

A-1451

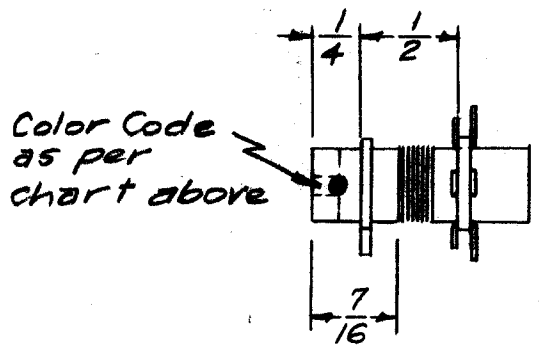
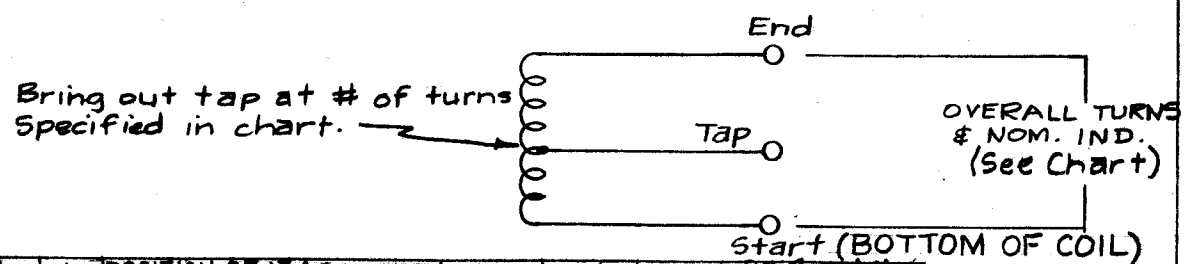
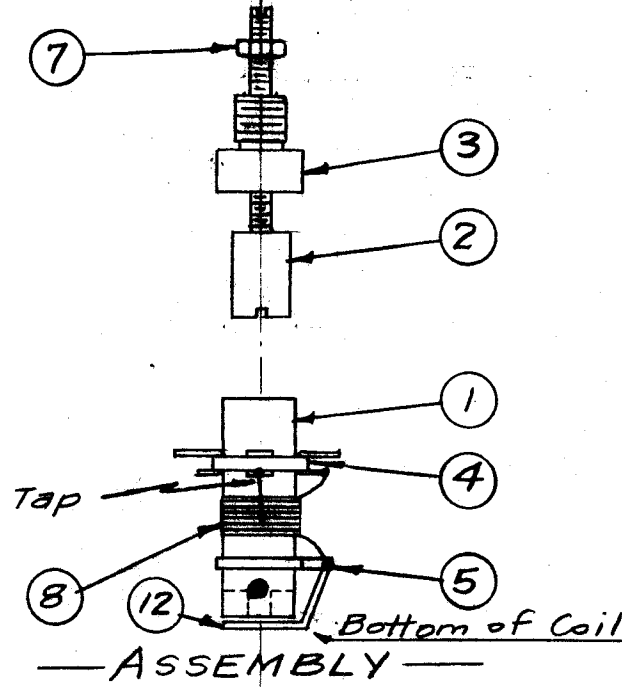
TMC MFG. NO.	NO. OF COIL TURNS OVERALL	BRING OUT TAP AT (No. of Turns)	NOM. IND. (uhy)	Q/A	FREQ. (Mcs)	FREQ. MUST BE GREATER THAN	ITEM # 8 (Wire)	QUAN. PER UNIT	BAND	DRIVE FREQ. (Mcs.)	COLOR CODE	SCHEM. SYM.	TMC PART NO.	CHG SYMBOL NO's	UNIT
A-1451-1	42	8	25.5 (23.5-27.5)		2.5	60	WI-104-54IDSQS	1	1	2-4.3	Blk.	T120	CL-161	—	—
A-1451-2	42	16	25.5 (23.5-27.5)		2.5	60	WI-104-54IDSQS	1	1	2-4.3	Brn.	T116	CL-162	—	—
A-1451-3	20	6	3.7 (3.4 - 4.3)		7.9	90	WI-107-15	3	2	4-8	Red	T113, T117, T121	CL-163	T1108, 1111, 1115, 1119	4
A-1451-4	12	6	1.1 (1.0 - 1.2)		7.9	90	WI-107-5	2	3	8-16	Or.	T115, 119	CL-164	T1107, 1110, 1117	3
A-1451-5	12	3	1.1 (1.0 - 1.2)		7.9	90	WI-107-5	1	3	8-16	Yell.	T122	CL-165	T1114	1

WINDING MACHINE DATA

A-1451-1 & 2 will use a .125 Cam, 49 Cam Gear, and 95 Driver.
 A-1451-3, 4, & 5 will be close wound, single layer.

