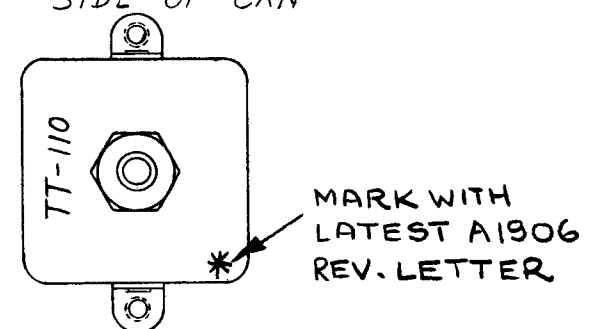
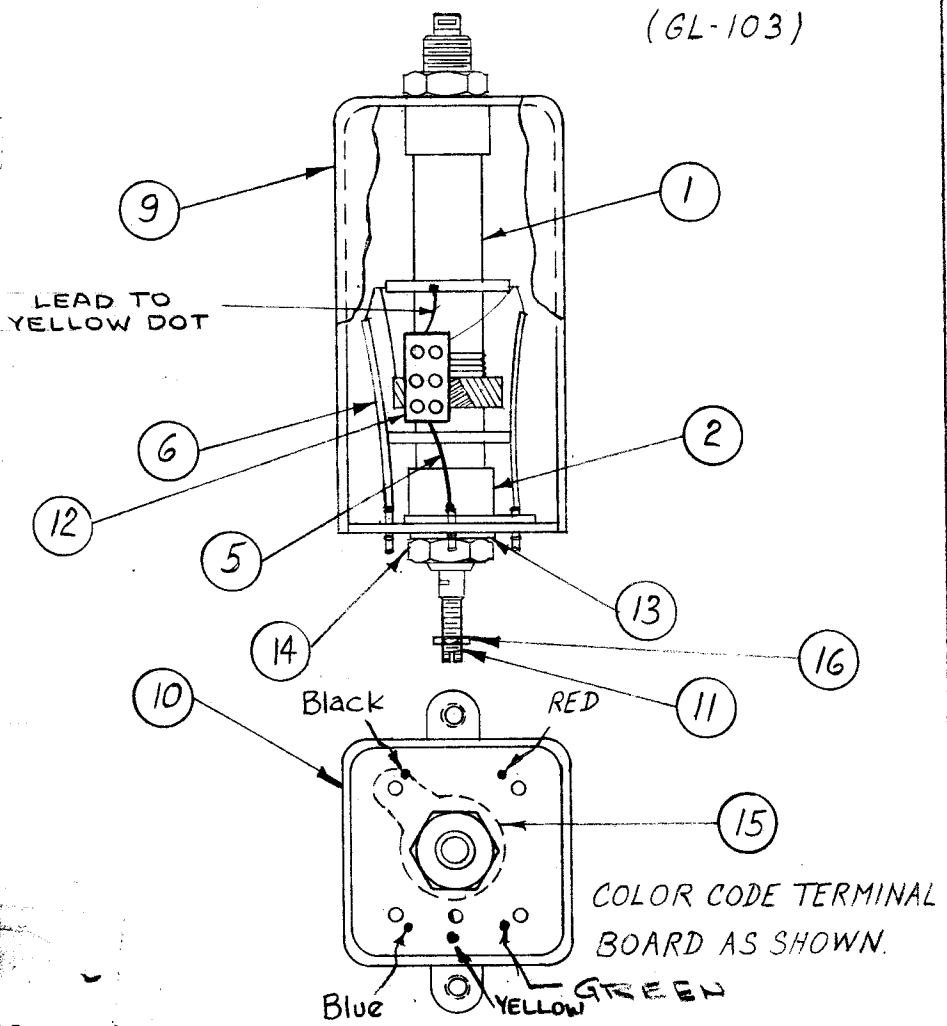


A-1906

STAMP CAN AS SHOWN - 1/8 HIGH BLACK GOTHIC
 NOTE: STAMP TMC INSIGNIA & APPROVAL ON
 SIDE OF CAN



CEMENT COIL FORM TO BUSHING WITH ITEM 7
 (GL-103)

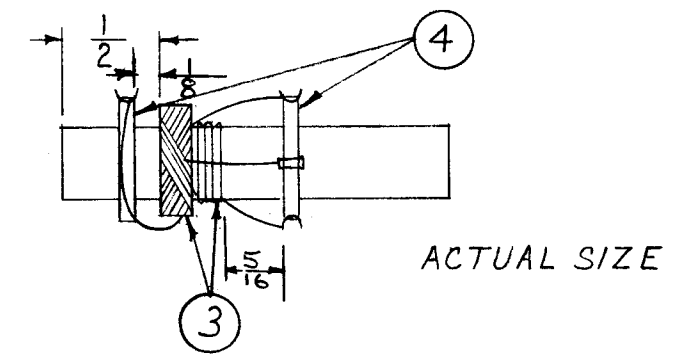


WINDING MACHINE DATA (FOR PI WINDING).

