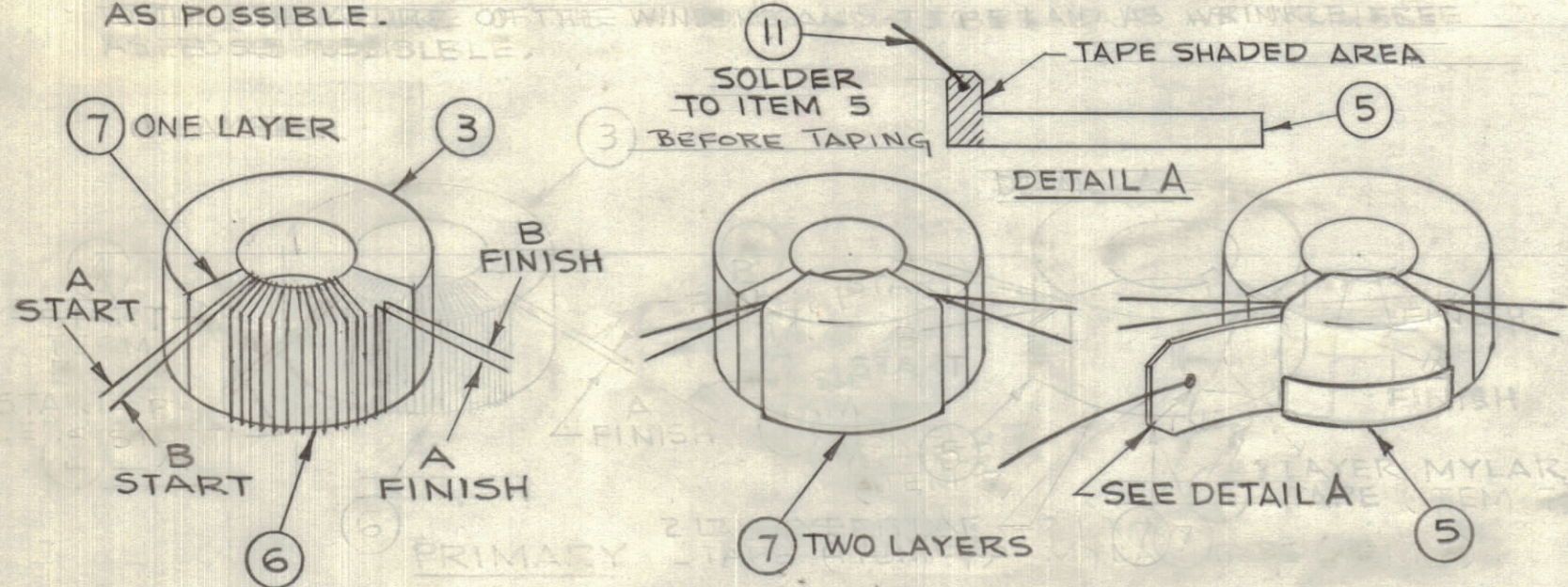


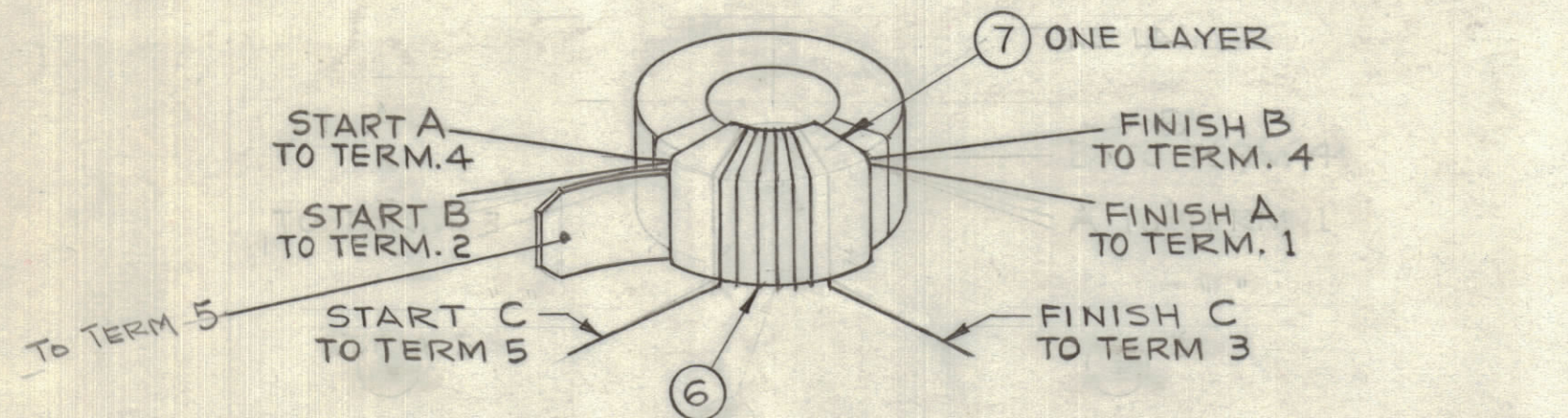
**STEP 1 - PRIMARY WINDING INSTRUCTIONS**

