .002 ( USED FEELER GAGE)	825-B.JA			A
(10)								02-24-07			*
*		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"	FEELER GAGES	MFG		J-1144	LESS THAN .002 ( USED FEELER GAGE)	825-B.JA			A
(15)								02-24-07			*
*		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 ( USED FEELER GAGE)	825-B.JA			A
(20)								02-24-07			*
*		THE MAX. GAP AT THE POLOIDAL BREAK PERIMETER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE.	FEELER GAGES	MFG		J-1144	LESS THAN .015 ( USED FEELER GAGE)	825-B.JA			A
(30)								02-24-07			*
1*	F2	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLIER  TORQUE WRENCH	MFG		J-1240  J-1040	1500LB	825-B.JA			A
(40)								02-24-07			*

Workorder: 65709/5-0 Sub:1 Op:132

Revision: 02/27/07 13:35

**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		
------------------------------	--	--	-------------------------	--	--	---------	--	--------------	--	--

\* 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.

### INSPECTION DATA CHECKLIST

A5

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		VISUAL	ACCEPT	242-M.G 02-27-07			A *
1* (20)	E8	FLANGE PROFILE +/- .25 IN THIS ARE A	CALIPER	QA		J-707	D IN TOLERANCE, E C HECKS UP TO +.019 [ N/C:21252-Doc:NC212 52]	242-M.G 02-27-07			R *
1* (30)	D8	<input type="text" value="//.02 A"/>	CMM	QA		00064	.003	242-M.G 02-27-07			A *
1* (40)	D8	54.20 ± .03	CMM	QA		00064	54.183	242-M.G 02-27-07			A *
1* (50)	C8	54.20 ± .03	CMM	QA		00064	54.186	242-M.G 02-27-07			A *
1* (60)	B8	<input type="text" value="//.02 A"/>	CMM	QA		00064	.002	242-M.G 02-27-07			A *
1* (70)	D5	<input type="text" value="//.02 A"/>	CMM	QA		00064	.006	242-M.G 02-27-07			A *
1* (80)	D5	48.50 ± .03	CMM	QA		00064	48.482	242-M.G 02-27-07			A *
1* (90)	C5	48.50 ± .03	CMM	QA		00064	48.478	242-M.G 02-27-07			A *
1* (100)	B5	<input type="text" value="//.02 A"/>	CMM	QA		00064	.004	242-M.G 02-27-07			A *
1* (110)	D4	VERIFY PART MARKING: MAJOR TOOL SE141-114 A(casting number) (weight) LBS.		QA		VISUAL	ACCEPT	242-M.G 02-27-07			A *
1*	D4			QA		VISUAL	5160	242-M.G			A

\* 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.

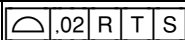
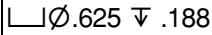



A5

(120)		RECORD WEIGHT					02-27-07		*
1*	D3		CMM	QA	00064	-.042 / .369 [N/C:2 1252-Doc:NC21252]	242-M.G		R
(130)		OUTER AS CAST SURFACES					02-27-07		*
2*	F8		CALIPER	QA	J-707	.39 - .40	242-M.G		A
(140)		2 X .40					02-27-07		*
2*	F8		CALIPER	QA	J-707	.015 - .030 [N/C:21 252-Doc:NC21252]	242-M.G		R
(150)		4 X .03 X 45					02-27-07		*
2*	G6		CALIPER	QA	J-707	ACCEPT	242-M.G		A
(160)		2 X R.187 +.025 / -.005					02-27-07		*
2*	F6		RADIUS GAGE	QA	R-25	ACCEPT	242-M.G		A
(165)		2X R.11					02-27-07		*
2*	G5		CMM	QA	00064	.023 / .131 [N/C:21 252-Doc:NC21252]	242-M.G		R
(170)		P T O M					02-27-07		*
2*	G5			QA	MTMFX-3473	REJECTED BETWEEN T HOLES: 5-9, 15-35, 40-41, 77, 88-93 [N /C:21252-Doc:NC2125 2]	242-M.G		R
(180)		DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473					02-27-07		*
2*	F5		CMM	QA	00064	-.0165 / .0198 [N/C :21252-Doc:NC21252]	242-M.G		R
(190)		M T O M I					02-27-07		*
2*	E5		CMM	QA	00064	-.012 / .016	242-M.G		A
(200)		M I T O N I					02-27-07		*
2*	G3		CMM	QA	00064	.0046 / .0943	242-M.G		A
(210)		Q T O N					02-27-07		*
2*	F3			QA	MTMFX-3473	REJECTED BETWEEN T	242-M.G		R

\* 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.

