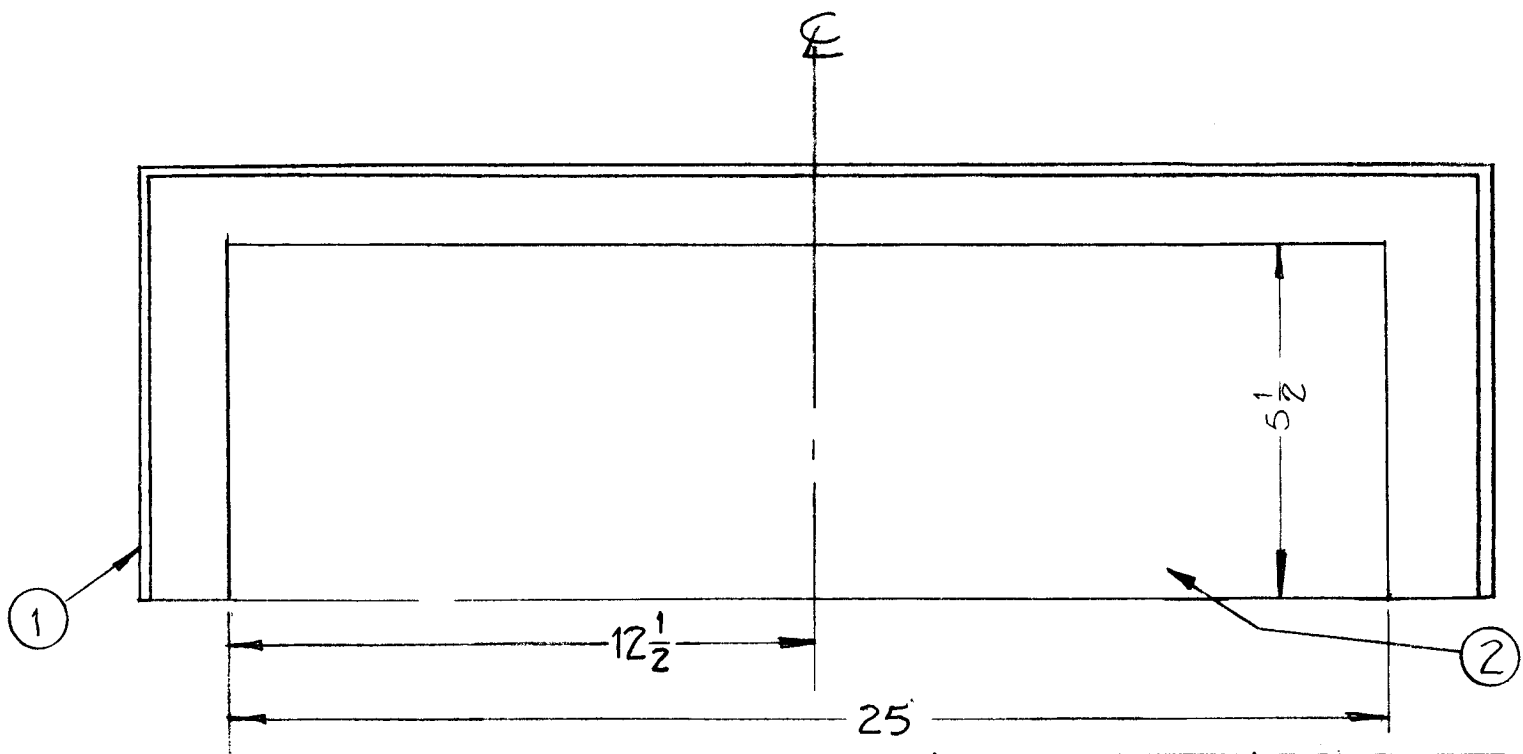


REQ. PER. UNIT	USED ON		
	MODEL	ASS'Y. NO.	DATE
1	GPT-10K	AX-139	11-12-59
1	GPT-40K	AR-116	3-10-60

A-1805 B

INTERIOR VIEW SHOWN

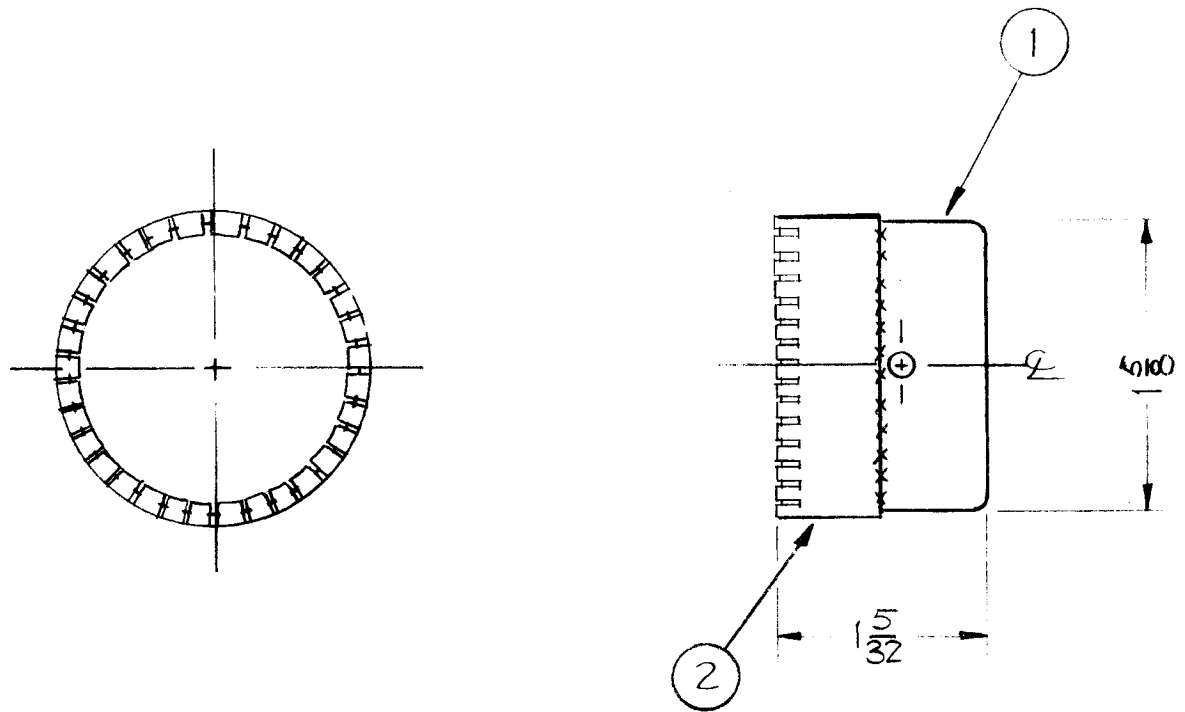


REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	3	GL-101-1	ADHESIVE, PLIOBOND	
1	2	IM-179-12	INSULATION SHEET	
1	1	MS-1631	COVER, RELAY PANEL	

THE TECHNICAL MATERIEL CORP.	
MAMARONECK, NEW YORK	
COVER, RELAY INSULATED	
STOCK SIZE	
MATERIAL	
TYPE & TEMPER	HEATTREAT. SPEC.
FINISH & SPEC. NO.	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	1	SEE EMN #10852	2/5/64	10852	A.M.	TR.	<i>[Signature]</i>
A		ITEM 2 was 5 1/2 x 12 1/2	3/10/60		<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
TOLERANCES			SCALE: NO NPL				
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. ±							

