

STEP (1)
 (4) REQ.

EDGES ARE TO BE SMOOTH AND CLEAN

TAPE 7 PIECES OF ITEM 1, USING 2 LAYERS OF ITEMS 2 & 3 AS SHOWN.

STEP (2)
 (1) REQ.

TAPE 2 STEP 1 PIECES TOGETHER USING 2 LAYERS OF ITEM 3 AS SHOWN

STEP (3)

WIND COUNTERCLOCKWISE

WIND CLOCKWISE

SLIDE ITEM 5 OVER ITEM 4 TO MAKE THE PRIMARY WINDING. THEN WIND TWO TURNS AROUND THE CORE ASSEMBLY AS SHOWN AND TAPE IN PLACE WITH ITEM 2

STEP 4 & 5

SIDE 1

SIDE 2

STEP 4
 WRAP THE SHIELD ITEM 6 AROUND THE PRIMARY WINDINGS AND TAPE AS SHOWN.

STEP 5
 NEXT WRAP 3 LAYERS OF TEFLON SHEET ITEM 8 OVER THE SHIELD AND HOLD IN PLACE WITH 6" OF TAPE ITEM 2

STEP 6 & 7

SECONDARY WINDING ITEM 7

(SHIELD TAB)
 (PRIMARY WINDING)

SIDE 1

SIDE 2

STEP 6
 WRAP THE SECONDARY WINDING ITEM 7 OVER THE TEFLON INSULATION. SLIP A PIECE OF TEFLON TUBING OVER EACH TAB AS SHOWN IN DETAIL "A"

STEP 7
 MAKE SURE THE TEFLON INSULATION ON THE SECONDARY WINDING IS CENTERED OVER THE TAB ON THE PRIMARY WINDING AND THEN WRAP 2 LAYERS OF TAPE ITEM 3 OVER SECONDARY TO HOLD IT IN PLACE.

STEP 8 & 9

SOLDER

PUNCH 1/4" LOCATE TO FIT HOLE IN ITEM 13

STEP 8
 PUT THE TWO SIDES AND CENTER TOGETHER AND WRAP WITH ONE LAYER OF TAPE ITEM 3. OVERLAP THE TAPE AT LEAST 3/4 INCH.

STEP 9
 BEND TABS AND CUT THEM AND THE TEFLON TUBING TO PROPER LENGTH AND SOLDER STRAPS TO PRIMARY AND SHIELD AS SHOWN.

PRIMARY SIDE

STEP 10

BEND TABS AND CUT THEM AND THE TEFLON TUBING TO PROPER LENGTH. PUNCH HOLES AND SOLDER STRAP AS SHOWN.

