

B5

Workorder: 65708/5-0 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			LESS THAN .002	825-B.JA			A
(10)								02-07-07			*
*		THE GAP BETWEEN THE POLOIDAL BREAK BUSHINGS AND FLANGE SHALL BE LESS THAN .002"		MFG			LESS THAN .002	825-B.JA			A
(15)								02-07-07			*
*		ENSURE THAT THE CUMULATIVE GAPS AT ANY SINGLE CROSS SECTION OF THE POLOIDAL FLANGE ELEMENTS IS LESS THAN .005".	FEELER GAGES	MFG		J-1149	LESS THAN .005	825-B.JA			A
(20)								02-07-07			*
*		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 .005	825-B.JA			A
(30)								02-07-07			*
1*	F3	TORQUE ASSEMBLY TO 1500 +/- 30 FT-LBS PER DRAWING NOTE 15.	TORQUE MULTIPLIE	MFG		J-1240	1500	825-B.JA			A
(40)								02-07-07			*

Workorder: 65708/5-0 Sub:1 Op:132

Revision: 02/09/07 11:00

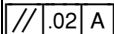
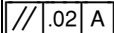
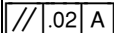
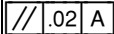


Part: SE141-115 - MODULAR COIL, TYPE B -

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	ACCEPT	242-M.G			A

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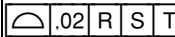

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(10)		SE141-115 B(casting number) (weight) LBS.						02-12-07	*
1* (20)	C3	RECORD FINAL PART WEIGHT		QA		5400 LB		503-B.HO 02-09-07	A *
1* (30)	F3	NOTE 14 BACK SPOTFACE ALL THRU HOLES TO MINIMUM CLEAN UP.		QA	VISUAL	ACCEPT		503-B.HO 02-09-07	A *
1* (40)	E7		CMM	QA		00064	.005	503-B.HO 02-09-07	A *
1* (50)	E6		CMM	QA		00064	.007	503-B.HO 02-09-07	A *
1* (60)	B6		CMM	QA		00064	.007	503-B.HO 02-09-07	A *
1* (70)	B5		CMM	QA		00064	.005	503-B.HO 02-09-07	A *
1* (90)	D3	 OUTER AS CAST SURFACES	CMM	QA		00064	.018 TO .546 [N/C:2 1142-Doc:NC21142]	339-E.RO 02-10-07	R *
2* (100)	G7	2X .03 X 45°		QA	VISUAL	ACCEPT		242-M.G 02-12-07	A *
2* (110)	G7	.40	CALIPER	QA		J-707	.390/.410 E SIDE .3 90/.410 D SIDE	503-B.HO 02-09-07	A *
2* (120)	G7	2X .03 X 45°		QA	VISUAL	ACCEPT		503-B.HO 02-09-07	A *
2* (130)	G8	2X R.11	RADIUS GAGE	QA		R-21	.100	503-B.HO 02-09-07	A *
2* (140)	H7	2X .31	CALIPER	QA		J-707	.310/.330 E SIDE .3 40 D SIDE	503-B.HO 02-09-07	A *
2*	H6		CMM	QA		00064	-.025 TO .021 [N/C:	339-E.RO	R

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(150)		MACHINED SURFACES M TO M1				21142-Doc:NC21142]		02-10-07	*
2* (160)	F5	DATUM D SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA	MTMFX-3473	REJECTED BETWEEN HOLES 82-83 AND 88-89 [N/C:21142-Doc:NC21142]		242-M.G 02-12-07	R
2* (170)	E6	 P TO M	CMM	QA	00064	.005 TO .100		339-E.RO 02-10-07	A*
2* (180)	H4	 MACHINED SURFACES M1 TO N1	CMM	QA	00064	-.010 TO .020		339-E.RO 02-10-07	A*
2* (190)	G3	 MACHINED SURFACES N TO N1	CMM	QA	00064	-.028 TO .022 [N/C: 21142-Doc:NC21142]		339-E.RO 02-10-07	R*
2* (200)	F3	DATUM E SIDE VERIFY SHELL INTERSECT CLEARANCE USING GAGE MTMFX-3473		QA	MTMFX-3473	REJECTED BETWEEN HOLES 32-46, 48-56, HOLE 59 AND 83-90 [N/C:21142-Doc:NC21142]		242-M.G 02-12-07	R*
2* (210)	F3	 Q TO N	CMM	QA	00064	.016 TO .092		339-E.RO 02-10-07	A*
2* (230)	C5	2X .06-.09 X 45°		QA	VISUAL	ACCEPT		503-B.HO 02-09-07	A*
2* (240)	C4	84X .375-16 UNC $\bar{\nabla}$.75	THREAD PLUG GAGE	QA	A-447	ACCEPT		242-M.G 02-12-07	A*