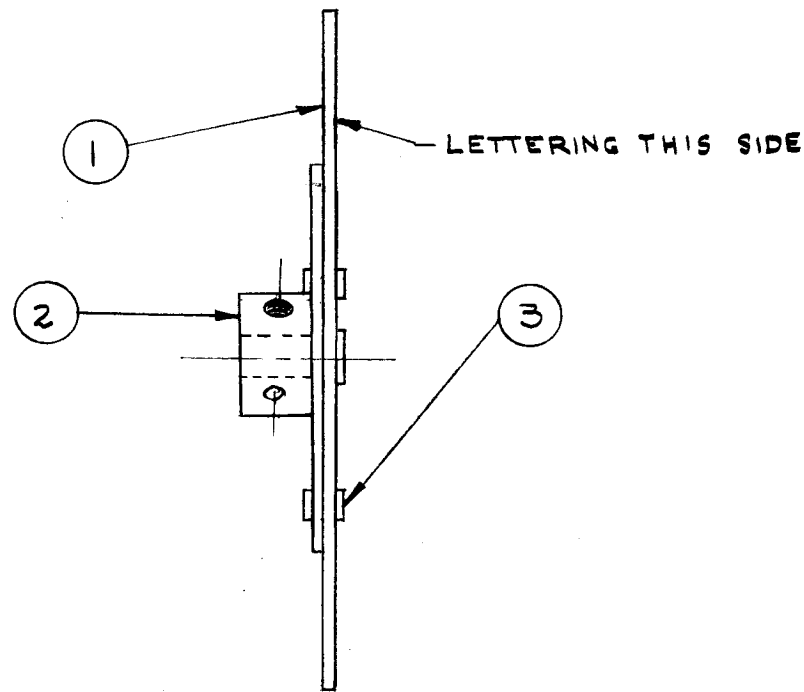
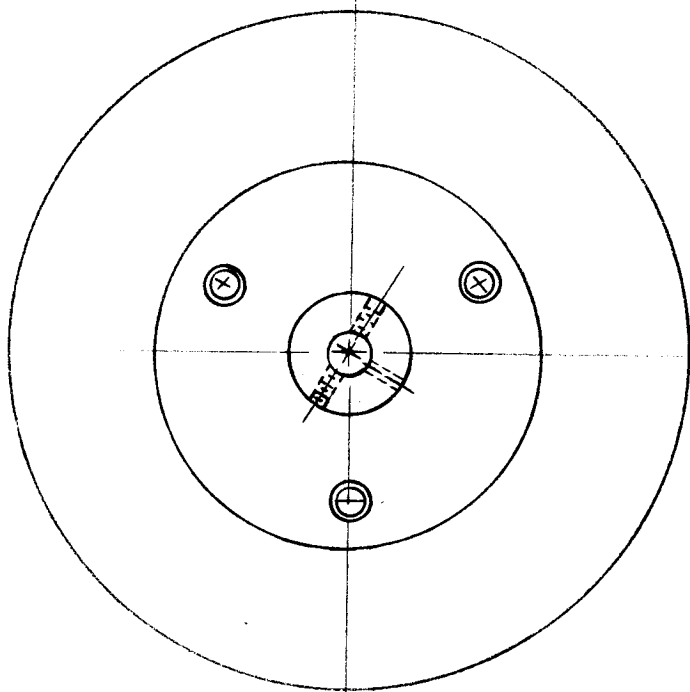
REQ. PER UNIT	USED ON			A-1806	B
	MODEL	ASS'Y. NO.	DATE		
2	SWR-3000 CU	A-1527 A-1528	11-16-57		



X	3	BS-100	SOLDER, SOFT	
1	2	FP-174-2	RING, CONTACT	
1	1	BX189	CAN, ROUND	
REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP.	
			MAMARONECK, NEW YORK	
			CAN, ASSEMBLY	
		STOCK SIZE		
		MATERIAL		
		TYPE & TEMPER	DRAWN	CHECKED
		HEATTREAT. SPEC.	FINAL APPROVAL	
		S-245 SILVER PLATE	A-1806 B	
		S423 CLEAR IRIDITE		
		FINISH & SPEC. NO.	ELEC. DES. APP	MECH. DES. APP

B	1	FINISH & SPEC WAS SILVER PLATE.0003	2-18-63	8276				
A	1	FINISH ADDED	3-10-61	4371				
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. ±								

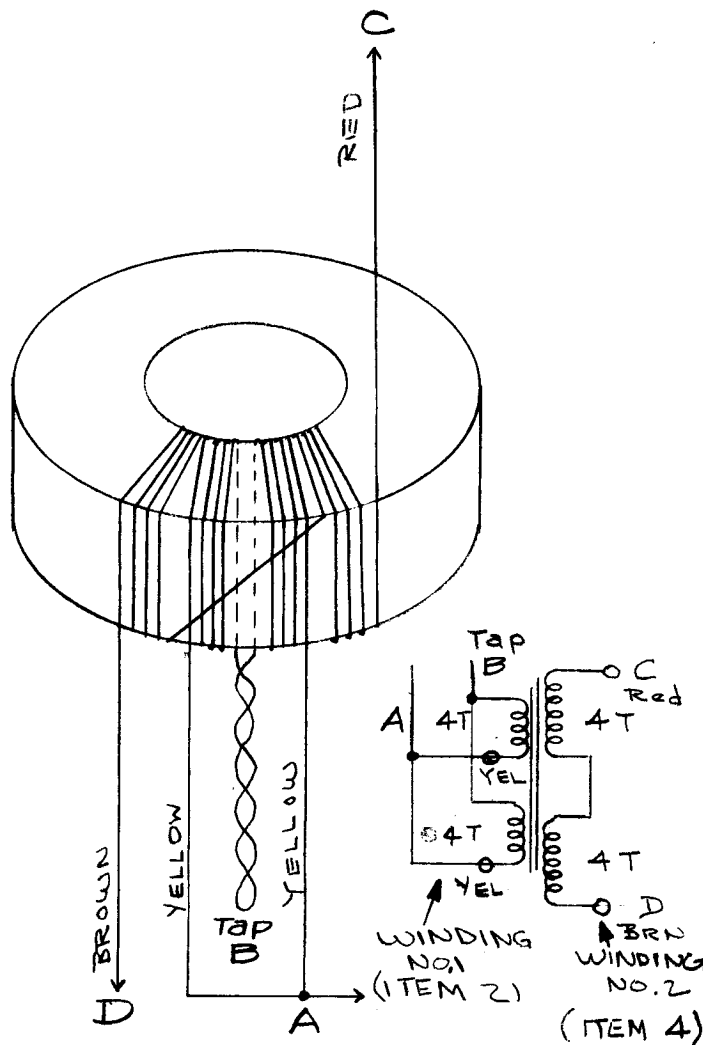
REQ. PER. UNIT	USED ON			A-1809	E
	MODEL	ASS'Y. NO.	DATE		
1	SBE-3	A0-101	11-24-59		



ASSY NO.	ITEM 1	USED ON
A1809	LD626	SBE-3,4
A1809-2	LD2034	SBE-8,9,10

3	3	EY-100-1	EYELET		
1	2	A-1023	SUPPORT PLATE ASS'Y		
1	1	SEE CHART	LETTERING, H.F. DIAL		
REQ. ITEM	PART NO.		DESCRIPTION	SYMBOL	
			THE TECHNICAL MATERIEL CORP.		
			MAMARONECK, NEW YORK		
			HF DIAL ASS'Y		
			STOCK SIZE		
			MATERIAL		
TYPE & TEMPER		HEATTREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
					A-1809 E
FINISH & SPEC. NO.			ELEC. DES. APP	MECH. DES. APP	

