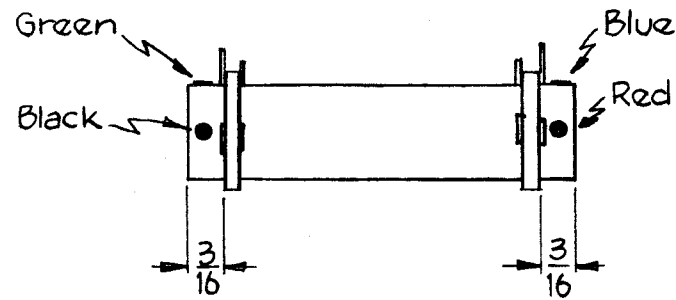


A-188Z



COIL FORM ASSY

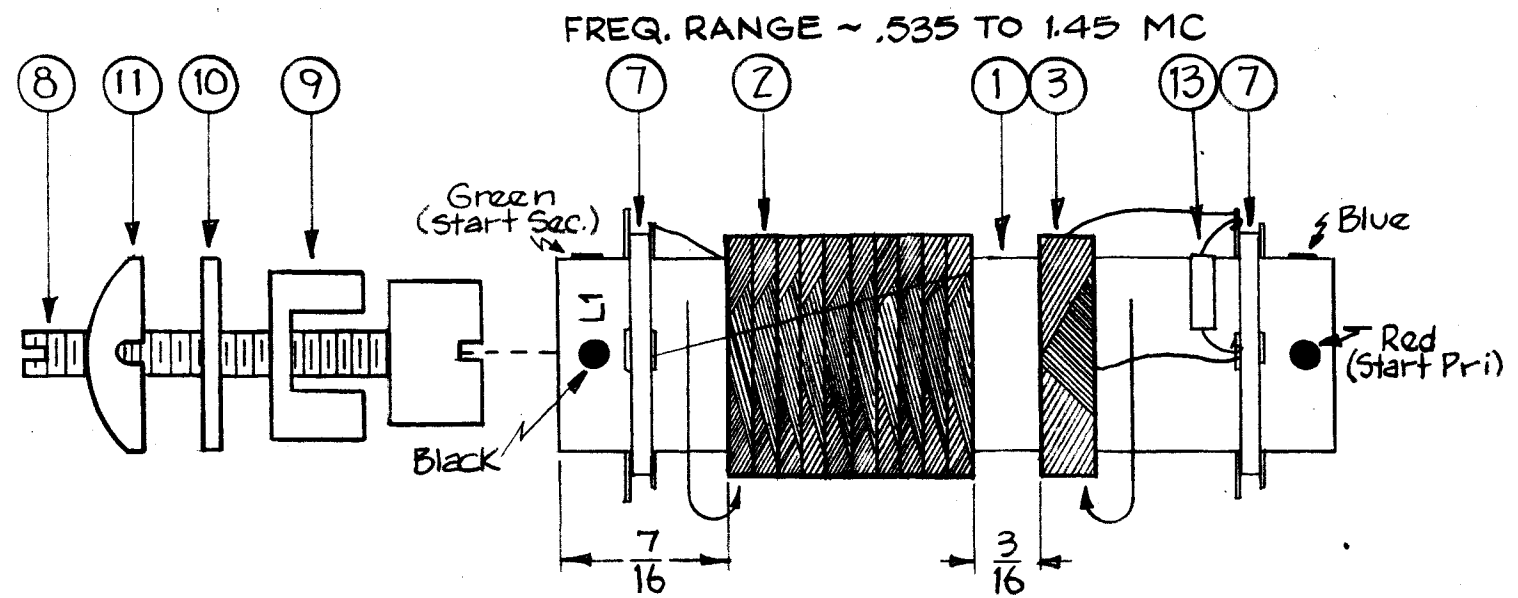
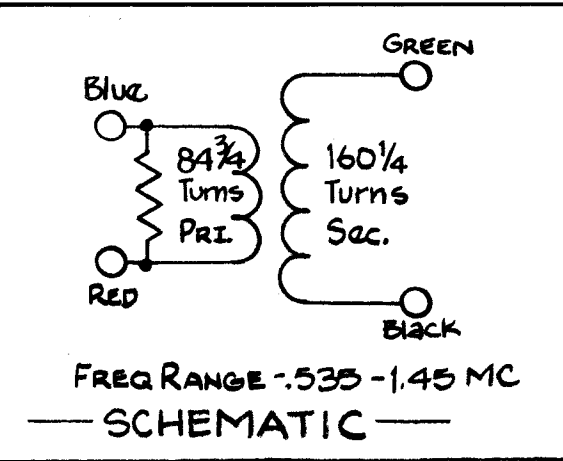
1. CEMENT TERMINAL RINGS TO COIL FORM WITH ITEM 4 IN POSITION SHOWN ABOVE,
2. COLOR CODE COIL FORM AS ABOVE.

