



**INSPECTION DATA CHECKLIST**

Quality Assurance Documentation for Part ID: REWORK - Item: 8

Workorder: 65708/2-0 Sub:15 Op:40

Part: REWORK - REWORK / REPAIR PER N/C - N/C # \_\_\_\_\_

Drawing ID: SE141-115 Rev: 9		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		NC 20449 PERMEABILITY OF WELD TO BE LESS THAN 1.02μ.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	854-R.UP		
(10)								10-04-06		

A

**INSPECTION DATA CHECKLIST**

Quality Assurance Documentation for Part ID: SE141-102 - Item: 11

Workorder: 65708/2-0 Sub:1 Op:140
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Part: SE141-102 - 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	
*		<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 G KOHMS	503-B.HO			A
(10)								10-23-06			
*		<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	2.2G KOHMS	503-B.HO			A
(20)								10-23-06			

**INSPECTION DATA CHECKLIST**

Quality Assurance Documentation for Part ID: SE141-115 - Item: 18

Workorder: 65708/2-0 Sub:1 Op:130
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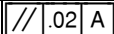
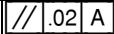
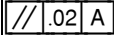
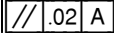

Part: SE141-115 - MODULAR COIL, TYPE B -

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.		MFG			LESS THAN .002	825-B.JA 10-19-06			A
* (15)		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"		MFG			LESS THAN .002	825-B.JA 10-19-06			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	.005	771-B.SC 10-25-06			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	.013	771-B.SC 10-25-06			A
1* (40)	F3	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLIE	MFG		J-1240	1500	825-B.JA 10-19-06			A




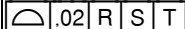

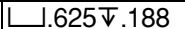
Quality Assurance Documentation for Part ID: SE141-115 - Item: 19

Workorder: 65708/2-0 Sub:1 Op:132

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* (10)	C3	VERIFY PART MARKING: MAJOR TOOL SE141-115 B(casting number) (weight) LBS.		QA		VISUAL	ACCEPT	533-B.CL  10-26-06			A
1* (20)	C3	RECORD FINAL PART WEIGHT		QA		VISUAL	5540	533-B.CL 10-26-06			A
1* (30)	F3	NOTE 14 BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.		QA		MTMFX-3564	ACCEPT	533-B.CL  10-25-06			A
1* (40)	E7		CMM	QA		00064	.0089	533-B.CL 10-25-06			A
1* (50)	E6		CMM	QA		00064	.0105	533-B.CL 10-25-06			A
1* (60)	B6		CMM	QA		00064	.027 [N/C:20676]	533-B.CL 10-25-06			R
1* (70)	B5		CMM	QA		00064	.007	533-B.CL 10-25-06			A
1* (90)	D3	 OUTER AS CAST SURFACES	CMM	QA		00064	-.0129 TO .306 [N/C :20676]	533-B.CL 10-26-06			R
2* (100)	G7	2X .03 X 45°		QA		VISUAL	ACCEPT	533-B.CL 10-25-06			A
2* (110)	G7	.40	CALIPER	QA		J-707	.390 TO .400	533-B.CL 10-25-06			A
2* (120)	G7	2X .03 X 45°		QA		VISUAL	ACCEPT	533-B.CL 10-25-06			A
2*	G8		RADIUS GAGE	QA		R-21	.110 TO .120 E SI DE HOLE#BREAK TO 7 18-25 38-43 48-57 59-64 73-84 ARE .25	533-B.CL			R