E	-A	QTY IT. 2 WAS 2	3-8-66	15861	WFW	QCS		
D	1	A1809-2 ADDED TO CHART	1/4/66	15496	W.V.	QCS		
C	1	ON ASSY. CHART: A1809-2 / LD1525/SBE-6, DELE.	1.14.66	13287	R.L.	QCS		
B	1	CHART ADDED	9.17.64	12361	WFB	QCS		
A	1	Item 2 Was MC-105-2	2-26-62	6436	GG	QCS		
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. ±								

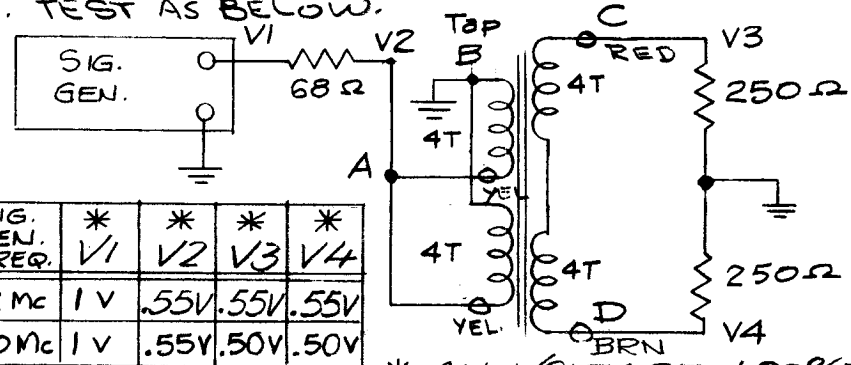


REQ. PER UNIT	USED ON		
	MODEL	ASS'Y. NO.	DATE
1	A-1454	A-1454	B-14-57
1	SBE-3	A-1454	11-30-59

A-1811 E

— PROCEDURE —

1. Wind Winding #1 USING IT.#2. (4 turns CCW, then tap, then 4 turns CW). Close Wound.
2. Wind Winding #2 USING IT.#4. (4 turns on one side of Winding #1 and 4 turns on the other side). Close Wound.
3. Bake for 1/2 hour at 210° F.
4. Paint Winding with GL-104-2 (item 3)
5. Bake for 1 hour at 210° F.
6. Note - Keep leads 2" long. Strip 1"
7. COLOR CODE LEADS AS SHOWN
8. TEST AS BELOW.



SIG. GEN. FREQ.	* V1	* V2	* V3	* V4
2 Mc	1 V	.55V	.55V	.55V
30 Mc	1 V	.55V	.50V	.50V

* ALL VOLTAGE ±20% TOLERANCE

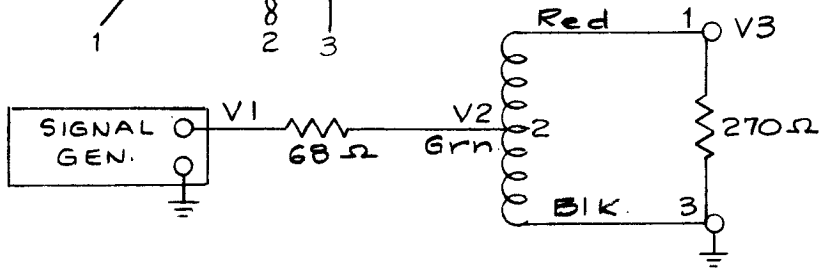
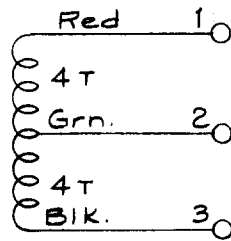
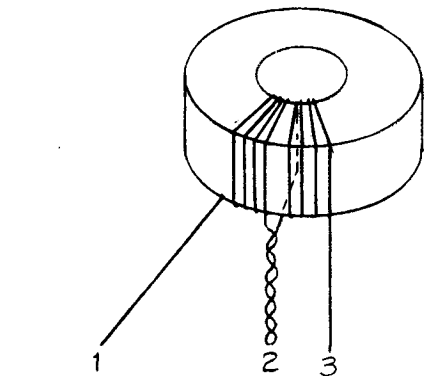
	4	WI102-9-6	WIRE, ELEC, MAG, EZ	#30
X	3	GL-104-2	Insulex, U-85	
X	2	WI-102-9-9	Wire, Magnet, D.S.E.	#30
1	1	CI-127-7	Core, Toroidal	

E		IT. 1 WAS CI 115, REV. 2, U3, U4. * NOTE 1 & 2. WAS WI 102-9, IT. 1, 11. ADD NOTE 1 & 2. REV. NOTE 7. ADD	5/24/70	1985	KL			
D	1	Schematic Clarified	8/17/65	14493	E			
C	1	ITEM 2 WAS WI-107-11	4/23/58	2	HL			
B	1	Schematic Corrected As per CK-339	1/4/57	1	16	EDA	HT	

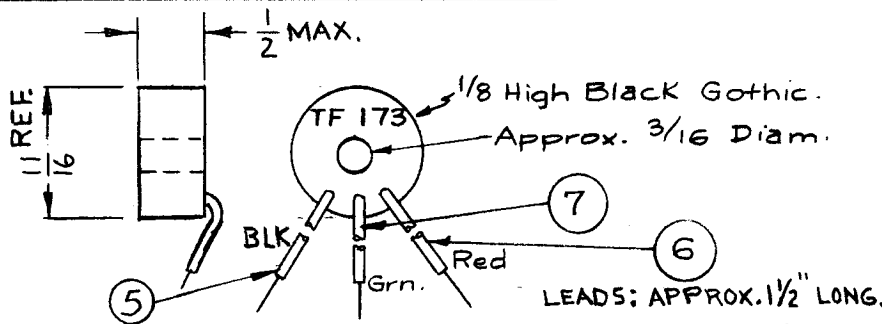
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE: \pm				
DEC. DIM. \pm			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. \pm							
ANGULAR DIM. \pm							

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
TF-172 ASSEMBLY			
MATERIAL			
TYPE & TEMPER		HEAT TREAT. SPEC.	
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

16
 DRAWN: RWR
 CHECKED: [Signature]
 FINAL: [Signature]
 A-1811 E



SIG. GEN. FREQ	V1	V2	V3
2 MC	1.0 V	.387V -.473V	.738V -.902V
8 MC	1.0 V	.414V -.506V	.792V -.968V
32 MC	1.0 V	.450V -.550V	.792V -.968V



1 1/8"	7	PX 104-4-.022	Insulation, Sleeving	# 24	Grn.
1 1/8"	6	PX 104-3-.022	Insulation, Sleeving	# 24	Red
1 1/8"	5	PX 104-1-.022	Insulation, Sleeving	# 24	Blk
X	4	GL 106	Compound, Plastic		
X	3	GL 104-2	Insulox, U 85		
X	2	WI 107-11	Wire, Magnet	# 30 DS	
1	1	CI 115	Core, Toroidal		

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
TF-173 ASSEMBLY			
MATERIAL			
TYPE & TEMPER	HEAT TREAT. SPEC.	RE-DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