1. WIND ONE LAYER OF TAPE (ITEM 7) ON THE CORE.\*
  2. BIFILAR WIND TWO CONDUCTORS WIRE (ITEM 6) FOR 9 FULL TURNS (18 TURNS-TOTAL) KEEPING TURNS CLOSE TOGETHER. CARE MUST BE TAKEN TO LAY THE TURNS STRAIGHT AND TO MAKE THE TURNS ON THE RIGHT THE MIRROR IMAGE OF THE TURNS ON THE LEFT TO PRESENT A BALANCED APPEARANCE.
  3. SECURE WITH CEMENT (ITEM 8).
  4. WHEN DRY, COVER WITH TWO LAYERS OF TAPE (ITEM 7) INSULATE WITH TAPE (ITEM 7) THE TAB END OF SHIELD (ITEM 5) SEE DETAIL A AND INSTALL THE SHIELD BY WINDING IT OVER THE PRIMARY WINDING FOR ONE COMPLETE TURN PLUS SLIGHT OVERLAP. CUT OFF EXCESS SHIELD LENGTH MAKING SURE THAT BEGINNING AND END DO NOT MAKE ELECTRICAL CONTACT.
  5. COVER SHIELD WITH ONE LAYER OF TAPE (ITEM 7).
- \* 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.



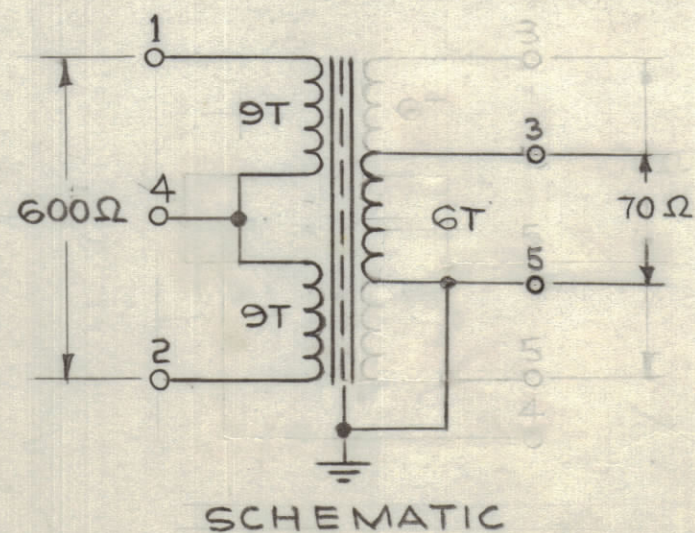
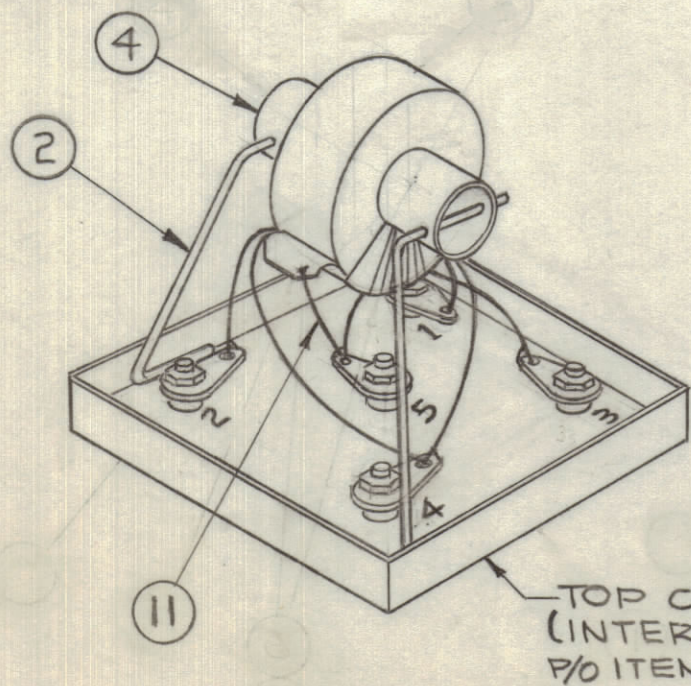
**STEP 2. SECONDARY WINDING INSTRUCTIONS**

