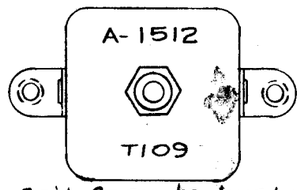
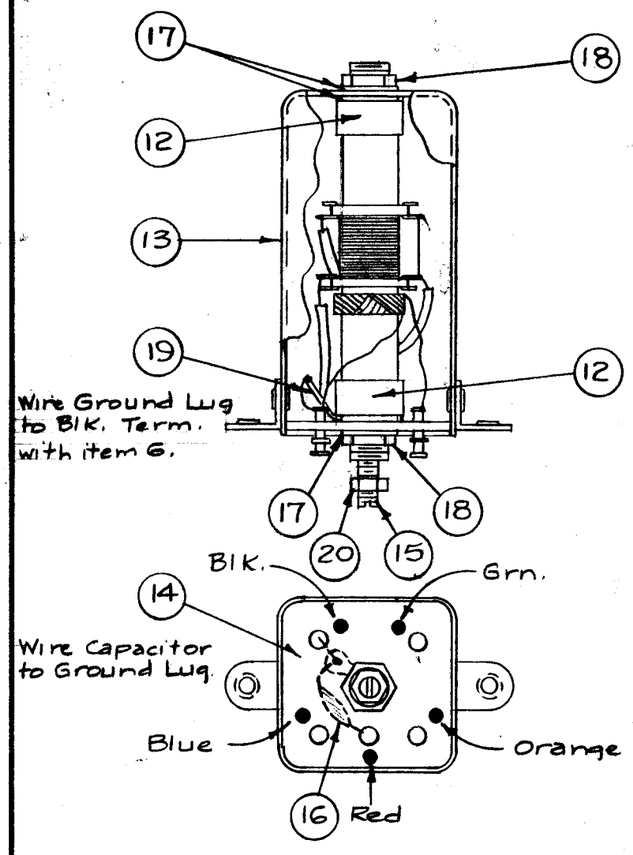
D

A-1512

Stamp Can as shown - 1/8 high Black Gothic.
Note - Stamp TMC Insigna & Approval on side of can.



Cement Coil form to bushings with item 11 (GL-104-2)



Color Code Terminal Bd. as shown.

Winding Machine Data (for Winding No. 1)

Cam Gear	49
Driver Gear	95
Cam	.125

Winding Data

1. Start Winding No. 1 5/8" from end of form.
2. End Winding No. 1 at 42 turns.
3. Keep all leads approx. 3" long.
4. Stake leads to coil form with GL-103 (item 10).
5. Assemble collar terminals (item 5) on form as shown and stake with GL-104-2 (item 11). Position as shown in drawing below.
6. Fasten one end of WI-102-9-6 (item 3) to terminal No. 1 (See Drawing below), and fasten one end of WI-102-9-9 (item 4,) to terminal No. 2.
7. Keeping wires parallel, close wind 11-1/2 turns. Fasten end of WI-102-9-9 (white wire, Item 4) to terminal No. 3. Fasten end of WI-102-9-6 (blue wire, Item 3) to terminal No. 4.
8. Bake unit for 1/2 hour at 215° F.
9. Coat windings and collar terminals with GL-104-2 (item 11).
10. Solder WL-100-8 (item 6) from terminal No. 1. to terminal No. 3.
11. Bake hard for 1/2 hour at 215° F.
12. Test as below.
13. Assemble as shown at left.

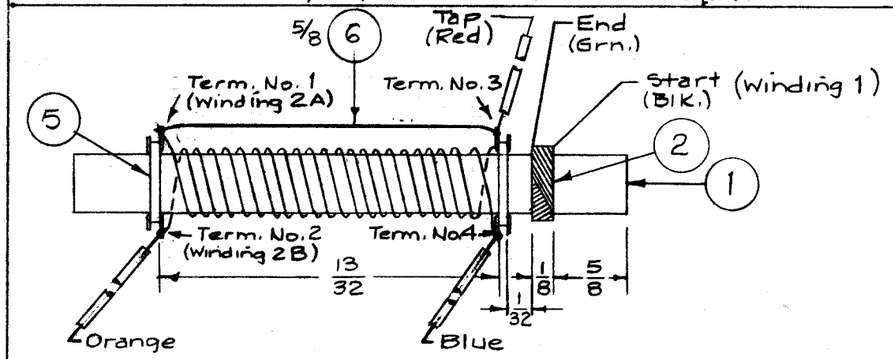
Test Data (without Core)

Winding No. 1 L1 (Grn.-Blk.) - 23.5 (20.5 to 26.5) microhenries. Q = 50 or Greater. Freq. = 2.5 Mc.