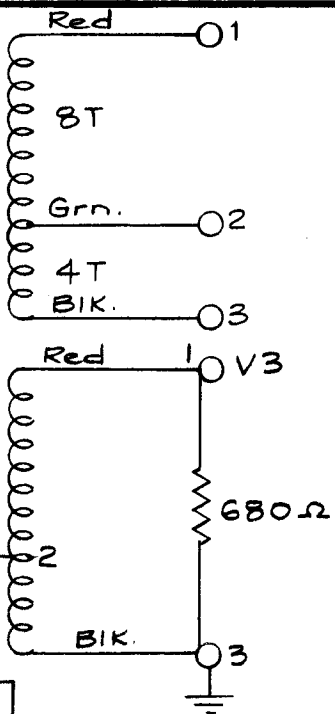
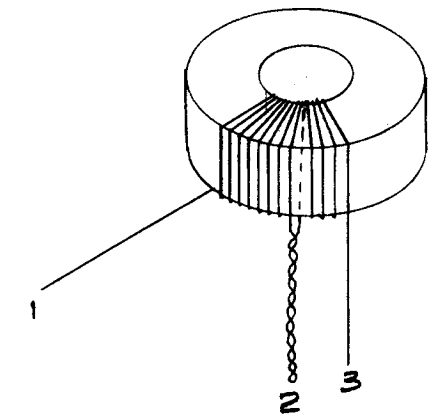
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	2	PICT: SIDE VIEW & LEAD NOTE ADD; FREQ. CHART: V2 & V3 COLS. REVISED.	2.8.65	13453	28	JCS	JCS
A	1	REDRAWN, SLEEVING (ITEMS 5, 6, 7) ADDED.	3/31/58	1	16	HLK	HLK
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.				
FRAC. DIM. ±			REMOVE ALL BURRS AND SHARP EDGES				
ANGULAR DIM. ±							

REQ. PER UNIT	USED ON		
	MODEL	SYMBOL NO.	DATE
1	A-1396	T123	9-19-57
1	A-1516	T123	3-27-57

A 1812 B

PROCEDURE

1. Wind as shown. (Four turns CW, then tap, then four turns CW) Close Wound.
2. Keep leads 1-5/8" long. Strip 5/8".
3. Bake for 1/2 hour at 210° F.
4. Paint Winding with GL 104-2 (Item 3)
5. Bake for 1 hour at 210° F.
6. Test as shown at left.
7. Place Sleeving on leads. Push Sleeving up to Core body.
8. Submerge Coil in Compound (item 4). Sleeving must protrude from Compound as shown in lower left detail.
9. Test as shown.
10. Stamp Unit as shown.



SIG. GEN. FREQ.	V1	V2	V3
3 MC	1.0V	.5V	1.5V

REQ. PER UNIT	USED ON		
	MODEL	SYMBOL NO.	DATE
1	A-1516	T124	3-31-58
1	RTF-2	1/c	12/9/58

A1813

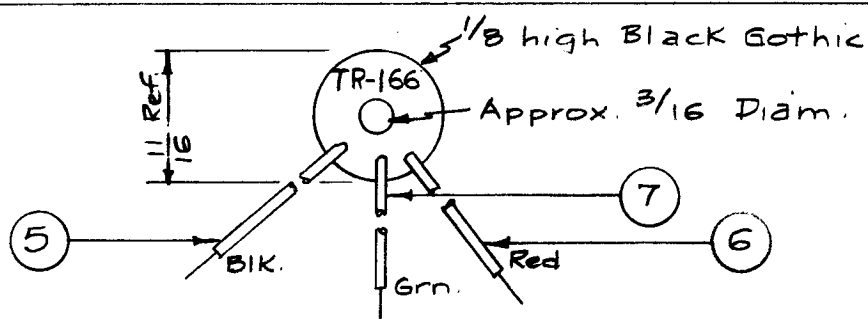
C

PROCEDURE

1. Wind as shown. (Eight turns CW, then tap, then four turns CW) Close Wound.
2. Keep leads 2" Long. Strip $5/8$ ".
3. Bake for $1/2$ hour at 210° F.
4. Paint winding with GL-104-2 (item 3)
5. Bake for 1 hour at 210° F.
6. Test as shown at left.
7. Place sleeving on leads. Push sleeving up to core body.
8. Submerge coil in Compound (item 4). Sleeving must protrude from Compound as shown in lower left detail.
9. Test as Shown.
10. Stamp unit as show

**NOT TO BE RELEASED
W/O AUTHORIZATION**

AUTH. BY: _____



$1\frac{1}{2}$ "	7	PX 104-4-.022	Insulation, Sleeving #24	Grn.
$1\frac{1}{2}$ "	6	PX 104-3-.022	Insulation, Sleeving #24	Red.
$1\frac{1}{2}$ "	5	PX 104-1-.022	Insulation, Sleeving #24	BIK.
X	4	GL 106	Compound, Plastic	
X	3	GL 104-2	Insulex, U85	
X	2	WI 107-11	Wire, Magnet #30DS	
1	1	CI 115	Core, Toroidal	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
C		STEP 2 WAS $1\frac{5}{8}$ LONG IT 5,6,7 WERE $1\frac{1}{8}$ "	1-23-67	17712	RME	<i>JCB</i>	<i>QJ3</i>
B	2	ON CHART V2 WAS .40V, V3 WAS .12V ON TOL. BLOCK V. $\pm 10\%$ AD	8.11.64	12095	NB	<i>WJ</i>	<i>QJ3</i>
A	2	TITLE WAS TF-183 ASS'Y.	8/21/61	5470	H. H.	<i>RU</i>	<i>SPM</i>
	1	STAMPING WAS TF-183					

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
TR-166 ASSEMBLY			
MATERIAL		16 $3/31/58$	<i>JND</i>
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

A 1813

C

PROCEDURE:

REQ. PER UNIT	USED ON			A-1816
	MODEL	ASSY. NO.	DATE	
2	SBT-1K	RAK-9	1-18-60	

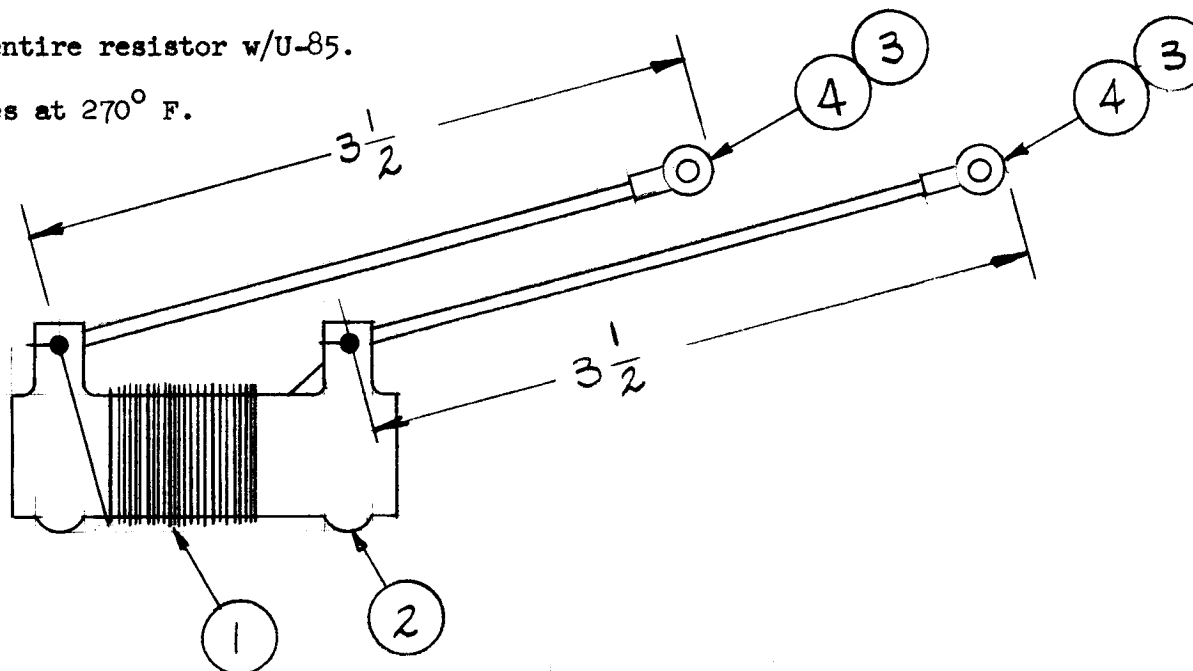
1. Wind 35 turns of wire (item 1) on resistor (item 2), clos wound.
2. Attach solder lugs (item 4) to, two 4" pieces of item 3 and solder wires to resistor as shown.
3. Coat winding and entire resistor w/U-85.
4. Bake for 30 minutes at 270° F.