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2* (250)	C4	84X \perp .625 ∇ .188	PIN GAGE	QA		J-652-3	ACCEPT	242-M.G 02-12-07		A *
2* (260)	C4	\varnothing .06 R S T	CMM	QA		00064	.004 TO .080 [N/C:2 1142-Doc:NC21142]	339-E.RO 02-10-07		R *
3* (270)	G7	9.00	CALIPER	QA		J-707	8.997-9.001	503-B.HO 02-09-07		A *
3* (280)	G7	4.50	CALIPER	QA		J-707	4.501	503-B.HO 02-09-07		A *
3* (290)	G6	3.00	CALIPER	QA		J-707	2.991	503-B.HO 02-09-07		A *
3* (300)	F7	1.50	CALIPER	QA		J-707	1.498	503-B.HO 02-09-07		A *
3* (310)	F7	4X \varnothing 1.0-8UNC ∇ 2.1	THREAD PLUG GAGE	QA		A-347	ACCEPT	503-B.HO 02-09-07		A *
3* (320)	G5	17.00 AT MOUNTING AREA	CMM	QA		00064	REFER TO IGES	339-E.RO 02-10-07		A *
3* (330)	H2	$\sqrt[125]{}$ DATUM E	PROFILOMETER	QA		J-1152	19/41	503-B.HO 02-09-07		A *
3* (340)	G1	\square .01 DATUM E	CMM	QA		00064	.018 [N/C:21142-Doc :NC21142]	339-E.RO 02-10-07		R *
3* (350)	G3	.25 \pm .01 DATUM E	CALIPER	QA		J-707	.253	503-B.HO 02-09-07		A *
3* (360)		\square .01 DATUM D	CMM	QA		00064	.036 [N/C:21142-Doc :NC21142]	339-E.RO 02-10-07		R *
3* (370)	E2	.25 \pm .01 DATUM D	CALIPER	QA		J-707	.254	503-B.HO 02-09-07		A *
3* (380)	E2	$\sqrt[125]{}$	PROFILOMETER	QA		J-1152	25/58	503-B.HO		A

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(380)		DATUM D						02-09-07		*
3* (390)	F4	2X Ø2.50	CALIPER	QA		J-707	2.501/2.503	503-B.HO 02-09-07		A *
3* (400)	F4	4X Ø1.0 -8UNC ▽2.5	THREAD PLUG GAGE	QA		A-347	ACCEPT	503-B.HO 02-09-07		A *
3* (410)	F4	1.72	CALIPER	QA		J-707	1.72	503-B.HO 02-09-07		A *
3* (420)	D5	8X Ø1-8UNC ▽ 1.5	THREAD PLUG GAGE	QA		A-347	ACCEPT	503-B.HO 02-09-07		A *
3* (430)	B7	4X 1-8UNC ▽ 2.5	THREAD PLUG GAGE	QA		A-347	ACCEPT	503-B.HO 02-09-07		A *
3* (440)	C1	1.50	CALIPER	QA		J-707	1.499	503-B.HO 02-09-07		A *
3* (450)	C1	3.00	CALIPER	QA		J-707	2.998	503-B.HO 02-09-07		A *
3* (460)	C1	4X Ø 1-8UNC ▽ 2.1	THREAD PLUG GAGE	QA		A-347	ACCEPT	503-B.HO 02-09-07		A *
3* (470)	C1	4.50	CALIPER	QA		J-707	4.5	503-B.HO 02-09-07		A *
3* (480)	B1	9.00	CALIPER	QA		J-707	8.98-9.002	503-B.HO 02-09-07		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	242-M.G 02-12-07		A *
4* (510)	E6	14X Ø1.885 ± .003 THRU	CALIPER	QA		J-707	1.882 TO 1.883	339-E.RO 02-10-07		A *
4* (520)	E6	14X └┘Ø3.00 SPOTFACE BACKSIDE MINIMUM TO CLEAN UP	CALIPER	QA		MTMFX-3564 J-707	ACCEPT	339-E.RO 02-10-07		A *

