

INSPECTION DATA CHECKLIST

Workorder: 65709/6-0 Sub:1 Op:132



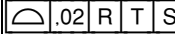
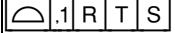

Revision: 03/23/07 12:37

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		VISUAL	ACC	667-J.BA 03-23-07			A *
1* (20)	E8	FLANGE PROFILE +/- .25 IN THIS ARE A	CALIPER	QA		J-707	SEE FLANGE PROFILE WORKSHEET [N/C:2148 3-Doc:NC21483]	667-J.BA 03-23-07			R *
1* (30)	D8	<input type="text" value="//.02 A"/>	CMM	QA		00064	.011	667-J.BA 03-23-07			A *
1* (40)	D8	54.20 ± .03	CMM	QA		00064	54.1943	667-J.BA 03-23-07			A *
1* (50)	C8	54.20 ± .03	CMM	QA		00064	54.2055	667-J.BA 03-23-07			A *
1* (60)	B8	<input type="text" value="//.02 A"/>	CMM	QA		00064	.002	667-J.BA 03-23-07			A *
1* (70)	D5	<input type="text" value="//.02 A"/>	CMM	QA		00064	.011	667-J.BA 03-23-07			A *
1* (80)	D5	48.50 ± .03	CMM	QA		00064	48.514	667-J.BA 03-23-07			A *
1* (90)	C5	48.50 ± .03	CMM	QA		00064	48.485	667-J.BA 03-23-07			A *
1* (100)	B5	<input type="text" value="//.02 A"/>	CMM	QA		00064	.013	667-J.BA 03-23-07			A *
1*	D4	VERIFY PART MARKING: MAJOR TOOL		QA		VISUAL	ACC	667-J.BA			A

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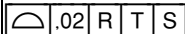
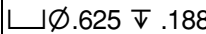



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(110)		SE141-114 A(casting number) (weight) LBS.						03-23-07	*
1* (120)	D4	RECORD WEIGHT		QA		VISUAL	5220	667-J.BA 03-23-07	A *
1* (130)	D3	 OUTER AS CAST SURFACES	CMM	QA		00064	-.044 TO .346 [N/C: 21483-Doc:NC21483]	242-M.G 03-23-07	R *
2* (140)	F8	2 X .40	CALIPER	QA		J-707	0.39-.40	667-J.BA 03-23-07	A *
2* (150)	F8	4 X .03 X 45	CALIPER	QA		J-707	ACCEPT	242-M.G 03-26-07	A *
2* (160)	G6	2 X R.187 +.025 / -.005	RADIUS GAGE	QA		R-25	ACCEPT	667-J.BA 03-23-07	A *
2* (165)	F6	2X R.11	RADIUS GAGE	QA		R-25	ACCEPT	242-M.G 03-23-07	A *
2* (170)	G5	 P TO M	CMM	QA		00064	.029 TO .119 [N/C:2 1483-Doc:NC21483]	242-M.G 03-23-07	R *
2* (180)	G5	DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	AREAS FROM T HOLES 84-94, 14-41, 5-10 REJECTED [N/C:21483 -Doc:NC21483]	242-M.G 03-23-07	R *
2* (190)	F5	 M TO M1	CMM	QA		00064	-.029 TO .018 [N/C: 21483-Doc:NC21483]	242-M.G 03-23-07	R *
2* (200)	E5	 MI TO N1	CMM	QA		00064	-.013 TO .013	242-M.G 03-23-07	A *
2* (210)	G3	 Q TO N	CMM	QA		00064	-.009 TO .086	242-M.G 03-23-07	A *

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INSPECTION DATA CHECKLIST

2*	F3			QA		MTM-3473	AREAS FROM T HOLES 84-90, 80, 47-53 RE JECTED [N/C:21483-D oc:NC21483]	242-M.G			R
(220)		DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473						03-23-07			*
2*	F3		CMM	QA		00064	-.018 TO .021 [N/C: 21483-Doc:NC21483]	242-M.G			R
(230)		N TO N1						03-23-07			*
2*	B4		CALIPER OD MICROMETER	QA		P-4432 P-4488	.060 X 45	667-J.BA 03-23-07			A
(240)		2 X .06/.09 X 45									*
2*	B5	Ø .375-16 UNC ▽ .750 + .1 -0 96 X	THREAD PLUG GAGE	QA	100%	A-444	ACC	667-J.BA 03-23-07			A
(250)											*
2*	B5	 Ø.625 ▽ .188	CALIPER	QA		J-707	DEPTH .177 - .206 & DIAMETER .617 - .61 9 [N/C:21483-Doc:NC 21483]	242-M.G			R
(260)								03-23-07			*
2*	B5		CMM	QA		00064	-.004 - .086 [N/C:2 1483-Doc:NC21483]	242-M.G			R
(270)		.375-16 HOLES						03-23-07			*
3*	H3		CMM	QA		00064	.0125 [N/C:21483-Do c:NC21483]	667-J.BA 03-23-07			R
(280)		DATUM E FLANGE									*
3*	H4	√ ¹²⁵	PROFILOMETER	QA		J-1152	50-100	667-J.BA 03-23-07			A
(285)		DATUM E FLANGE									*
3*	F2		CMM	QA		00064	.019 [N/C:21483-Doc :NC21483]	667-J.BA 03-23-07			R
(290)		DATUM D FLANGE									*
3*	F3	√ ¹²⁵	PROFILOMETER	QA		J-1152	50-70	667-J.BA			A