Note:

Test one unit of 100

R-min. .060 Ω

R-max. .070 Ω



X	5	BS-100	SOLDER, SOFT	
2	4	TE-155-34170	TERMINAL, SOLDERLESS	
X	3	MWC14(19)90	CABLE, INSULATED	W/BLK.
1	2	RW-109-28	RESISTOR, WIREWOUND	
X	1	WI-108-7	WIRE, CEROC (HI TEMP)	

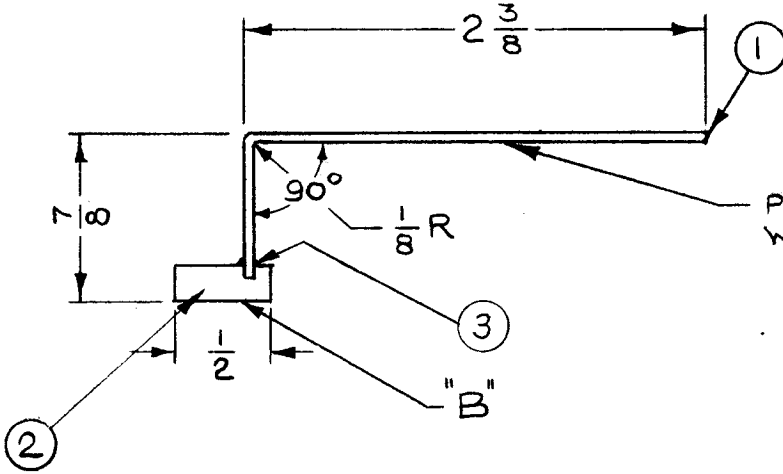
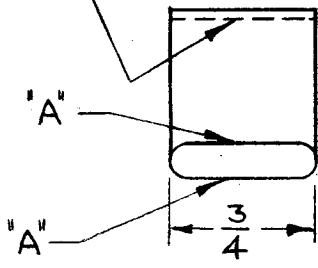
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. ±							
ANGULAR DIM. ±							

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK ASSEMBLY RESISTOR, SHUNT				
MATERIAL		LOBILLE 1-18-60 P.A.		
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
FINISH & SPEC. NO.		ELEC. DES. APP. MECH. DES. APP.		
				A-1816

REQ. PER UNIT	USED ON		
	M DEL	ASS'Y. NO.	DATE
5	AT-101	GPT-40K	3-11-60

A-1819 H

PARALLEL TO "A" WITHIN .005 TOTAL



PARALLEL TO "B" WITHIN .005 TOTAL

NOTE: (HEAT TREATMENT)
600°F FOR 2 HOURS IN CLOSED OVEN AFTER ASSEMBLY AND SOLDERING.

H	3	ADDED BS101-1. DELETED NOTE SILVER SOLDER	3-7-67	17885	L.A.K.	<i>[Signature]</i>	<i>[Signature]</i>
G	1	PICT. REVISED COMP.	5-26-64	11428	N.B.	<i>[Signature]</i>	<i>[Signature]</i>
F	1	AX-209 Ref. Deleted	12-15-62	6371	L.L.	<i>[Signature]</i>	<i>[Signature]</i>
E	1	HEAT TREATMENT NOTE ADDED	9-26-60	3085	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
D	2	CHG. DELETED	9-8-60	2915	R.U.	<i>[Signature]</i>	<i>[Signature]</i>
C	1	MODIFICATIONS REDIMENSIONING	4-25-60	2168	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
B	1	A-1819-1 + 1819-2 ADDED	3-14-60	~	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
A	2	A-1819-2 DELETED AT-101 ADDED	3-11-60	~	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	3	BS101-1	SOLDER, SILVER	
	1	Z PM-586	SHOE, CONTACT	
	1	MS1984-1	LEAF, CONTACT	
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK ASSEMBLY, SHOE CONTACT				
STOCK SIZE				
MATERIAL				
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
RHODIUM .000025			<i>[Signature]</i>	<i>[Signature]</i>
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	
			<i>[Signature]</i>	A-1819 H

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES		SCALE: <i>[Signature]</i>					
DEC. DIM. ±		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES					
FRAC. DIM. ± 1/64							
ANGULAR DIM. ± 0.5°							

WINDING ~

185 TURNS OF ITEM 2
UNIVERSAL WOUND.

MACHINE DATA ~

DRIVER GEAR 49
CAM GEAR 104
CAM .375
POWER MAIN 38
POWER DRIVE 95

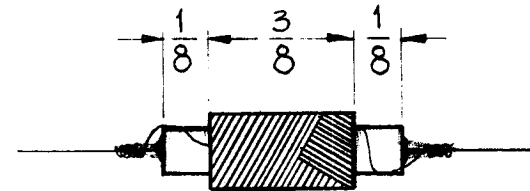
ELECTRICAL DATA ~

L-370 μ hy (360-380)
Q- > 70
F- 790 KC

FABRICATION ~

STAKE LEADS WITH ITEM 4.
SOLDER LEADS AS SHOWN.
COAT WITH ITEM 3, SUBMERGE
FOR 15 MIN.

REQ. PER UNIT	USED ON			A-1839
	MODEL	ASS'Y. NO.	DATE	
1	GPR90RXD		2-18-60	



X	5	BS-100	SOLDER, SOFT
X	4	GL-103	CEMENT (SPOT)
X	3	GL-100	WAX
X	2	WI-107-17	Double Silk Covered, WIRE #36
1	1	CI-114	CORE, POWDERED IRON

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. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. ±							
ANGULAR DIM. ±							

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL			CL-230 ASSY	
TYPE & TEMPER		HEATTREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP	MECH. DES. APP	A-1839

