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REV	DATE	APPROVAL	DESCRIPTION
В	06/02/2003	DCN E030308-00-E	
С	08/15/2003	DCN E030418-00-E	
Е	08/04/2008	A. STEIN	BROKE INTO 2 SEPARATE CONFIGURATIONS. HAM HEPI CONFIG IS SHORTER BY 1.65".

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NOTES:

1) BREAK ALL SHARP EDGES.

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2) AGE C-300 FOR 6 HOURS @ 925°F AIR COOL. CERTIFICATE OF HEAT TREAT REQUIRED. TEST FOR ROCKWELL HARDNESS (1 ONLY). CERTIFICATE REQUIRED.

3) JOIN ASSEMBLY PER FOLLOWING PROCEDURE:

WIRE BRUSH THREADS ON MATING PARTS. SOLVENT CLEAN TO REMOVE OILS. APPLY SILVER SOLDER PASTE (ALL-STATE SILVER SOLDER OR EQUIVALENT) TO MATING THREADS ON CLEANED, DRY PARTS. ASSEMBLE PARTS. CONNECTORS (D020407) MUST SEAT FULLY TO OBTAIN 24.00" ± .06" OVERALL LENGTH. BAKE FOR 4 HOURS @ 400°F. REMOVE PARTS AND AIR COOL TO 120°F. WIRE BRUSH TO REMOVE EXCESS FLUX.

4) ELECTROLESS NICKEL PLATE ASM PER FOLLOWING PROCEDURE:

RECOMMENDED SURFACE PREP: CATHODIC ALKALINE CLEAN, 75 ASF, 1 MIN. PUMICE SCRUB AND RINSE. CATHODIC ALKALINE CLEAN, 75 ASF, 15 SEC. WATER RINSE. ANODIC IN 25% SULFURIC ACID, 200 ASF, 2 MIN AT ROOM TEMP. DIP IN CHROMIUM-SULFURICE ACID, 1 MIN. WATER RINSE HOT. WATER RINSE COLD.

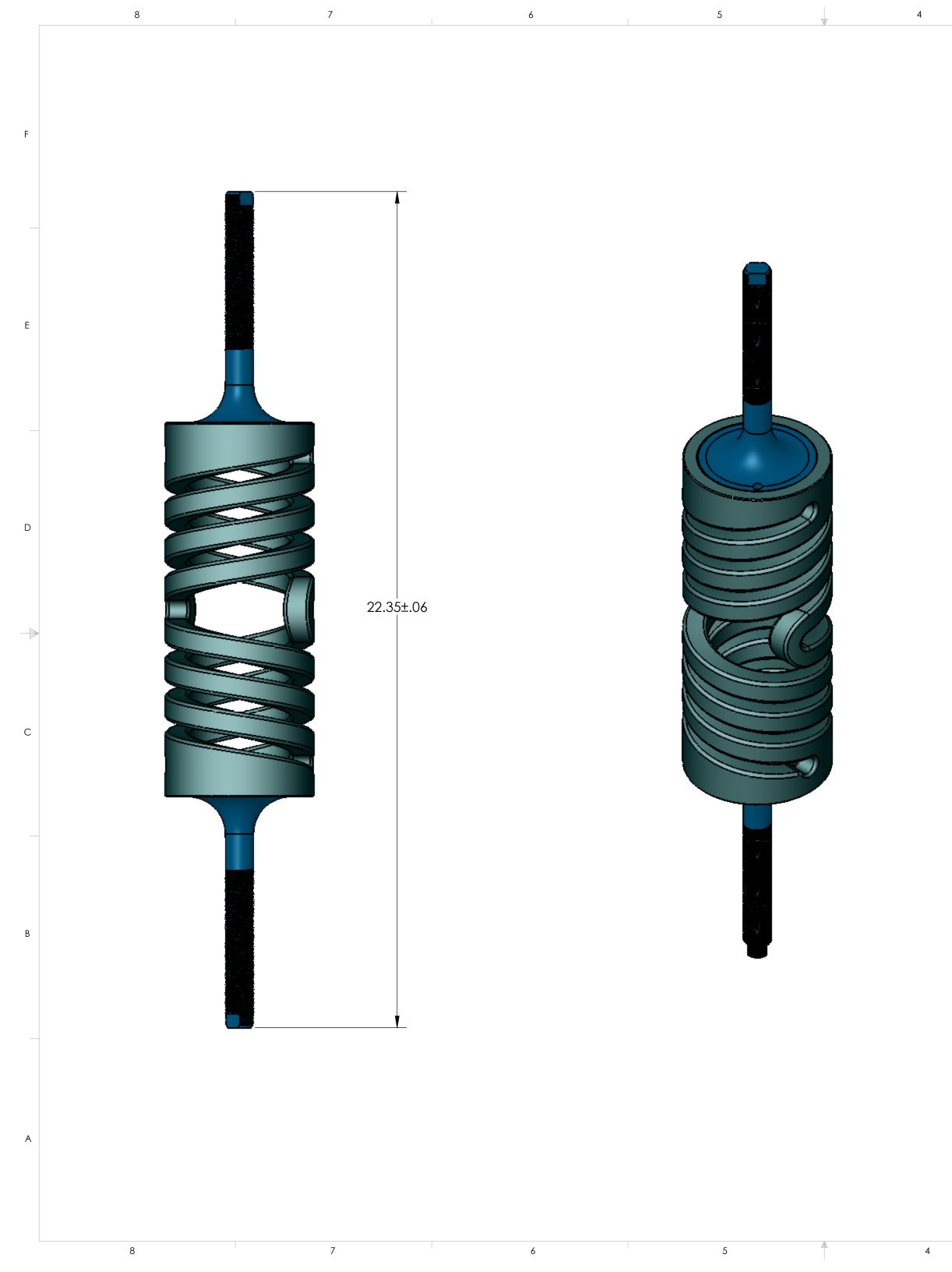
PLATING PROCEDURE: PROTECT 3/4"-20 THREADS ON D020407 PER BEST SHOP PRACTICE. IMMERSE 1 MIN AND PLATE 1 MIN 30 ASF IN ACID NICKEL CHLORIDE BATH AT ROOM TEMP. TRANSFER WITHOUT RINSING TO REGULAR NICKEL PLATING BATH.