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(295)		DATUM D FLANGE					03-23-07		*
3* (300)	E4	Ø2.50 THRU	CALIPER	QA	P-4432	2.509	667-J.BA 03-23-07		A *
3* (310)	F4	Φ .060 A B C Ø2.50	CMM	QA	00064	SEE IGS	242-M.G 03-23-07		A *
3* (320)	C7	8X Ø1-8UNC ∇ 2	THREAD PLUG GAGE	QA	A-347	ACCEPT	242-M.G 03-23-07		A *
3* (330)	C7	Φ .010 A B C 8X Ø1-8 UNC	CMM	QA	00064	.011 - .077 [N/C:21 483-Doc:NC21483]	242-M.G 03-23-07		R *
3* (340)	D5	8X Ø1-8UNC THRU	THREAD PLUG GAGE	QA	A-347	ACCEPT [N/C:21483-D oc:NC21483]	242-M.G 03-23-07		R *
3* (350)	D5	Ø .010 A B C 8X Ø1-8 UNC	CMM	QA	00064	.011 - .077 [N/C:21 483-Doc:NC21483]	242-M.G 03-23-07		R *
3* (360)	D3	Ø2.50 THRU	CALIPER	QA	P-4432	2.509	667-J.BA 03-23-07		A *
3* (370)	D3	Φ .060 A B C Ø2.5	CMM	QA	00064	SEE IGS	242-M.G 03-23-07		A *
3* (380)	D1	40.90	CMM	QA	00064	40.912	667-J.BA 03-23-07		A *
4* (390)	H6	└┐Ø2.000-2.001 ∇0.990-1 .000	DEPTH MICROMETE DIAL BORE GAGE	QA	P-4472 J-1401	.997-.999 / 2.0008- 2.0013 [N/C:21483-D oc:NC21483]	242-M.G 03-23-07		R *
4* (400)	F4	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA	A-375	ACC	667-J.BA 03-23-07		A *
4* (410)	F4	Φ Ø.06 M A D Ø1.375-6	CMM	QA	00064	.0036 - .06	242-M.G 03-23-07		A *
4* (420)	D4 &	Ø1.885 ± .003 THRU	CMM	QA	00064	1.885-1.886	667-J.BA 03-23-07		A *

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INSPECTION DATA CHECKLIST

4* (430)	D4 &	Φ .06 M A D Ø1.885	CMM	QA		00064	.0038 - .06	242-M.G 03-23-07			A *
4* (440)	B6	3X Ø1.5	CMM	QA		00064	1.503-1.5159-1.521	667-J.BA 03-23-07			A *
4* (450)	B6	Φ .06 M A D 3X Ø1.5	CMM	QA		00064	.0038 - .06	242-M.G 03-23-07			A *
4* (460)	A4	6X .25-20 UNC ∇ .5 .030 X 45° CHAMFER	THREAD PLUG GAGE	QA		A-727	ACC	667-J.BA 03-23-07			A *
5* (470)	D8/D6	Ø1.885 ±.003	CMM	QA		00064	1.885-1.886	667-J.BA 03-23-07			A *
5* (480)	D8/D6	Φ .06 N A E Ø1.885	CMM	QA		00064	.011 - .065 [N/C:21 483-Doc:NC21483]	242-M.G 03-23-07			R *
5* (490)	F8	Ø1.375-6UNC THRU	THREAD PLUG GAGE	QA		A-375	ACC	667-J.BA 03-23-07			A *
5* (500)	F8	Φ .06 N A E Ø1.375-6 UNC	CMM	QA		00064	.011 - .065 [N/C:21 483-Doc:NC21483]	242-M.G 03-23-07			R *
5* (510)	F6	8X 1/4 -20 UNC-2B	THREAD PLUG GAGE	QA		A-727	ACC	667-J.BA 03-23-07			A *
5* (520)	D6	3X Ø1.5 ∇ 2.33	CALIPER	QA		P-1504	ACCEPT	242-M.G 03-23-07			A *
5* (530)	D6	Φ .06 N A E 3X Ø1.5	CMM	QA		00064	.011 - .065 [N/C:21 483-Doc:NC21483]	242-M.G 03-23-07			R *
5* (540)	B3	6X .25 - 20 UNC ∇ .5 .030 X 45° CHAMFER	THREAD PLUG GAGE	QA		A-727	ACC/ REJ CHAMFER .0 5 [N/C:21483-Doc:NC 21483]	667-J.BA 03-23-07			R *
6* (550)	H7	6.00		QA			SEE IGES	242-M.G 03-23-07			A *