WINDING ~

255 TOTAL TURNS OF ITEM 2
 UNIVERSAL WOUND. TAP AT
 25 TURN FROM END.
 85 TURNS PER PI.

MACHINE DATA ~

DRIVER GEAR - - - 95
 CAM GEAR - - - - 103
 CAM - - - - - - - .093

ELECTRICAL DATA ~

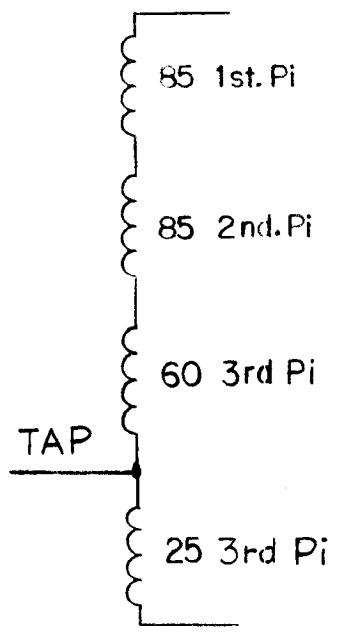
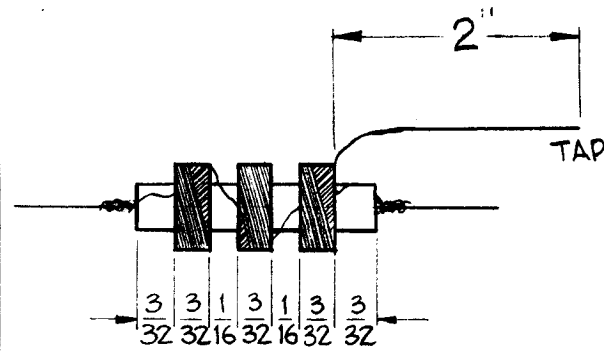
L - 585 μ hy (575-600)
 Q - >80
 F - 790 KC
 TAP - F=2.5 L=13 \pm 2 Q+10

FABRICATION ~

STAKE LEADS WITH ITEM 4
 SOLDER LEADS AS SHOWN.
 SUBMERGED 15 MIN. IN ITEM
 3.
 TAP LEED LENGTH - 1-3/8 IN. LONG,
 TINNED 1/2 IN.

REQ. PER UNIT	USED ON		
	MODEL	ASS'Y. NO.	DATE
1	GPR-90RXD		2-18-60

A-1840



- SCHEMATIC -

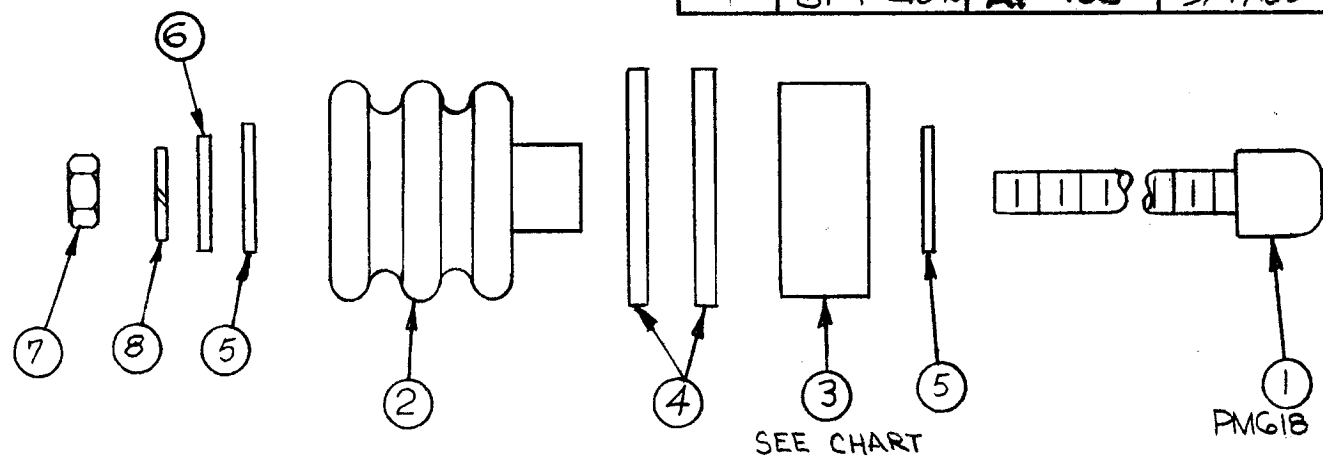
X	5	BS-100	SOLDER SOFT	
X	4	GL-103	CEMENT, SPOT	
X	3	GL-100	WAX	
X	2	WI-107-17	DOUBLE SILK COVERED, WIRE	#36
1	1	CI-114	CORE, POWDERED IRON	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE: _____				
DEC. DIM. \pm			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. \pm							
ANGULAR DIM. \pm							

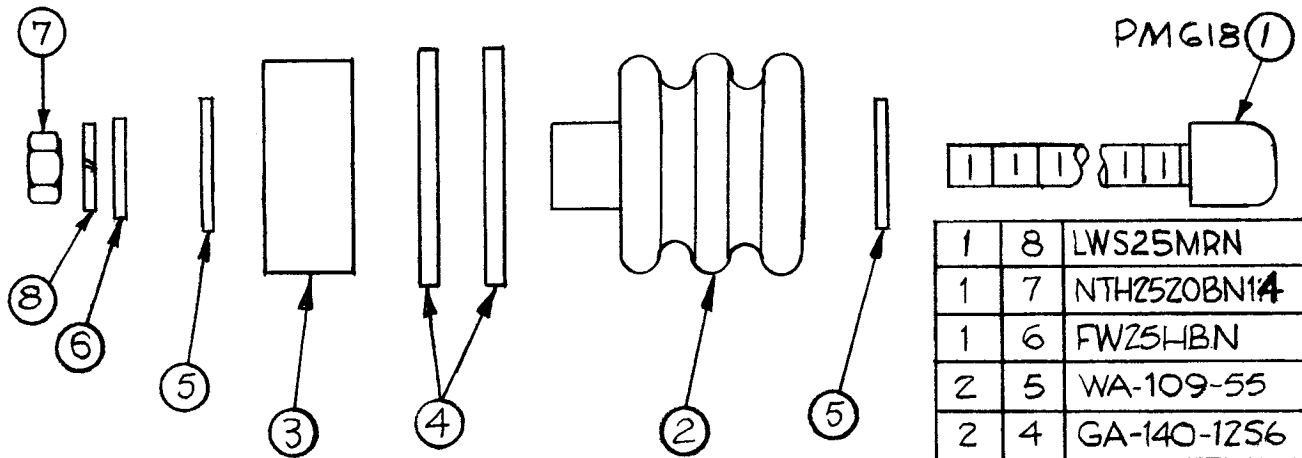
REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL			CL-231 ASSY	
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP	MECH. DES. APP	A-1840

TMC P/N	ITEM 3
A1841-1	PX533
A1841-2	PX533
A1841-3	PX533-3

REQ. PER UNIT	USED ON			A-1841	F
	MODEL	ASSY. NO.	DATE		
	GPT-40K	AP-105	3/7/60		



A1841-3
(AX220-3)
OR
A1841-2
(AX220-2)



A1841-1
(AX220-1)