### INSPECTION DATA CHECKLIST

(130)		2X R.11				OR [N/C:20676]	10-25-06		
2*	H7		CALIPER	QA	J-707	.305 TO .317	533-B.CL		A
(140)		2X .31					10-25-06		
2*	H6		CMM	QA	00064	-.0178 TO .0251 [N/C:20676]	533-B.CL		R
(150)		MACHINED SURFACES M TO M1					10-26-06		
2*	F5			QA	MTMFX-3473	ACCEPT IN ALL AREAS EXCEPT BETWEEN HOLE #83-84 AND 88-94 [N/C:20676]	533-B.CL		R
(160)		DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473					10-25-06		
2*	E6		CMM	QA	00064	-.0316 TO .1214 [N/C:20676]	533-B.CL		R
(170)		P TO M					10-26-06		
2*	H4		CMM	QA	00064	-.0322 TO .0315	533-B.CL		A
(180)		MACHINED SURFACES M1 TO N1					10-26-06		
2*	G3			QA		-.0282 TO .0265 [N/C:20676]	533-B.CL		R
(190)		MACHINED SURFACES N TO N1					10-26-06		
2*	F3			QA	MTMFX-3473	ACCEPT IN ALL AREAS EXCEPT BETWEEN HOLE #30-46 49-56 & 82-84 [N/C:20676]	533-B.CL		R
(200)		DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473					10-25-06		
2*	F3		CMM	QA	00064	.022 TO .1179 [N/C:20676]	533-B.CL		R
(210)		Q TO N					10-26-06		
2*	D6			QA	VISUAL	NO COUNTERBORE ON PART DUE TO REV CHANGE	533-B.CL		A
(220)		HOLE 63 THRU 73					10-25-06		
2*	C5	2X .06-.09 X 45°		QA	VISUAL	ACCEPT	533-B.CL		A
(230)							10-25-06		
2*	C4	84X .375-16 UNC $\nabla$ .75	THREAD PLUG GAGE	QA	A-233	ALL THREADS ARE GOOD EXCEPT 1 HOLE IS REJECTED HOLE #91 IS TAPPED AT AN ANGLE	533-B.CL		R

### INSPECTION DATA CHECKLIST

(240)			DEPTH MICROMETE			J-1024	[N/C:20676]	10-26-06		
2*	C4	84X $\perp$ .625 $\nabla$ .188	CALIPER	QA		J-707	.156 TO .190 44 HOLES ARE UNDERSIZE D ON DEPTH [N/C:206	533-B.CL		R
(250)			DEPTH MICROMETE			J-1062	76]	10-25-06		
2*	C4	$\varnothing$ .06 R S T	CMM	QA		00064	.003 TO .144 [N/C:2	533-B.CL		R
(260)							0676]	10-26-06		
3*	G7			QA		VISUAL	SEE IGES DATA	533-B.CL		A
(270)		9.00						10-25-06		
3*	G7			QA		VISUAL	SEE IGES DATA	533-B.CL		A
(280)		4.50						10-25-06		
3*	G6			QA		VISUAL	SEE IGES DATA	533-B.CL		A
(290)		3.00						10-25-06		
3*	F7			QA		VISUAL	SEE IGES DATA	533-B.CL		A
(300)		1.50						10-25-06		
3*	F7	4X $\varnothing$ 1.0-8UNC $\nabla$ 2.1	THREAD PLUG GAGE	QA		A-670	ACCEPT	533-B.CL		A
(310)								10-25-06		
3*	G5			QA		VISUAL	SEE IGES DATA	533-B.CL		A
(320)		17.00 AT MOUNTING AREA						10-25-06		
3*	H2	$\sqrt{R}$ DATUM E	PROFILOMETER	QA		J-1152	11 TO 62	533-B.CL		A
(330)								10-25-06		
3*	G1	$\square$ .01 DATUM E	CMM	QA		00064	.045 [N/C:20676]	533-B.CL		R
(340)								10-26-06		
3*	G3	.25 $\pm$ .01 DATUM E	CMM	QA		00064	.250	533-B.CL		A
(350)								10-26-06		
3*		$\square$ .01 DATUM D	CMM	QA		00064	.032 [N/C:20676]	533-B.CL		R
(360)								10-26-06		
3*	E2	.25 $\pm$ .01 DATUM D	CMM	QA		00064	.250	533-B.CL		A
(370)								10-26-06		
3*	E2	$\sqrt{R}$ DATUM D	PROFILOMETER	QA		J-1152	18 TO 47 TWO SPO TS HAVE CIRCULAR TO OL DAMAGE	533-B.CL		A
(380)								10-26-06		
3*	F4	2X $\varnothing$ 2.50	CALIPER	QA		J-707	2.510	533-B.CL		A
(390)								10-25-06		
3*	F4	4X $\varnothing$ 1.0 -8UNC $\nabla$ 2.5	THREAD PLUG GAGE	QA		A-185	ACCEPT	533-B.CL		A
(400)								10-26-06		