PROCEDURE

- Secure terminals (items 4 & 5) to coil form (item 1) with Insulex (item 10).
- Wind required number of turns of item 8 on coil form and bring out tap when required as per chart.
- Stake coil ends to coil form with Q-Max (item 9).
- Solder coil leads & terminal lug (item 12) to term.
- Bake coil for 1/2 hour at 210° F.
- Paint coil with Insulex (item 10).
- Do NOT allow Insulex to form on top end of coil form where bushing will be assembled.
- Test unit as per chart and schematic, without core. (Use Boonton Q-Meter Model 160A or Equiv.)
- Items 2, 3, 6 & 7 to be left as a separate assembly which will be inserted, but not secured in coil form.



MODEL USED ON	TMC PART NO.	SYMBOL NO.	QUAN. PER UNIT
SBE-1	CL-161	T-120	1
	CL-162	T-116	1
	CL-163	T-113, T117, T121	3
SBE-2	CL-164	T-115, T119	2
	CL-165	T-122	1
CHG-2	CL-163	T-2709, 2713, 2711, 2704	4
	CL-164	T-2708, 2712, 2705	3
	CL-165	T-2716	1

1	12	TE-104-3	TERMINAL, LOCKING
X	11	BS-100	Solder, Soft
X	10	GL-104-2	Insulex, U-85
X	9	GL-102	Lacquer, Q-Max.
X	8	See Chart	Wire
1	7	NTH0632BCB	Nut, Hex.
	6	Deleted	(was SP108)
1	5	TE-153-2	Terminal, Ring Type
1	4	TE-170-3	Terminal, Collar
1	3	SM-145	Bushing, Coil Mtg.
1	2	CI-109-7	Core, Tuning
1	1	CF-123	Coil Form

G	1	POSITION OF IT.4 REVERSED	6-7-66	116347	N.C.	JCB	
F	1	POSITION OF IT.5 REVERSED	9-22-64	12434	JTB		
E	1	ITEM 3 WAS SM110	3-6-63	8380	RC		
D	2	CHG-2 ADDED TO SYMBOL CHART	1-24-62	6245	G.S.		
C	1	ITEM 12 WAS TE-116-4					
C	2	ADDED QUANT. & SYMBOL COLUMN TO CHART	12/19/60	3751	DJM		
B	1	-3 NO TURNS W/21, L W/25 (3.4-4.0)	8/27/59	1187	J.C.B.		
B	1	TTG Deleted from chart.					
A	1	chart added	4/14/59	1	J.C.B.		

CHART	CHG-1				
CHART	SBE-3		AX-204	11-30-59	
CHART	SBE-1 & 2			8-12-67	
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE	
					USED ON

REQ. PER UNIT	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
STOCK SIZE				
CL-161 thru CL-165 ASS'Y. (COIL, RF, TUNED)				
MATERIAL				
6 ⁰ /13/57				
TYPE & TEMPER HEAT TREAT. SPEC. DRAWN CHECKED FINAL APPROVAL				
FINISH & SPEC. ELEC. DES. APP. MECH. DES. APP.				

