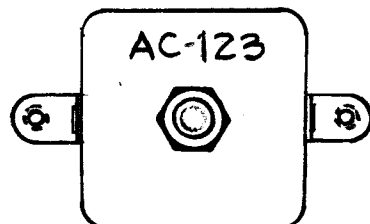
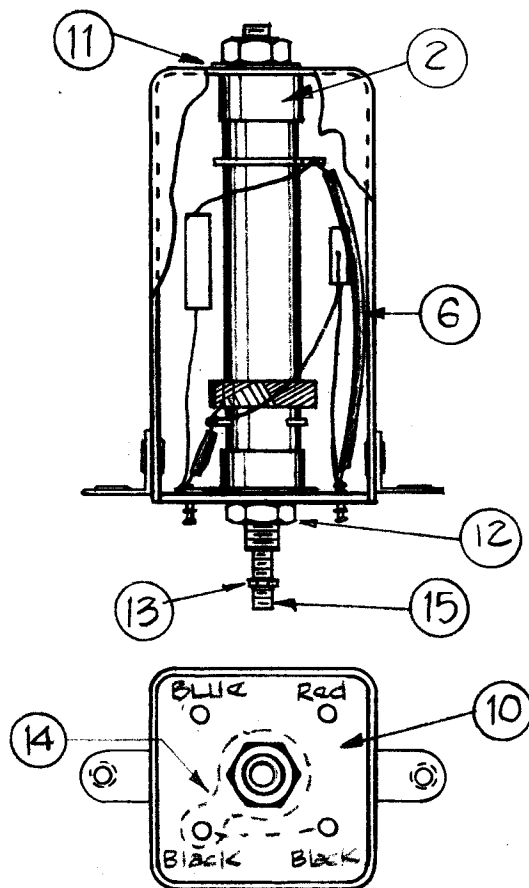


A-1894 E

STAMP CAN AS SHOWN 1/8 HIGH BLACK GOTHIC, NOTE ~ STAMP TMC INSIGNIA & APPROVAL ON SIDE OF CAN.



CEMENT COIL FORM BUSHING WITH ITEM 7.



COLOR CODE TERMINAL BOARD AS SHOWN

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
E	1	QUAN. WAS 2, ITEM 4	10-9-61	5678	EE	as	<i>[Signature]</i>
D	1	RING DIMENSIONS ADDED ON COIL FORM	6/30/61	5172	HQ	JCB	<i>[Signature]</i>
C	1	On Test Data Q: Was 75	6-9-61	5047	H.U.F.	JCB	<i>[Signature]</i>
B	1	Test Data, "L" WAS 100 Microhenries	10-24-60	3147	J.C.B.	JCB	<i>[Signature]</i>
A	1	WINDING DATA, NO. OF TURNS WAS 85	6-30-60	2576	cy	JCB	<i>[Signature]</i>

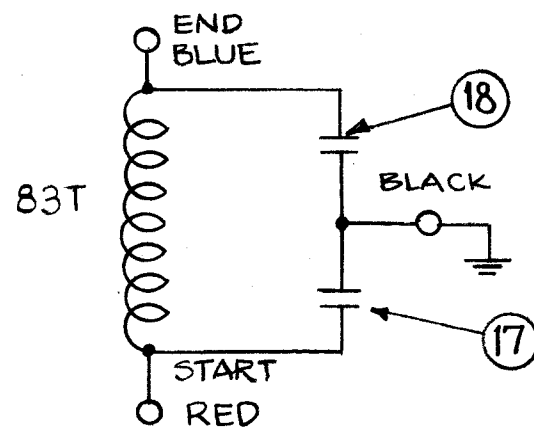
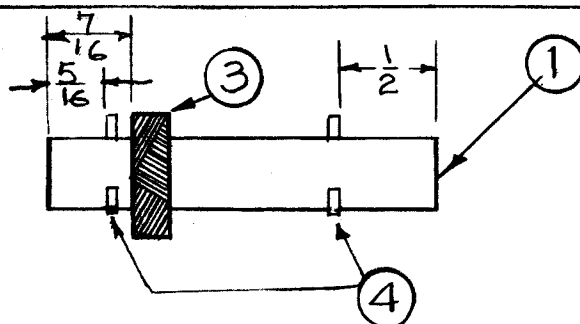
TOLERANCES		SCALE:
DEC. DIM. ±		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES
FRAC. DIM. ±		
ANGULAR DIM. ±		

WINDING MACHINE DATA

Cam Gear 104  
Driver Gear 68  
Cam .187

WINDING DATA

1. Start winding 7/16 from end of form.
2. End winding at 83 turns.
3. Keep all leads approximately 3" long.
4. Stake leads to coil form W/GL-103.
5. Assemble ring terminals (Item 4) on form as shown and stake W/GL-104-2 (Item 8). Position rings as shown.
6. Fasten ends of WI-104-541 (Item 3) to ring terminals.
7. Bake unit for 1/2 hour at 215° F.
8. Coat windings and ring terminals W/GL-104-2.
9. Bake hard for 1/2 hour at 215° F.
10. Test as shown below.
11. Assemble as shown.



COLOR CODE FOR TERMINAL BOARD SHOWN

TEST DATA (W/OUT CORE)

L = 85 ±10 Microhenries  
Q = 50 or Greater  
Freq. = 2.5 MC

Use Booton Radio Corp. Q Meter Model 160 A or Equiv.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
1	18	CM20C102K	CAPACITOR, FIXED
1	17	CM20C301G	CAPACITOR, FIXED
X	16	BS-100	SOLDER, SOFT
1	15	CI-109-7	CORE, TUNING
1	14	TE-104-5	TERMINAL, LOCKING
1	13	NTH0632BC8	NUT, HEX.
2	12	NTH2528BC14	NUT, HEX.
2	11	LWIZ5MRC	LOCKWASHER
1	10	PX-547	TERMINAL BOARD
1	9	A-1513	CAN, ASSEMBLY
X	8	GL-104-2	INSULEX, U 85
X	7	GL-103	CEMENT, DUCO
X	6	PX-100-6-.022	INSULATION, SLEEVING
X	5	WL-100-8	WIRE, BUSS BAR #24
1	4	TE-153-2	TERMINAL, RING
X	3	WI-104-541 DSQS	WIRE, MAGNET 5/41 LITZ
2	2	SM-145	BUSHING, COIL MOUNTING
1	1	CF-117-2.0	COIL FORM 3/8" OD

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK, NEW YORK			
AC-123 ASSEMBLY			
TRANSFORMER I.M.C.			
TYPE & TEMPER		HEAT TREAT. SPEC.	FINISH & SPEC. NO.
DRAWN		CHECKED	FINAL APPROVAL
ELEC. DES. APP.		MECH. DES. APP.	A-1894 E

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	CSS-1			5-2-60
USED ON				