

A-1248

WINDING MACHINE DATA

CAM GEAR - 105
 DRIVER GEAR - 69
 CAM - .250

WINDING PROCEDURE (UNIVERSAL)

PRIMARY - START $\frac{3}{8}$ " FROM END OF COIL FORM.

WIND ON 220 TURNS OF ITEM 2.

STAKE COIL ENDS WITH ITEM 4.

SECONDARY - START $\frac{1}{2}$ " FROM PRIMARY AS SHOWN.

WIND ON $62\frac{1}{2}$ TURNS.

BRING OUT TAP.

END WINDING AT 125 TURNS.

STAKE ENDS & TAP WITH ITEM 4.

COIL ENDS & TAP TO BE APPROX 2" LONG.

BAKE FOR $\frac{1}{2}$ HOUR AT 215°F. SATURATE COILS WITH ITEM 3 AND AIR DRY FOR 10 MIN. BAKE FOR 2 HOURS AT 215°F.

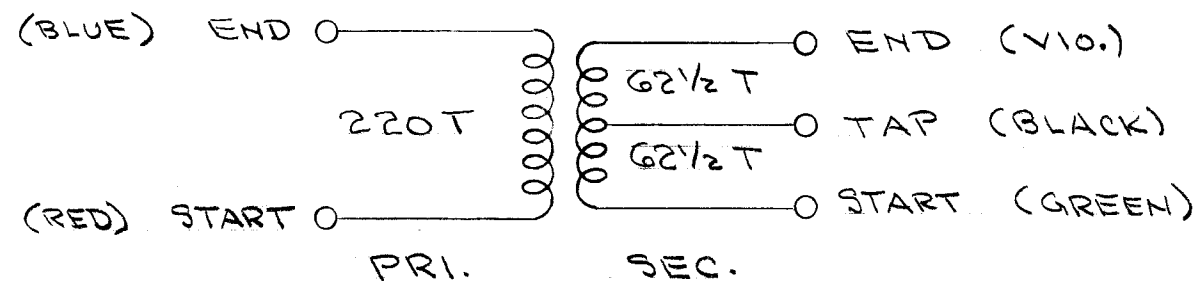
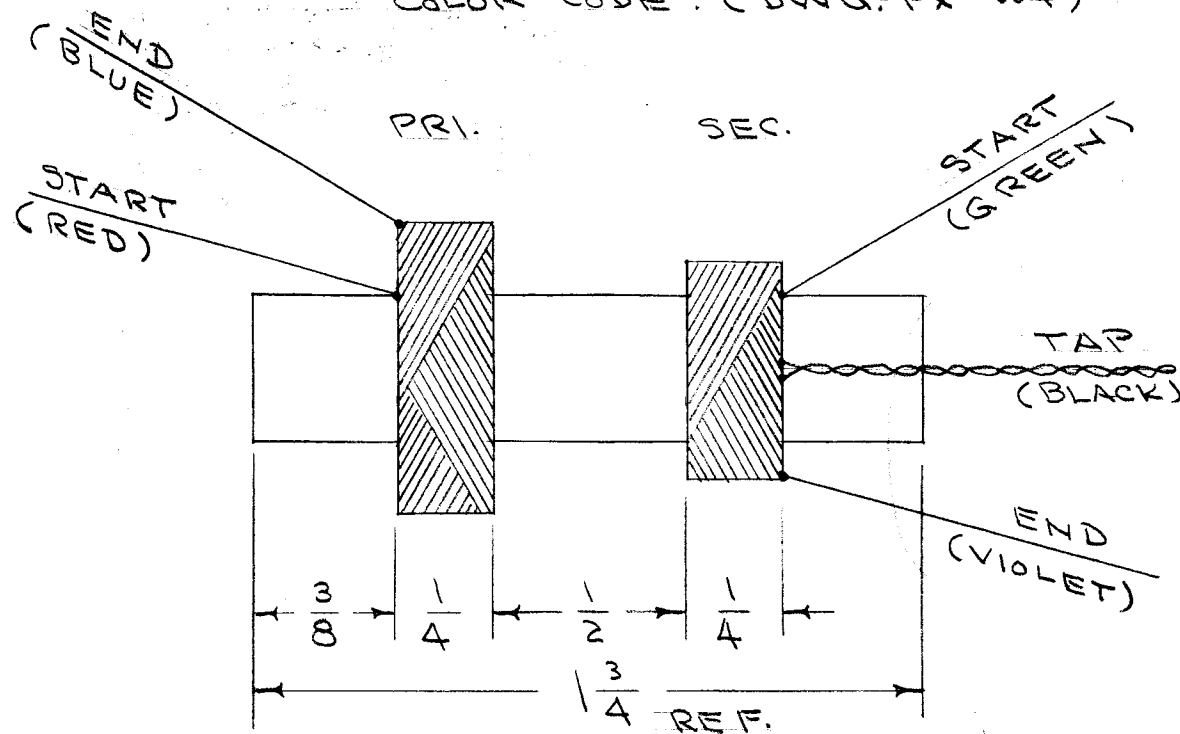
TEST (W/O CORE)

USE BOONTON Q METER 160A OR EQUIVALENT.

TEST LEADS TO BE $\frac{1}{2}$ " LONG.

	PRI. BLUE/RED	SEC VIO/GRN	1/2 SEC GRN/BLACK
L	520μh (493-547)	152μh (144-160)	50μh (45-55)
F	790 KC	790 KC	2.5 MC
Q	GREATER THAN 60	GREATER THAN 80	GREATER THAN 20

COLORS SHOWN REFER TO TERMINAL BOARD COLOR CODE. (DWG. PX-334)



NOTICE TO PERSONS RECEIVING THIS DRAWING

THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from THE TECHNICAL MATERIEL CORPORATION to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.

Property of:
 THE TECHNICAL MATERIEL CORPORATION
 MAMARONECK, NEW YORK

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 4	GL-103	CEMENT	
X 3	GL-104-2	INSULEX, U-85	
X 2	WI-104-541-DSQS	WIRE, MAGNET	
1 1	CF-100	COIL FORM	
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
I.F. XFMR SUB ASSY.			
MATERIAL			
XTAL FILTER			
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	1	test data chgd	6/14/56	1	HQ	P.L.X	A.J.J.
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. ±							
ANGULAR DIM. ±							

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	FFRD-1,2,3	E-458-7	A-1249	3-15-56
USED ON				