

A-1308

WINDING MACHINE DATA

DRIVER GEAR - 95  
 CAM GEAR - 49  
 CAM - .125

ASSEMBLY

AFFIX ITEM 2 ON END OF COIL FORM WITH ITEM 6. AIR DRY.

WINDING PROCEDURE

- 1- START WINDING 1/2" FROM LUG END OF COIL FORM AND IN LINE WITH BLACK LUG. (USE WINDING FINGER WITH GUIDE ON LEFT. START WINDING WITH FINGER IN EXTREME LEFT HAND POSITION OF TRAVEL.
2. TAP AS SHOWN IN SCHEMATIC, AT 3 3/4 T & AT 6 3/4 T. END P1 AT 100 1/2 T.
- 3- STAKE ENDS & TAPS TO COIL FORM WITH ITEM 6. AIR DRY.
- 4- SOLDER CONNECT ENDS & TAPS AS SHOWN.
- 5- BAKE FOR 1/2 HOUR AT 215° F. SATURATE COIL ITEM 3 AND AIR DRY FOR 10 MIN. BAKE FOR 2 HOURS AT 215° F.

TEST DATA W/O CORE

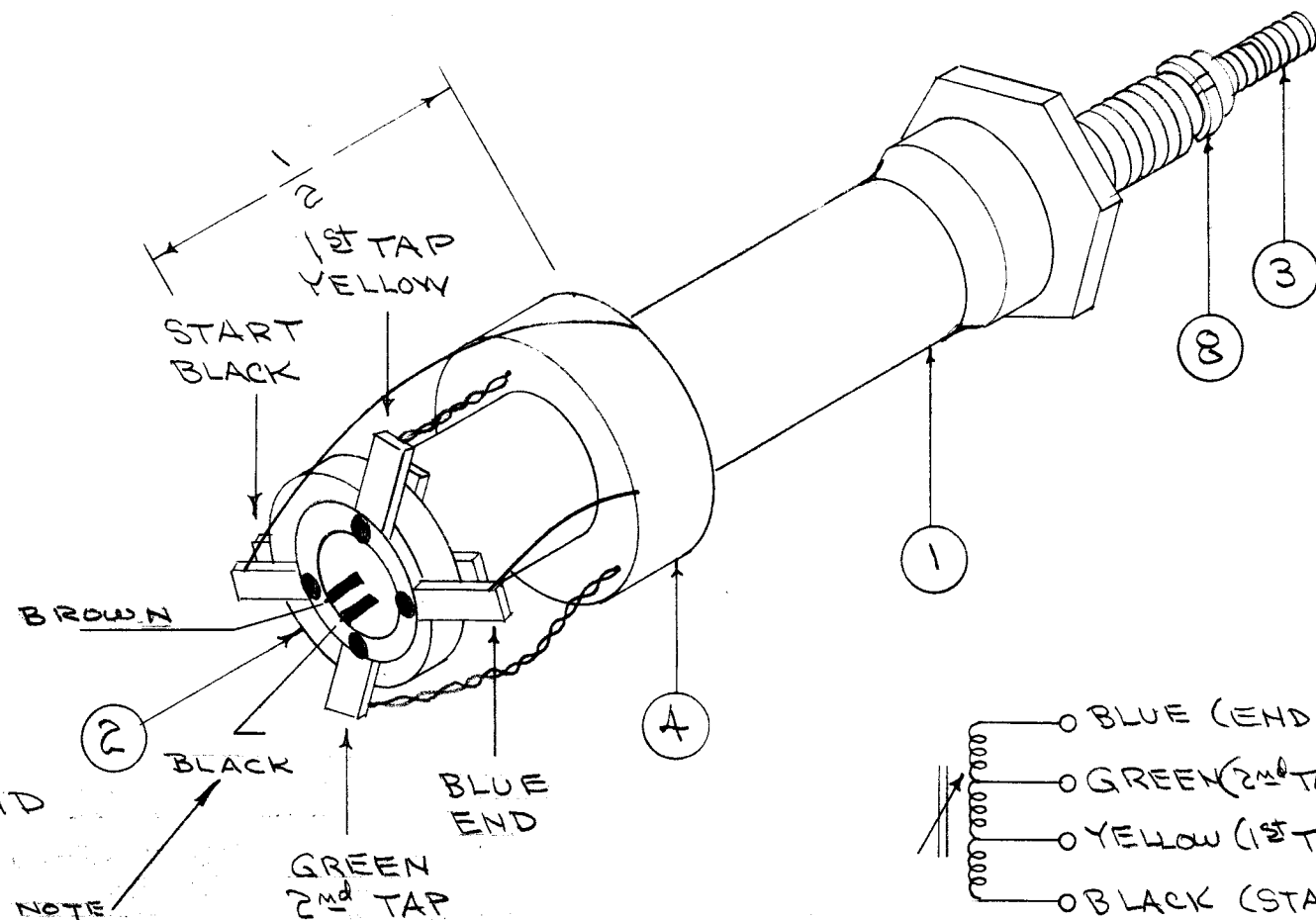
USE BOONTON Q METER 160A OR EQUIVALENT.

	BLACK/BLUE	BLACK/GREEN	BLUE/YELLOW
L	196 $\mu$ h (186 to 206)	100 $\mu$ h (90 - 110)	110 $\mu$ h (100 - 120)
Q	> 30	> 20	> 50
F	790 KC	2.5 MC	790 KC

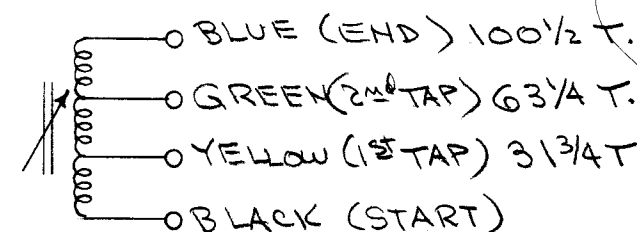
MISC. TEST INFO.

OUT OF CAN, WITH CORE F = 780 KC  
 L MAX. 420  $\mu$ h Q: 140  
 L MIN. 196  $\mu$ h Q: 75  
 IN CAN WITH CORE  
 L MAX. 355  $\mu$ h Q: 75  
 L MIN. 185  $\mu$ h Q: 75

COLOR CODE COIL FORM AS BELOW



NOTE  
 COLOR CODE AS SHOWN  
 INSIDE OF COIL FORM  
 (REF: CH-102)



SCHEMATIC DIAGRAM

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-04-5A1DSQS	WIRE, 5A1 DSQS
1	3	CI03 D7B5	CORE
1	2	TE-146-4	COLLAR & LUGS
1	1	CF-114-3	COIL FORM

STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL		OSC. COIL SUB ASSY FFRD-3	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	1	TEST DATA CHGD	6/4/56	2		P.L.K.	A.J.J.
A	1	COLOR CODE ADDED	5/31/56	1		P.L.K.	A.J.J.

DEC. DIM. $\pm$	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES
FRAC. DIM. $\pm$	
ANGULAR DIM. $\pm$	

1	FFRD-3	458	A-1312	5-28-56
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE

USED ON

TYPE & TEMPER HEAT TREAT. SPEC. DRAWN CHECKED FINAL APPROVAL  
 P.L.K. W.L. A-1308 B