

A-1679 A

WINDING ~

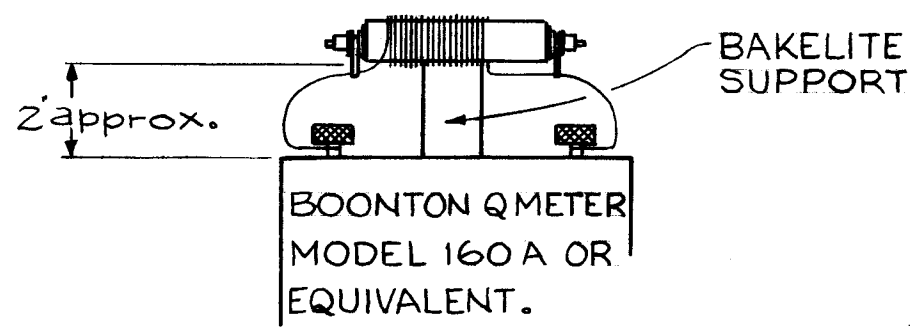
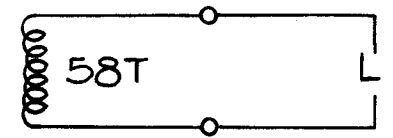
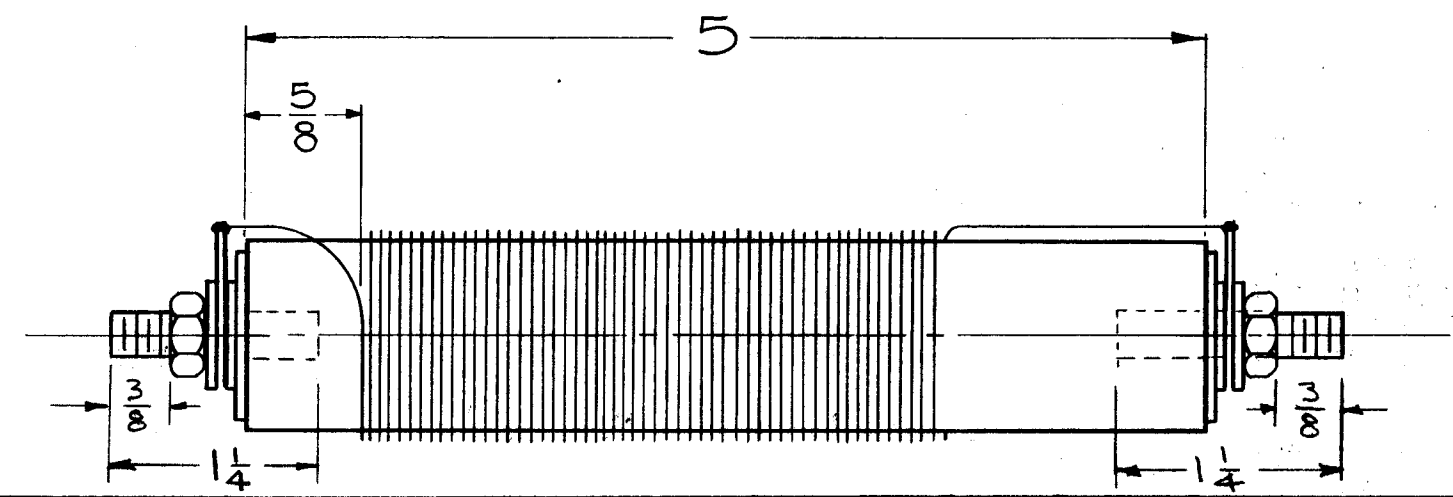
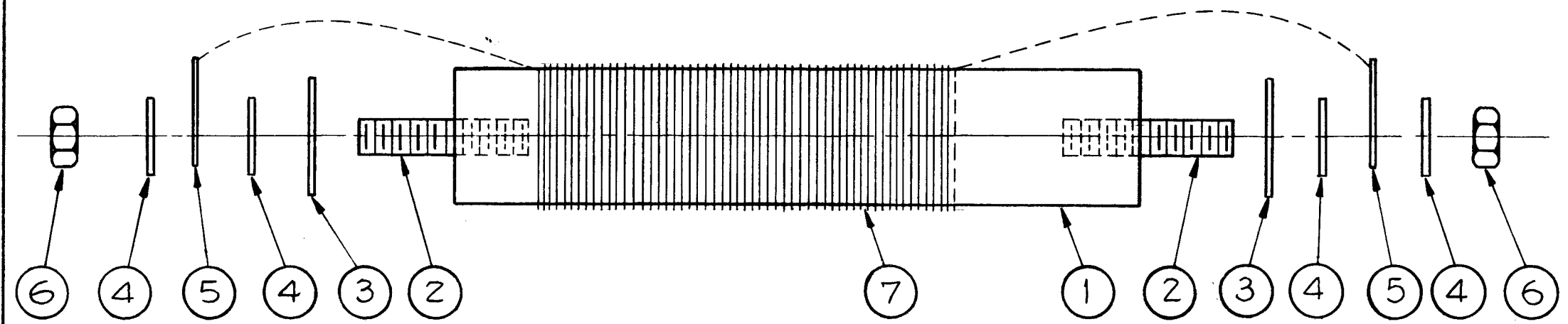
58 TURNS CLOSE WOUND OF (ITEM 7)
(WI-125-2)

FABRICATION ~

- 1~ THREAD ROD (ITEM 2) INTO INSULATOR (ITEM 1).
- 2~ ASSEMBLE ITEMS 3,4,5,4 IN ORDER, AS SHOWN.
- 3~ THREAD NUT (ITEM 6) ONTO ROD (ITEM 2) AND SECURE TIGHTLY.
- 4~ WIND 58 TURNS OF WIRE (ITEM 7) ON INSULATOR (ITEM 1), START 5/8" FROM END.
- 5~ STAKE WIRE TO INSULATOR BODY WITH (ITEM 10), AND SOLDER ENDS TO (ITEM 5).
- 6~ COAT WINDING WITH (ITEM 9) INSULEX.
- 7~ BAKE FOR 1 HR. AT 250° F.
- 8~ ALLOW UNIT TO COOL.
- 9~ TEST AS SHOWN

TEST DATA ~

L ~ 25 μ hy $\pm 10\%$
Q ~ 180 OR GREATER
F ~ 2.5 mc



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 10	GL-103	CEMENT, DUCO	
X 9	GL-104-2	INSULEX, U-85	
X 8	BS-100	SOLDER, SOFT	
X 7	WI-125-2	WIRE, MAGNET, CEROC 'T'	
2 6	NTH2520BC14	NUT, HEXAGON, DOUBLE CHAMFER	
2 5	TE-104-5	TERMINAL, LOCKING	
4 4	FW-25 LRC	WASHER, FLAT	
2 3	WA-109-55	WASHER, FIBRE	
2 2	SM2520BNI.250	ROD, THREADED	
1 1	NS3W0440	INSULATOR, PILLAR ROUND	

STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL		PLATE CHOKE ASSEMBLY (CL-167)	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		J.C. BIELE	FINAL APPROVAL
		ELEC. DES. APP.	MECH. DES. APP.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	1	TOL. ADDED TO L-25 μ hy	3.25.64	11091	WB	@	QJ
TOLERANCES		SCALE:					
DEC. DIM. \pm		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.					
FRAC. DIM. $\pm 1/64$		REMOVE ALL BURRS AND SHARP EDGES					
ANGULAR DIM. \pm							

1	GPT 10K	PROJECT NO.	ASS'Y. NO.	4-28-59
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
USED ON				

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