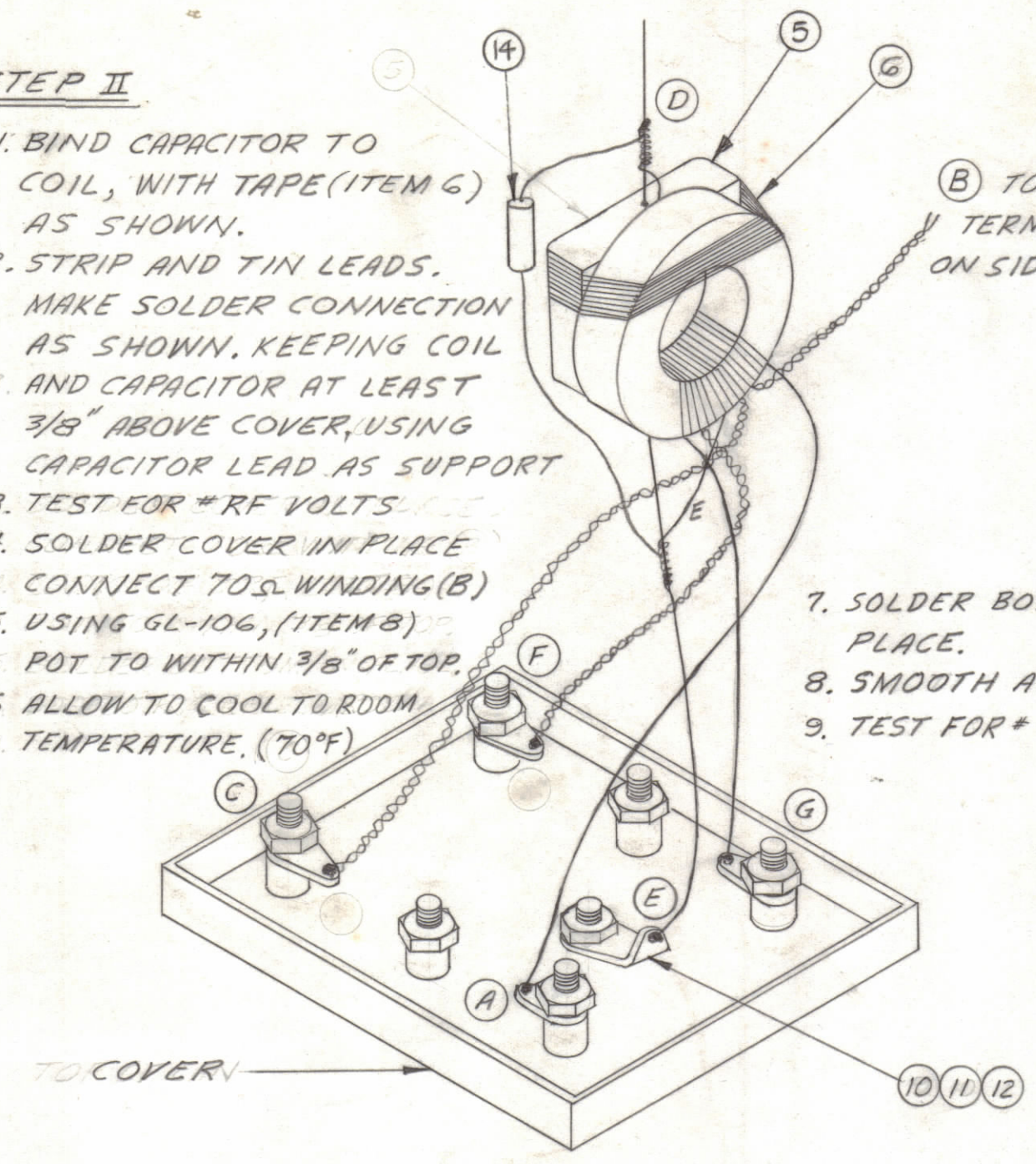


STEP I
 WINDING - AS ABOVE (CLOSE WOUND TURNS)
 1. ALL LEADS TO BE 3" LONG.
 2. STAKE WINDING & LEADS TO COIL
 3. FORM WITH CEMENT (ITEM 3),
 4. COAT COIL WITH U85 (ITEM 4)
 5. BAKE FOR 1 HOUR AT 150°C, COOL
 TO ROOM TEMPERATURE. (10°F)