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4* (530)	E6	$\Phi .06$ M A D 14 X $\Phi 1.885$	CMM	QA		00064	.003 TO .041	339-E.RO 02-10-07		A *
4* (540)	D6	10X $\Phi 1.885 \pm .003$ THRU	CALIPER	QA		J-707	1.882 TO 1.884	339-E.RO 02-10-07		A *
4* (550)	D6	10X └┐ $\Phi 3.00$ SPOTFACE BACKSIDE MINIMUM TO CLEAN UP	CALIPER	QA		MTMFX-3564 J-707	ACCEPT	339-E.RO 02-10-07		A *
4* (560)	D6	$\Phi .06$ M A D 10 X $\Phi 1.885$	CMM	QA		00064	.013 TO .022	339-E.RO 02-10-07		A *
4* (580)	C7	3X └┐ $\Phi 2.000 - 2.001$ ▽ .990 - 1.000	CALIPER	QA		J-707	2.000 TO 2.0005 / . 991 - .994	339-E.RO 02-10-07		A *
4* (590)	C7	$\Phi \Phi .06$ M A D 3X $\Phi 1.130$	CMM	QA		00064	.012, .016, .017	339-E.RO 02-10-07		A *
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	339-E.RO 02-10-07		A *
4* (610)	D4	$\Phi .06$ M A D $\Phi 1.375-6UNC$	CMM	QA		00064	.022	339-E.RO 02-10-07		A *
4* (620)	E2	10X .25-20UNC-2B	THREAD PLUG GAGE	QA		A-729	ACCEPT	503-B.HO 02-09-07		A *
4* (630)	E2	$\Phi .03$ X 45° CHAMFER		QA		VISUAL	ACCEPT	503-B.HO 02-09-07		A *
5* (640)	F7	12X .25-20UNC-2B	THREAD PLUG GAGE	QA		A-729	ACCEPT	503-B.HO 02-09-07		A *
5* (650)	F7	$\Phi .03$ X 45° CHAMFER		QA		VISUAL	ACCEPT	503-B.HO 02-09-07		A *
5* (660)	G6	3X 1.0	PIN GAGE	QA		J-921	.997/1.00	503-B.HO 02-09-07		A *

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5* (670)	G6	3X Ø3.00	CMM	QA		00064	2.998, 2.998, 2.999	339-E.RO 02-10-07			A *
5* (680)	G6	3X Ø1.50	CMM	QA		00064	1.49 / 1.5	339-E.RO 02-12-07			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 02-09-07			A *
5* (700)	E3	Φ .06 N A E 12X Ø1.375-6	CMM	QA		00064	.001 TO .020	339-E.RO 02-10-07			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 02-09-07			A *
5* (720)	D4	Φ .06 N A E 14X Ø1.375-6	CMM	QA		00064	.001 TO .033	339-E.RO 02-10-07			A *
5* (730)	E3	3X Ø1.885 ±.003 THRU	CALIPER	QA		J-707	1.883	503-B.HO 02-09-07			A *
5* (740)	E3	3X \square Ø3.00 SPOTFACE BACKSIDE MINIMUM CLEAN UP		QA		VISUAL	ACCEPT	503-B.HO 02-09-07			A *
5* (750)	E3	Φ .06 N A E 3X Ø1.885	CMM	QA		00064	.002	339-E.RO 02-10-07			A *
6* (760)	G7	5.00	CMM	QA		00064	REFER TO IGES	339-E.RO 02-12-07			A *
6* (770)	H7	5.00	CMM	QA		00064	REFER TO IGES	339-E.RO 02-12-07			A *
6* (780)	H6	5.00	CMM	QA		00064	REFER TO IGES	339-E.RO 02-12-07			A *
6* (790)	C6	6.00	CMM	QA		00064	REFER TO IGES	339-E.RO 02-12-07			A *
6*	C6		CMM	QA		00064	REFER TO IGES	339-E.RO			A