A5

(220)		DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473					HOLES: 48-51, 80-82 , 87-90 [N/C:21252- Doc:NC21252]	02-27-07	*
2* (230)	F3	 N TO N1	CMM	QA	00064		-.0186 / .0127 [N/C :21252-Doc:NC21252]	242-M.G 02-27-07	R *
2* (240)	B4	2 X .06/.09 X 45	CALIPER	QA	J-707		ACCEPT	242-M.G 02-27-07	A *
2* (250)	B5	Ø .375-16 UNC ▽ .750 + .1 -0 96 X	THREAD PLUG GAGE	QA	100%	A-151	ACCEPT	533-B.CL 02-26-07	A *
2* (260)	B5	 Ø.625 ▽ .188	CALIPER	QA		P-2056	.621 - .624 / .17 - .196 [N/C:21252-Doc :NC21252]	242-M.G 02-27-07	R *
2* (270)	B5	 .375-16 HOLES	CMM	QA	00064		.042 MAX	242-M.G 02-27-07	A *
3* (280)	H3	 DATUM E FLANGE	CMM	QA	00064		.0177 [N/C:21252-Do c:NC21252]	242-M.G 02-27-07	R *
3* (285)	H4	<sup>/125</sup> DATUM E FLANGE	PROFILOMETER	QA	J-1152		17-25	242-M.G 02-27-07	A *
3* (290)	F2	 DATUM D FLANGE	CMM	QA	00064		.017 [N/C:21252-Doc :NC21252]	242-M.G 02-27-07	R *
3* (295)	F3	<sup>/125</sup> DATUM D FLANGE	PROFILOMETER	QA	J-1152		28 TO 108	533-B.CL 02-26-07	A *
3* (300)	E4	Ø2.50 THRU	CALIPER	QA	J-707		2.514 [N/C:21252-Do c:NC21252]	242-M.G	R

\* 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.

A5

(300)							02-27-07		*
3* (310)	F4	$\Phi$ .060 A B C Ø2.50	CMM	QA	00064	SEE IGS	242-M.G 02-27-07		A *
3* (320)	C7	8X Ø1-8UNC ▽ 2	THREAD PLUG GAGE	QA	A-71	ACCEPT	242-M.G 02-27-07		A *
3* (330)	C7	$\Phi$ .010 A B C 8X Ø1-8 UNC	CMM	QA	00064	.046 MAX	242-M.G 02-27-07		R *
3* (340)	D5	8X Ø1-8UNC THRU	THREAD PLUG GAGE	QA	A-71	ACCEPT	242-M.G 02-27-07		A *
3* (350)	D5	$\Phi$ .010 A B C 8X Ø1-8 UNC	CMM	QA	00064	.046 MAX. [N/C:2125 2-Doc:NC21252]	242-M.G 02-27-07		R *
3* (360)	D3	Ø2.50 THRU	CALIPER	QA	J-707	2.512 [N/C:21252-Do c:NC21252]	242-M.G 02-27-07		R *
3* (370)	D3	$\Phi$ .060 A B C Ø2.5	CMM	QA	00064	SEE IGS	242-M.G 02-27-07		A *
3* (380)	D1	40.90	CMM	QA	00064	40.89-40.9	242-M.G 02-27-07		A *
4* (390)	H6	$\perp$ Ø2.000-2.001 ▽0.990-1 .000		QA		2.0008-2.0009	242-M.G 02-27-07		A *
4* (400)	F4	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA	A-375	ACCEPT	533-B.CL 02-26-07		A *
4* (410)	F4	$\Phi$ Ø.06 M A D Ø1.375-6	CMM	QA	00064	ALL DATUM D HOLES . 037 MAX	242-M.G 02-27-07		A *
4* (420)	D4 &	Ø1.885 ± .003 THRU	CALIPER	QA	J-707	1.508-1.510	242-M.G 02-27-07		A *
4* (430)	D4 &	$\Phi$ Ø.06 M A D Ø1.885	CMM	QA	00064	ALL DATUM D HOLES . 037 MAX	242-M.G 02-27-07		A *

\* 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.

