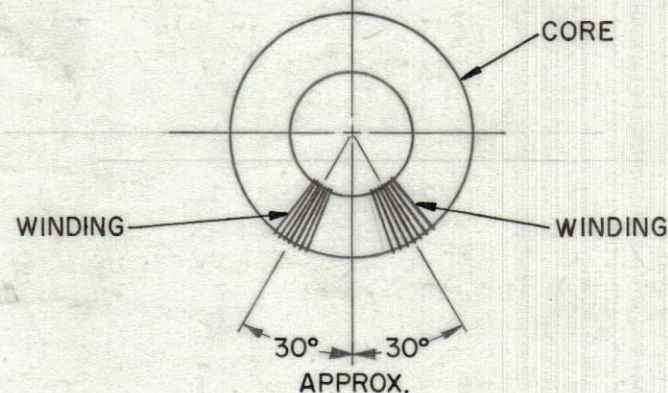
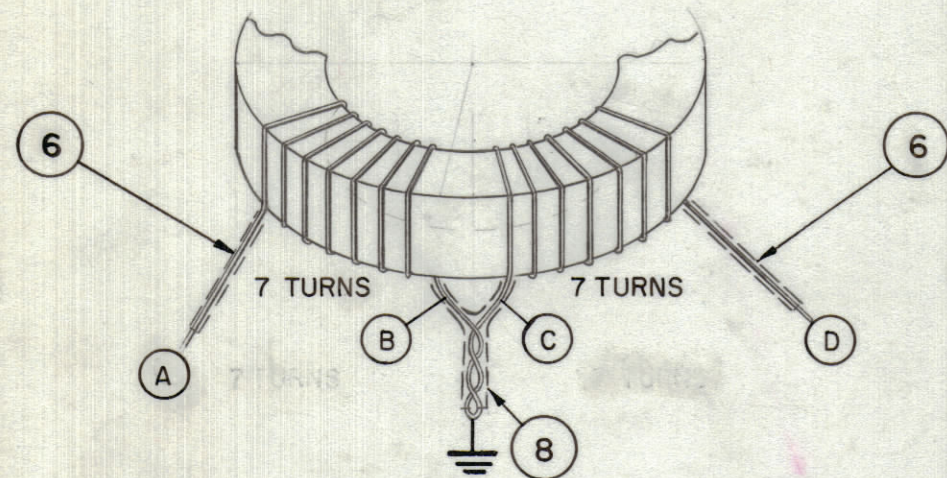


STEP 1 - WINDING INSTRUCTIONS

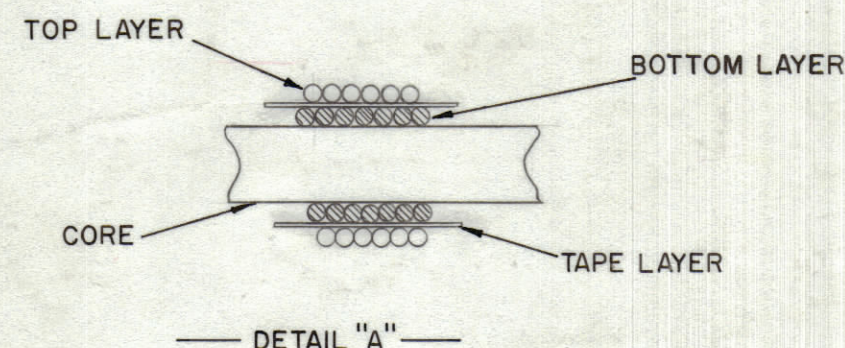
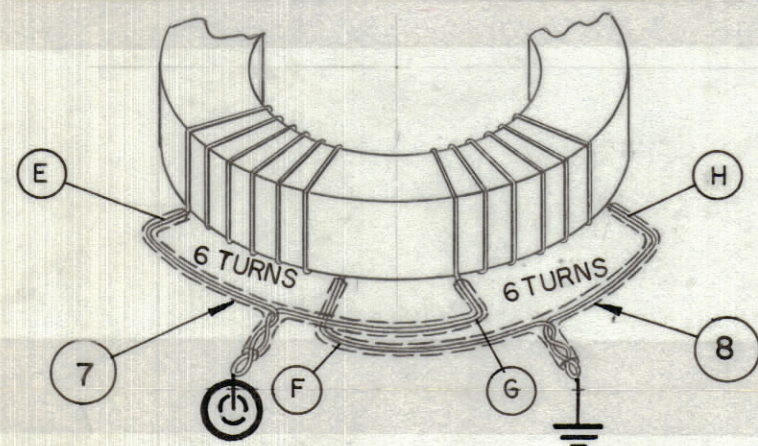
- A. Bottom Layer (secondary)  
Close wind as shown keeping wire taut. Center of left winding should be 60° from center of right winding. Wire, (item 4). Stake winding to core with (item 11) cement. Leave leads approximately 2" long.
- B. Cover secondary with layer of tape (item 9).\*



