

A-1317 B

WINDING MACHINE DATA

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

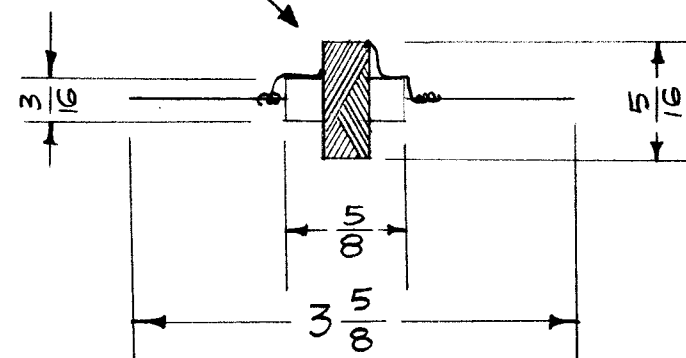
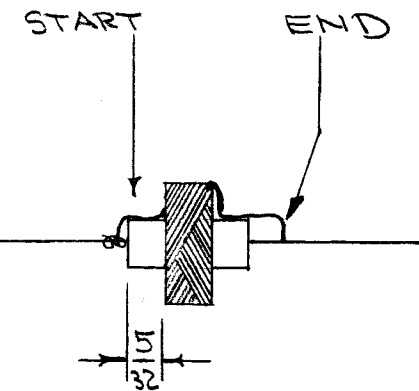
WINDING PROCEDURE

- 1- START WINDING 5/32 FROM END OF COIL FORM. (USE WINDING FINGER WITH GUIDE ON LEFT. START WINDING WITH FINGER IN EXTREME LEFT HAND POSITION OF TRAVEL.
- 2- WIND ON 83 TURNS. AFFIX ENDS TO COIL FORM WITH CEMENT. (ITEM 3).
- 3- TIN & SOLDER "START" LEAD AS SHOWN
- 4- TIN & TACK "END" LEAD AS SHOWN.
- 5- CHECK INDUCTANCE - REMOVE WIRE UNTIL L IS WITHIN 92 μ h TO 94 μ h.
- 6- SOLDER "END" LEAD IN PLACE AS SHOWN.

TEST DATA:

USE BOONTON Q METER 160A OR EQUIVALENT
 L - 93 μ h (92 TO 94 μ h.)
 Q - 70 OR GREATER
 F - 2.5 MC.

- 7 - BAKE 1/2 HOUR AT 105°C
- 8 - SATURATE COIL WITH U85 (ITEM 4). AIR DRY FOR 10 MINUTES. BAKE FOR 2 HOURS AT 105°C.



DIMENSIONS FOR REF ONLY

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 MAMARONECK, NEW YORK

X	5	BS-100	SOLDER, SOFT	
X	4	GL-104-2	INSULEX, U85	
X	3	GL-103	CEMENT	
X	2	WI-104-541DSQS	WIRE, 5/41 DSQS	
1	1	CI-114	COIL FORM	
REQ. ITEM	PART NO.		DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL			COIL ASSY., ANTENNA FILTER L 302, L303 FFRD-3	
TYPE & TEMPER			DRAWN	CHECKED
HEAT TREAT. SPEC.			ADD 5/28/56	A. J. J.
FINISH & SPEC. NO.			ELEC. DES. APP.	MECH. DES. APP.

B	1	DIM. ADDED	12/1/56	2	16	JAL	WDC
A	1	CI-114 superseded by CF-116	8/1/56	1		JAL	AJT
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.				
FRAC. DIM. ±			REMOVE ALL BURRS AND SHARP EDGES				
ANGULAR DIM. ±							

2	FFRD-3	AS8	5-28-56
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.
USED ON			