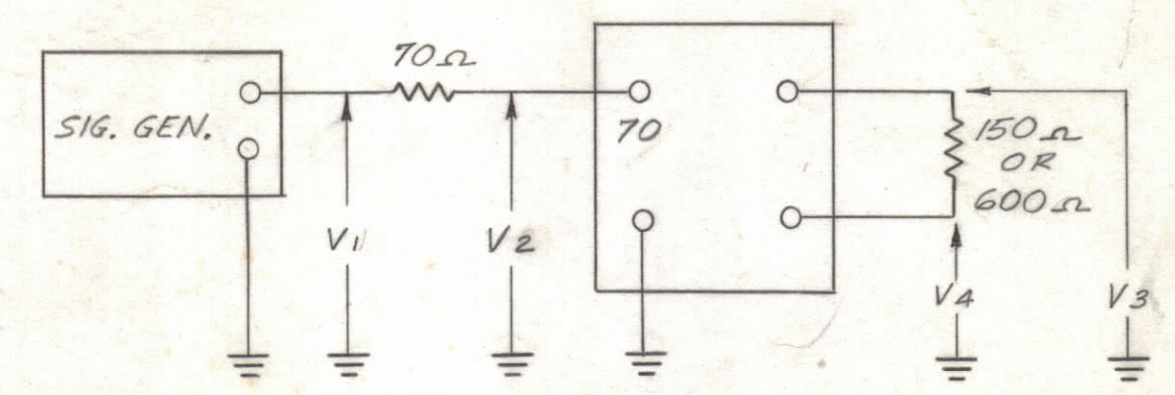
STEP II
 1. BIND CAPACITOR TO COIL, WITH TAPE (ITEM 6) AS SHOWN.
 2. STRIP AND TIN LEADS. MAKE SOLDER CONNECTION AS SHOWN, KEEPING COIL AND CAPACITOR AT LEAST 3/8" ABOVE COVER, USING CAPACITOR LEAD AS SUPPORT
 3. TEST FOR * RF VOLTS
 4. SOLDER COVER IN PLACE
 5. CONNECT 70Ω WINDING (B) USING GL-106, (ITEM 8)
 6. POT TO WITHIN 3/8" OF TOP
 7. ALLOW TO COOL TO ROOM TEMPERATURE. (70°F)
 8. SOLDER BOTTOM IN PLACE.
 9. SMOOTH ALL SEAMS
 10. TEST FOR * RF VOLTS



LEGEND
 A & G - 600Ω TERMINALS
 B - 70Ω OUTPUT
 C & F - 150Ω TERMINALS
 E - GROUND

NOT TO BE RELEASED W/O AUTHORIZATION
 AUTH. BY.....
 DATE:.....

