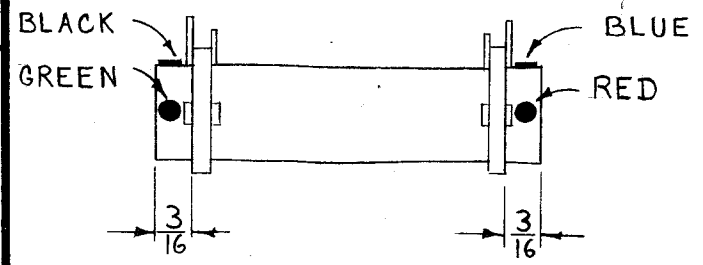


A-1902



COIL FORM ASS'Y

- 1- CEMENT TERMINAL RINGS TO COIL FORM WITH ITEM 4 IN POSITION SHOWN ABOVE.
- 2- COLOR CODE COIL FORM AS ABOVE.

WINDING MACHINE DATA

SECONDARY		PRIMARY	
RACK GEAR	100	DRIVER GEAR	95
RACK DRIVER	56	CAM GEAR	49
CAM	.187	CAM	.125
CAM GEAR	66		
DRIVER GEAR	63		

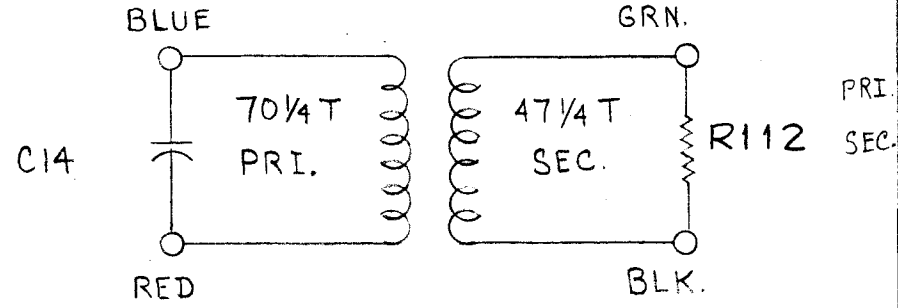
WINDING DATA

- 1- SECONDARY (WIND ON, BEFORE PRIMARY), STARTING AT BLACK LUG, 47 1/4 TURNS OF ITEM 2, (PROGRESSIVE UNIVERSAL WINDING) ENDING ON GREEN LUG.
- 2- PRIMARY - STARTING ON BLUE LUG, 70 1/4 TURNS OF ITEM 3 (UNIVERSAL WINDING) END ON RED LUG.
- 3- STAKE LEADS TO COIL FORM WITH ITEM 4. STRIP, TIN & SOLDER LEADS TO LUGS AS SHOWN.
- 4- BAKE FOR 1/2 HOUR AT 215° F.
- 5- SATURATE COILS WITH ITEM 5. BAKE FOR 1/2 HOUR AT 215° F.
- 6- REPEAT STEP 5.
- 7- SOLDER CONNECT TEST LEADS TO LUGS (APPROX. 1/4" OF #22 BUSS BAR). TEST AS BELOW. REMOVE TEST LEADS.)