CAM GEAR = 95
 DRIVER GEAR = 99
 CAM = .187

WINDING DATA

- 1- START WINDING 1/2" FROM END OF FORM.
- 2- END WINDING AT APPROX. 105 TURNS, UNTIL INDUCT. IS MET.
- 3- KEEP ALL LEADS APPROXIMATELY 3" LONG.
- 4- STAKE LEADS TO COIL FORM W/GL-103.
- 5- START LINK WINDING AGAINST LATTER WINDING. (close wound).
- 6- END WINDING AT 6 TURNS.
- 7- ASSEMBLE TERMINAL COLLAR (ITEM 4) ON FORM AS SHOWN AND STAKE W/GL-103 (ITEM 7), POSITION AS SHOWN.
- 8- COAT WINDINGS AND TERMINAL COLLAR W/GL-104-2
- 9- BAKE HARD FOR 1/2 HOUR AT 215°F.
- 10- TEST AS SHOWN BELOW
- 11- ASSEMBLE AS SHOWN.

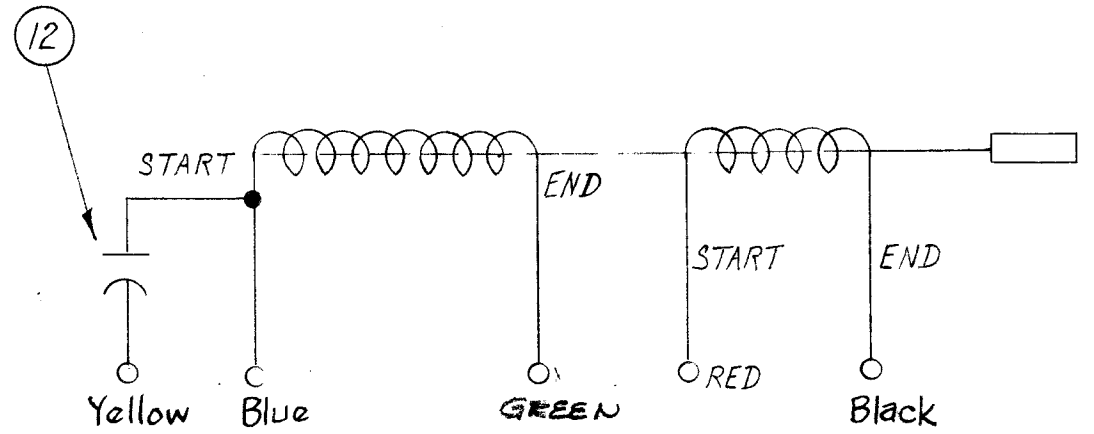


* - REF: A-1868 & A-1869

TEST DATA (W/OUT CORE).

L = 126 μ HY \pm 10 μ HY
 Q = 40 OR GREATER
 FREQ = 790 KCS.

COLOR CODES FOR TERMINAL BD. SHOWN BELOW



REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	17	BS-100	SOLDER, SOFT	
1	16	NTH0632BN8	NUT, HEXAGON	
1	15	TE-104-5	TERMINAL, LUG	
2	14	NTH2528BN14	NUT, HEXAGON	
3	13	LWI 25MRN	LOCK WASHER, INTERNAL	
1	12	CM20F821G03	CAPACITOR, FIXED	
1	11	CI-116-2	CORE, TUNING	
1	10	PX-403	TERMINAL, BOARD	
1	9	A-1513	ASSEMBLY, CAN	
X	8	GL-104-2	INSULEX, U85	
X	7	GL-103	CEMENT, DUCO	
X	6	PX-104-2-034	INSULATION, SLEEVING	RED
X	5	WL-100-8	BUSS BAR # 24	
2	4	TE-170-4	TERMINAL, COLLAR	
X	3	WI-106-17	WIRE, MAGNET # 36 DSB	
2	2	SM-145	BUSHING, COIL MOUNTING	
1	1	CF-117-2.0	COIL FORM, 3/8 O.D.	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
F		CHGD "C" TO "N" ON IT. 13, 14 & 16. IT 12 WAS CM 20C82IK. IT 6 WAS PX104-2.022	10-18-66	17048	RME	[Signature]	[Signature]

TOLERANCES: DEC. DIM. \pm , PRAC. DIM. \pm , ANGULAR DIM. \pm

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

1	CLL-1		5-19-60
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.
			DATE

TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
		[Signature]	[Signature]	[Signature]
FINISH & SPEC. NO.		ELEC. DES. APP. MECH. DES. APP.		

THE TECHNICAL MATERIEL CORP.
 MAMARONECK, NEW YORK
 TT-110 ASS'Y
 TRANSFORMER, RF, TUNED

A-1906