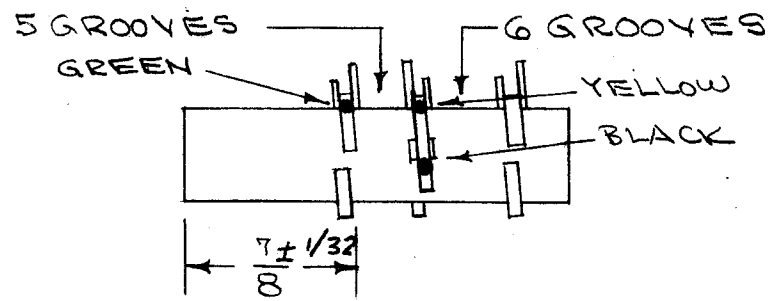


C
A-1355



COIL FORM ASSEMBLY

- 1- SPLIT THE TERMINAL RINGS.
- 2- CEMENT THE TERMINAL RINGS TO COIL FORM WITH ITEM 5. (NOTE THAT RINGS FOLLOW COIL FORM GROOVES.)
- 3- LUGS & GROOVED AREAS BETWEEN RING MUST BE FREE OF U-85.
- 4- BAKE FOR ONE HOUR AT 300°F. ALLOW TO COOL AT ROOM TEMPERATURE.
- 5- COLOR CODE RINGS AS ABOVE.

WINDING DATA

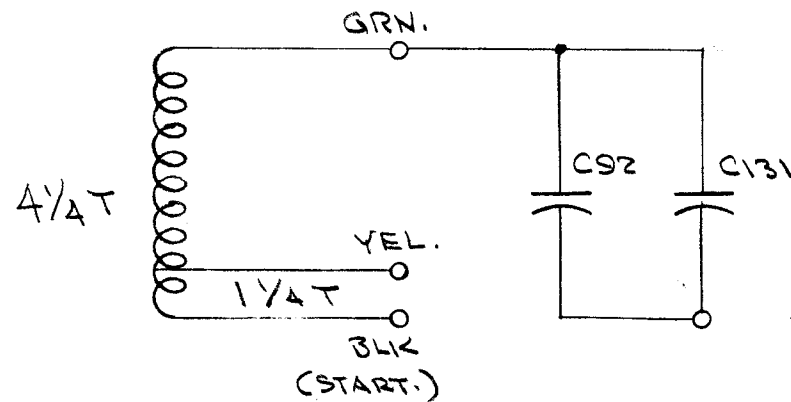
- NOTE - KINKS MUST BE REMOVED FROM ALL WIRE USED.
- 1- WRAP AROUND BLACK LUG. WIND ON TIGHTLY IN GROOVES 4 1/4 TURNS OF ITEM 2. (ALLOW 2" LEAD EACH END FOR TEST PURPOSES). END WINDING ON GREEN LUG.
 - 2- WRAP ITEM 3 AROUND YELLOW LUG. SOLDER TAP TO COIL AT 1/4 TURNS FROM START.
 - 3- COAT WINDING, TAP & RINGS WITH ITEM 5. (LUGS AND WIRE ON LUGS MUST BE FREE OF U-85).
 - 4- BAKE FOR ONE HOUR AT 300°F. COOL AT ROOM TEMPERATURE.
 - 5- MAKE SOLDER CONNECTIONS ON LUGS.
 - 6- SOLDER CONNECT CAPACITORS IN PLACE AS SHOWN. (TWIST CAP. LEADS TOGETHER.)
 - 7- TIE CAPACITORS TO COIL FORM WITH ITEM 9. SEAL KNOTS WITH ITEM 10.

