

B4

Workorder: 65708/4-0 Sub:1 Op:130

Revision:

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*	D2	Ø.001 - Ø.002 CHECK CLEARANCE OF ITEM 5 TO ITEM 6.		MFG		FEELER STOCK	LESS THAN .001"	242-M.G			A
(10)								01-17-07			*
*		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"		MFG		FEELER STOCK	LESS THAN .001"	242-M.G			A
(15)								01-17-07			*
*		ENSURE THAT THE CUMULATIVE GAPS AT ANY SINGLE CROSS SECTION OF THE POLOIDAL FLANGE ELEMENTS IS LESS THAN .005".		MFG		FEELER STOCK	LESS THAN .001"	242-M.G			A
(20)								01-17-07			*
*		THE MAX. GAP AT THE POLOIDAL BREAK PERIMETER IS .015" AND CANNOT EXCEED 1/8" FROM THE EDGE.	FEELER GAGES	MFG		J-1203	ACCEPT	242-M.G			A
(30)								01-17-07			*
1*	F3	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLIE	MFG		J-1240	1500 FT-LBS	242-M.G			A
(40)								01-17-07			*

Workorder: 65708/4-0 Sub:1 Op:132

Revision: 01/16/07 14:20

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	VERIFY PART MARKING: MAJOR TOOL		QA		VISUAL	SE141-115B4	503-B.HO			A

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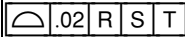


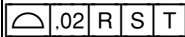

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(10)		SE141-115 B(casting number) (weight) LBS.						01-17-07	*
1* (20)	C3	RECORD FINAL PART WEIGHT	SCALE	QA	J-1173	5360 LB	503-B.HO	01-17-07	A*
1* (30)	F3	NOTE 14 BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.		QA	VISUAL	ACCEPT	503-B.HO	01-16-07	A*
1* (40)	E7	<input type="checkbox"/> <input type="checkbox"/> .02 A	CMM	QA	00064	.0088	339-E.RO	01-19-07	A*
1* (50)	E6	<input type="checkbox"/> <input type="checkbox"/> .02 A	CMM	QA	00064	.0088	339-E.RO	01-19-07	A*
1* (60)	B6	<input type="checkbox"/> <input type="checkbox"/> .02 A	CMM	QA	00064	.0037	339-E.RO	01-19-07	A*
1* (70)	B5	<input type="checkbox"/> <input type="checkbox"/> .02 A	CMM	QA	00064	.0037	339-E.RO	01-19-07	A*
1* (90)	D3	<input type="checkbox"/> <input type="checkbox"/> .5 A C B OUTER AS CAST SURFACES	CMM	QA	00064	-.074 TO .355 [N/C: 21032-Doc:NC21032]	339-E.RO	01-19-07	R*
2* (100)	G7	2X .03 X 45°	CALIPER	QA	J-707	.010 TO .040 [N/C:2 1032-Doc:NC21032]	533-B.CL	01-18-07	R*
2* (110)	G7	.40	CALIPER	QA	P-2056	ACCEPT	503-B.HO	01-18-07	A*
2* (120)	G7	2X .03 X 45°	CALIPER	QA	J-707	.01 TO .040 [N/C:21 032-Doc:NC21032]	533-B.CL	01-18-07	R*
2* (130)	G8	2X R.11	RADIUS GAGE	QA	R-25	.090 TO .110 ON E S IDE .090 TO .110 ON D SIDE [N/C:21032-D oc:NC21032]	533-B.CL	01-18-07	R*

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2* (140)	H7	2X .31	CALIPER	QA		P-2056	ACCEPT	503-B.HO 01-18-07			A *
2* (150)	H6	 MACHINED SURFACES M TO M1	CMM	QA		00064	-.026 TO .014 [N/C: 21032-Doc:NC21032]	339-E.RO 01-19-07			R *
2* (160)	F5	DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	AT HOLE 82 WILL NOT ACCEPT GAGE [N/C:21 032-Doc:NC21032]	503-B.HO 01-18-07			R *
2* (170)	E6	 P TO M	CMM	QA		00064	-.018 TO .104 [N/C: 21032-Doc:NC21032]	339-E.RO 01-19-07			R *
2* (180)	H4	 MACHINED SURFACES M1 TO N1	CMM	QA		00064	-.019 TO .021	339-E.RO 01-19-07			A *
2* (190)	G3	 MACHINED SURFACES N TO N1	CMM	QA		00064	-.026 TO .024 [N/C: 21032-Doc:NC21032]	339-E.RO 01-19-07			R *
2* (200)	F3	DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA		MTMFX-3473	AT HOLE 37 THRU 45, 50 THRU 57 AND AT 6 1 WILL NOT ACCEPT G AGE [N/C:21032-Doc: NC21032]	503-B.HO 01-18-07			R *
2* (210)	F3	 Q TO N	CMM	QA		00064	.014 TO .102 [N/C:2 1032-Doc:NC21032]	339-E.RO 01-19-07			R *