### INSPECTION DATA CHECKLIST

3* (410)	F4	1.72	CALIPER	QA		J-707	1.710	533-B.CL 10-25-06			A
3* (420)	D5	8X Ø1-8UNC ▽ 1.5	THREAD PLUG GAGE	QA		A-185	ACCEPT	533-B.CL 10-26-06			A
3* (430)	B7	4X 1-8UNC ▽ 2.5	THREAD PLUG GAGE	QA		A-185	ACCEPT	533-B.CL 10-26-06			A
3* (440)	C1	1.50		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06			A
3* (450)	C1	3.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06			A
3* (460)	C1	4X Ø 1-8UNC ▽ 2.1	THREAD PLUG GAGE DEPTH MICROMETE	QA		A-670 J-1024	ACCEPT	533-B.CL 10-25-06			A
3* (470)	C1	4.50		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06			A
3* (480)	B1	9.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06			A
4* (500)	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	533-B.CL 10-26-06			A
4* (510)	E6	14X Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA		J-1400	1.884 TO 1.886 HO LE #6 1.884 - 1.889 HOLE #10 1.884 - 1.893 [N/C:20676]	533-B.CL 10-25-06			R
4* (520)	E6	14X └┘Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP		QA		MTMFX-3564	ACCEPT	533-B.CL 10-26-06			A
4* (530)	E6	$\text{⌀} \begin{matrix} .06 &   & M &   & A &   & D \end{matrix}$ 14 X Ø1.885	CMM	QA		00064	.046 TO .060	533-B.CL 10-26-06		A	
4* (540)	D6	10X Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA		J-1400	1.884 TO 1.886 HOLE #19 HAS A GROO VE .400 TALL BY .01 8 DEEP [N/C:20676]	533-B.CL 10-25-06			R
4* (540)	D6	10X └┘Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP		QA		MTMFX-3564	ACCEPT	533-B.CL			A

### INSPECTION DATA CHECKLIST


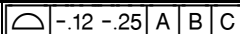
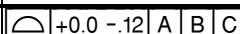
(550)							10-26-06		
4* (560)	D6	$\Phi$ .06 M A D 10 X $\Phi$ 1.885	CMM	QA	00064	.0316 TO .063 [N/C :20676]	533-B.CL 10-26-06		R
4* (580)	C7	3X $\square$ $\Phi$ 2.000 - 2.001 $\nabla$ .990 - 1.000		QA	LARGE DEA	3X - 2.0002 BY 1.00 3 [N/C:20676]	854-R.UP 10-03-06		R
4* (590)	C7	$\Phi$ $\Phi$ .06 M A D 3X $\Phi$ 1.130	CMM	QA	00064	.054 TO .066 [N/C:2 0676]	533-B.CL 10-26-06		R
4* (600)	D4	$\Phi$ 1.375-6UNC THRU OR $\Phi$ 1.375-6UNC X 1.5 MIN FOR FLANGE THK GREATER 1.5	THREAD PLUG GAGE	QA	A-375	ACCEPT	533-B.CL 10-26-06		A
4* (610)	D4	$\Phi$ .06 M A D $\Phi$ 1.375-6UNC	CMM	QA	00064	.022 TO .072 [N/C:2 0676]	533-B.CL 10-26-06		R
4* (620)	E2	10X .25-20UNC-2B	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 10-25-06		A
4* (630)	E2	$\Phi$ .03 X 45° CHAMFER	CALIPER	QA	J-707	.500 [N/C:20676]	533-B.CL 10-25-06		R
5* (640)	F7	12X .25-20UNC-2B	THREAD PLUG GAGE	QA	A-716	ACCEPT	533-B.CL 10-25-06		A
5* (650)	F7	$\Phi$ .03 X 45° CHAMFER	CALIPER	QA	J-707	.505 [N/C:20676]	533-B.CL 10-25-06		R
5* (660)	G6	3X 1.0	DEPTH MICROMETE	QA	J-1024	ACCEPT	533-B.CL 10-25-06		A
5* (670)	G6	3X $\Phi$ 3.00	CALIPER	QA	J-707	3.003	533-B.CL 10-25-06		A
5* (680)	G6	3X $\Phi$ 1.50	CALIPER	QA	J-1103	1.476 TO 1.491 [N/C :20676]	533-B.CL 10-25-06		R
5* (690)	E3	12X $\Phi$ 1.375-6UNC THRU OR $\Phi$ 1.375-6UNC X $\nabla$ 1.5 MIN FOR FLANGE THK GREATER THAN 1.5	THREAD PLUG GAGE	QA	A-375	ACCEPT	533-B.CL 10-25-06		A
5* (700)	E3	$\Phi$ .06 N A E 12X $\Phi$ 1.375-6	CMM	QA	00064	.010 TO .028	533-B.CL 10-26-06		A
5*	D4	14X $\Phi$ 1.375-6UNC THRU OR $\Phi$ 1.375-6UNC X $\nabla$ 1.5 MIN FOR FLANGE THK GREATER THAN 1.5	THREAD PLUG GAGE	QA	A-375	ACCEPT	533-B.CL		A