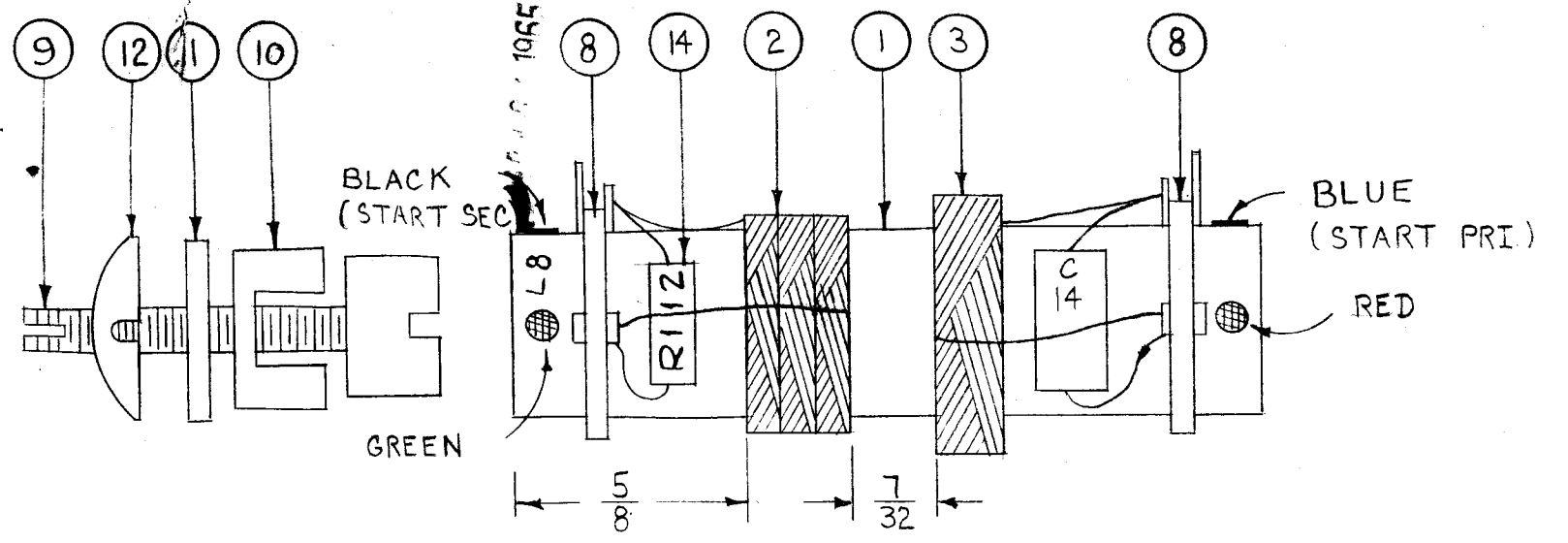
TEST DATA w/o CORE & w/o (ITEM 14)

WINDING	* L μh	* Q	F	** R Ω APPROX.
SEC.	27.5 (26.1-28.9)	90 OR GREATER	2.5 MC	2.0
PRI.	94 (89 - 99)	40 " "	790 KC	5.0

* USE BOONTON Q METER 160A OR EQUIV.
 ** " SIMPSON OHMETER 260 " "



FREQ RANGE 1.43 - 33 MC



NOTE: COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 9-10-11-12 ARE CEMENTED TO COIL FORM WITH ITEM 13.

FOR IDENTIFICATION, STAMP THE NUMBER L8 ON THE COIL FORM IN ANY CONVENIENT SPOT.

1	14	RC20GF153J	RESISTOR, FIXED, COMP.	R112
X	13	GL-111	ADHESIVE	
1	12	FS-112	FASTENER	
1	11	WA-125-2	WASHER, FIBER	
1	10	NT-112	NUT, SPEED	
1	9	CI-109-7	CORE	
2	8	TE-146-2A	TERMINAL, RING	
1	7	CM15F271G03	CAPACITOR, FIXED, MICA	C14
X	6	BS-100	SOLDER, SOFT	
X	5	GL-102	ADHESIVE, Q-MAX.	
X	4	GL-103	ADHESIVE, DUCO	
X	3	WI-107-17	WIRE, MAGNET, #36 DSC	
X	2	WI-104-541-SN-QS	WIRE, LITZ, 5/41 SN-QS	
1	1	CF-112	FORM, COIL	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP.			
MAMARONECK, NEW YORK			
STOCK SIZE			
TT-109 ASS'Y			
MATERIAL			
TRANSFORMER, R.F. TUNED, BAND 2			
TYPE & TEMPER		HEAT TREAT. SPEC.	DATE
DRAWN		CHECKED	FINAL APPROVAL
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

D	B/M UPDATED	10.18.66	17039	WTW		
C	IT. 7 WAS CM15C271G	9-28-66	16893	HGA		
B	ITEM 2 WAS WI-104-541-SNE	2/5/64	10847	A.M.		
A	IN BUILD-UP, ITEM (1) WAS WA-125, (1-5913) CLARIFIED, MODEL ADDED	8-14-63	9753	AL		

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES							
SCALE:							
DEC. DIM. ±							
FRAC. DIM. ±							
ANGULAR DIM. ±							
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES							

1	GPR-91 RXD		8-2-63
1	GPR-90 RXD		5-6-60
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.
USED ON			