

A-1307

ASSEMBLY

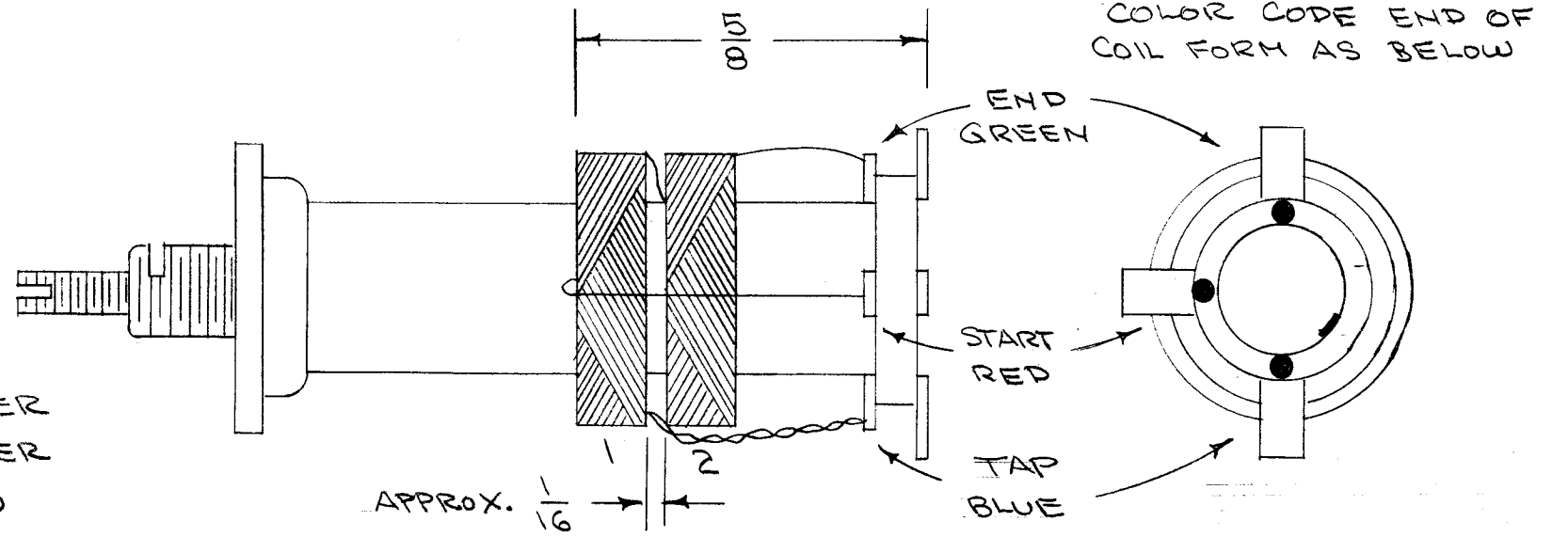
AFFIX COLLAR TO COIL FORM WITH ITEM 6. AIR DRY.

WINDING MACHINE DATA

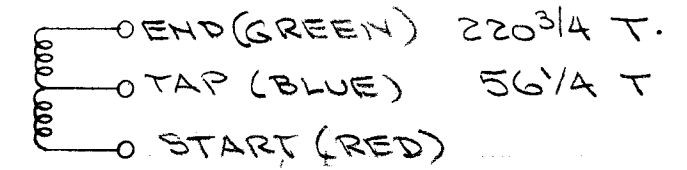
DRIVE GEAR - 95
CAM GEAR - 49
CAM - .125

WINDING PROCEDURE

- 1- START 1st PI 5/8" FROM LUG END OF COIL FORM AND IN LINE WITH RED LUG. (USE WINDING FINGER WITH GUIDE ON LEFT. START WINDING WITH FINGER IN EXTREME LEFT HAND POSITION OF TRAVEL.)
- 2- TAP 1st PI AT 56 1/4 T. ADJACENT TO BLUE LUG.
- 3- END 1st PI AT 110 TURNS.
- 4- START 2nd PI 1/16" FROM 1st PI.
- 5- END 2nd PI AT 220 3/4 T. ADJACENT TO GREEN LUG.
- 6- STAKE TAP & ENDS TO COIL FORM WITH ITEM 6. AIR DRY.
- 7- BAKE FOR 1/2 HOUR AT 215° F. SATURATE COIL WITH ITEM 5 AND AIR DRY FOR 10 MIN. BAKE FOR 2 HOURS AT 215° F.

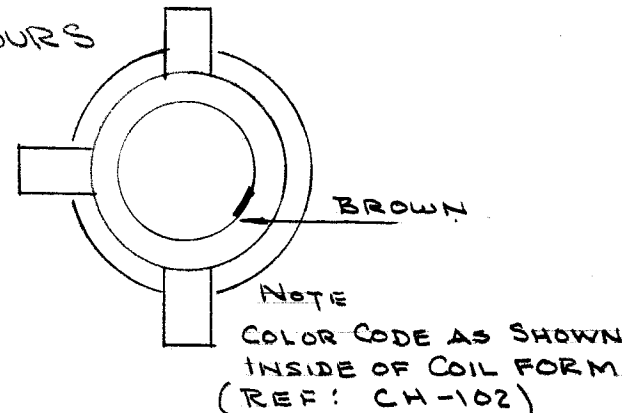


TAP 1 st PI	56 1/4 TURNS FROM START
END 1 st PI	110 " " "
END 2 nd PI	220 3/4 " " "



TEST DATA w/o CORE

	RED/GREEN	GREEN/BLUE (GND)
L	650 μh (615 TO 685)	400 μh (360 - 440)
Q	790	> 75
F	790 KC	790 KC



USE BOONTON Q METER
160A OR EQUIVALENT

MISC TEST DATA WITH CORE

OUT OF CAM
MIN. L .72 mh Q-110 F-780 KC
MAX. L 1.57 mh Q-120 F-245 KC

IN CAM
MIN. L .64 mh Q 83 F-780 KC
MAX. L 1.3 mh Q 50 F-245 KC

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
1	8	SP-102	LOCKING SPRING
X	7	BS-100	SOLDER, SOFT
X	6	GL-103	CEMENT, DUCCO
X	5	GL-104-2	INSULEX, U85
X	4	WI-104-5A1DSQS	WIRE, 5/16 DSQS
1	3	CI103D7B5	CORE
1	2	TE-146-3	COLLAR & LUGS
1	1	CF-114-3	COIL FORM

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	1	TEST DATA CHGD.	6/14/56	2	JAR	P.L.X.	A.J.J.
A	1	COLOR CODE ADDED	5/31/56	1	JAR	P.L.X.	A.J.J.

TOLERANCES: DEC. DIM. ±, FRAC. DIM. ±, ANGULAR DIM. ±

SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

2	FFRD-3	458	A-1314	5-28-56
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
MIXER & RF COIL SUB ASSY.			
T301 - T302 FFRD-3			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
		5/28/56 JAR	A.J.J.
		P.L.X.	WC
		A-1307	B