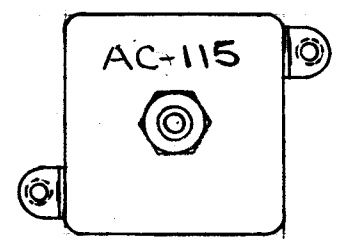
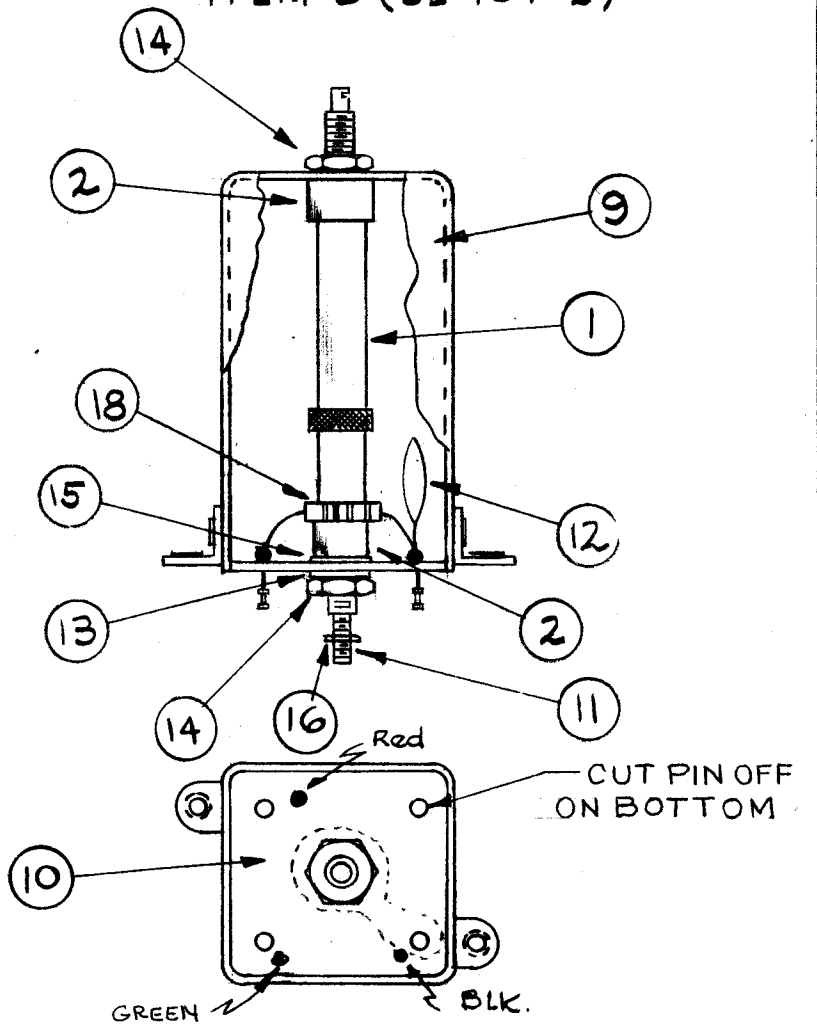


A.1865

STAMP CAN AS SHOWN 1/8 HIGH BLACK GOTHIC. (AC-115)
 NOTE: STAMP TMC INSIGNIA & APPROVAL ON SIDE OF CAN.



CEMENT COIL FORM TO BUSHINGS WITH ITEM B (GL-104-2)



WINDING MACHINE DATA (FOR PI WINDING)

Cam Gear = 49
 Driver Gear = 95
 Cam = .125

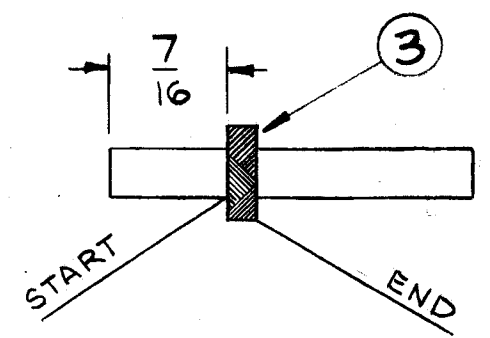
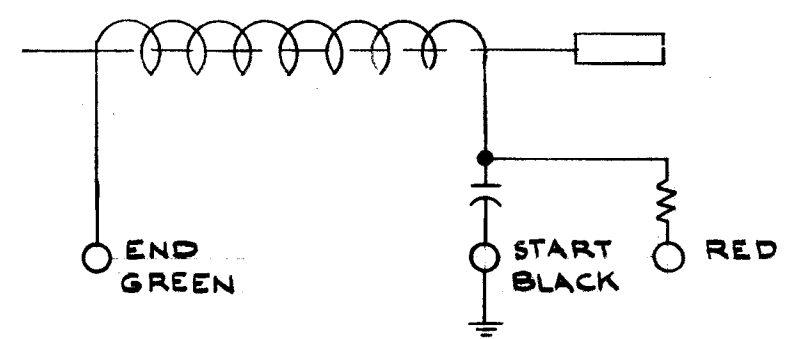
WINDING DATA

1. Start winding 7/16 from end of form.
2. End winding at 35 turns.
3. Keep all leads approximately 3" long.
4. Stake leads to coil form W/GL-103.
5. Fasten ends of WI-106-17 (Item 3) to Terminal Board..
6. Bake unit for 1/2 hour at 215° F.
7. Coat windings W/GL-104-2.
8. Bake hard for 1/2 hour at 215° F.
9. Test as shown below.
10. Assemble as shown.

TEST DATA (W/OUT CORE)

L = 19.4 μ H $\pm 15\%$
 Q = 40 or greater
 FREQ. = 2.5 mc.

COLOR CODES FOR TERMINAL Bd. SHOWN BELOW



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
1	18	RC20GF153J	RESISTOR, FIXED
X	17	BS 100	SOLDER, SOFT
1	16	NTH0632BN8	NUT, HEXAGON
1	15	TE 104-5	TERMINAL, LUG
2	14	NT 102	NUT, HEXAGON
3	13	LWI25MRN	LOCK WASHER, INTERNAL
1	12	CC-100-24	CAPACITOR, FIXED
1	11	CI 109-7	CORE, TUNING
1	10	PX-547	TERMINAL BOARD
1	9	A-1864	ASSEMBLY, CAN
X	8	GL-104-2	INSULEX, U85
X	7	GL-103	CEMENT, DUCO
	6	DELETED	
	5	DELETED	
	4	DELETED	
X	3	WI-106-17	Wire, Magnet #36 DSB
2	2	SM-145	BUSHING, COIL MOUNTING
1	1	CF-117-2.0	COIL FORM, 3/8 OD

THE TECHNICAL MATERIEL CORP.
 MAMARONECK, NEW YORK

AC-115 ASSEMBLY
 COIL, RF TUNED

TYPE & TEMPER	HEAT TREAT	SPEC.	DRAWN	CHECKED	FINAL APPROVAL
			A.R.F.		A1865 F
FINISH & S. NO.	ELEC. DES. APP.		MECH. DES. APP.		

DEC. DIM. \pm	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.					
FRAC. DIM. \pm	REMOVE ALL BURRS AND SHARP EDGES					
ANGULAR DIM. \pm						
TOLERANCES	SCALE:					
ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
F	B/U UPDATE	1-23-67	17680	RME		

1	CMO	T 304	AX-224	4-14-60
REQ. PER UNIT	MODEL	SYMBOL	ASSY. NO.	DATE
	USED ON			