1. CLOSE WIND SIX FULL TURNS OF WIRE (ITEM 6), CENTER SECONDARY WINDING OVER PRIMARY WINDING.
2. LIGHTLY CEMENT SECONDARY WINDING. CARE MUST BE EXERCISED THAT MANDREL THROUGH CORE DOES NOT BIND. POSITION WINDING TO PROVIDE 40 DB, OF BALANCE TO UNBALANCE VOLTAGE RATIO AT 30 M/CS.



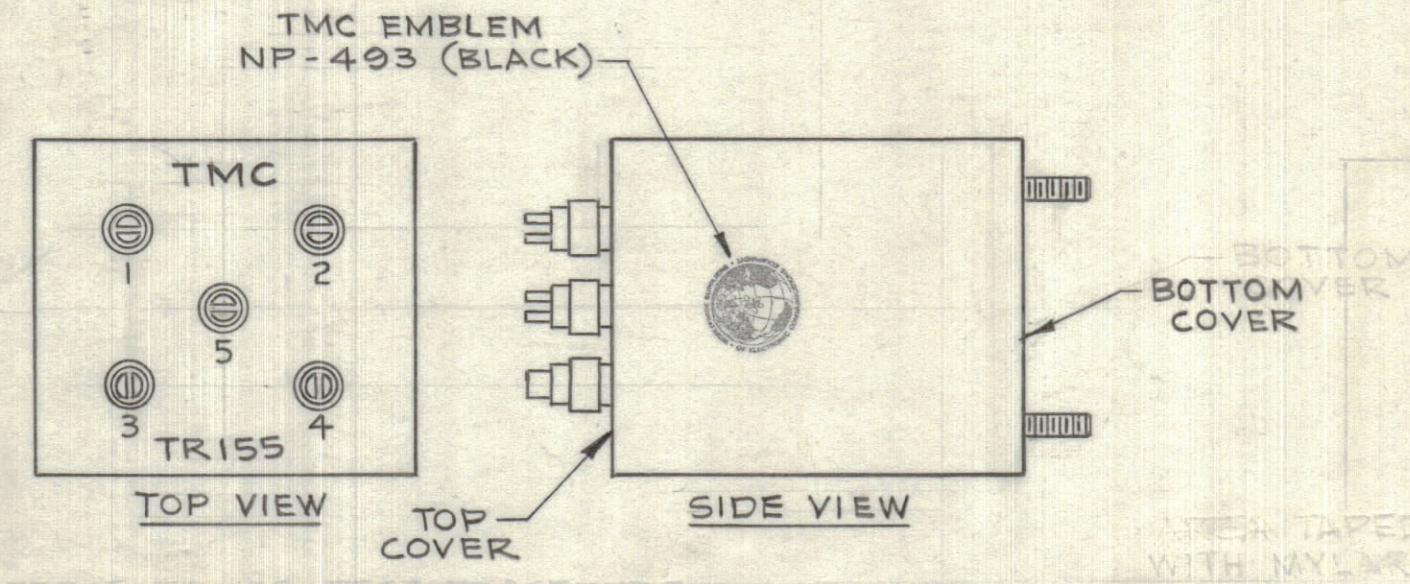
**STEP 3. CONNECTIONS**

1. ASSEMBLE STABILIZERS (ITEM 2) TO COIL FORM ASSEMBLY AND ATTACH TO TOP COVER.
2. SOLDER LEADS TO TERMINALS. MAINTAIN LEAD LENGTHS AS SHORT AS PRACTICABLE.
3. SOLDER WIRE (ITEM 11) TO TERMINAL 5.
4. SOLDER TOP COVER INTO CASE.



