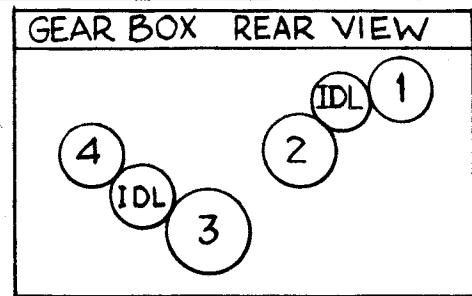


A-1883 C

WINDING MACHINE DATA

- 1.-66
- 2.-62
- 3.-100
- 4.-26
- CAM-.093



WINDING DATA

1. SECONDARY :

STARTING 3/8 FROM EDGE OF COIL , WIND 274-1/4 TURNS OF ITEM 5, SPOT w/ ITEM 7.

2. COVER START OF SECONDARY w/ 1-1/4 TURNS OF TAPE (ITEM 8).

PRIMARY 3. WIND 24-1/4 TURNS OF ITEM 5 ON TAPE. (STARTING 1/32 FROM START OF SECONDARY) SPOT w/ ITEM 7.

4. ASSEMBLE TERMINAL RING 1/16 FROM STARTING EDGE OF SECONDARY AND SPOT CEMENT.

5. CONNECT LEADS AS PER WIRING DIAGRAM.

6. CHECK AS PER TEST DATA.

7. ASSEMBLE ITEMS 1 & 2 AS SHOWN.

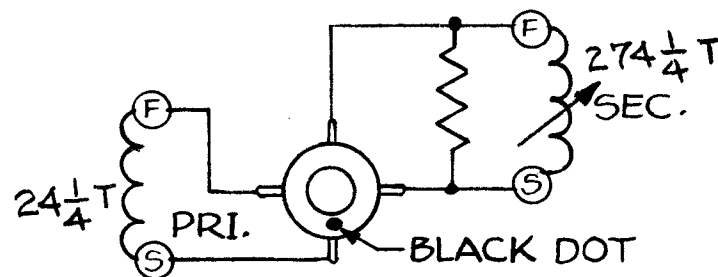
8. BAKE COIL ASS'Y FOR 15 MIN. AT 200°F.

9. DIP COIL ASS'Y INTO GL-110 (ITEM 9) UNTIL ALL BUBBLES DISAPPEAR. NOTE ~ REMOVE EXCESS WAX FROM TERMINAL RING.

TEST DATA W/O CORE & RESISTOR

WINDING	L wh	Q	F	RESISTOR
PRI.	10 (9.5-10.5)	8 >	2.5 MCS	1.2 Ω
SEC.	340 (320-360)	50 >	790 KC	12.5 Ω

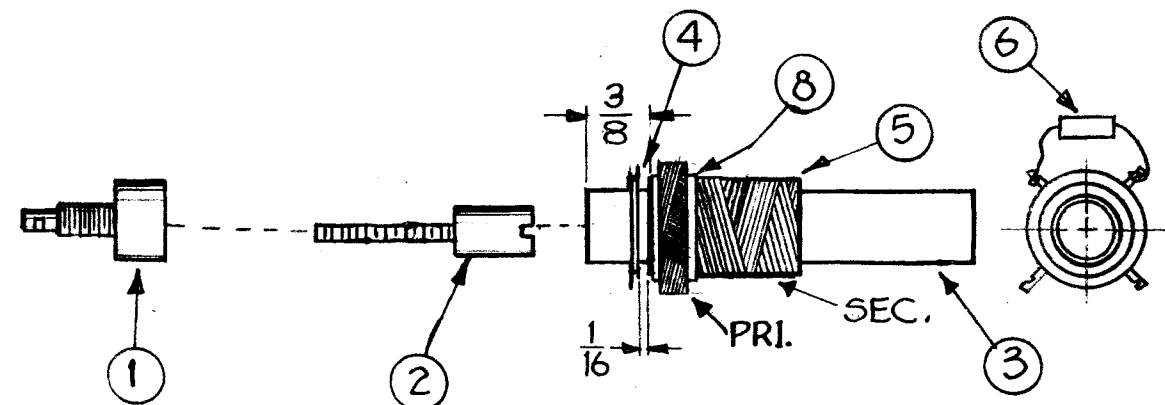
11. STAMP TMC PARTNUMBER (TT-102) IN ANY CONVENIENT SPOT.



WIRING DIAGRAM TOP VIEW

S=START

F=FINISH



X	9	GL-110	IMPREGNATING WAX	
X	8	TA-105-3	MASKING TAPE 1/4"	
X	7	GL-111	CEMENT "INSA-LUTE"	
1	6	RC20GF563J	RESISTOR, CARBON, FIXED	R110
X	5	WI-107-17	MAGNET WIRE, DOUBLE SILK COVERED	
1	4	TE-170-4	TERMINAL COLLAR	
1	3	CF-117-1.25	COIL FORM, 1-1/4"	
1	2	CI-109-5	CORE, TUNING	
1	1	SM-110	COIL MOUNTING BUSHING	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP.			
MAMARONECK, NEW YORK			
TT-102 ASSEMBLY			
MATERIAL			
TYPE & TEMPER		HEAT TREAT. SPEC.	FINISH & SPEC. NO.
DRAWN		CHECKED	FINAL APPROVAL
ELEC. DES. APP.		MECH. DES. APP.	

C	1	ITEM (6) SYM WAS R107	5-22-63	9070			
B	1	Item 8 Part No. Added	2-1-62	6282			
A	1	on Pictorial Winding D. 3/8 was 5/16	1-30-61	4026			
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-92	T103		10-16-62			
	GPR-90-RXD						
USED ON							