### INSPECTION DATA CHECKLIST

(710)								10-25-06		
5* (720)	D4	$\Phi$ .06 N A E 14X Ø1.375-6	CMM	QA		00064	.006 TO .052	533-B.CL 10-26-06		A
5* (730)	E3	3X Ø1.885 ±.003 THRU	DIAL BORE GAGE	QA		J-1400	1.886	533-B.CL 10-25-06		A
5* (740)	E3	3X $\perp$ Ø3.00 SPOTFACE BACKSIDE MINIMUM CLEAN UP		QA		MTMFX-3564	ACCEPT	533-B.CL 10-26-06		A
5* (750)	E3	$\Phi$ .06 N A E 3X Ø1.885	CMM	QA		00064	.024 TO .026	533-B.CL 10-26-06		A
6* (760)	G7	5.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (770)	H7	5.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (780)	H6	5.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (790)	C6	6.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (800)	C6	5.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (810)	F6	4X Ø1.00	CALIPER	QA		J-707	1.001 TO 1.002	533-B.CL 10-25-06		A
6* (820)	F7	6.50		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (830)	F6	2.00		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
6* (840)	H5	2X .88/1.13	CALIPER	QA		J-707	1.090 AND 1.170 [N/ C:20676]	533-B.CL 10-25-06		R
6* (850)	C5	2.250 ± .010	CALIPER	QA		J-707	2.240	533-B.CL 10-25-06		A
6* (860)	F4	.06 - .09 X 45°	CALIPER	QA		J-707	.070	533-B.CL 10-25-06		A
7* (880)	C4	2X 1.56	CALIPER	QA		J-707	1.78 TO 1.81 [N/C:2 0676]	533-B.CL 10-25-06		R
7* (890)	C4	5.190		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06		A
7* (900)	C3	6X	THREAD PLUG GAGE	QA		A-233	ALL GOOD EXCEPT ONE	533-B.CL		R

### INSPECTION DATA CHECKLIST

(900)		.375-16UNC-2B TAP ▽ .75 .03 X 45° CHAMFER				HOLE THE NOGO GOES 4 TURNS [N/C:20676 ]	10-25-06		
7* (910)	B3	3.75		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06	A
7* (920)	B3	7.50		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06	A
8* (930)	C5	4 X Ø1.0 T H R U	CALIPER	QA		J-707	1.003 TO 1.010	533-B.CL 10-25-06	A
9* (940)	C7	2X Ø.50 THRU	CALIPER	QA		J-707	.495 TO .499	533-B.CL 10-25-06	A
9* (950)	F4	10.15		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06	A
9* (960)	F4	1.63		QA		VISUAL	SEE IGES DATA	533-B.CL 10-25-06	A
9* (970)	D4	Ø.25 ▽5.0 └┘Ø.625 ▽3.0	PIN GAGE	QA		J-652-1	.245 DEPTH 5.7 .625 DPETH 3.6	533-B.CL 10-26-06	A
9* (980)	E2	Ø.25 └┘Ø.625 DETAIL D	PIN GAGE	QA		J-652-1	.625 .246	533-B.CL 10-26-06	A
9* (990)	F2	4X Ø1.0 THRU	CALIPER	QA		J-707	1.001 TO 1.004	533-B.CL 10-25-06	A
11* (1010)	E5	 AS CAST SURFACES	CMM	QA		00064	-.309 TO .435 [N/C: 20676]	533-B.CL 10-26-06	R
11* (1020)	C8	 WING SURFACES	CMM	QA		00064	-.029 TO .055	533-B.CL 10-26-06	A
11* (1030)	D1	 WING POCKET	CMM	QA		00064	-.035 TO .028	533-B.CL 10-26-06	A

Quality Assurance Documentation for Part ID: SE141-115 - Item: 21

Workorder: 65708/2-0 Sub:1 Op:136

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	
*		<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	< 1.02	495-D.CO			A
(10)								10-23-06			
*		<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	< 1.02	495-D.CO			A
(20)								10-23-06			



**INSPECTION DATA CHECKLIST**

Quality Assurance Documentation for Part ID: SE141-139 - Item: 25

Workorder: 65708/2-0 Sub:11 Op:30

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-R.UP		
(10)								07-09-06		

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**INSPECTION DATA CHECKLIST**

Quality Assurance Documentation for Part ID: SE141-140 - Item: 28

Workorder: 65708/2-0 Sub:12 Op:30
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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
1*	G2	RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	854-R.UP		
(10)								07-16-06		

A

Employees: 495-D.Coffman / 503-B.Houk / 533-B.Clevenger / 771-B.Schultz / 825-B.Jarrett / 854-R.Upchurch