

A-1309

ASSEMBLY

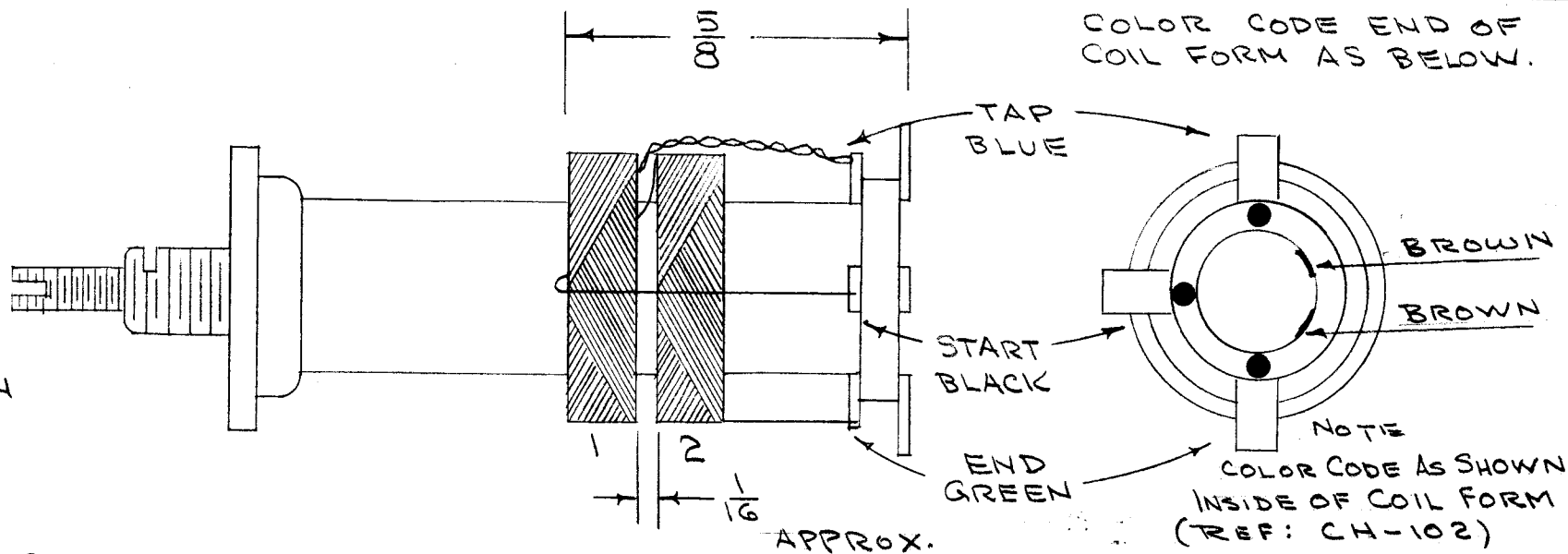
AFFIX COLLAR TO COIL FORM WITH ITEM 6. (CEMENT).
AIR DRY.

WINDING MACHINE DATA

DRIVER 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 BLACK LUG. USE WINDING FINGER WITH GUIDE ON LEFT. START WINDING WITH FINGER IN EXTREME LEFT HAND POSITION OF TRAVEL.
- 2- TAP 1st PI AT 11 3/4 TURNS, ADJACENT TO BLUE LUG.
- 3- END 1st PI AT 110 TURNS.
- 4- START 2nd PI 1/16" FROM 1st.
- 5- END 2nd PI IN LINE WITH GREEN LUG AT 220 1/4 TURNS.
- 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 1st PI AT 11 3/4 TURNS FROM START
END 1st PI AT 110 TURNS " " "
END 2nd PI AT 220 1/4 " " "

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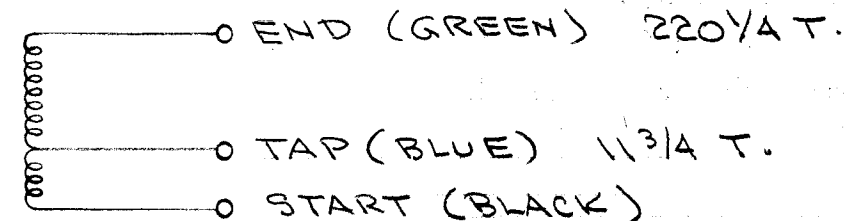
TEST DATA W/O CORE

USE BOONTON Q METER 160A OR EQUIVALENT.

	GREEN-BLACK	BLUE-GREEN (GND.)
L	650 μ h (615 TO 685)	590 μ h (560 TO 620)
Q	> 100	> 90
F	790 KC	790 KC

MISC. TEST DATA

IN CAN WITH CORE - L MAX. 1.30mh Q-50 F-780KC
L MIN .64mh Q-70 F 2.45MC
OUT OF CAN WITH CORE - L MAX. 1.57mh Q-155
L MIN. .72mh Q-110



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
1	8	SP-102	SPRING LOCK
X	7	BS-100	SOLDER, SOFT
X	6	GL-103	CEMENT
X	5	GL-104-2	INSULEX, U85
X	4	WE-104-541-DSQS	WIRE
1	3	CIJ03DMB5	CORE
1	2	TE-146-3	COLLAR & LUGS
1	1	CF-114-3	COIL FORM
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
ANTENNA COIL SUB ASSY. FFRD-3			
MATERIAL			
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	COLOR CODE ADDED	5/31/56	1		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. ±							

1	FFRD-3	458	A-1313	5-25-56
REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
USED ON				