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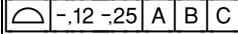
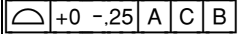
INSPECTION DATA CHECKLIST

6* (560)	H7	1.00		QA			SEE IGES	242-M.G 03-23-07			A *
6* (570)	G8	6.70		QA			SEE IGES	242-M.G 03-23-07			A *
6* (600)	F8	6.70		QA			SEE IGES	242-M.G 03-23-07			A *
6* (610)	E7	5.75		QA			SEE IGES	242-M.G 03-23-07			A *
6* (620)	E7	1.00		QA			SEE IGES	242-M.G 03-23-07			A *
6* (630)	E6	4X Ø1.00	CALIPER	QA		P-4432	1.005	667-J.BA 03-23-07			A *
6* (640)	G5	2X .88 - 1.13		QA		VISUAL	ACC	667-J.BA 03-23-07			A *
6* (650)	F5	.06-.09 X 45° TYP	CALIPER	QA		P-1504	ACCEPT	242-M.G 03-23-07			A *
7* (660)	G2	19.00		QA			SEE IGES	242-M.G 03-23-07			A *
7* (670)	F2	2.00		QA			SEE IGES	242-M.G 03-23-07			A *
7* (680)	F2	6.75		QA			SEE IGES	242-M.G 03-23-07			A *
7* (690)	F2	3.75		QA			SEE IGES	242-M.G 03-23-07			A *
7* (700)	F1	4X Ø.75-10 UNC ▽ 1.50	THREAD PLUG GAGE	QA		A-68	ACC	667-J.BA 03-23-07			A *
7* (710)	D1	2X 1.56 OPEN THRU	CALIPER	QA		J-707	1.56	667-J.BA 03-23-07			A *
7* (720)	C1	.375-16 UNC-2B TAP ▽ .75 .03 X 45° CHAMFER 6X	THREAD PLUG GAGE	QA		A-447	ACC	667-J.BA 03-23-07			A *

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INSPECTION DATA CHECKLIST

7* (730)	C4	VERIFY THAT HOLE LOCATIONS ARE SCRIBED ON THE PART.	CALIPER	QA	VISUAL	ACC	667-J.BA 03-23-07			A *
7* (740)	B3	8.50 DISTANCE BETWEEN SCRIBE MARKINGS.	CALIPER	QA	P-4587	8.5	667-J.BA 03-23-07			A *
9* (750)	H1	2X Ø.50	CALIPER	QA	P-4432	.510-.515	667-J.BA 03-23-07			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-4432	ACC	667-J.BA 03-23-07			A *
* (770)		TC1 LOCATION AND CONFIGURATION MODIFIED. HOLE TO HAVE .625 CLEARANCE AND AT LEAST 1" OF DEPTH AT THE .25"	CALIPER	QA	P-4432	ACC	667-J.BA 03-23-07			A *
10* (780)	F5	 INNER AS CAST SURFACES	CMM	QA	00064	-.365 TO .17 [N/C:2 1483-Doc:NC21483]	242-M.G 03-23-07			R *
10* (790)	D5	 WING SURFACES	CMM	QA	00064	-.17 TO -.20	242-M.G 03-23-07			A *
10* (795)	E5	 WING POCKET SURFACES	CMM	QA	00064	.265 TO -.48 [N/C:2 1483-Doc:NC21483]	242-M.G 03-23-07			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	32-80	667-J.BA 03-23-07		A *
Drawing ID: ECN-5185 Rev: NONE			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT

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INSPECTION DATA CHECKLIST

* (810)		VERIFY CLEARANCE ABOVE SPOTFACE 3" DIAMTER CYLINDER 3" HIGH 1/4" BLEND IN RADIUS WERE APPLICABLE.		QA		MTMFX-3564	ACC	667-J.BA 03-23-07		A *
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Employees: 242-M.Griffith / 667-J.Bannister

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