TEST DATA w/o CORE

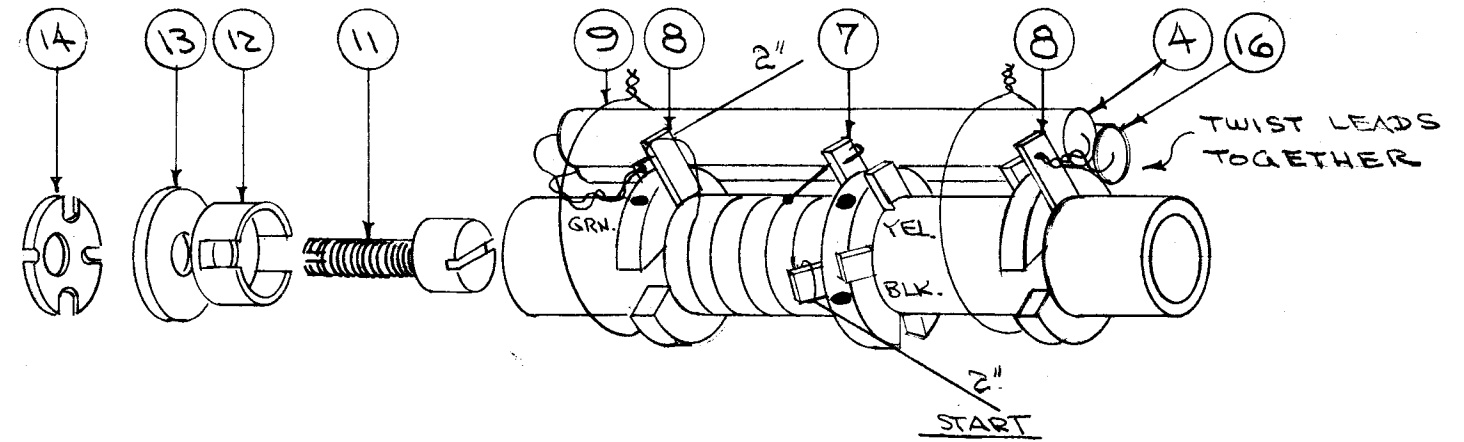
USE BOONTON Q METER 160 A OR EQUIVALENT.

- L - .25 μh (.22-.28)
 - Q - 145 OR GREATER
 - F - 25 M.C.
- TEST LEADS TO BE 1/4" OVERALL

USE FOR
MARK II SERIES
ONLY



FREQ. RANGE 21.255 TO 35.455 MC.



NOTE: KEEP CAPACITOR LEADS SHORT BUT DO NOT ALLOW CAP. TO TOUCH A LUG.

COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 11-12-13-14 ARE CEMENTED TO COIL FORM WITH ITEM 15.

FOR IDENTIFICATION STAMP THE NUMBER L18 ON THE COIL FORM IN ANY CONVENIENT SPOT.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL	
1	16	CC45TH391J	CAPACITOR, FIXED	C131
X	15	GL-111	CEMENT, "INSA-LUTE"	
1	14	FS-112	FASTENER	
1	13	WA-125-2	WASHER, FIBER	
1	12	NT-112	NUT, SPEED	
1	11	CI-169-7	CORE	
X	10	GL-163	CEMENT, DUCCO	
X	9	CD-101-1-MW	LACING CORD	
2	8	TE-146-1	RING, TERMINAL	
1	7	TE-146-2A	" " "	
X	6	BS-100	SOLDER, SOFT	
X	5	GL-104-2	INSULEX, U-85	
1	4	CC45SH391J	CAPACITOR, FIXED	C92
X	3	WL-100-7	WIRE, BUSS BAR #22	
X	2	WL-100-6	" " " #20	
1	1	PX-323	COIL FORM	

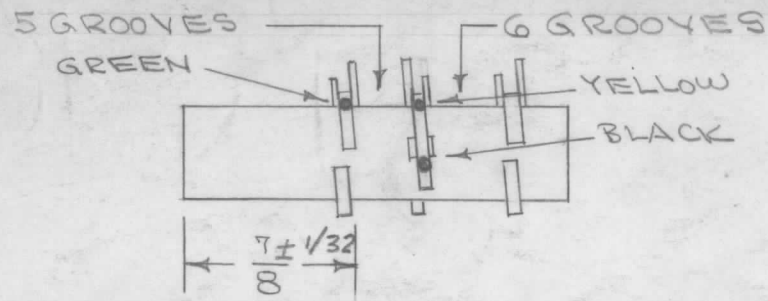
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
C		IT.9 WAS CD101-3MM	10/19/66	17040	RME	JY	
B	-	± 1/32 ADD TO 1/8 DIM.	4/11/66	15558	R.V.	JCB	
A	3	CHANGE TITLE	5	2271	Cy	JCB	
	2	NT-112 WAS NT-113	19/60				
	1	WA125-2 WAS WA125					

