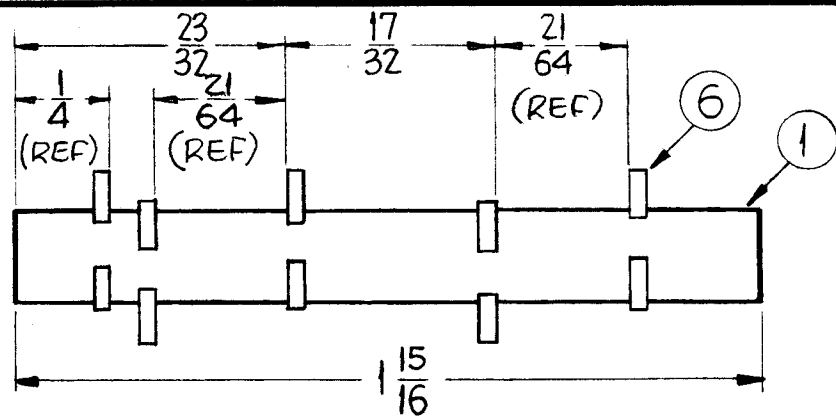
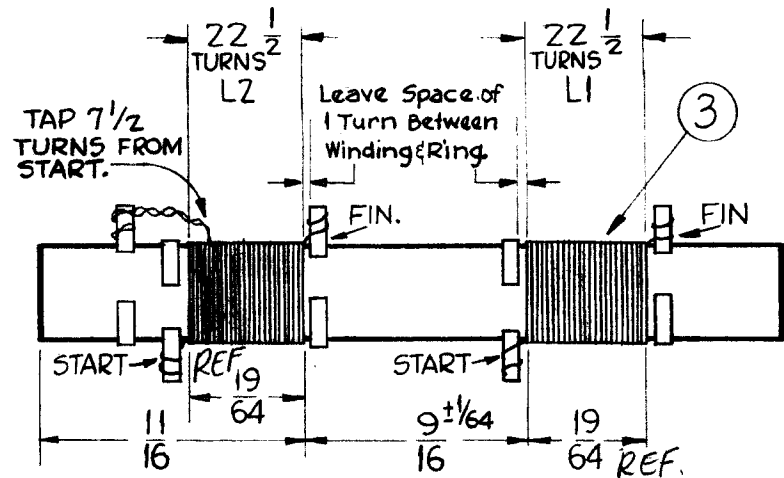