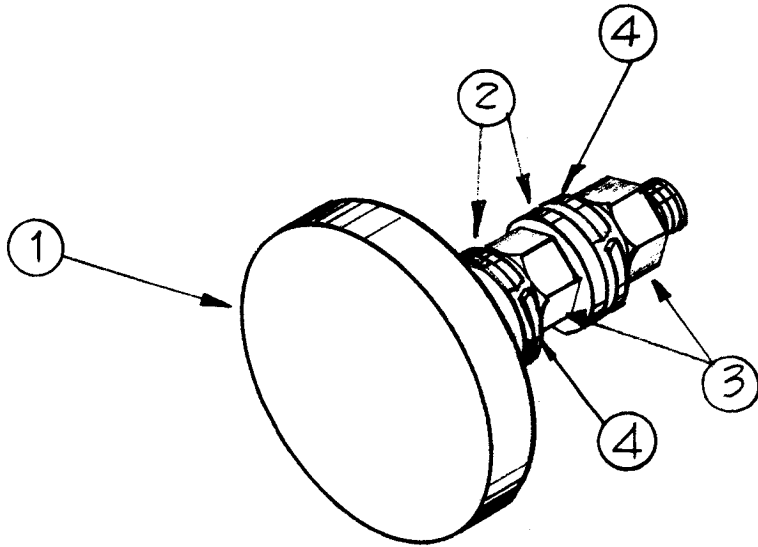
1	8	LWS25MRN	WASHER, LOCK SPLIT	
1	7	NTH25Z0BN14	NUT, HEX	
1	6	FW25HBN	WASHER, FLAT	
2	5	WA-109-55	WASHER, NM	
2	4	GA-140-1256	GASKET,	
1	3	SEE CHART	INSULATOR, BEAD	
1	2	NS-127-1	INSULATOR, BUSHING	
1	1	SEE PICTORIAL	CONTACT, BUTTON	

F		ADD P/N CHART & SEE CHART TO IT 3 CAL. LOTS. ADD -3 TO -2 PICT	9-22-66	16862	RME	QCB	QCB
E		IT.1 ADD. "SEE PICT"	3/21/66	15981	HKA	QCB	QCB
D	1	A1841-2 ADDED	6/12/64	11520	A.M.	@	
C	1	SEE EMN*10865	2/10/64	10865	A.M.	T.R.	QCB
B	1	ITEM 4 WAS NEOPRENE GASKET.	1/14/64	10723	QCB	QCB	QCB
A	2	ITEM 8 ADDED					
A	1	ITEM 6 WAS FW25MRN	1-2-62	6193	QCB	QCB	QCB

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
		T LERANCES					
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.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
AX-220 ASSY. FEEDTHRU INSULATED CONTACT H.V.R.				
MATERIAL				
STOCK SIZE				
TYPE & TEMPER HEAT TREAT. SPEC.				
FINISH & SPEC. NO.				
			DRAWN	CHECKED
			FINAL APPR VAL	
			A-1841	
			F	

REQ. PER UNIT	USED ON			A-1862	B
	MODEL	ASS'Y. NO.	DATE		
1	GPT-40K	AT-102	4-12-60		

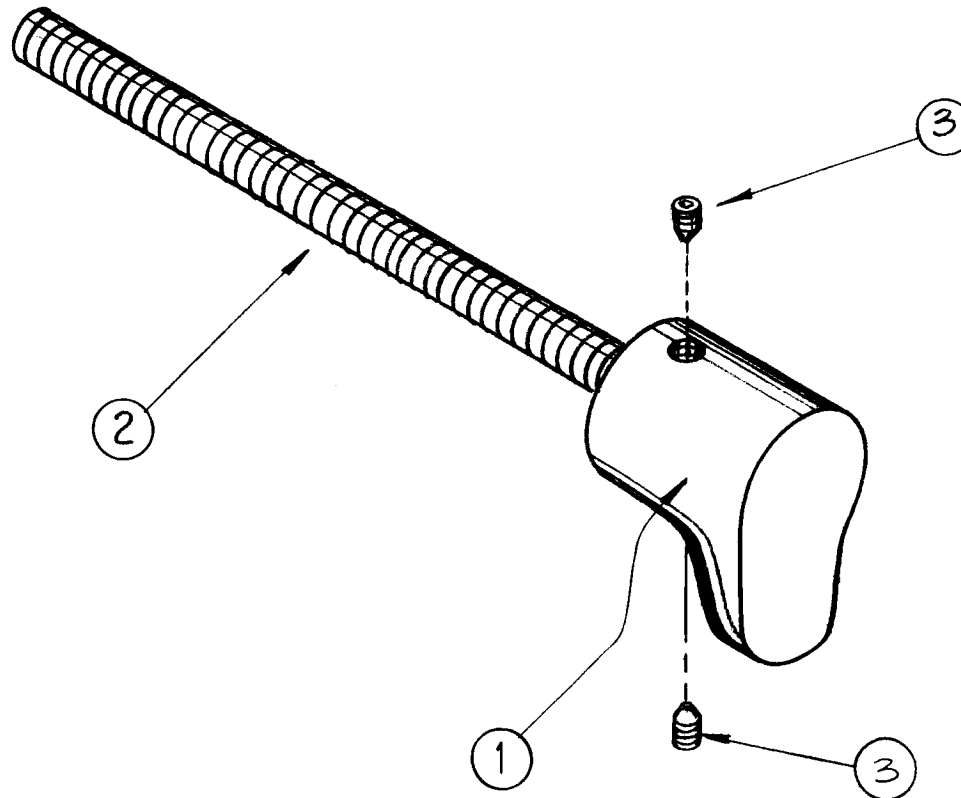


2	4	LWS25MRN	WASHER, LOCK, SPLIT	
2	3	NTH2520BNI4	NUT, HEX	
2	2	FW25HBN	WASHER, FLAT	
1	1	PM-621	CONTACT	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	1	Item 4 was LWS25MRN 1, REQ	10-31-61	5788	GA	<i>[Signature]</i>	<i>[Signature]</i>
A	1	Item 2 was FW25MRN	5-3-61	4825	J.C.B.	<i>[Signature]</i>	<i>[Signature]</i>
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				

REG.	ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL			AX-222, ASSEMBLY	
			BUTTON, CONTACT	
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
			<i>[Signature]</i>	<i>[Signature]</i>
FINISH & SPEC. NO.		ELEC. DES. APP	MECH. DES. APP	
			<i>[Signature]</i>	A-1862
				B

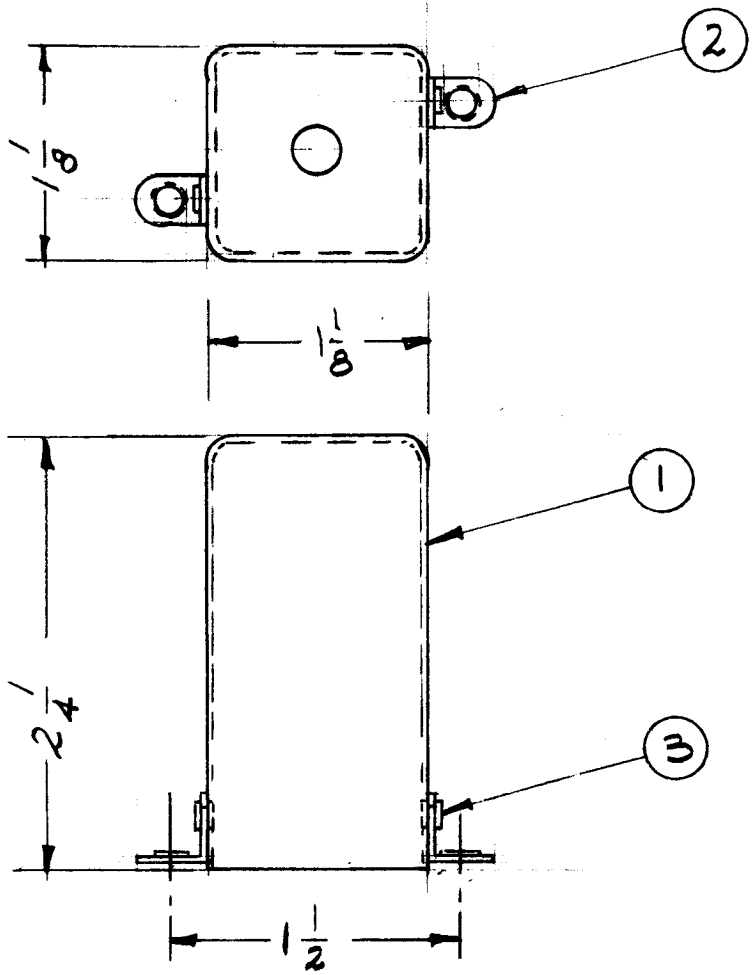
REQ. PER UNIT	USED ON			A 1863	B
	MODEL	ASSY. NO.	DATE		
2	SPT-40K		4-12-60		