A5

4* (440)	B6	3X Ø1.5	CALIPER	QA		J-1103	1.508-1.510	242-M.G 02-27-07			A *
4* (450)	B6	$\Phi$ .06 M A D 3X Ø1.5	CMM	QA		00064	ALL DATUM D HOLES . 037 MAX	242-M.G 02-27-07			A *
4* (460)	A4	6X .25-20 UNC ▽ .5 .5 X 82° CHAMFER	THREAD PLUG GAGE	QA		A-730	ACCEPT	533-B.CL 02-26-07			A *
5* (470)	D8/D6	Ø1.885 ±.003	CALIPER	QA		J-707	1.883-1.884	242-M.G 02-27-07			A *
5* (480)	D8/D6	$\Phi$ Ø.06 N A E Ø1.885	CMM	QA		00064	ALL DATUM E HOLES . 060" MAX.	242-M.G 02-27-07			A *
5* (490)	F8	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA		A-375	ACCEPT	242-M.G 02-27-07			A *
5* (500)	F8	$\Phi$ Ø.06 N A E Ø1.375-6 UNC	CMM	QA		00064	ALL DATUM E HOLES . 060" MAX.	242-M.G 02-27-07			A *
5* (510)	F6	8X 1/4 -20 UNC-2B	THREAD PLUG GAGE	QA		A-730	ACCEPT	242-M.G 02-27-07			A *
5* (520)	D6	3X Ø1.5 ▽ 2.33	CALIPER CALIPER	QA		J-65 J-1389	ACCEPT	242-M.G 02-27-07			A *
5* (530)	D6	$\Phi$ Ø.06 N A E 3X Ø1.5	CMM	QA		00064	ALL DATUM E HOLES . 060" MAX.	242-M.G 02-27-07			A *
5* (540)	B3	6X .25 - 20 UNC ▽ .6 Ø.5 X 82° CHAMFER	CALIPER THREAD PLUG GAGE	QA		J-707 A-730	ACCEPT	242-M.G 02-27-07			A *
6* (550)	H7	6.00	CMM	QA		00064	SEE IGS	242-M.G 02-27-07			A *
6* (560)	H7	1.00	CMM	QA		00064	SEE IGS	242-M.G 02-27-07			A *

\* 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.

INSPECTION DATA CHECKLIST


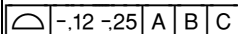
A5

6* (570)	G8	6.70	CMM	QA		00064	SEE IGS	242-M.G 02-27-07			A *
6* (600)	F8	6.70	CMM	QA		00064	SEE IGS	242-M.G 02-27-07			A *
6* (610)	E7	5.75	CMM	QA		00064	SEE IGS	242-M.G 02-27-07			A *
6* (620)	E7	1.00	CMM	QA		00064	SEE IGS	242-M.G 02-27-07			A *
6* (630)	E6	4X Ø1.00	CALIPER	QA		J-707	1.002	242-M.G 02-27-07			A *
6* (640)	G5	2X .88 - 1.13	CALIPER	QA		J-707	1.128	242-M.G 02-27-07			A *
6* (650)	F5	.06-.09 X 45° TYP	CALIPER	QA		J-707	ACCEPT	242-M.G 02-27-07			A *
7* (660)	G2	19.00	CMM	QA		00064	SEE IGS	242-M.G 02-27-07			A *
7* (670)	F2	2.00	CMM	QA		00064	SEE IGS	242-M.G 02-27-07			A *
7* (680)	F2	6.75	CMM	QA		00064	SEE IGS	242-M.G 02-27-07			A *
7* (690)	F2	3.75	CMM	QA		00064	SEE IGS	242-M.G 02-27-07			A *
7* (700)	F1	4X Ø.75-10 UNC ▽ 1.50	THREAD PLUG GAGE	QA		A-11	ACCEPT	242-M.G 02-27-07			A *
7* (710)	D1	2X 1.56 OPEN THRU	CALIPER	QA		J-1103	1.559	242-M.G 02-27-07			A *
7* (720)	C1	.375-16 UNC-2B TAP ▽ .75 .03 X 45° CHAMFER 6X	THREAD PLUG GAGE	QA		A-151	ACCEPT	242-M.G 02-27-07			A *
7*	C4	VERIFY THAT HOLE LOCATIONS ARE		QA		VISUAL	ACCEPT	242-M.G			A

\* 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.

