

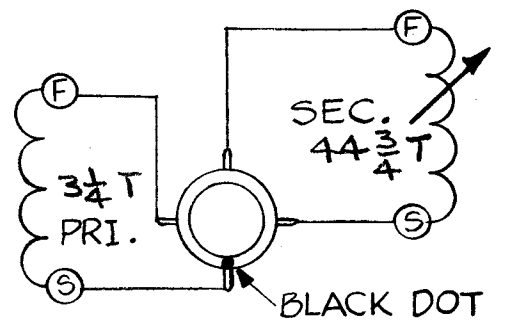
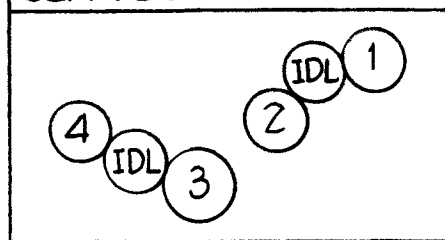
COIL FORM ASSY

1. CEMENT TERMINAL RINGS TO COIL FORM AS SHOWN.

WINDING MACHINE DATA

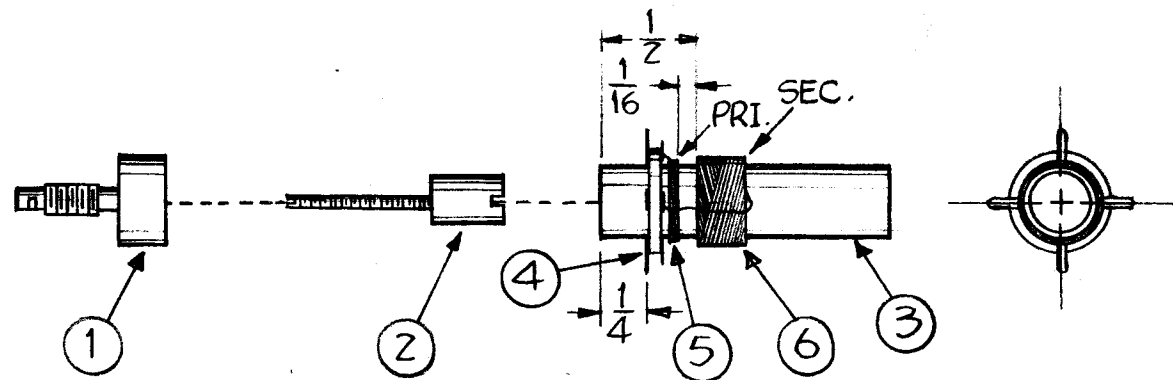
- 1. — 66
- 2. — 62
- 3. — 100
- 4. — 45
- CAM-156

GEAR BOX REAR VIEW



WIRING DIAGRAM TOP VIEW

S-START F-FINISH



WINDING DATA

1. SECONDARY

STARTING 1/2" FROM EDGE OF ITEM 3, WIND 44-3/4 TURNS OF ITEM 6, SPOT w/ITEM 7.

2. WIND 3-1/4 TURNS OF ITEMS 5, 3/32 FROM SECONDARY, SPOT w/ITEM 7.

3. CONNECT LEADS AS PER WIRING DIAGRAM.

4. CHECK AS PER TEST DATA.

5. ASSEMBLE ITEMS 1 & 2 AS SHOWN.

6. BAKE COIL ASSY FOR 15 MIN. AT 200°F.

7. DIP COIL ASSY INTO ITEM 8 UNTIL ALL BUBBLES DISAPPEAR.

NOTE ~ REMOVE EXCESS WAX FROM TERMINAL RING.

8. TEST DATA W/O CORE

WINDING	Luh	Q	F	R ₂ #Aprox
PRI.	.29-.35	17±5%	25	.15
SEC.	17.5-21.0	68-80	2.5	1.2

* SIMPSON # 260

9. STAMP TMC PARTNUMBER TT-104, } IN ANY CONVENIENT SPOT.
WITH LATEST REVISION LETTER

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 8	GL-110	IMPREGNATING WAX	
X 7	GL-111	CEMENT "INSA-LUTE"	
X 6	WI-104-541-0505	WIRE, LITZ	
X 5	WI-107-17	MAGNET, WIRE, DOUBLE SILK COVERED	
1 4	TE-170-4	TERMINAL, COLLAR	
1 3	CF-117-1.0	COIL FORM	
1 2	CI-109-7	CORE, TUNING	
1 1	SM-110	COIL MOUNTING BUSHING	

STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL		TT-104 ASSEMBLY	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
D	1	TEST DATA SEC. "F" WAS 2.5	6.8.64	11501	JTB	@	[Signature]
C	1	1 Req. Added To Items 1, 2, 3, 4	2-1-62	6282	JTB	[Signature]	[Signature]
B	1	PRI. "Q" 17 ± 5% WAS 17	8-23-61	5486	E.I.	[Signature]	[Signature]
A	3	ON ASSY DIM. 1/16 WAS 3/32	8-14-61	5423	G.D.V.	[Signature]	[Signature]
	2	ON TEST DATA W/O CORE "Q PRI." WAS 20 & "Q SEC" WAS 75					
A	1	ON TEST DATA W/O CORE "Luh PRI." WAS 32 & "Luh SEC" WAS 19.0					

TOLERANCES	SCALE:	1	GPR-92	T105	10-16-62
DEC. DIM. ±	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES		GPR-90-RXD		5-10-60
PAC. DIM. ±		REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.
ANGULAR DIM. ±					USED ON