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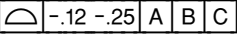
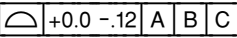
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(800)		5.00					02-12-07		*
6* (810)	F6	4X Ø1.00	PIN GAGE	QA	J-921	.998/1.002	503-B.HO 02-09-07		A *
6* (820)	F7	6.50	CMM	QA	00064	REFER TO IGES	339-E.RO 02-12-07		A *
6* (830)	F6	2.00	CMM	QA	00064	REFER TO IGES	339-E.RO 02-12-07		A *
6* (840)	H5	2X .88/1.13	CALIPER	QA	J-707	1.17 / 1.13 [N/C:21 142-Doc:NC21142]	339-E.RO 02-12-07		R *
6* (850)	C5	2.250 ± .010		QA	VISUAL	UNABLE TO MEASURE	339-E.RO 02-12-07		A *
6* (860)	F4	.06 - .09 X 45°		QA	VISUAL	UNABLE TO MEASURE	339-E.RO 02-12-07		A *
7* (880)	C4	2X 1.56	CALIPER	QA	J-707	1.558	503-B.HO 02-09-07		A *
7* (890)	C4	5.190	CALIPER	QA	J-707	5.193	503-B.HO 02-09-07		A *
7* (900)	C3	6X .375-16UNC-2B TAP ▽ .75 .03 X 45° CHAMFER	THREAD PLUG GAGE	QA	A-47	ACCEPT	503-B.HO 02-09-07		A *
7* (910)	B3	3.75	CALIPER	QA	J-707	3.748	503-B.HO 02-09-07		A *
7* (920)	B3	7.50	CALIPER	QA	J-707	7.494	503-B.HO 02-09-07		A *
8* (930)	C5	4 X Ø1.0 T H R U	CALIPER	QA	J-707	1.00	339-E.RO 02-12-07		A *
9* (940)	C7	2X Ø.50 THRU	CMM	QA	00064	0.49 TO 0.50	339-E.RO 02-12-07		A *
9*	F4		CMM	QA	00064	REFER TO IGES	339-E.RO		A

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(950)		10.15						02-12-07		*	
9* (960)	F4	1.63	CMM	QA		00064	REFER TO IGES	339-E.RO 02-12-07		A *	
9* (970)	D4	Ø.25 ∇5.0 └┘Ø.625 ∇3.0	CALIPER	QA		J-707	.625 / 2.94 / .25 / 4.96	339-E.RO 02-12-07		A *	
9* (980)	E2	Ø.25 └┘Ø.625 DETAIL D	CMM	QA		00064	.25 / .625	339-E.RO 02-12-07		A *	
9* (990)	F2	4X Ø1.0 THRU	CALIPER	QA		J-707	1.00	339-E.RO 02-12-07		A *	
11* (1010)	E5	 AS CAST SURFACES	CMM	QA		00064	-.267 TO .253 [N/C: 21142-Doc:NC21142]	339-E.RO 02-12-07		R *	
11* (1020)	C8	 WING SURFACES	CMM	QA		00064	-.0371 TO +.026 [N/ C:21142-Doc:NC21142]	242-M.G 02-12-07		R *	
11* (1030)	D1	 WING POCKET	CMM	QA		00064	-.076 TO .004 [N/C: 21142-Doc:NC21142]	339-E.RO 02-12-07		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	TAPE MEASURE	QA		P-5139	ACCEPT	339-E.RO 02-12-07		A *	
* (1050)		VERIFY CLEARANCE ABOVE SPOTFACE 3" DIAMTER CYLINDER 3" HIGH 1/4" BLEND IN RADIUS WERE APPLICABLE.	TAPE MEASURE	QA		P-5139	ACCEPT	339-E.RO 02-12-07		A *	

Workorder: 65708/5-0 Sub:1 Op:136

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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)								02-08-07			*
*		<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	242-M.G			A
(20)								02-12-07			*

Workorder: 65708/5-0 Sub:1 Op:140

Revision:

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	.7 GOHMS	503-B.HO			A
(10)								02-08-07			*
*		<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	2.2 GOHMS	503-B.HO			A
(20)								02-08-07			*

Workorder: 65708/5-0 Sub:11 Op:30

Revision:

Part: SE141-139 - SHORT BEARING PLATE TYPE "B" -

Drawing ID: SE141-139 Rev: 1			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
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INSPECTION DATA CHECKLIST

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SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1* (10)	G2	RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1270	LESS THAN 1.02	854-R.UP 07-09-06			A *

Workorder: 65708/5-0 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	
1* (10)	G2	RECORD MAGNETIC PERMEABILITY. RESULTS TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	854-R.UP 07-16-06			A *

* To Far Right Indicates Data Package Requirement

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