A

A-2139

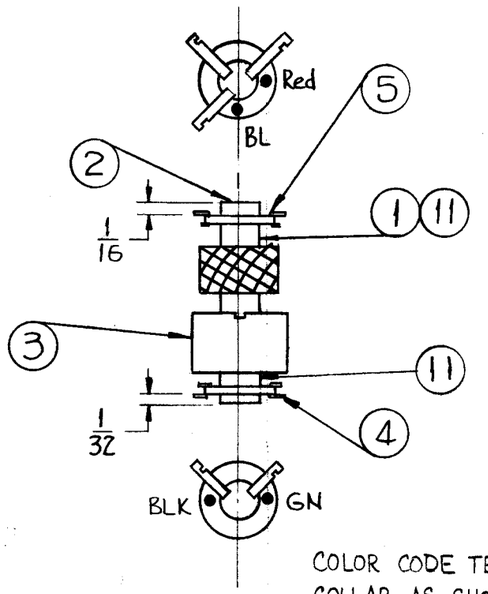
COIL DATA

SPECIFICATIONS	PRIMARY	SECONDARY
CAM	.250	.250
CAM GEAR	102	102
CAM DRIVER	69	69
IDLER	60-60	60-60
TURNS	200	170
WIRE	3/41 LITZ	3/41 LITZ
TAP AT	-	84T.
±10% L (UH) *	220	190
MIN Q AT 790 KC*	50	55
APPROX. R (Ω)	8.0	0-3.2-7

* WITHOUT TUNING CORE

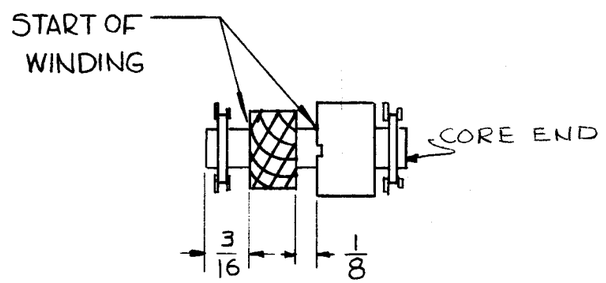
1. Wind primary first, 3/16" from end of form
2. Beginning 1/8" from finish of primary, wind on secondary, take tap out to right at 84 turns.
3. Cement loose ends. Let dry.
4. Immerse coil in hot wax (GL-100) until bubbles cease.
5. Slide cup over secondary, bringing tap and finish through hole.
6. Wrap 1 turn, ½" masking tape around both ends of coil form. Do not cover leads.
7. Slip collar TE-181-3 over primary end, collar TE-181-2A over secondary end; cement both in place.
8. Connect primary start to blue lug
   primary finish to red lug
   Secondary start to unmarked lug
   Secondary tap to black lug
   Secondary finish to green lug
   Solder all connections.
9. Solder Buss-Bar, 1½" long to all lugs.
10. Test as per chart above.
11. Insert tuning core into secondary end.

COLLAR ASS'Y

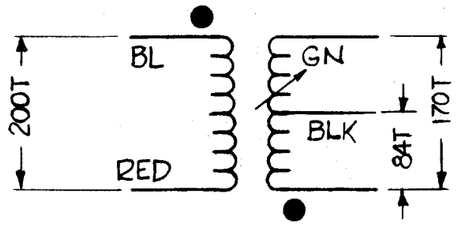


COLOR CODE TERMINAL COLLAR AS SHOWN

COIL SPACING



SCHEMATIC



● INDICATES START OF WINDING

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	11	TA-105-3	TAPE, MASKING	
X	10	WI-104-341-DSQS	WIRE, LITZ, 3/41	
X	9	BS-100	SOLDER, SOFT	
X	8	WL-100-7	WIRE, BUSS BAR	
X	7	GL-103	CEMENT, DUCO	
X	6	GL-100	POTTING COMPOUND, WAX	
1	5	TE-181-3	TERMINAL, COLLAR	
1	4	TE-181-2A	TERMINAL, COLLAR	
1	3	CI-122	CORE, CUP	
1	2	CI-121	CORE, THREADED	
1	1	CF-132	FORM, COIL	

STRUMER

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	WINDING DATA CLARIFIED	4-5-61	8714	RC		

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

REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.	DATE
1	GPR-92	FX-177	A-2120	9-7-61

USED ON

STOCK SIZE

MATERIAL

TYPE & TEMPER | HEAT TREAT. SPEC.

FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

TT-154 ASSY

DRAWN	CHECKER	FINAL APPROVAL	
RUZZO			
ELEC. DES. APP.	MECH. DES. APP.	A-2139	A

TMC FORM NO. 109

DEFIANCE NO. 1080