

A-1383 A

Winding Machine Data

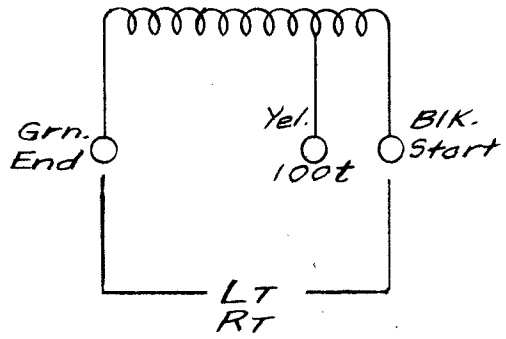
1. Place Toroid (item 1) within wire ring.
2. Load ring with 55 turns of wire. (item 2)

Winding Data

1. Wind 100 turns onto core.
2. Bring out 1st Tap.
3. Continue winding & end coil at 43.0 millihenries.
4. Remove coil from machine.
5. Tape "End Tap" to coil as shown in illustration.
6. Bake for 1/2 hour at 105°C.
7. Submerge hot coil in Compound (item 4)
8. Measure coil, following Test Data below.

Test Data

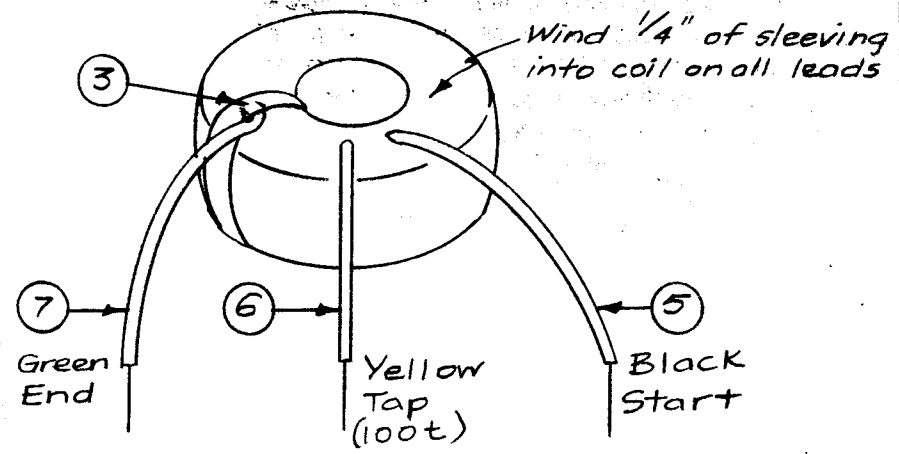
- * Lt - 42.5 to 44.5 mhy.
- * Q - 20 or Greater
- ** Rt - 9.5 to 11.5 ohms.



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MAMARONECK, NEW YORK



NOTE - THIS DWG IS A TMC MANUFACTURING DWG. OF TF-178 AND MUST BE DISREGARDED. TF-178 IS NOW A PURCHASED ITEM. IF TF-178 MUST BE MANUFACTURED BY TMC, THIS DWG. MAY BE UTILIZED FOR WINDING INFO, BUT THE END ITEM MUST CONFORM PHYSICALLY TO DWG. NO. TF-178 AND MUST STAMPED TF-178.

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

A	1	NOTE ADDED	7 26 60	2641	CW	JCB	
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

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

1	MSR-1	A-1384	3-1-57
REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.
USED ON			

1 1/4"	7	PX-104-4-.022	Insulation, Sleeving (Size 24)	Green
1 1/4"	6	PX-104-2-.022	" " " "	Yellow
1 1/4"	5	PX-104-1-.022	" " " "	Blk.
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, Toroid	
REQ. ITEM	PART NO.		DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
TF-178 ASSY (Transformer A.F.)				
MATERIAL		63-1-57	JAC	AJJ
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
FINISH & SPEC. NO.		P.L.K.		A-1383
ELEC. DES. APP.		MECH. DES. APP.		