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	GPR-90-RXD		5-23-60
1	GPR-90	L18	11/8/56
REQ. PER UNIT	MODEL	PROJECT NO.	SYMBOL NO.
USED ON			

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
COIL, RF, TUNED OSCILLATOR, BAND 6			
MATERIAL	TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN
			P.L.X.
			A.J.J.
			A-1355
			C

C
A-1355



COIL FORM ASSEMBLY

- 1- SPLIT THE TERMINAL RINGS.
- 2- CEMENT THE TERMINAL RINGS TO COIL FORM WITH ITEM 5. (NOTE THAT RINGS FOLLOW COIL FORM GROOVES.)
- 3- LUGS & GROOVED AREAS BETWEEN RING MUST BE FREE OF U-85.
- 4- BAKE FOR ONE HOUR AT 300°F. ALLOW TO COOL AT ROOM TEMPERATURE.
- 5- COLOR CODE RINGS AS ABOVE.

WINDING DATA

- NOTE - KINKS MUST BE REMOVED FROM ALL WIRE USED.
- 1- WRAP AROUND BLACK LUG. WIND ON TIGHTLY IN GROOVES 4 1/4 TURNS OF ITEM 2. (ALLOW 2" LEAD EACH END FOR TEST PURPOSES). END WINDING ON GREEN LUG.
 - 2- WRAP ITEM 3 AROUND YELLOW LUG. SOLDER TAP TO COIL AT 1/4 TURNS FROM START.
 - 3- COAT WINDING, TAP & RINGS WITH ITEM 5. (LUGS AND WIRE ON LUGS MUST BE FREE OF U-85).
 - 4- BAKE FOR ONE HOUR AT 300°F. COOL AT ROOM TEMPERATURE.
 - 5- MAKE SOLDER CONNECTIONS ON LUGS.
 - 6- SOLDER CONNECT CAPACITORS IN PLACE AS SHOWN. (TWIST CAP. LEADS TOGETHER.)
 - 7- TIE CAPACITORS TO COIL FORM WITH ITEM 9. SEAL KNOTS WITH ITEM 10.

TEST DATA w/o CORE

USE BOONTON Q METER 160 A OR EQUIVALENT.

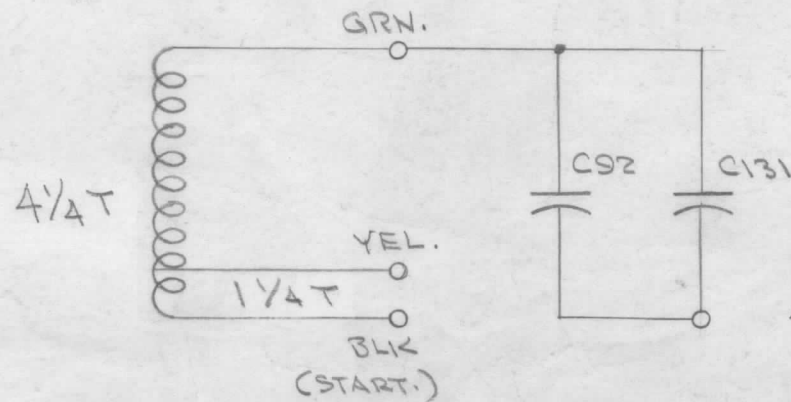
L - .25 μh (.22-.28)