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INSPECTION DATA CHECKLIST


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2* (230)	C5	2X .06-.09 X 45°	CALIPER	QA		J-707	.06/.120 X 45 [N/C: 21032-Doc:NC21032]	533-B.CL 01-18-07			R *
2* (240)	C4	84X .375-16 UNC ∇ .75	THREAD PLUG GAGE	QA		A-233	ACCEPT	503-B.HO 01-18-07			A *
2* (250)	C4	84X \square .625 ∇ .188	CALIPER	QA		P-2056	.622/.625 X .161/.2 08 [N/C:21032-Doc:N C21032]	503-B.HO 01-18-07			R *
2* (260)	C4	$\text{⌀} .06$ R S T	CMM	QA		00064	.009 TO .083 [N/C:2 1032-Doc:NC21032]	339-E.RO 01-19-07			R *
3* (270)	G7	9.00	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07			A *
3* (280)	G7	4.50	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07			A *
3* (290)	G6	3.00	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07			A *
3* (300)	F7	1.50	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07			A *
3* (310)	F7	4X $\text{⌀} 1.0-8\text{UNC}$ $\nabla 2.1$	THREAD PLUG GAGE	QA		A-71	ACCEPT	503-B.HO 01-16-07			A *
3* (320)	G5	17.00 AT MOUNTING AREA	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07			A *
3* (330)	H2	$\sqrt[125]{}$ DATUM E	PROFILOMETER	QA		J-1152	60	533-B.CL 01-17-07			A *
3* (340)	G1	\square .01 DATUM E	CMM	QA		00064	.021 [N/C:21032-Doc :NC21032]	339-E.RO 01-19-07			R *
3*	G3	.25± .01 DATUM E	CMM	QA		00064	.24 TO .25	339-E.RO			A

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(350)							01-19-07		*
3*		 .01	CMM	QA	00064	.017 [N/C:21032-Doc :NC21032]	339-E.RO		R
(360)		DATUM D					01-19-07		*
3*	E2	.25± .01	CMM	QA	00064	.24 TO .25	339-E.RO		A
(370)		DATUM D					01-19-07		*
3*	E2	¹²⁵ / _√	PROFILOMETER	QA	J-1152	90	533-B.CL		A
(380)		DATUM D					01-18-07		*
3*	F4	2X Ø2.50	CALIPER	QA	P-2056	2.515/2.523 [N/C:21 032-Doc:NC21032]	503-B.HO		R
(390)							01-16-07		*
3*	F4	4X Ø1.0 -8UNC ∇2.5	THREAD PLUG GAGE	QA	A-71	ACCEPT	503-B.HO		A
(400)							01-16-07		*
3*	F4		CALIPER	QA	J-707	1.72	503-B.HO		A
(410)		1.72					01-16-07		*
3*	D5	8X Ø1-8UNC ∇ 1.5	THREAD PLUG GAGE	QA	A-71	ACCEPT	503-B.HO		A
(420)							01-16-07		*
3*	B7	4X 1-8UNC ∇ 2.5	THREAD PLUG GAGE	QA	A-71	ACCEPT	503-B.HO		A
(430)							01-16-07		*
3*	C1		CMM	QA	00064	REFER TO IGES	339-E.RO		A
(440)		1.50					01-19-07		*
3*	C1		CMM	QA	00064	REFER TO IGES	339-E.RO		A
(450)		3.00					01-19-07		*
3*	C1	4X Ø 1-8UNC ∇ 2.1	THREAD PLUG GAGE	QA	A-71	ACCEPT	503-B.HO		A
(460)			CALIPER		J-707		01-16-07		*
3*	C1		CMM	QA	00064	REFER TO IGES	339-E.RO		A
(470)		4.50					01-19-07		*
3*	B1		CMM	QA	00064	REFER TO IGES	339-E.RO		A
(480)		9.00					01-19-07		*
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	503-B.HO		A

