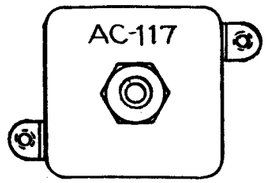
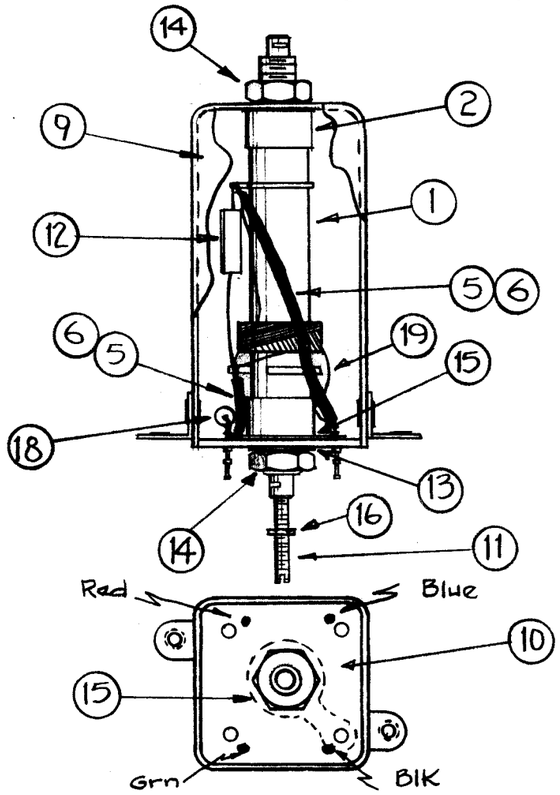
A 1867 B

Stamp Can as shown - 1/8 high Black Gothic
Note ~ Stamp TMC insignia & Approval ON Side of Can.



Cement Coil form to bushings with item 8 (GL-104-2).



Color Code Terminal Bd as shown

WINDING MACHINE DATA (FOR PI WINDING)

Cam Gear = 104
Driver Gear = 68
Cam = .187

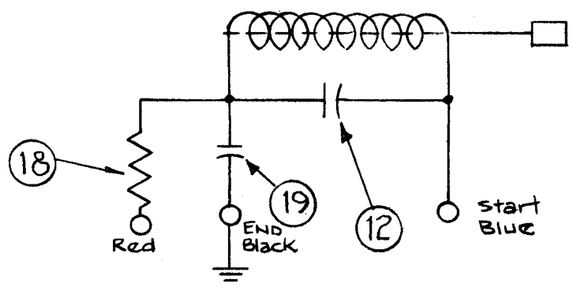
WINDING DATA

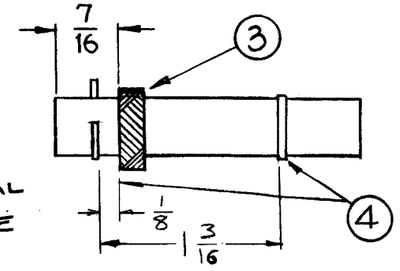
1. Start winding 7/16 form end of form.
2. End Winding at 93 turns.
3. Keep all leads approximately 3" long.
4. Stake leads to coil form W/GL-103.
5. Assemble ring terminals (Item 4) on form as shown and stake W/GL-104-2 (Item 8). Position rings as shown.
6. Fasten ends of WI-104-541 (Item 3) to ring terminals.
7. Bake unit for 1/2 hour at 215° F.
8. Coat windings and ring terminals W/GL-104-2.
9. Bake hard for 1/2 hour at 215° F.
10. Test as shown below.
11. Assemble as shown.

TEST DATA (W/OUT CORE)

L = 96 uh ± 3 uh
Q = 75 or greater
FREQ. = 790 kcs.

Color Code for Terminal Bd Shown Below.





REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
1	19	CC 100-24	CAPACITOR, DISC, FIXED	
1	18	RC20GF103J	RESISTOR, FIXED COMPOSITION	
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	CM20F751G03	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	
X	6	PX-104-5-022	INSULATION, SLEEVING	GREEN
X	5	WL 100-8	BUSS BAR #24	
2	4	TE 153-2	TERMINALS, RING	
X	3	WI 104-541 DSQS	Wire, Magnet 5/14 Litz	
2	2	SM-145	BUSHING, COIL MOUNTING	
1	1	CF-117-2.0	COIL FORM, 3/8 OD	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B		B/U UPDATED	1-23-67	17680	RME		
A	2	1/8 DIM ADDED	9/23/60	3069	US		
	1	1-3/16 DIM. ADDED					

TOLERANCES
DEC. DIM. ±
FRAC. DIM. ±
ANGULAR DIM. ±

SCALE:
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
REMOVE ALL BURRS AND SHARP EDGES

REQ. PER UNIT	MODEL	SYMBOL	ASS'Y. NO.	DATE
1	CMO	T308	AX-224	4-19-60

USED ON

STOCK SIZE
MATERIAL
TYPE & TEMPER | HEAT TREAT. SPEC.
FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK. NEW YORK

AC-117 ASSEMBLY
COIL, RF, TUNED

DRAWN	CHECKED	FINAL APPROVAL
a.R.F.		A1867 B

ELEC. DES. APP. | MECH. DES. APP.

FORM 109-A