2	3	SLHCO832SP6	SET SCREW	
1	2	SM5020BS8.750	ROD, THREADED, 8 3/4 Lg.	
1	1	PM 620	CONTACT	
REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP.	
			MAMARONECK, NEW YORK	
			AX-223 ASSEMBLY	
			(CONTACT ASSY, BAL. OUTPUT)	
			DRAWN <i>[Signature]</i> CHECKED <i>[Signature]</i>	FINAL APPR VAL <i>[Signature]</i>
			TYPE & TEMPER HEATTREAT. SPEC.	A 1863
			FINISH & SPEC. NO.	B

B		IT. 3 WAS AN565D8H6 IT. 2 WAS SM520BS8.75	3-1-67	17880	RME	<i>[Signature]</i>	
A	2	ITEM (3) QTY WAS 1, PICT. ADDED	11-14-63	10358	<i>[Signature]</i>	<i>[Signature]</i>	
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				

REQ. PER UNIT	USED ON			A-1864
	MODEL	ASSY. NO.	DATE	
1	CMO.		3-22-60	



2	3	EY-100-1	EYELET
2	2	TE-167	LUG, ANGLE, THREADED
1	1	FP-177	CAN, ASSY

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: REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. ±							
ANGULAR DIM. ±							

REG.	ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL			CAN ASSY	
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP	MECH. DES. APP	A-1864

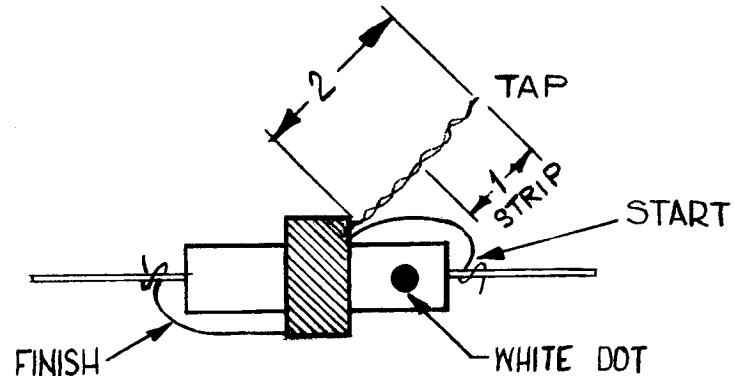
WINDING MACHINE DATA

DRIVER GEAR - 68
 CAM GEAR - 104
 CAM - .187

REQ. PER UNIT 3	USED ON			A 1871	D
	MODEL CMO	ASS'Y. NO.	DATE 4-15-60		

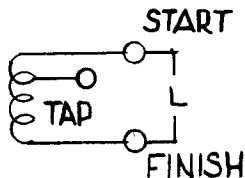
WINDING PROCEDURE

1. WIND 63 TURNS AND BRING OUT 2" TAP; THEN WIND 127 ADDITIONAL TURNS.
2. STAKE LEADS OF WINDING TO CORE BODY WITH ITEM 3
3. BAKE DRY AT 100°C
4. SOLDER COIL LEADS TO CORE LEADS AS SHOWN.
5. COAT WINDING WITH ITEM 4
6. BAKE DRY AT 100°C
7. TEST AS BELOW. (USE BOONTON Q-METER 160A OR EQUIV.)
8. PAINT WHITE DOT ON START SIDE OF COIL. SEE ILLUSTRATION AT RIGHT FOR LOCATION OF DOT.



TEST DATA

L = 500 μH ± 5%
 Q = 90 OR GREATER
 F = 790 KC



X	5	BS-100	SOLDER, SOFT
X	4	GL-102	Q-MAX
X	3	GL-103	CEMENT
X	2	WI-106-17	WIRE #36 DSB
1	1	CI-114	CORE FIXED W/LEADS

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
D	1	CLERICAL CHANGE	11.17.64	-	JB	PL	
C	1	TEST DATA 'L' ± 5% WAS 100μH	5-3-61	4797	RU	JCB	
B	1	STEP 8 Added, SCHEM. CLAIRED	4-28-61	4728	RU	JCB	
A	1	1" STRIP ADDED TO TAP	4-7-61	4580	WCF	JCB	STW
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.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
STOCK SIZE				
CL 227 ASS'Y				
(COIL, RF, FIXED, 500 UHY)				
MATERIAL				
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES.	APP MECH. DES.	APP
			A 1871	D

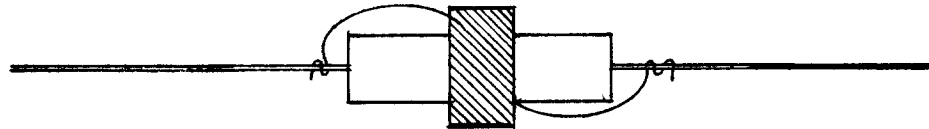
REQ. PER UNIT	USED ON			A-1872	A
	MODEL	ASSY. NO.	DATE		
3	CMO		4-15-60		

WINDING MACHINE DATA

DRIVER GEAR - 68
 CAM GEAR - 104
 CAM - .187

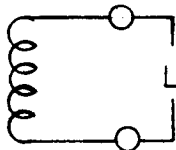
WINDING PROCEDURE

1. WIND 45 TURNS OF ITEM 2.
2. STAKE LEADS OF WINDING TO CORE BODY WITH ITEM 3.
3. BAKE DRY AT 100°C
4. SOLDER COIL LEADS TO CORE LEADS AS SHOWN.
5. COAT WINDING WITH ITEM 4.
6. BAKE DRY AT 100°C
7. TEST AS BELOW. (USE BOONTON Q-METER 160A OR EQUIVALENT)



TEST DATA

L = 32 μ H \pm 5 μ H
 Q = 60 OR GREATER
 F = 2.5. MC



X	5	BS-100	SOLDER, SOFT	
X	4	GL-102	Q-MAX	
X	3	GL-103	CEMENT	
X	2	WI-106-17	WIRE, #36 DSB	
I	1	CI-114	CORE FIXED W/LEADS	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL					
A	1	On test data \pm 5 μ H was \pm 1 μ H	6-1-61	4984	24	JCB											
TOLERANCES								SCALE:									
DEC. DIM. \pm FRAC. DIM. \pm ANGULAR DIM. \pm								MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES									
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK CL-228 ASS'Y (COIL, RF, FIXED, 32 UHY)																	
MATERIAL								TYPE & TEMPER.		HEATTREAT. SPEC.		DRAWN		CHECKED		FINAL APPROVAL	
												A.R.F.		A-1872		A	
FINISH & SPEC. NO.								ELEC. DES. APP. MECH. DES. APP.									