CONFIGURATION: **BSC HEPI** TYPE 00

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				BILL OF MATERIALS								
	ITEM NO.	BSC Hepi	PART NUMBER		DESCRIPTION	COI	NFIGL	JRATION	MATERIAL			
1	1	1	D020406	DOUB	DOUBLE START COUNTERWOUND SPRING			-		300 MARAGING STEEL		
	2	2	D020407		BLE START COUNTERW SPRING CONNECTOR)	BSC	HEPI	Steel		
					SPECIFIED)							
					1. DO NOT SCALE FROM DRAWING.		NS ARE IN IN	ICHES	LIGO MASSACHUSETTS INSTITUTE OF TECHNOLOGY			
					2. CLEAN THOROUGHLY TO REMOVE ALL OIL, DIRT, AND CHIPS.	TOLERANC	15		IGR, GLASGOW UNIVERSITY GEO 600 GROUP			
						.XX ± 0.015 .XXX ± 0.005			AL	ligo		
						ANGULAR ± 0.5 °			SUB-SYSTEM SEI			
							SEE BOM		NEXT ASSY D030320			
						FINISH						
						SE	ENOT			OUBLE STAF		
						DRAWN	MAME M.	DATE 05/14/2003	_		REV.	
						CHECKED	HAMMOND	00/14/2000	C	D020408	D	
						ATTROVED			SCALE: 1:2 PRO	Jection: 🕀 🖯	SHEET 1 OF 2	
			3		2					1		



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		REV	DATE	APPROVAL	DESCRIPTION	
		-	-	-	See Sheet 1.	_
						_
						F
NOTES:						
1) B	REAK ALL SHARP	edg	ES.			
AIR	AGE C-300 FOR 6 1 COOL. CERTIFIC, I FOR ROCKWELL	ATE (OF HEA	T TREAT R	EQUIRED. CERTIFICATE REQUIRED.	E
3) J	OIN ASSEMBLY PE	R FC	DLLOWI	NG PROC	EDURE:	
SOL APF TC ASS TC BAK REA) MATING THREAD	REM(R PA) OS ON ONNI 06'' (0 400 AIR	OVE OII STE (ALI N CLEA ECTORS OVERAL D°F. COOL	ls. L-state SI NED, DRY S (D02040 L LENGTH TO 120°F.	7) MUST SEAT FULLY	
4) E	LECTROLESS NICK	EL P	LATE AS	SM PER FC	DLLOWING PROCEDURE:	
C/ PU C/ W/ Al DI W/	Commended Sur Athodic Alkalin Imice Scrub And Athodic Alkalin Ater Rinse. Nodic In 25% Sul P In Chromium-S Ater Rinse Hot. Ater Rinse Cold	IE CL D RIN IE CL FURI SULFL	LEAN, 7 ISE. LEAN, 7 C ACIE	5 ASF, 1 N 5 ASF, 15), 200 ASF	SEC. , 2 MIN AT ROOM TEMP.	D
PR	TING PROCEDURE	READ	DS ON [D020407 F	PER BEST SHOP PRACTICE.	

IMMERSE 1 MIN AND PLATE 1 MIN 30 ASF IN ACID NICKEL CHLORIDE BATH AT ROOM TEMP. TRANSFER WITHOUT RINSING TO REGULAR NICKEL PLATING BATH.

CONFIGURATION: **HAM HEPI** TYPE 01

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	BILL OF MATERIALS													
	ITEM NO.	HAM HEPI	PART NUMBER		DESCRIPTION			CONFIGUR			N N	MATERIAL		
\square	1	1	D020406	DOUBLE START COUNTERWC SPRING			DNUC				300 MARAGIN STEEL			5
	2	2	D020407	DOUBLE START COUNTERWOUND SPRING CONNECTOR					HAM HEPI			4340 Steel		
					NOTES: (UNLESS O 1. DO NOT SCALE FROM DRAWING, 2. CLEAN THOROUGHLY TO REMOVE ALL OIL, DIRT, AND CHIPS.		SE SPECIFIED) DIMENSIONS AF TOLERANCES: .XX ± 0.015 .XXX ± 0.005 ANGULAR± 0.5 MATERIAL SEE FINISH SEE N		M ES 05/14/2003	SUB-SYSTEM NEXT ASSY PART NAME	D030320 DOUBL IERWOUT	CED LI	GO NG AS	M REV.
			3			2					1			