Winding No. 2A (Term. 1-4), L2 (Red-Blue) - 1.15 (1.0 to 1.3) microhen. Q = 40 or Greater. Freq. = 7.9 Mc.

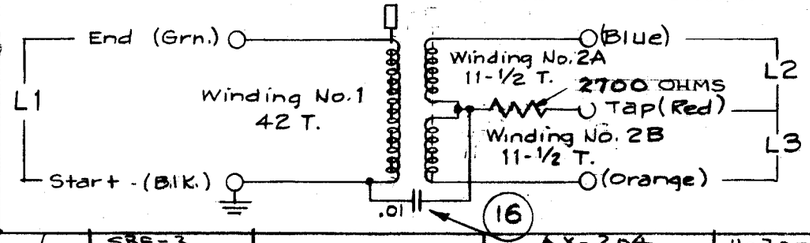
Winding No. 2B (Term. 2-3) L3 (Red-Orange) - 1.15 (1.0 to 1.3) microhen. Q = 40 or Greater. Freq. = 7.9 Mc.

Use Boonton Radio Corp. Q Meter Model 160A or Equiv.

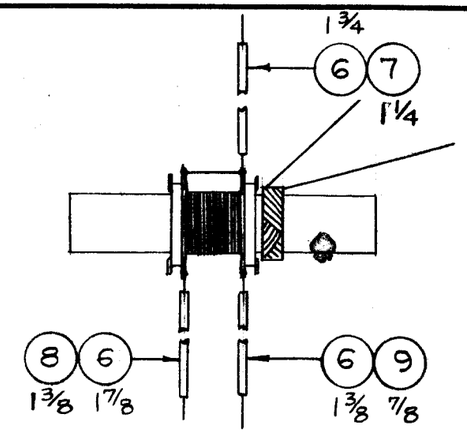


This Detail is not to scale. See Dwg. in upper right corner for Actual Size

Color Codes Shown below are the terminal board colors.



ACTUAL SIZE



REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
1	22	RC30GF272K	RESISTOR, FIXED	
X	21	BS-100	Solder, Soft	
1	20	NTH0632BN8	Nut, Hex.	
1	19	TE-104-5	Terminal Lug	
2	18	NTH2528BN14	Nut, Hex.	
3	17	LW125MRN	Lockwasher, Int.	
1	16	CC-100-16	Capacitor, Fixed	.01
1	15	CI-109-7	Core, Tuning	
1	14	PX-403	Terminal Board	
1	13	A-1513	Can Ass'y.	
2	12	SM-145	Bushing, Coil Mtg.	
X	11	GL-104-2	Insulex, U85	
X	10	GL-103	Cement, Duco	
X	9	PX-104-6-.034	Insulation, Sleeving Size 20	Blue
X	8	PX-104-8-.034	Insulation, Sleeving Size 20	Or.
X	7	PX-104-3-.034	Insulation, Sleeving Size 20	Red
X	6	WL-100-8	Wire, Buss Size 24	
2	5	TE-170-2	Terminal, Collar	
X	4	WI-102-9-9	Wire, Magnet Size 30	White
X	3	WI-102-9-6	Wire, Magnet Size 30	Blue
X	2	WI-104-541-D5QS	Wire, Litz	
1	1	CF-117-2.00	Coil Form, 3/8 O.D.	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
D	1	TEST DATA: Winding 1 "Was Q65 TEST DATA Winding 2A, 2B Was Q60	7-5-61	5177	B.D.L	RL	
C	2	ON TEST DATA WINDING #1 20.5 TO 26.5 WAS 22.5 TO 24.5	6-26-61	5136		JCB	
	1	ON TEST DATA WINDING #2A, 2B 1.0 TO 1.3 WAS 1.1 TO 1.2					
B	1	FIXED RESISTOR ADDED TO SCHEMATIC	12-15-58	547	JCB		
A	1	ITEM 6 WAS WL-100-7	4/28/58	1			

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. ±	

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
/	SBE-3		AX-204	11-30-55
1	SBE-2		T109	3-13-58

USED ON

STOCK SIZE

MATERIAL

TYPE & TEMPER | HEAT TREAT. SPEC.

FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK. NEW YORK

TRANSFORMER, 2-4 MC MF MOD.

DRAWN	CHECKED	FINAL APPROVAL
16 3/13/58		AMB
ELEC. DES. APP.	MECH. DES. APP.	A-1512 D

FORM-109-A