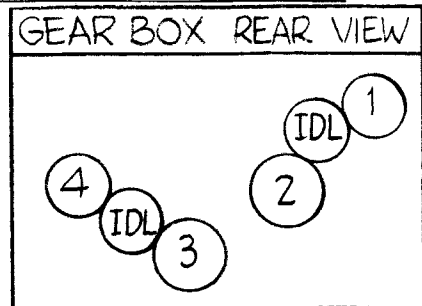


COIL FORM ASS'Y

1. CEMENT TERMINAL RINGS TO COIL FORM AS SHOWN.

WINDING MACHINE DATA

- 1. —
- 2. —
- 3. —
- 4. —
- CAM. —



WINDING DATA

1. PRIMARY:

STARTING 1/32 FROM ITEM 4, WIND 3-3/4 TURNS OF ITEM 5, SPOT w/ITEM 6.

2. SECONDARY:

WIND 22-1/4 TURNS OF ITEM 5, 3/32 FROM PRI., SOLENOID WIND (NO SPACE), SPOT w/ITEM 6.

3. CONNECT LEADS AS PER WIRING DIAGRAM.

4. CHECK AS PER TEST DATA.

5. ASSEMBLE ITEMS 1 & 2 AS SHOWN.

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

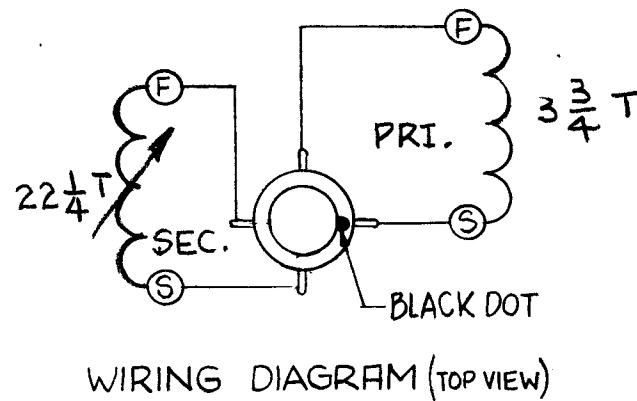
7. DIP COIL ASS'Y INTO ITEM 7 UNTIL ALL BUBBLES DISAPPEAR. **NOTE** ~ REMOVE EXCESS WAX FROM TERMINAL RING.

TEST DATA w/o CORE

WINDING	L _{uh}	Q	F	R _Ω	A _{prox} *
PRI.	.25 TO .3	>90	25	0	0
SEC.	2.4-2.6	>100	7.9	0	0

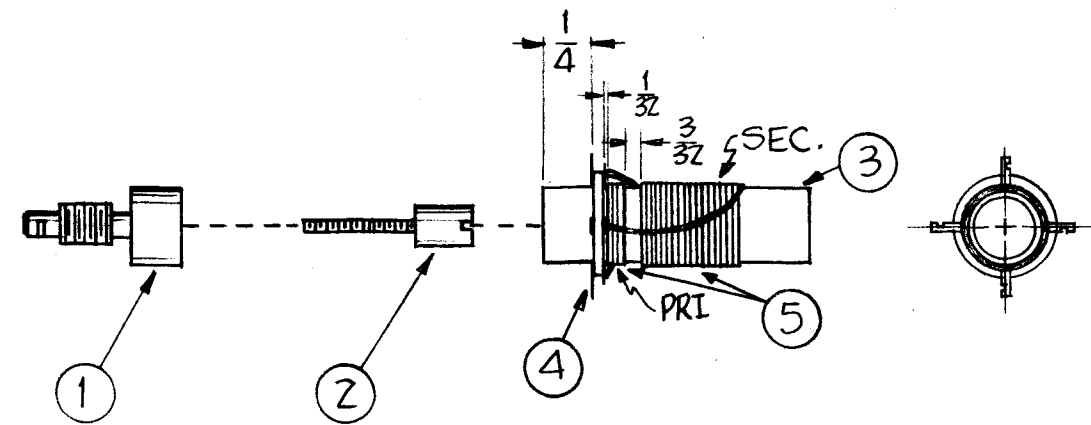
* SIMPSON #260

8. STAMP TMC PART NUMBER TT-106 IN ANY CONVENIENT SPOT.



S-START

F-FINISH



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 7	GL-110	IMPREGNATING WAX	
X 6	GL-111	CEMENT "INSA-LUTE"	
X 5	WI-107-5	MAGNET WIRE, DOUBLE SILK COVER	
1 4	TE-170-4	TERMINAL COLLAR	
1 3	CF-117-1.25	COIL FORM 1-1/4"	
1 2	CI-109-15	CORE TUNING	
1 1	SM-110	COIL MOUNTING BUSHING	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP.			
MAMARONECK, NEW YORK			
TT-106 ASS'Y			
STOCK SIZE			
MATERIAL			
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
			A-1887 B

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B 1	BLACK DOT RELOCATED.	10-25-63	10288	G.D.L.	<i>mlt</i>	<i>ms</i>
A 1	ON TEST DATA w/o CORE L _{UH} (PRI.) WAS 3 Q PRI. WAS 120 L _{UH} (SEC.) WAS 2.5 Q SEC. WAS 100	7-7-61	5196	G.D.L.	<i>gcl</i>	<i>spm</i>

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

1	GPR-92	T107	10-16-62
1	GPR-90-RXD	L32	5-12-60
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.
USED ON			