C. Top Layer (Primary)

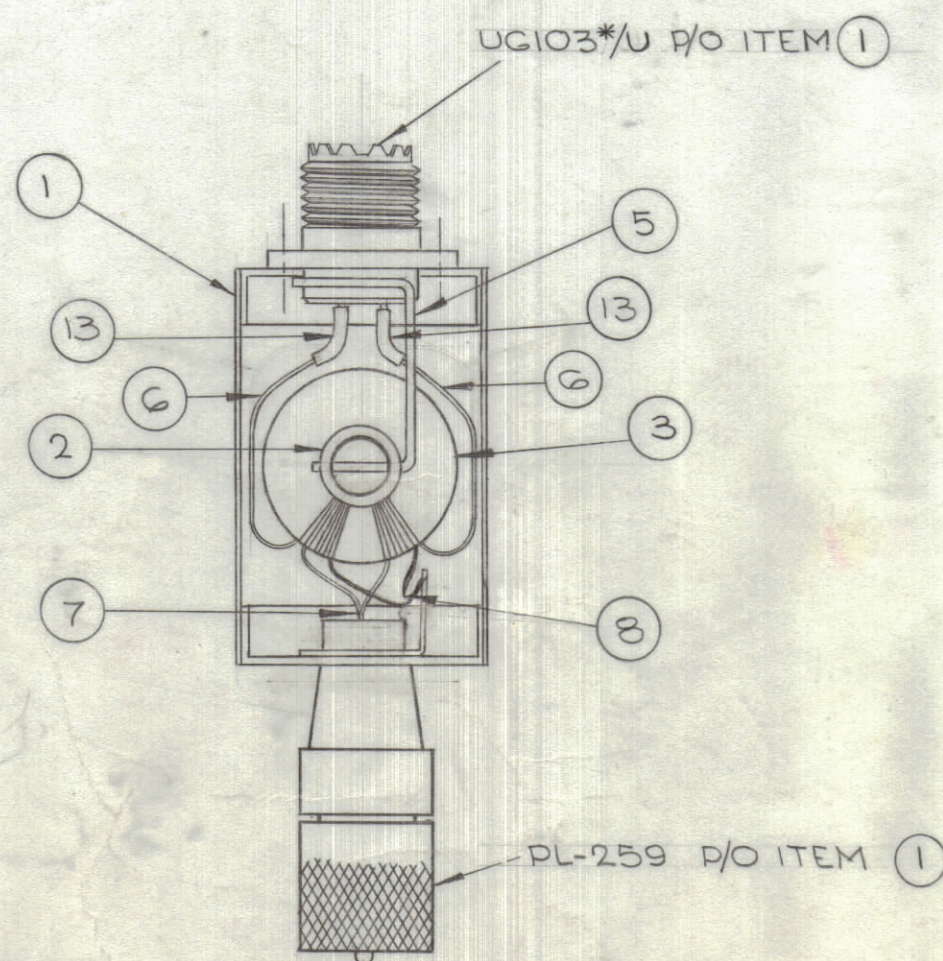
Wind Primary as shown using wire (item 4).  
CAUTION: WIRE OF UPPER LAYER MUST BE LAID EXACTLY BETWEEN TURNS OF LOWER LAYER (AS SHOWN IN DETAIL "A"). LEAVE LEADS APPROXIMATELY 2" LONG. STAKE WINDING IN PLACE USING (ITEM 11) CEMENT.

\*NOTE:  
Whenever tape is applied it is to be stretched to conform to the curvature of the winding and to be laid as wrinkle free as possible.



STEP 2 - MOUNTING INSTRUCTIONS

- A. Bend stabilizer (item 5) 90° close to coil form (item 2) and stake in place using (item 11) cement.
- B. Insert coil form (item 2) in center of core (item 3) and cement in place with (item 11).
- C. Add second stabilizer (item 5) in the same manner as in "A" above.
- D. On leads "A" and "D" of the secondary winding, slip red sleeving (item 6) on 2" leads. Then slip a 3/8 inch length of Black sleeving (item 13) over the red sleeving (item 6). Solder leads "A" & "D" to twin contact receptacle mounted in one of the covers, one lead to each contact. Take care not to run solder inside contacts. Pull down the black sleeving (item 13) over the contacts. Coat with (item 11) cement, to seal against leakage of potting compound into contacts.
- E. Solder stabilizers (item 5) to the cover carrying the twin contact receptacle. Also solder leads B, C, F & H to the solder lug mounted on the cover.
- F. Join leads "E" and "G" near winding and solder together making a single lead about 3" long covered with (item 7) red sleeving.
- G. Insert cover with items 2, 3, 4 & 5 assembled into can and solder in place. The lead connected from "E" & "G" should protrude from the other end of can and be positioned in the center of the opening at that end of the can.
- H. Insert the remaining cover into the can and feed the lead into the center pin of the plug (PL-259). If necessary remove cover and trim lead to suit. Replace cover and solder lead into pin temporarily. Solder one corner of cover to case.
- J. Pre-test as per (step 4) before potting.