Q - 145 OR GREATER

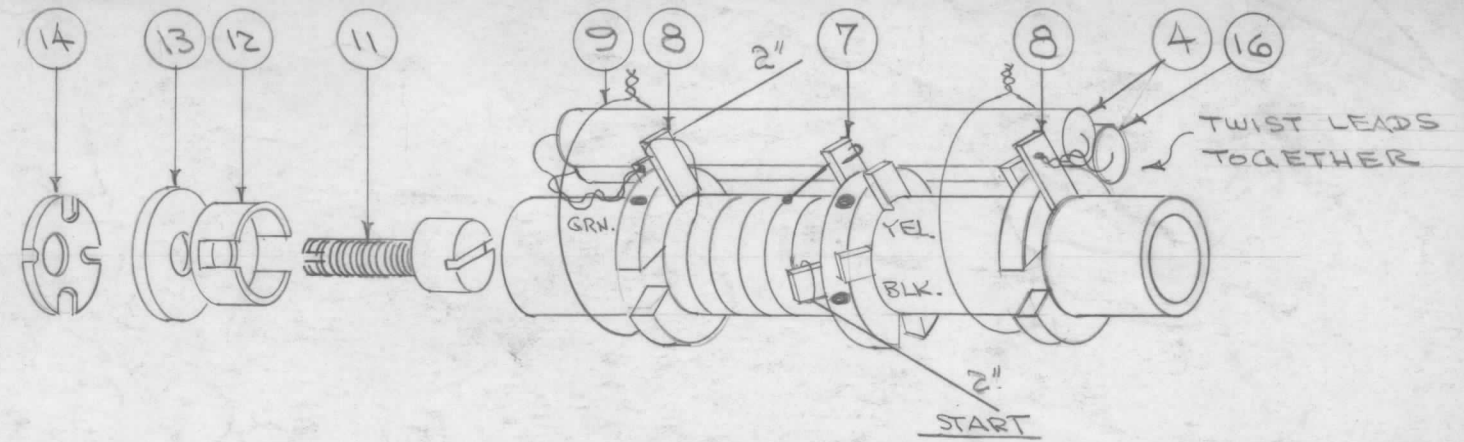
F - 25 M.C.

TEST LEADS TO BE 1/4" OVERALL

USE FOR
MARK II SERIES
ONLY



FREQ. RANGE 21.255 TO 35.455 MC.



NOTE: KEEP CAPACITOR LEADS SHORT BUT DO NOT ALLOW CAP. TO TOUCH A LUG.

COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 11-12-13-14 ARE CEMENTED TO COIL FORM WITH ITEM 15.

FOR IDENTIFICATION STAMP THE NUMBER L18 ON THE COIL FORM IN ANY CONVENIENT SPOT.

1	16	CC45TH391J	CAPACITOR, FIXED	C131
X	15	GL-111	CEMENT, "INSA-LUTE"	
1	14	FS-112	FASTENER	
1	13	WA-125-2	WASHER, FIBER	
1	12	NT-112	NUT, SPEED	
1	11	CI-169-7	CORE	
X	10	GL-163	CEMENT, DUCO	
X	9	CD-101-1-MW	LACING CORD	
2	8	TE-146-1	RING, TERMINAL	
1	7	TE-146-2A	" " "	
X	6	BS-100	SOLDER, SOFT	
X	5	GL-104-2	INSULEX, U-85	
1	4	CC45SH391J	CAPACITOR, FIXED	C92
X	3	WL-100-7	WIRE, BUSS BAR #22	
X	2	WL-100-6	" " " #20	
1	1	PX-323	COIL FORM	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
COIL, RF, TUNED OSCILLATOR, BAND 6			
MATERIAL		DATE	APPROVED
		5/5/56	A.J.J.
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
		P.L.X.	A.J.J.
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
		A-1355	C

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
C		IT. 9 WAS CD101-3MM	10/19/66	17040	RME	JCS	MMK
B	-	± 1/32 ADD TO 1/8 DIM.	4/1/66	15558	H.V.	JCS	MMK
A	3	CHANGE TITLE	5	2271	Cy	JCS	MMK
	2	NT-112 WAS NT-113	19/60				
	1	WA125-2 WAS WA125					

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. ±		

REQ. PER UNIT	MODEL	PROJECT NO.	SYMBOL NO.	DATE
1	GPR-90-RXD		L18	5-23-60
1	GPR-90			11/8/56