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(500)								01-16-07		*
4*	E6	14X Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA		J-1400	1.879/1.892 [N/C:21 032-Doc:NC21032]	242-M.G		R
(510)								01-19-07		*
4*	E6	14X └┘Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP	CALIPER	QA		P-2056	3.0	503-B.HO		A
(520)								01-16-07		*
4*	E6	⊕.06 M A D 14 X Ø1.885	CMM	QA		00064	.008 TO .024	339-E.RO		A
(530)								01-19-07		*
4*	D6	10X Ø1.885 ± .003 THRU	DIAL BORE GAGE	QA		J-1400	1.875/1.898 [N/C:21 032-Doc:NC21032]	503-B.HO		R
(540)								01-16-07		*
4*	D6	10X └┘Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP	CALIPER	QA		P-2056	3.0	503-B.HO		A
(550)								01-16-07		*
4*	D6	⊕.06 M A D 10 X Ø1.885	CMM	QA		00064	.009 TO .028	339-E.RO		A
(560)								01-19-07		*
4*	C7	3X └┘Ø2.000 - 2.001 ▽ .990 - 1.000	DIAL BORE GAGE	QA		J-1400	2.0005 X .922/1.000	503-B.HO		A
(580)			CALIPER			P-2056		01-16-07		*
4*	C7	⊕.06 M A D 3X Ø1.130	CMM	QA		00064	.009, .010, .013	339-E.RO		A
(590)								01-19-07		*
4*	D4	Ø1.375-6UNC THRU OR Ø1.375-6UNC X 1.5 MIN FOR FLANGE THK GREATER 1.5	THREAD PLUG GAGE	QA		A-375	ACCEPT	503-B.HO		A
(600)								01-16-07		*
4*	D4	⊕.06 M A D Ø1.375-6UNC	CMM	QA		00064	.58	339-E.RO		A
(610)								01-19-07		*
4*	E2	10X .25-20UNC-2B	THREAD PLUG GAGE	QA		A-727	ACCEPT	503-B.HO		A
(620)								01-16-07		*

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4* (630)	E2	Ø.03 X 45° CHAMFER	CALIPER	QA		P-2056	.030 X 45	503-B.HO 01-16-07			A *
5* (640)	F7	12X .25-20UNC-2B	THREAD PLUG GAGE	QA		A-727	ACCEPT	503-B.HO 01-16-07			A *
5* (650)	F7	Ø.03 X 45° CHAMFER	CALIPER	QA		P-2056	.03 X 45	503-B.HO 01-16-07			A *
5* (660)	G6	3X 1.0	CALIPER	QA		P-2056	.998	503-B.HO 01-16-07			A *
5* (670)	G6	3X Ø3.00	CALIPER	QA		P-2056	3.004	503-B.HO 01-16-07			A *
5* (680)	G6	3X Ø1.50	CALIPER	QA		P-2056	1.504	503-B.HO 01-16-07			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	503-B.HO 01-16-07			A *
5* (700)	E3	Φ .06 N A E 12X Ø1.375-6	CMM	QA		00064	.002 TO .028	339-E.RO 01-19-07			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	503-B.HO 01-16-07			A *
5* (720)	D4	Φ .06 N A E 14X Ø1.375-6	CMM	QA		00064	.004 TO .064 [N/C:2 1032-Doc:NC21032]	339-E.RO 01-19-07			R *
5* (730)	E3	3X Ø1.885 ±.003 THRU	DIAL BORE GAGE	QA		J-1400	1.882/1.888	503-B.HO 01-16-07			A *
5* (740)	E3	3X L┘Ø3.00 SPOTFACE BACKSIDE MINIMUM CLEAN UP	CALIPER	QA		P-2056	ACCEPT	503-B.HO 01-16-07			A *
5* (750)	E3	Φ .06 N A E 3X Ø1.885	CMM	QA		00064	.016 TO .018	339-E.RO 01-19-07			A *