TEST DATA



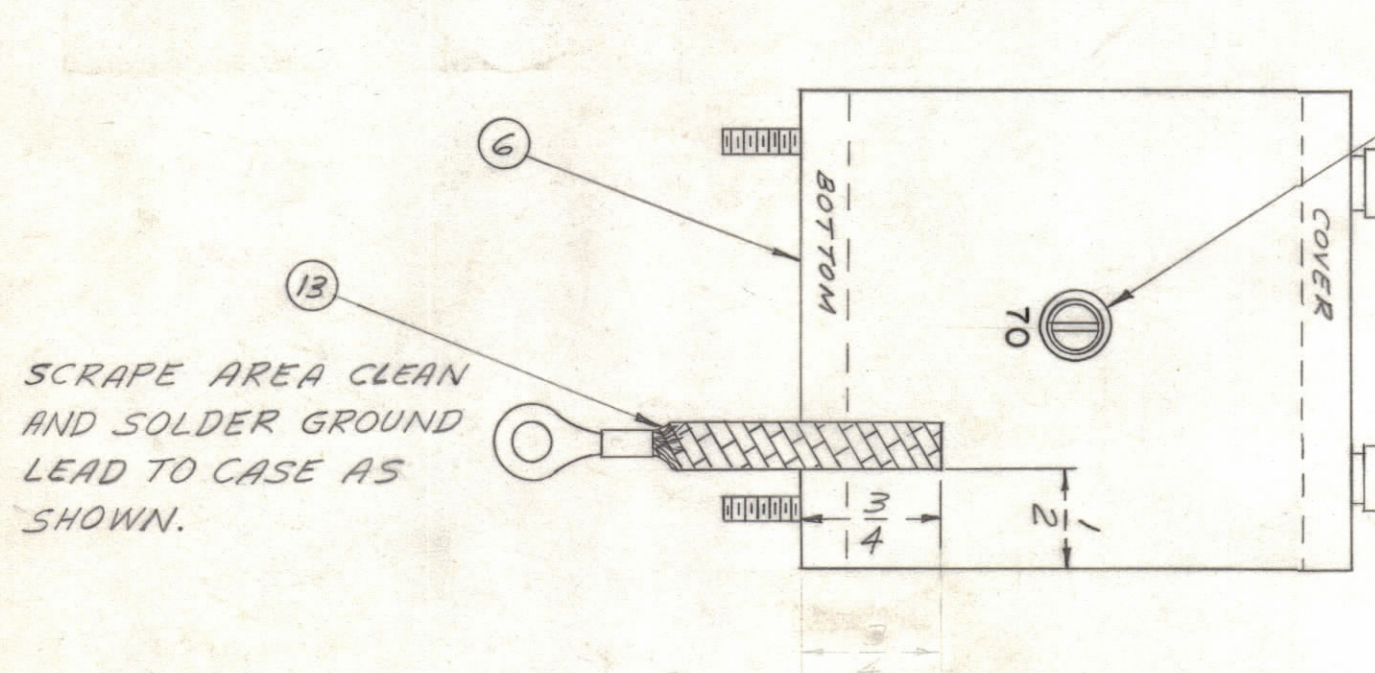
600Ω TERMINALS

FREQ.	MCS	* RF VOLTS V1	* RF VOLTS V2	* RF VOLTS V3	* RF VOLTS V4
2	2	1.0	0.50	0.70	0.64
8	8	1.0	0.48	0.67	0.60
30	30	1.0	0.45	0.60	0.62

150Ω TERMINALS

FREQ.	MCS	* RF VOLTS V1	* RF VOLTS V2	* RF VOLTS V3	* RF VOLTS V4
2	2	1.0	0.42	0.32	0.33
8	8	1.0	0.42	0.33	0.32
30	30	1.0	0.50	0.32	0.34

* HP VTVM BASED ON POTTED UNIT TOLERANCE ± 0.1 VOLT.



STEP III
 1. SOLDER ITEM 13 IN PLACE AS SHOWN.
 2. CLEAN CASE. FINISH TOP & SIDES WITH S-115 SMOOTH GRAY ENAMEL. (DO NOT PAINT STUD END)
 3. AFTER PAINTING, STAMP TOP & SIDE AS SHOWN.
 1/8 HIGH BLACK GOTHIC

QTY	ITEM	PART NO.	DESCRIPTION	SYMBOL
1	14	RC20GF 103K	RESISTOR, FIXED, COMPOSITION	
1	13	CA-409-88-2.25	GROUND STRAP ASS'Y	
1	12	NTH0440BNG	NUT, HEX	
1	11	TE-104-1	LUG, LOCKING	
1	10	SCBPO440BNA	SCREW MACHINE	
X	9	BS-100	SOLDER SOFT	
X	8	GL-106	COMPOUND POTTING	
1	7	BX-148	CASE & COVER ASS'Y	
X	6	TA-100-1	TAPE, VINYL PLASTIC	
1	5	CM35C202J	CAPACITOR, FIXED	
X	4	GL-104-2	INSULEX, U-85	
X	3	GL-103	CEMENT	
X	2	WI-102-7-9	MAGNET WIRE, COPPER-ENAMELED S.C.C.	
1	1	CI-104	CORE, TOROIDAL	

SYM	ZONE	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	H4, G7	IT 14 ADD. TO PICT. & SCHEMATIC C2 ITEM 14 ADD., IT 13 WAS A-1151	8.4.64	12035	W.B.	M.P.	M.M.

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

SCALE TR-092

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS & SHARP EDGES

REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.	DATE
1	RAC-37		A-2205	10-9-61

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
TRANSFORMER ASS'Y TR-092				
DRAWN		CHECKED		FINAL APPROVAL
TYPE & TEMPER		HEAT TREAT. SPEC.		
FINISH & SPEC. NO.			ELEC. DES. APP.	MECH. DES. APP.
			A-2204 A	