

A-2137

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— COIL WINDING DATA —

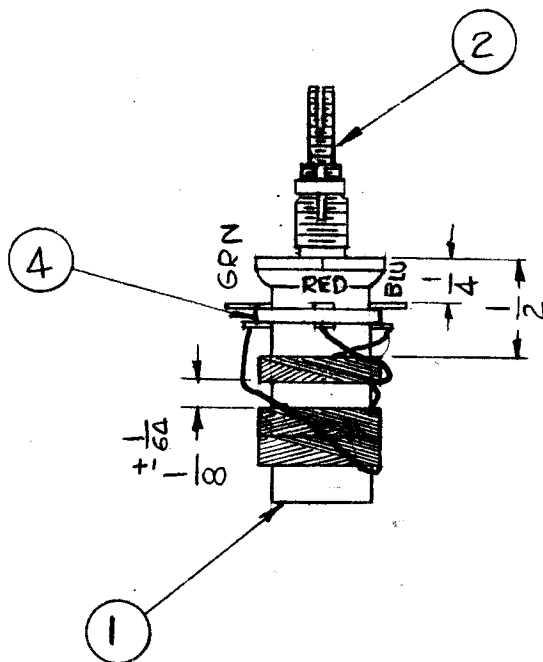
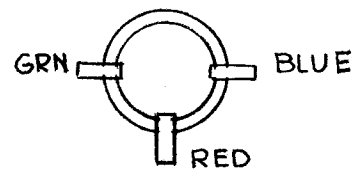
CAM .125
 CAM GEAR 70
 CAM DRIVER 65
 IDLER 66-66
 TURNS 3PI, 60t/PI, TAP AT 1st 35t
 WIRE 12/43 LITZ

— ASSEMBLY —

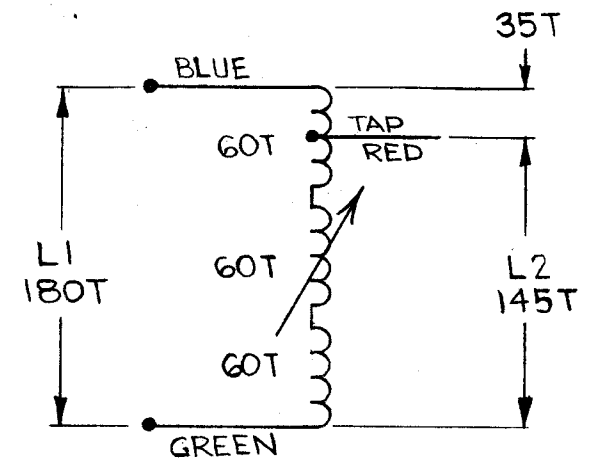
- 1- ASSEMBLE COLLAR ITEM 4 TO ITEM 1. COLOR CODE AS SHOWN.
- 2- STARTING 1/2 INCH IN, WIND FIRST PI. WITH ITEM 3. TAKE A TAP OUT AT 35 TURNS. CONTINUE FOR TOTAL OF 60 TURNS.
- 3- STARTING 1/8" FROM END OF FIRST PI. WIND ON 60 TURNS FOR SECOND PI.
- 4- STARTING 1/8" FROM END OF SECOND PI. WIND ON THIRD PI. OF 60 TURNS. AFTER THIRD PI HAS BEEN WOUND, PUSH UP AGAINST SECOND PI.
- 5- STAKE ENDS WITH ITEM 5, DUCCO CEMENT.
- 6- STRIP & TIN LEADS. SOLDER TO PROPER COLOR-CODED LUGS ON COLLAR.
- 7- BAKE COIL FOR 1/2 HOUR AT 215 F.
- 8- DIP IN HIGH MELTING POINT WAX ITEM 6 UNTIL BUBBLES CEASE
- 9- TEST AS PER CHART ABOVE

NOTE:
 COLOR CODE TERMINALS AS SHOWN.

— TOP VIEW —



— COIL FORM ASSEMBLY —



TEST DATA

L (uh) + 5% L1 = 330, L2 = 250
 Q @ 795 KC Q1 = 115, Q2 = 110
 R (APPROX) R1 = 5Ω, R2 = 4Ω

X	6	GL-100	POTTING COMPOUND-WAX
X	5	GL-103	CEMENT, DUCCO
1	4	TE-146-3	TERMINAL, COLLAR
X	3	WI-104-1234-SC-Q5	WIRE, LITZ-12/43
1	2	CI-109-21	CORE, TUNING
1	1	CF-129	FORM, COIL

D	L1 WAS 300, L2 WAS 220 Q1 WAS 130, Q2 WAS 125	6/8/64	11506	A.M.	@	
C	IN BUILDUP ITEM 2 WAS CI-116-10. COIL ASSY PICT & NOTE 4 CLARIFIED.	8-29-63	9861	AL	JAS	
B	SCHEMATIC REVISED	4-10-63	8708	RE	JAS	
A	REDRAWN & REVISED	2-7-63	8196	GDL		
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°
 SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

1	GPR-92	BFO	A-3112	2-7-63
REQ. PER UNIT	MODEL	SECTION	ASSY. NO.	DATE
USED ON				

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
TT-189 ASS'Y				
MATERIAL				
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
			G.D.L.	MP
FINISH & SPEC. NO.			ELEC. DES. APP.	MECH. DES. APP.
				A-2137
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