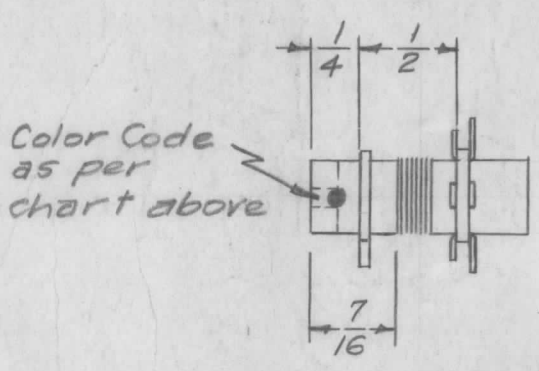
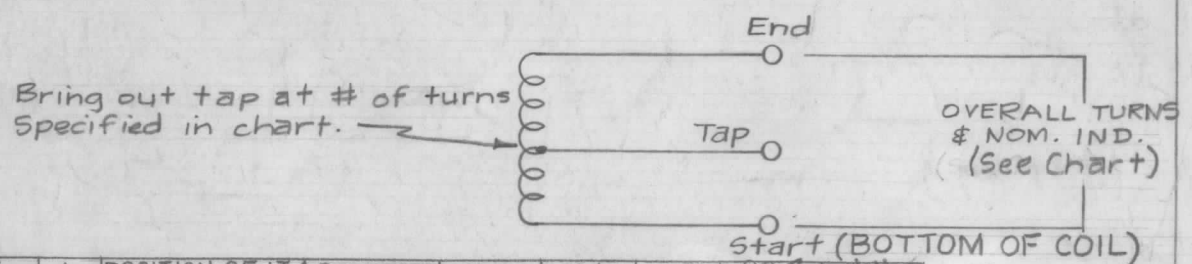
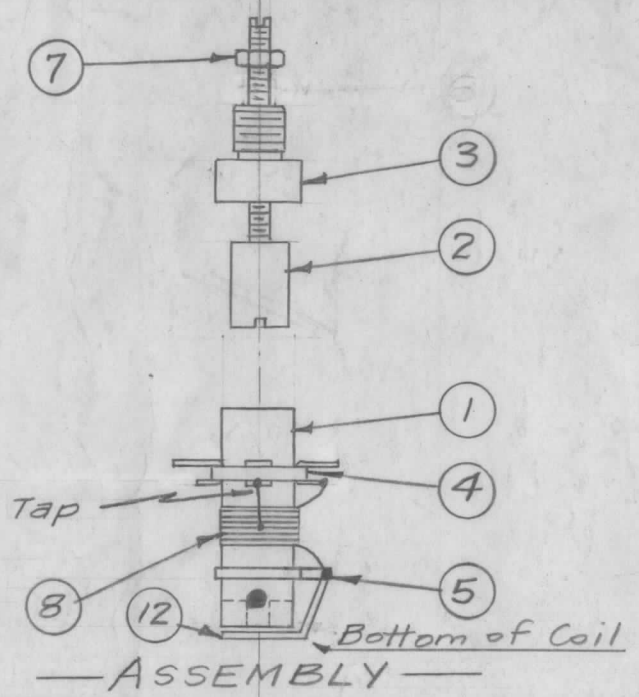
G	TMC MFG. NO.	NO. of COIL TURNS OVERALL	BRING OUT TAP AT- (No. of Turns)	NOM. IND. O/A W/O CORE (uhy)	TEST FREQ. (Mcs)	Q at TEST FREQ. MUST BE GREATER THAN	ITEM # 8 (Wire)	QUAN. PER UNIT	BAND	BAND FREQ. (Mcs.)	COLOR CODE	SCHEM. SYM.	TMC PART NO.	CHG SYMBOL NO's	QTY PER UNIT
A-1451-1	A-1451-1	42	8	25.5 (23.5-27.5)	2.5	60	WI-104-54IDSQS	1	1	2-4.3	Blk.	T120	CL-161	—	—
A-1451-2	A-1451-2	42	16	25.5 (23.5-27.5)	2.5	60	WI-104-54IDSQS	1	1	2-4.3	Brn.	T116	CL-162	—	—
A-1451-3	A-1451-3	20	6	3.7 (3.4 - 4.3)	7.9	90	WI-107-15	3	2	4-8	Red	T113, T117, T121	CL-163	T1108, 1111, 1115, 1119	4
A-1451-4	A-1451-4	12	6	1.1 (1.0 - 1.2)	7.9	90	WI-107-5	2	3	8-16	Or.	T115, 119	CL-164	T1107, 1110, 1117	3
A-1451-5	A-1451-5	12	3	1.1 (1.0 - 1.2)	7.9	90	WI-107-5	1	3	8-16	Yell.	T122	CL-165	T1114	1

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PROCEDURE

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- Wind required number of turns of item 8 on coil form and bring out tap when required as per chart.
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- Solder coil leads & terminal lug (item 12) to term.
- Bake coil for 1/2 hour at 210° F.
- Paint coil with Insulex (item 10).
- Do NOT allow Insulex to form on top end of coil form where bushing will be assembled.
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	CL-162	T-116	1
SBE-2	CL-163	T-113, T117, T121	3
	CL-164	T-115, T119	2
	CL-165	T-122	1
CHG-2	CL-163	T-2709, 2713, 2717, 2706	4
	CL-164	T-2708, 2712, 2705	3
	CL-165	T-2716	1

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X	11	BS-100	Solder, Soft
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X	9	GL-102	Lacquer, Q-Max.
X	8	See Chart	Wire
1	7	NTH0632BC8	Nut, Hex.
	6	Deleted	(was SP-102)
1	5	TE-153-2	Terminal, Ring Type
1	4	TE-170-3	Terminal, Collar
1	3	SM-145	Bushing, Coil Mtg.
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1	1	CF-123	Coil Form

G	1	POSITION OF IT.4 REVERSED	6-7-66	16347	N.C.	JCB	MM
F	1	POSITION OF IT.5 REVERSED	9-22-64	12434	WB	CP	PP
E	1	ITEM 3 WAS SM110	3-6-63	8380	RC	PTG	PTG
D	2	CHG-2 ADDED TO SYMBOL CHART	1-24-62	6245	G.S.	STB	STB
C	1	ITEM 12 WAS TE-116-4	12/19/60	3751	DJM	HLE	JL
B	1	ADDED QUANT. SYMBOL COLUMN TO CHART	8/27/59	1187	J.C.B.	RWS	AM
A	1	-3 NO TURNS WAS 21, L WAS 3.4-4.0	4/14/59	1	J.C.B.	JL	AM
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. ±							

CHART	CHG-1				
CHART	SBE-3	AX-204	11-30-59		
CHART	SBE-112		8-12-57		
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE	
					USED ON

REQ. PER UNIT	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP.				
MAMARONECK, NEW YORK				
CL-161 thru CL-165 ASS'Y.				
(COIL, RF, TUNED)				
STOCK SIZE				
MATERIAL				
TYPE & TEMPER HEAT TREAT. SPEC. DRAWN CHECKED FINAL APPROVAL				
FINISH & SPEC. NO. ELEC. DES. APP. MECH. DES. APP.				