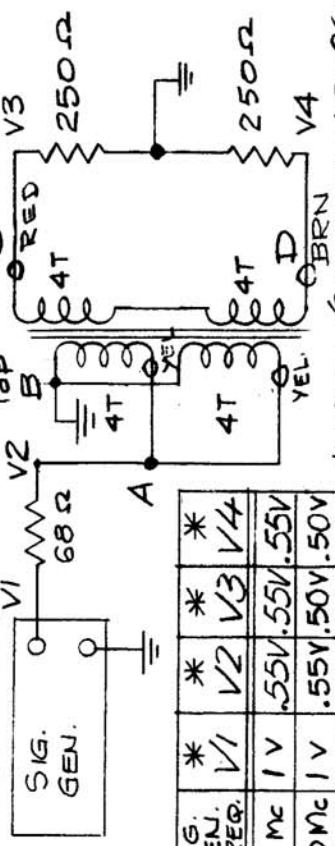


A-1811 E

REQ. PER UNIT	MODEL	USED ON	DATE
1	A-1454	ABBY. NO.	B-14-57
1	SB E-3	A-1454	W-30-59
	AK-104		

PROCEDURE

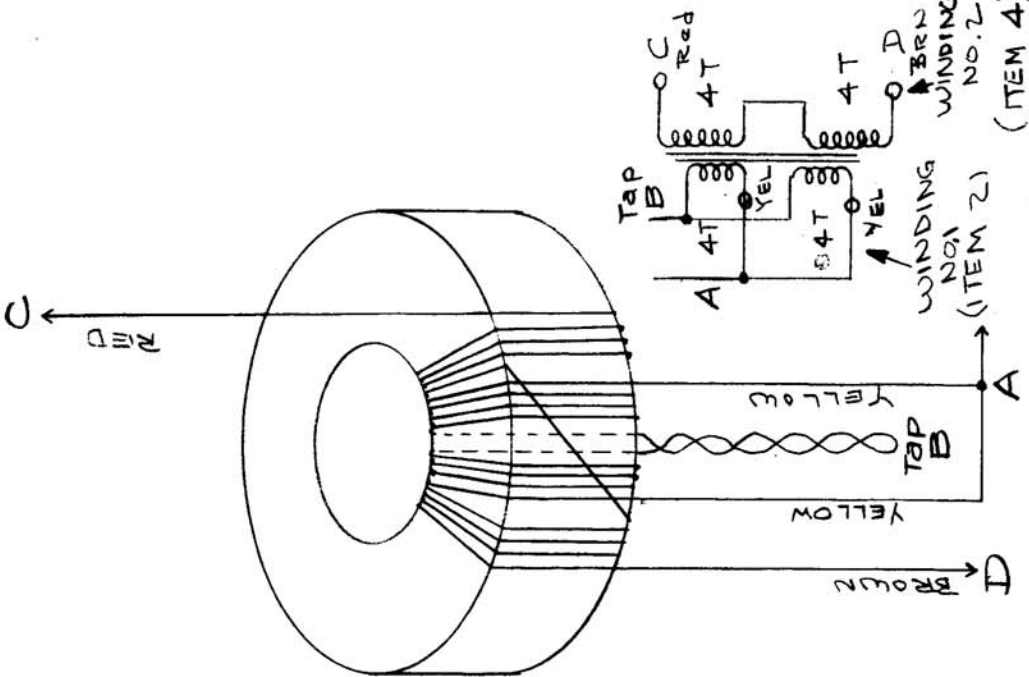
1. Wind Winding #1 using IT.#2. (4 turns CCW, then tap, then 4 turns CW). Close Wound.
2. Wind Winding #2 using IT.#4. (4 turns on one side of Winding #1 and 4 turns on the other side). Close Wound.
3. Bake for 1/2 hour at 210° F.
4. Paint Winding with GL-104-2 (item 3)
5. Bake for 1 hour at 210° F.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



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

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			
MATERIAL			
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
TF-172 ASSEMBLY			

TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL
		RB	RB	A-1811
FINISH & SPEC. NO.		ELEC. DES. APP. MECH. DES. APP.		



ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
E	IT. 1 WAS CI 115, REV 112, V3, V4 *NOTE ADDED 8/22/58	8/22/58	433	YOB	YOB	YOB
D	IT. 2 WAS WI-102-9-11, *NOTE ADDED 8/17/65	8/17/65	14493	YOB	YOB	YOB
C	Schematic Clarified	8/22/58	433	YOB	YOB	YOB
B	ITEM 2 WAS WI-107-11	4/23/58	2	YOB	YOB	YOB
A	Schematic Corrected	1/14/57	1	YOB	YOB	YOB

TOLERANCES
SCALE: 1"

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