1) Break all sharp edges

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 the following procedure:
   - Wire brush threads on mating parts.
   - Solvent clean to remove oils.
   - Apply silver solder paste (All-State Silver Solder or equivalent) to the mating threads of the cleaned and dry parts.
   - Assemble parts together. Assure that Connectors (D020407) seat entirely to obtain 24" overall length.
   - Bake at 400 degrees for 4 hours.
   - Remove parts and allow cooling to 120 degrees.
   - Wire brush to remove excess flux.

4) Electroless Nickel Plate per the 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 temperature
     - Dip in chromium-sulfuric acid 1 min.
     - Water Rinse hot
     - Water rinse Cold
   - Electroless Nickel Plating
     - Protect 3/4-20 threads on D020407 per best shop practice.
     - Immerse 1 minute and plate one minute at 30 asf in acid nickel chloride bath at room temperature. Transfer w/out rinsing to regular nickel plating bath.

1) Break all sharp edges
SECTION D-D
SCALE 1 : 1

Double start profile:
- Pitch 2° (far side near side)
- Revolutions: 2
- Left side: CCW
- Right side: CW

Width of cut: .334

.085 Fillet typ farside and nearside

3 1/4-16 UN-1A thread x .385 deep typ both sides

.25 fillet typ 4 pcs
**CHANGE DESCRIPTION (FROM/TO):**

Added flat for a 5/8 wrench on part Double Start Counterwound Spring Connector (D020407-B-E).

Sheet 3 affected only.

**REASON FOR CHANGE:** ease of installation

**ACTION:**
- Incorporate Change
- Attach DCN to Drawings
- Other Action (specify):

**DISPOSITION OF HARDWARE (IDENTIFY SERIAL NUMBERS)**

- No hardware was affected (record change only):
- List S/Ns which comply already:
- List S/Ns to be reworked/scrapped:
- List S/N’s to be built with this change: all
- List S/Ns to be retested per this change: all

**DCN DISTRIBUTION**

- Barish
- Coles
- Coyne
- Lazzarini
- Lindquist
- Sanders
- Shoemaker
- Stapfer
- Tyler
- Weiss
- Whitcomb
- Matherny
- Raab

**SAFETY, COST, SCHEDULE, REQUIREMENTS IMPACT?**

- NO
- YES (If YES, enter CR (CCB) or TCP (TRB) #)

**APPROVALS:**

<table>
<thead>
<tr>
<th>ORIGINATOR:</th>
<th>DATE</th>
<th>OTHER APPROVALS (SPECIFY)</th>
<th>DATE</th>
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</thead>
<tbody>
<tr>
<td>Marcel Hammond</td>
<td>8/14/03</td>
<td>Brian Lantz</td>
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<tr>
<td>TASK LEADER:</td>
<td>Jonathan Kern</td>
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<tr>
<td>GROUP LEADER:</td>
<td>Dennis Coyne</td>
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<td>DCC RELEASE:</td>
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