A5

(730)		SCRIBED ON THE PART.						02-27-07		*
7*	B3	8.50 DISTANCE BETWEEN SCRIBE MARKINGS.	CALIPER	QA		J-1103	8.5	242-M.G		A
(740)								02-27-07		*
9*	H1	2X Ø.50	CALIPER	QA		P-2056	.505-.503	242-M.G		A
(750)								02-27-07		*
9*	B7	TC2 HOLE TO BE .625" IN DIAMETER APPROX. 2.52" DEEP AND .25" IN DIAMETER AT LEAST 1" DEEP.	CALIPER	QA		P-2056	.626-.627 / .250	242-M.G		A
(760)								02-27-07		*
*		TC1 LOCATION AND CONFIGURATION MODIFIED. HOLE TO HAVE .625 CLEARANCE AND AT LEAST 1" OF DEPTH AT THE .25"	CALIPER	QA		P-2056	.626-.627 / .250	242-M.G		A
(770)								02-27-07		*
10*	F5		CMM	QA		00064	E= -.289 / .068 D= -.382 / .067 [N/C:2 1252-Doc:NC21252]	242-M.G		R
(780)		INNER AS CAST SURFACES						02-27-07		*
10*	D5		CMM	QA		00064	E= -.206 / .005 D= -.186 / -.172 [N/C: 21252-Doc:NC21252]	242-M.G		R
(790)		WING SURFACES						02-27-07		*
<b>Drawing ID: NCSX-CSPEC-141-03 Rev: 11</b>			<b>INSPECTION INSTRUCTIONS</b>			<b>RESULTS</b>		<b>INSPECTED BY</b>		
<b>SHEET</b>	<b>ZONE</b>	<b>CHARACTERISTIC</b>	<b>GAGE/EQUIP</b>	<b>BY</b>	<b>SAMPLE</b>	<b>SER#</b>	<b>DATA/REMARKS</b>	<b>INSP</b>	<b>VERFD</b>	<b>AUDIT</b>
4*	3.1.1.4	<sup>125</sup> THE TWO "L" MACHINED SURFACES OF TEE MUST HAVE A RMS OF 125.	PROFILOMETER	QA		J-1152	17-63	242-M.G		A
(800)								02-27-07		*
<b>Drawing ID: ECN-5185 Rev: NONE</b>			<b>INSPECTION INSTRUCTIONS</b>			<b>RESULTS</b>		<b>INSPECTED BY</b>		
<b>SHEET</b>	<b>ZONE</b>	<b>CHARACTERISTIC</b>	<b>GAGE/EQUIP</b>	<b>BY</b>	<b>SAMPLE</b>	<b>SER#</b>	<b>DATA/REMARKS</b>	<b>INSP</b>	<b>VERFD</b>	<b>AUDIT</b>
*				QA		VISUAL	HOLE #10 IN DATUM E	242-M.G		R

\* 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.



A5

(810)	VERIFY CLEARANCE ABOVE SPOTFACE 3" DIAMTER CYLINDER 3" HIGH 1/4" BLEND IN RADIUS WERE APPLICABLE.					FLANGE WILL NOT ACC EPT GAGE [N/C:21252 -Doc:NC21252]		02-27-07	*
-------	--	--	--	--	--	---	--	----------	---

Workorder: 65709/5-0 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
(10)	*	<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-1270	LESS THAN 1.02	667-J.BA		A
								02-27-07		*
(20)	*	<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-1270	LESS THAN 1.02	667-J.BA		A
								02-27-07		*

Workorder: 65709/5-0 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
(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	110 MOHMS	503-B.HO		A
								02-27-07		*
	*	<u>T E S T 2</u>	MULTIMETER	QA		J-1358	110 MOHMS	503-B.HO		A

\* 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.

A5

(20)	RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE JUMPERED BOLTS AND JUMPERED MID-PLANE CASTING AND WINDING FORM.							02-27-07		*
------	--	--	--	--	--	--	--	----------	--	---

Workorder: 65709/5-0 Sub:12 Op:30

Revision:

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-1165	LESS THAN 1.02	503-B.HO		
(10)								06-29-06		A*

Workorder: 65709/5-0 Sub:13 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*	G2	RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	503-B.HO		
(10)								07-19-06		A*

\* 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.