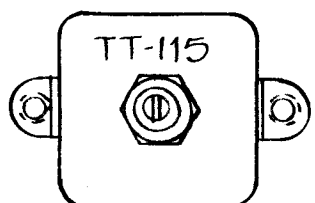
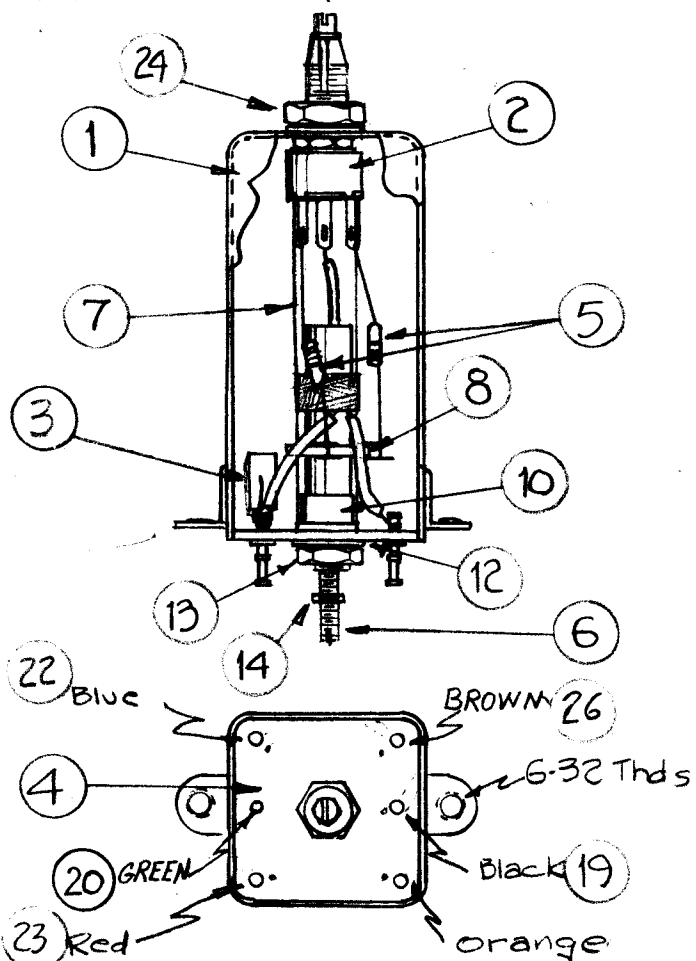


A-1965

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



CEMENT COIL FORMS TO BUSHINGS WITH GL-103.
COLOR CODE TERM BD AS SHOWN



Winding Machine Data (For PI winding)

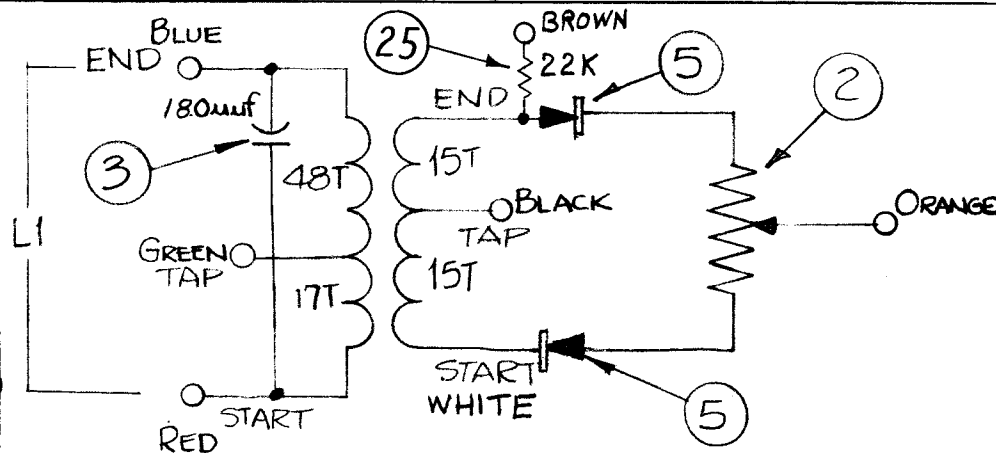
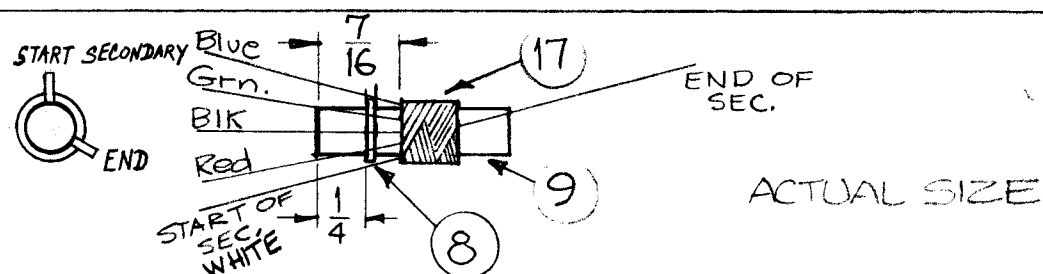
Cam Gear -- 105