CUT TO LENGTH AND SOLDER TOGETHER

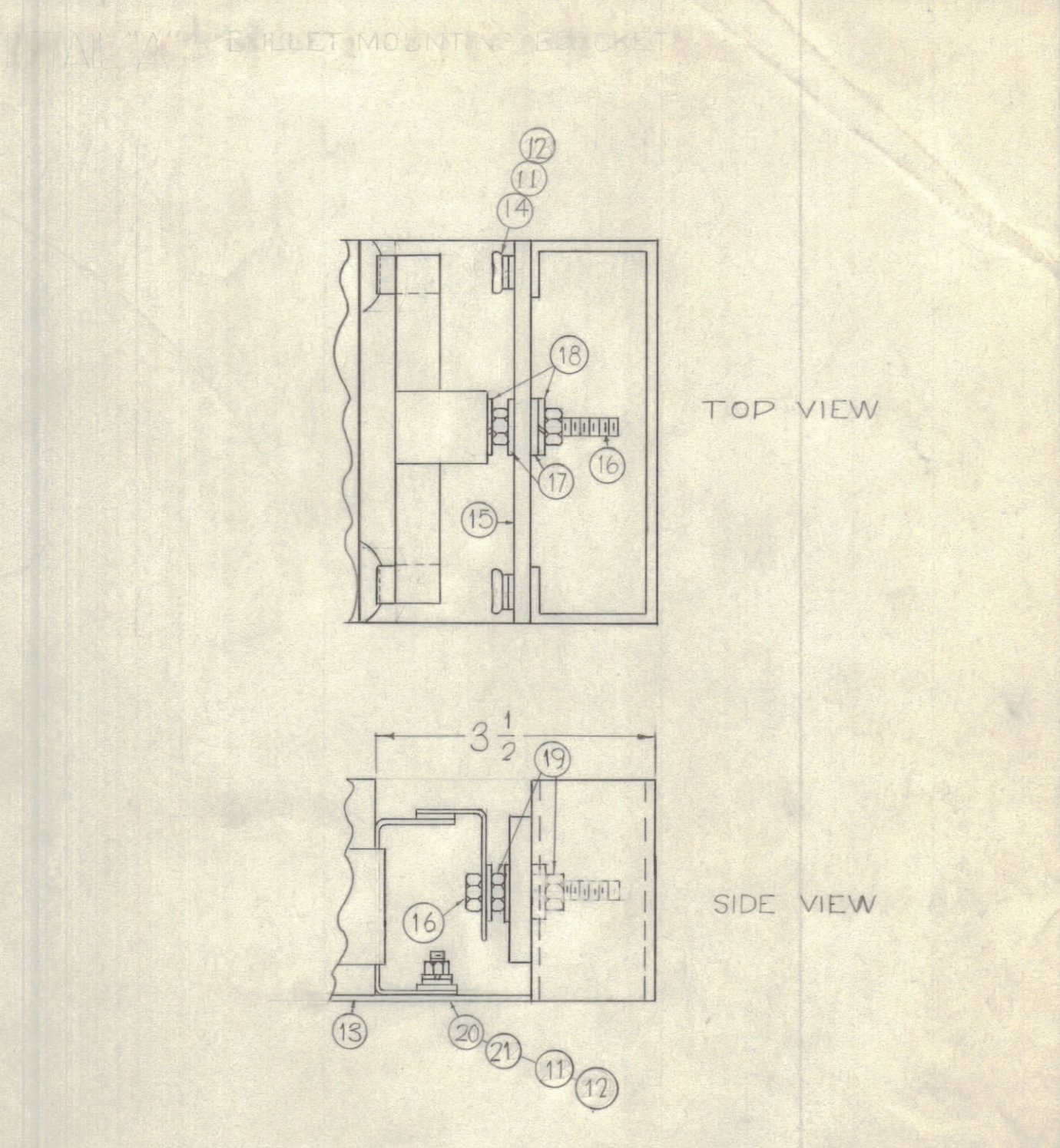
SECONDARY SIDE

STEP 11

PLACE TRANSFORMER ON MTG PLATE AND WRAP WITH 2 LAYERS OF TAPE ITEM 3. OVERLAP TAPE 3/4

SEE DETAIL "A"

BE SURE THAT THESE STRAPS ARE NOT TOUCHING MTG PLATE



DETAIL "A" BULLET MOUNTING BRACKET

QTY	SYMBOL	DESCRIPTION	REMARKS
X	22	BS-100	SOLDER, SOFT
1	21	SCFP1032BN6	SCREW, FLAT HEAD
1	20	NTH1082BN12	NUT, HEX
2	19	NTH2520BN14	NUT, HEX
2	18	LWS25MRN	LOCKWASHER, SPLIT
2	17	FW25HBN	WASHER, FLAT
1	16	SCHH2520BN24	BOLT, HEX
1	15	PX-614	CONTACT SUPPORT
4	14	SCBP1032BN10	SCREW, MACHINE
1	13	MS-2649	TRANSFORMER, MTG. PLATE
5	12	LWS10MRN	LOCKWASHER, SPLIT
5	11	FW10HBN	WASHER, FLAT
1	10	MS-783-8-22-S	STRAP, COPPER 1/2" X 2 3/4"
3	9	MS-783-8-40-S	STRAP, COPPER 1/2" X 5"
2	8	PX-669-2	TEFLON SHEET 1/2"
2	7	A-3066	TRANSFORMER WINDING ASS'Y
2	6	A-3065	SHIELD ASS'Y
64'	5	PX-370-43-7	SLEEVING, TEFLON
2	4	MS-783-9-256-S	STRAP, COPPER 9/16" X 32"
80'	3	TA-108-9	TAPE THERMOSETTING 1 3/4" WIDE
31'	2	TA-108-5	TAPE THERMOSETTING 3/4" WIDE
28	1	CI-101-3-Q	CODE, FEDDAME "C" TYPE

REQ'D. ITEM		PART NUMBER	DESCRIPTION	SYMBOL
BODETTI LIST OF MATERIAL				
MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
FINISH		TITLE: FINAL ASSEMBLY TR-176		
QTY./UNIT	SCALE	MODEL USED ON	DATE	DATE
1	1:1	TR-176	12-1-64	12-1-64
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN: JF VITRO CHECKED: JCB ELECT. DATE: JCB MECH. DATE: aa	DATE: 12-3-62 SHEET: 1	FINAL APPROVAL: [Signature] DATE: 12-3-62
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.		DECIMALS: .XX ± .01 FRACTIONS: 1/64 ANGLES: ± 0° 30'	TOLERANCES: ± 0.005	REV. LTR.

NOTES