COIL MACHINE DATA

SECONDARY		PRIMARY	
RACK GEAR	100	DRIVER GEAR	95
RACK DRIVER	40	CAM GEAR	49
CAM	.125	CAM	.125
CAM GEAR	49		
DRIVER GEAR	95		

WINDING DATA

1. SECONDARY (WIND ON BEFORE PRIMARY), STARTING AT GREEN LUG WIND ON 160 1/4 TURNS OF ITEM 2. (PROGRESSIVE UNIVERSAL WINDING). END AT BLACK LUG.
2. PRIMARY - STARTING AT RED LUG WIND ON 84 3/4 TURNS OF ITEM 3 (UNIVERSAL WINDING) END AT BLUE LUG.
3. STAKE LEADS TO COIL FORM WITH ITEM 4. STRIP, TINE & SOLDER LEADS TO LUGS.
4. BAKE FOR 1/2 HOUR AT 215° F.
5. SATURATE COILS WITH ITEM 5. BAKE FOR 1/2 HOUR AT 215° F.
6. REPEAT STEP 5.
7. SOLDER CONNECT TEST LEADS TO LUGS (APPROX 1-1/4" #22 BUSS-BAR), TEST AS BELOW. REMOVE TEST LEADS.



NOTE - COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 8-9-10-11 ARE CEMENTED TO COIL FORM WITH ITEM 12. FOR IDENTIFICATION, STAMP TMC PART No TT-101 ON THE COIL FORM IN ANY CONVENIENT SPOT.

TEST DATA % CORE

WINDING	* L uh	* Q	F	R _Q APPROX
SEC.	195 (185-205)	60 or Greater	790KC	10.0
PRI.	138 (130-148)	45 or Greater	790KC	5.7

* USE BOONTON Q METER 160A or EQUIVALENT
 ** USE SIMPSON OHMETER 260 or EQUIVALENT

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
1	13	RCZOGF123J	RESISTOR, CARBON, FIXED	R91
X	12	GL-111	CEMENT, "INSA-LUTE"	
1	11	FS-11Z	FASTENER	
1	10	WA-125-2	WASHER, FIBER	
1	9	NT-11Z	NUT, SPEED	
1	8	CI-109-11	CORE, TUNING	
2	7	TE-146-2A	TERMINAL RING	
X	6	BS-100	SOLDER, SOFT	
X	5	GL-10Z	Q MAX	
X	4	GL-103	CEMENT, DUCO	
X	3	WI-107-17	WIRE, MAGNET #36 DSC	
X	2	WI-104-341-SCQS	WIRE, LITZ 3/41 SSE	
1	1	CF-11Z	COIL FORM	

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. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	GPR-90-RXD		L1	5-13-60
USED ON				

STOCK SIZE	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
	TT-101 ASSY		
MATERIAL	DRAWN		CHECKED
	D. J. Man		A. J. Co.
TYPE & TEMPER	HEAT TREAT. SPEC.	FINAL APPROVAL	
		A-188Z	
FINISH & SPEC. NO.	ELEC. DES. APP.	MECH. DES. APP.	