NOTES

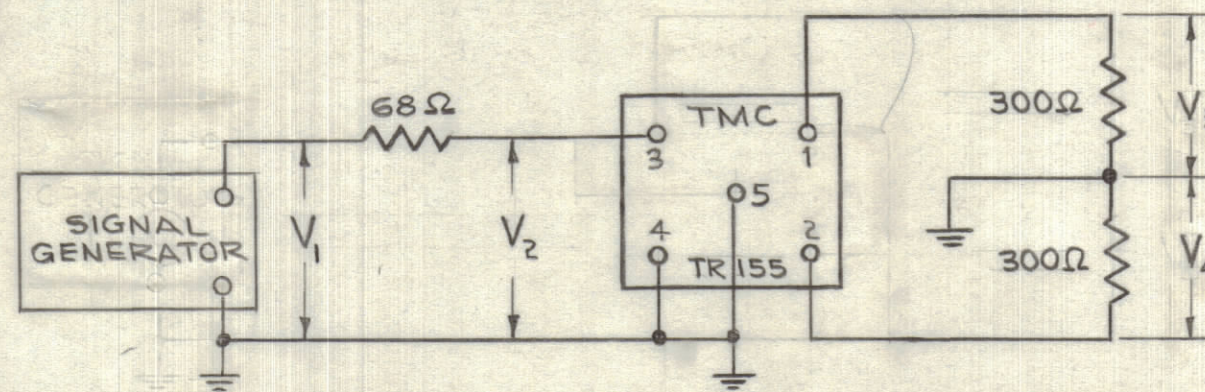
- STEP 4. 1. PRETEST ACCORDING TO STEP 6 REQUIREMENTS, PRIOR TO ACTUAL POTTING.**
- STEP 5. POTTING & FINISH.**
1. AFTER PRETEST, BAKE ASSEMBLY FOR ONE HOUR AT 80°C, POT IMMEDIATELY WITH COMPOUND (ITEM 9) TO WITHIN 3/8 OF BOTTOM.
  2. SOLDER BOTTOM IN PLACE AND SMOOTH ALL SEAMS.
  3. PRIME CASE WITH S-114 (ZINC CHROMATE PRIMER) AND FINISH TOP AND SIDES ONLY WITH S-115 (SMOOTH GRAY ENAMEL).
  4. STAMP TOP AND SIDES WITH 1/8 HIGH BLACK GOTHIC LETTERING. AS SHOWN.



**STEP 6. TEST EQUIPMENT REQUIRED**

1. VTVM HEWLETT PACKARD 410B OR EQUIVALENT.
1. RF GENERATOR MEASUREMENTS CORP. MO. 82 OR EQUIVALENT.
2. 300 OHM 1/2 WATT RESISTORS ± 5%, CARBON
1. 68 OHM 1/2 WATT RESISTOR ± 5%, CARBON

**TEST CIRCUIT SHOWN BELOW:**



**ELECTRICAL TEST DATA**

FREQUENCY	RF VOLTS			
MC	V <sub>1</sub>	V <sub>2</sub>	V <sub>3</sub>	V <sub>4</sub>
2	1.0	.48	.715	.715
4	1.0	.48	.715	.715
8	1.0	.46	.69	.69
16	1.0	.40	.67	.67
30	1.0	.38	.59	.59

READINGS BASED ON POTTED UNIT TOLERANCE ± 10%

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**ELECTRICAL TEST DATA**

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READINGS BASED ON POTTED UNIT TOLERANCE ± 10%

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	11	WL-100-7	WIRE, BUS-BAR, TINNED	
X	10	BS-100	SOLDER, SOFT	
X	9	GL-10003	COMPOUND, POTTING, ARALDINE	
X	8	GL-10001	CEMENT, RADIO SERVICE	
X	7	TA-10002-2-T	TAPE, MYLAR	
X	6	WI-10001-11	WIRE, 30 DCC	
1	5	MS-10487	SHIELD	
1	4	CF-10012	COIL FORM	
1	3	CI-10001-3	CORE, 3C TOROIDAL	
2	2	MS-10259	STABILIZER	
1	1	BX-10011	CASE AND COVERS	

**LIST OF MATERIAL**

MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH		TITLE TRANSFORMER ASSEMBLY TR-155			
QTY./UNIT	TR 155	MODEL USED ON	ASSY. NO.	DRAWN	DATE
SCALE	NONE	CODE		CHECKED	DATE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DECIMALS	FRACTIONS	ELECT. DES.	DATE
TOLERANCES		.X ± .05	± 1/64	MECH. DES.	DATE
		.XX ± .01	ANGLES ± 0° 30'		
		.XXX ± .005			

REVISIONS					
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	APPD
~	D	REVISED & REDRAWN	5-31-63	2257	JNY JLB VSP

A-10280 D