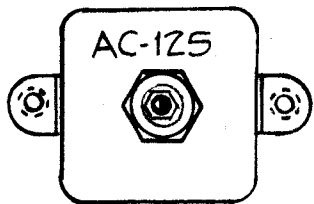


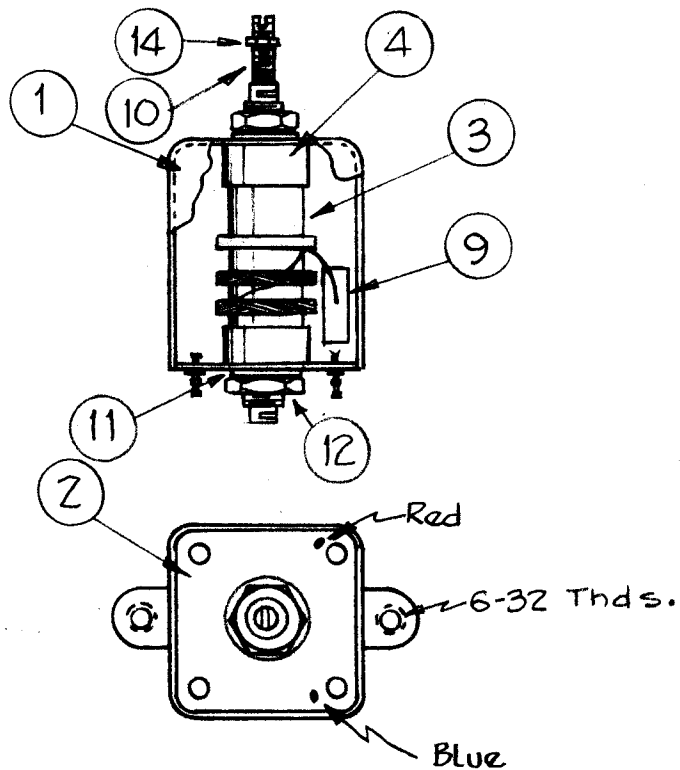
A-1954 E

Stamp can as shown - 1/8 high black Gothic.

NOTE - Stamp T.M.C. insignia & approval on side of can.



CEMENT COIL FORMS TO BUSHINGS WITH GL-103.



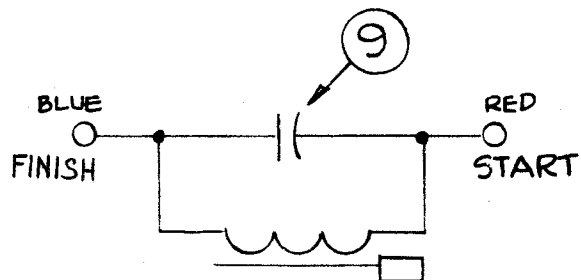
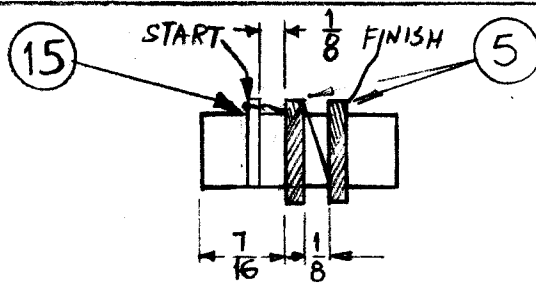
COLOR CODE TERMINAL BOARD AS SHOWN.

WINDING MACHINE DATA (For PI winding)

Cam Gear - 49
Driver Gear - 95
Cam - .125

WINDING DATA

1. Start first PI winding 7/16" from end of form.
2. End winding at 125 turns
3. Start second PI winding 1/8" from end of first PI, end at 125 turns.
4. Keep all leads approx. 3" long.
5. Stake leads to coil form with GL-103 (Item 7).
6. Assemble ring terminal (Item 15) on form as shown, and stake with GL-104-2 (Item 8).
7. Fasten start of winding (Item 5) to ring terminal.
8. Bake unit for 1/2 hour at 215° F.
9. Coat windings and ring terminals with GL-104-2 (Item 8).
10. Bake Hard for 1/2 hour at 215° F.
11. Test as shown in test data.
12. Assemble as shown.



TEST DATA (w/out Core)

L = 540 uh ± 10%
Q = 50 or greater
FREQ. = 790 KC

USE BOONTON CORP Q METER MODEL 160A OR EQUIV.

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
1	15	TE-153-2	TERMINAL RING	
1	14	NTH0632BN8	NUT, HEX HEAD	
X	13	BS-100	SOLDER, SOFT	
2	12	WT-102	NUT, HEX HEAD	
2	11	LWI25 MRN	LOCKWASHER, INTERNAL	
1	10	CI-109-7	CORE, TUNING	RED
1	9	CM20F681G03	CAPACITOR, FIXED	
X	8	GL-104-2	INSULEX, U85	
X	7	GL-103	CEMENT, DUCO	
X	6	PX-104-3-.034	INSULATION, SLEEVING	RED
X	5	WI-107-19	WIRE, MAGNET, # 38 DSC	
2	4	SM-145	BUSHING, COIL MOUNTING	
1	3	CF-117-1.0	COIL FORM 3/8 OD	
1	2	PX-585-2	TERMINAL BOARD	
1	1	A-1950-2	CAN ASS'Y	

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
AC-125 COIL ASSEMBLY				
250 KC PLATE				
MATERIAL				
STOCK SIZE				
FINISH & SPEC. NO.				
TYPE & TEMPER		HEAT TREAT. SPEC.		FINAL APPROVAL
DRAWN		CHECKED		A-1954 F
ELEC. DES. APP.		MECH. DES. APP.		

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
E		IT9 WAS CM20C681K	11-1-66	17128	LHW	JCS	
E	1	DWG UPDATED	12/19/63	10473	MAF	JCS	
D	2	ADDED TOL DIM & NOTE TO TOL CHART	5-3-61	4807	MAF	JCS	
C	2	ON TEST DATA L WAS 540 uh ± 15					
C	1	WINDING DATA REVISED	3-11-61	4396	MAF	JCS	
B	1	ITEM 15 ADDED					
B	1	ON ACTUAL SIZE WORDS	12-21-60	3793	MAF	JCS	
A	1	START & FINISH ADDED					
A	1	Item 2 WAS CM20C561K	11-15-60	3480	RL	JCS	

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	HFS-1		AX-389	11-5-63
1	CHG-2		DIVIDER	11-5-63
1	CHG-1		DIVIDER	9-1-60
USED ON				