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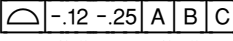
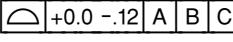
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6* (760)	G7	5.00	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07			A *
6* (770)	H7	5.00	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07			A *
6* (780)	H6	5.00	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07			A *
6* (790)	C6	6.00	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07			A *
6* (800)	C6	5.00	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07			A *
6* (810)	F6	4X Ø1.00	CALIPER	QA		P-2056	1.005	503-B.HO 01-16-07			A *
6* (820)	F7	6.50	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07			A *
6* (830)	F6	2.00	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07			A *
6* (840)	H5	2X .88/1.13	CALIPER	QA		P-2056	1.060 / 1.160 [N/C: 21032-Doc:NC21032]	503-B.HO 01-16-07			R *
6* (850)	C5	2.250 ± .010	CALIPER	QA		P-2056	2.251	503-B.HO 01-17-07			A *
6* (860)	F4	.06 - .09 X 45°	CALIPER	QA		P-2056	.065 X45	503-B.HO 01-16-07			A *
7* (880)	C4	2X 1.56	CALIPER	QA		P-2056	1.560	503-B.HO 01-16-07			A *
7* (890)	C4	5.190	CALIPER	QA		P-2056	5.195	503-B.HO 01-16-07			A *
7* (900)	C3	6X .375-16UNC-2B TAP ▽ .75 .03 X 45° CHAMFER	THREAD PLUG GAGE	QA		A-443	ACCEPT	503-B.HO 01-16-07			A *
7* (910)	B3		CMM	QA		00064	REFER TO IGES	339-E.RO			A

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(910)		3.75						01-19-07		*
7* (920)	B3	7.50	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07		A *
8* (930)	C5	4 X Ø1.0 THRU	CALIPER	QA		P-2056	1.005	503-B.HO 01-16-07		A *
9* (940)	C7	2X Ø.50 THRU	CALIPER	QA		P-2056	.505	503-B.HO 01-16-07		A *
9* (950)	F4	10.15	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07		A *
9* (960)	F4	1.63	CMM	QA		00064	REFER TO IGES	339-E.RO 01-19-07		A *
9* (970)	D4	Ø.25 ∇5.0 └┘Ø.625 ∇3.0	CALIPER	QA		P-2056	.253 X 5.0 .627 X 3 .0	503-B.HO 01-17-07		A *
9* (980)	E2	Ø.25 └┘Ø.625 DETAIL D	CALIPER	QA		P-2056	.253 .267	503-B.HO 01-17-07		A *
9* (990)	F2	4X Ø1.0 THRU	CALIPER	QA		P-2056	1.005	503-B.HO 01-16-07		A *
11* (1010)	E5	 AS CAST SURFACES	CMM	QA		00064	-.286 TO .241 [N/C: 21032-Doc:NC21032]	339-E.RO 01-19-07		R *
11* (1020)	C8	 WING SURFACES	CMM	QA		00064	.0672 - .2509	242-M.G 01-19-07		R *
11* (1030)	D1	 WING POCKET	CMM	QA		00064	-.086 TO .051 [N/C: 21032-Doc:NC21032]	339-E.RO 01-19-07		R *
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* (1040)		VERIFY 9.00" +/- .05" CLEARANCE	SCALE	QA		J-922	9.030	533-B.CL 01-18-07		A *

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*		VERIFY CLEARANCE ABOVE SPOTFACE 3" DIAMTER CYLINDER 3" HIGH 1/4" BLEND IN RADIUS WERE APPLICABLE.	CALIPER	QA		P-2056	ACCEPT	503-B.HO			A
(1050)								01-17-07			*

Workorder: 65708/4-0 Sub:1 Op:136

Revision:

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-1271	LESS THAN 1.02	503-B.HO			A
(10)								01-17-07			*
*		<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-1271	LESS THAN 1.02	503-B.HO			A
(20)								01-17-07			*

Workorder: 65708/4-0 Sub:1 Op:140

Revision:

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	
*		<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 OHMS	503-B.HO			A
(10)								01-18-07			*
*		<u>T E S T 2</u> RESISTANCE TO BE >500 kohms CHECK RESISTANCE BETWEEN THE	MULTIMETER	QA		J-1358	2.2 G OHMS	503-B.HO			A

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INSPECTION DATA CHECKLIST

B4

(20)	JUMPERED BOLTS AND JUMPERED MID-PLANE CASTING AND WINDING FORM.							01-18-07		*
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Workorder: 65708/4-0 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-R.UP		
(10)								07-09-06		

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Workorder: 65708/4-0 Sub:12 Op:30

Revision: 07/09/06 15:50

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		

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* To Far Right Indicates Data Package Requirement

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