NOT TO BE RELEASED  
WITHOUT AUTHORIZATION

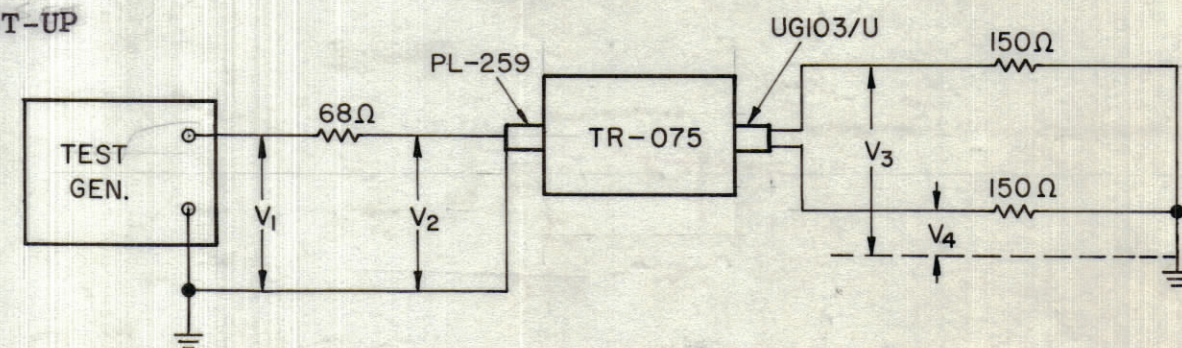
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE NONE	CODE A	
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.		

REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD
B	-	REPLACES REV. A W/CHANGES	1/18/63	9811	50	100

STEP 3 POTTING & FINISH

- A. Remove cover installed during "H" above and bake XFMR for 1/2 hour at . Then using (item 12) pot to within 3/8" of top.
- B. When potting compound (item 12) has hardened, replace cover and solder in place.
- C. Smooth all seams.
- D. Prime can with S-114 Zinc Chromate Primer and finish with, S-115 smooth gray enamel.
- E. Stamp TMC part no. 1/8 high black gothic per TMC Spec S-727. Also stamp TMC emblem (NP-493) in black, both on side of can.

TEST SET-UP



TEST FREQ.	R. F. VOLTS			
	V1	V2	V3	V4
2 MC	1.0	0.40-0.50	0.45-0.55	0.45-0.55
8 MC	1.0	0.40-0.50	0.45-0.55	0.45-0.55
16 MC	1.0	0.40-0.50	0.45-0.55	0.45-0.55
32 MC	1.0	0.40-0.50	0.42-0.52	0.42-0.52

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	13	PX-100-1-085	INSULATION SLEEVING	BLACK
X	12	GL-10002	COMPOUND, POTTING	
X	11	GL-103	ADHESIVE	
X	10	BS-100	SOLDER, SOFT	
X	9	TA-100-1	TAPE, VINYL PLASTIC	
X	8	PX-104-1-034	INSULATION SLEEVING	BLACK
X	7	PX-104-4-034	INSULATION SLEEVING	GRN
X	6	PX-104-3-034	INSULATION SLEEVING	RED
2	5	MS-10259	STABILIZER	
X	4	WI-10001-11	WIRE, ELEC	
1	3	CI-10001-3	CORE	
1	2	CF-10012	FORM, COIL	
1	1	A-3446	CASE & COVERS	

R. HAY LIST OF MATERIAL

MATERIAL: \_\_\_\_\_

FINISH: \_\_\_\_\_

TITLE: TRANSFORMER (TR-075)

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES

DECIMALS: .X ± .05, .XX ± .01, .XXX ± .005

FRACTIONS: ± 1/64

ANGLES: ± 0° 30'

DRAWN: [Signature] DATE: 1/18/63

CHECKED: [Signature] DATE: 12/27/63

ELECT. DES. DATE: \_\_\_\_\_

MECH. DES. DATE: \_\_\_\_\_

FINAL APPROVAL: [Signature] DATE: \_\_\_\_\_

SHEET: A-10128 B

A-10128 B