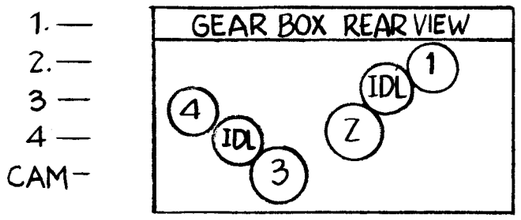
C

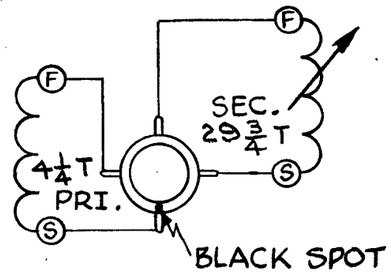
A-1886

COIL FORM ASS'Y

1. CEMENT TERMINAL RINGS TO COIL FORM AS SHOWN.

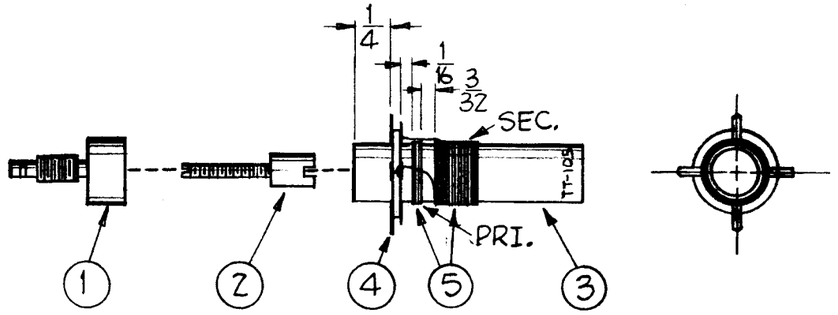
WINDING MACHINE DATA





WIRING DIAGRAM TOP VIEW

S=START F=FINISH



WINDING DATA

1. PRIMARY:
   STARTING 1/16, INSIDE, FROM ITEM 4, WIND 4 1/4 TURNS OF ITEM 5, SPOT w/ITEM 6.
Secondary 2. WIND 29 3/4 . TURNS OF ITEM 5, 3/32 FROM PRI SOLENOID WIND (CLOSE WOUND) SPOT WITH ITEM 6.
3. CONNECT LEADS AS PER WIRING DIAGRAM.
4. CHECK AS PER DATA SHEET.
5. ASSEMBLE ITEMS 1&2 AS SHOWN.
6. BAKE COIL ASSEMBLY FOR 15 MIN AT 200°F.
7. DIP COIL ASS'Y INTO ITEM 7 UNTIL ALL BUBBLES DISAPPEAR. NOTE~ REMOVE ALL EXCESS WAX FROM TERMINAL RING.
8. TEST DATA W/O CORE

WINDING	L uh	Q	F	Rs* APPROX
PRI.	.42 ±10%	≥50	25	.1
SEC.	7.0 ±10%	≥100	7.9	.8

* SIMPSON # 260

9. STAMP TMC PART NUMBER TT-105 IN ANY CONVENIENT SPOT.

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

STOCK SIZE

MATERIAL

TYPE & TEMPER | HEAT TREAT. SPEC. | FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK. NEW YORK

TT-105 ASS'Y

DRAWN | CHECKED | FINAL APPROVAL

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

A-1886 C

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
C	1	ON TEST DATA CHART "L" PRI. & "L" SEC. TOL ADDED	9-13-63	9922	G.DL		
B		WIND DATA #8 Q PRI. WAS 90, SEC. WAS 100	6-26-62	6839	R.T.		
A	1	1 Req. Added To Items 1,2,3,4	2-1-62	6282	LL		

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	PROJECT NO.	ASS'Y. NO.	DATE
1	GPR-92		T106	10-16-62
	GPR-90-RXD	L	L31	5-12-60

USED ON

FORM 109-A