A-1382 B

Winding Machine Data

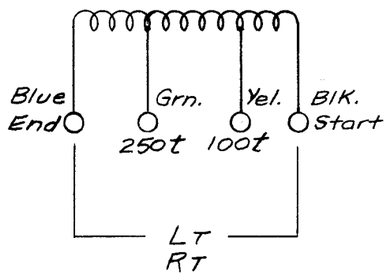
1. Place Toroid (item 1) within wire ring.
2. Load ring with 55 turns of wire. (item 2)

Winding Data

1. Wind 100 turns onto core.
2. Bring out 1st Tap.
3. Continue winding & bring out 2nd Tap at 250 turns.
4. Continue winding & end coil at 43.0 millihenries.
5. Remove coil from machine.
6. Tape "End Tap" to coil as shown in illustration.
7. Bake for ½ hour at 105° C.
8. Submerge hot coil in compound, (item 4)
9. Measure coil, following Test Data below.
10. Dip coil quickly to produce smooth covering.

Test Data

* L_T - 42.5 to 44.5 mhy.
* Q - 20 or Greater
** R_T - 9.5 to 11.5 ohms.



* General Radio Impedance Bridge Type 650A or Equiv.
** Simpson Ohmeter Model 260 or Equiv.

NOTICE TO PERSONS RECEIVING THIS DRAWING

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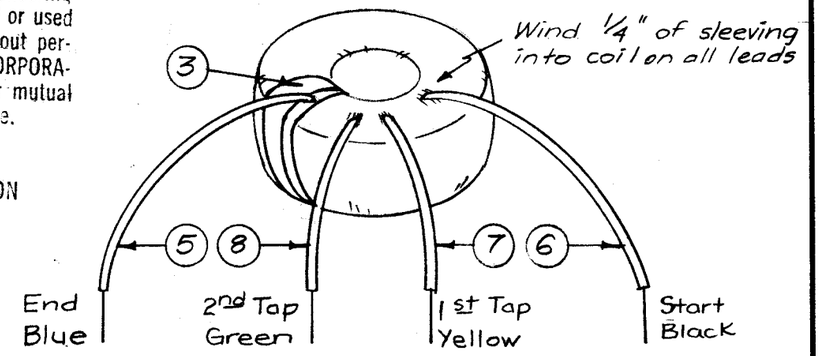

NOTE – THIS DWG. IS A TMC MANUFACTURING DWG. OF TF-177 AND MUST BE DISREGARDED. TF-177 IS NOW A PURCHASED ITEM.
IF TF-177 MUST BE MANUFACTURED BY TMC, THIS DWG. MAY BE UTILIZED FOR WINDING INFO, BUT THE END ITEM MUST CONFORM PHYSICALLY TO DWG. NO. TF-177 AND MUST STAMPED TF-177.

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
1¼"	8	PX-104-4-.022	Insulation, Sleeving (Size 24)	Green
1¼"	7	PX-104-2-.022	" , " "	Yell.
1¼"	6	PX-104-1-.022	" , " "	BIK.
1¼"	5	PX-104-6-.022	" , " "	Blue
X	4	GL-100	Compound, Potting	
X	3	TA-105-3	Tape	
X	2	WI-123-30	Wire, #30 Formex	
1	1	CI-103-9	Core	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	1	NOTE ADDED	7/26/60	2641	CY	JCK	AJJ
A	1	ITEM 10 ADDED TO WINDING DATA	5/7/57	1	EC	JCK	AJJ

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

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	ML-1381			5-11-58
1	GSB-1	MARK II (T2)	S-332	5-7-57
1	MSR-1	(T3)	A-1381	2-28-57

USED ON

STOCK SIZE
MATERIAL
TYPE & TEMPER | HEAT TREAT. SPEC.
FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK. NEW YORK

TF-177 ASSY
TRANSFORMER A.F.

DRAWN	CHECKED	FINAL APPROVAL
6-28-57		AJJ

ELEC. DES. APP.	MECH. DES. APP.		
P.L.K.		A-1382	B