Driver Gear -- 69

Cam -- .250

WINDING DATA

1. Start winding primary 7/16 from end of form.
2. Tap at 17 turns.
3. Continue winding and stop at total of 65 turns.
4. Wind secondary over primary
5. Tap at 15 turns.
6. Continue winding and end at total of 30 turns.
7. Keep all leads approx. 3" long.
8. Stake leads to coil form w/GL-103 (Item 15).
9. Assemble item 8 on form as shown and stake with item 16.
10. Fasten ends of item 17 as shown.
11. Bake unit for 1/2 hour at 215° F.
12. Coat windings and terminal collar with item 16.
13. Bake hard for 1/2 hour at 215° F.
14. Test as shown in Test Data.
15. Assemble as shown, CENTERING ITEM #7 ON ITEM # 4
16. STAKE ITEM #7 TO ITEM # 4 WITH GL129 (ITEM # 27)



Test Data (w/out Core) Primary (L1)

L. -- 24 uh #3

Q. -- 40 or greater (secondary not connected to diodes)

FREQ. -- 2.5 Mc

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 27	GL129	ADHESIVE, QUICK SETTING	
	26	PX-104-5-.022 SLEEVING	BRN.
1 25	RC20GF223J	RESISTOR, FIXED	
1 24	NTH253ZBN1Z	HEX, NUT	
X 23	PX-104-3-.022	SLEEVING	RED
X 22	PX-104-6-.022	SLEEVING	BLUE
X 21	PX-104-8-.022	SLEEVING	ORN
X 20	PX-104-4-.022	SLEEVING	GRN.
X 19	PX-104-1.022	SLEEVING	BLK.
X 18	WL-100-8	WIRE, BUSS-BAR #24	
X 17	WI-107-19	WIRE, MAGNET #38 DSC	
X 16	GL-104-2	INSULEX U85	
X 15	GL-103	CEMENT, DUCO	
1 14	NTH0348BNG	NUT, HEX	
1 13	NTH0832BN10	NUT, HEX	
1 12	LW108MRN	LOCKWASHER, INT.	
X 11	BS-100	SOLDER, SOFT	
1 10	SM-140-2	BUSHING, COIL FORM	
1 9	CF-122-1.0	FORM COIL	
1 8	TE-181-2A	TERMINAL, COLLAR, 1/4 I.D.	
1 7	MS-2383	BKT, POTENTIOMETER, MTG.	
1 6	CI-116-5	CORE, TUNING	RED
2 5	DD-102-1	SILICON DIODES	
1 4	PX-505-1	TERMINAL BOARD	
1 3	CM15F181J03	CAPACITOR, MICA, FIXED	
1 2	RV106UX8B252A	2500 Ω POTENTIOMETER	
1 1	A-1950-3	CAN ASSEMBLY	

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
TT-115, TRANSFORMER ASS'Y			
ZMC PHASE DETECTOR			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
		J.R.F.	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
G		IT 25 WAS RC20GF223K IT 3 WAS CM15F181J	11.1.66	17128	WHD	JCF	
F		ON WDCHT IT IS CLARIFIED & IT 16 ADDED OU B/M IT 27 ADDED	5A.66	16213	WHD	JCF	
E	2	SEE EMN 10844 FOR CHG	2-4-64	10844	A.M.	TR	
D	1	COLOR WHITE added to SCHEMATIC & Actual Size Diag	12/20/60	3797	DM	JCF	
C	1	Item 2 WAS RV106UX8B252A	11-11-60	3452	RL	JCF	
B	1	ITEM 24 WAS NT-10Z	10/27/60	3329	DM	JCF	
A	4	ITEM 4 WAS PX-505-1	10/6/60	3151	DM	JCF	
	3	IN ACTUAL SIZE END VIEW ADDED					
	2	ITEM 25 & 26 ADDED					
	1	ITEM 20 RELOCATED					

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

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	CHG-2, 2A		SYNTH	2-4-64
1	CHG-1		SYNTH.	9-7-60