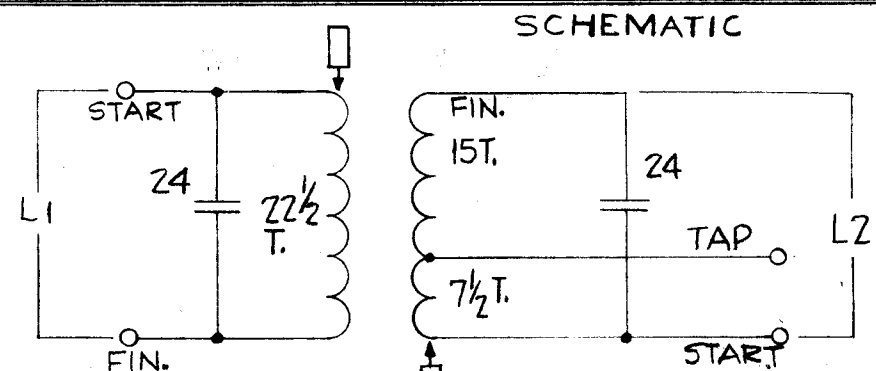
A 2078 F



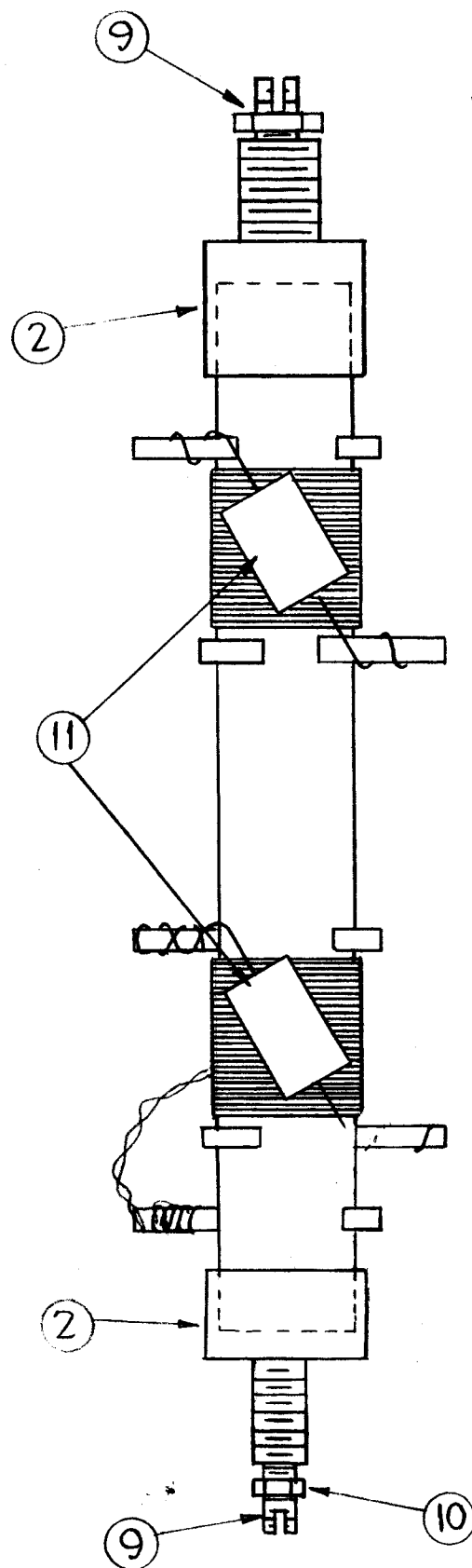
(1) LAYOUT FOR TERMINAL RINGS.



(2) WINDING DIMENSIONS.



SCHEMATIC



(3) FINAL ASSEMBLY

WINDING DATA

1. Assemble ring terminals on form as shown and stake with GL-104-2.
2. Wind L1, 22 1/2 Turns.
3. Wind L2, 22 1/2 Turns, tap at 7 1/2 Turns from start.
4. Stake and Coat Windings with GL-104-2.
5. Bake until hard for 1/2 hour at 215° F.
6. Test and assemble as specified.

TEST DATA (%out Core)

L1, L2 = 2 uH ± 10%
Q = 55 or Greater
Freq. = 7.9 Mcs.

CRITICAL COUPLING DATA

OPEN CIRCUIT Q = 80
CRITICAL COUPLING = 48
(FOR REF. ONLY)

NOTE: THIS DRAWING REPLACED BY DWG NO. TT128 AS PER EMN 18365

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
2	11	CM15C240J03	CAPACITOR, FIXED, MICA	C2549 C2550
2	10	NTH0348BN6	NUT, HEX	
2	9	CI-116-5	CORE, TUNING	RED
X	8	BS-100	SOLDER, SOFT	
5	6	TE-153-1	TERMINAL RING	
X	5	GL-104-2	INSULEX	
X	3	WI-123-28	WIRE, ENAMELLED #28	
2	2	SM-140-2	BUSHING, COIL MOUNTING	
1	1	CF-122-1.93	COIL FORM 1/4 O.D.	

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
TT-128 ASSEMBLY 18MC COIL				
MATERIAL				
STOCK SIZE				
TYPE & TEMPER				
HEAT TREAT. SPEC.				
DRAWN				
CHECKER				
FINAL APPROVAL				
FINISH & SPEC. NO.				
ELEC. DES. APP. MECH. DES. APP.				

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
F	REPLACED BY TT128	7-20-61	18365			
E	"REF" ADDED TO DIM	1-16-67	17673	WHD		
D	ITEM 11 WAS CM15C240J	11.1.66	17128	WHD		
C	GROUND DELETED ON SCHEMATIC	9-				
	C2549, C2550 ADDED ITEM 11					
	ON ITEM 10-C1552, C1553 DELETED		5597	LG		
	ITEM 12 DELETED WAS TE-104-3	19-				
B	ITEM 7 DELETED WAS NTH 0832BN10	61				
	ITEM 4 DELETED WAS RG-174/U					
B	On Test Data Q 55 was 70	8/29/61	5508	EA	RU	
A	SYMBOLS C1552 & C1553 WAS ADDED TO SCHEMATIC	4/26/61	4718			
A	ITEM 10 WAS NTH0348BN16 QUANT. WAS 1					
A	ITEM 6 WAS TE-153-1					

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°

SCALE: Do Not SCALE
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
REMOVE ALL BURRS AND SHARP EDGES

REQ. PER UNIT	MODEL	SECTION	ASSY. NO.	DATE
1	CHG-2	SYNTH	TT-128	3-10-61
USED ON				