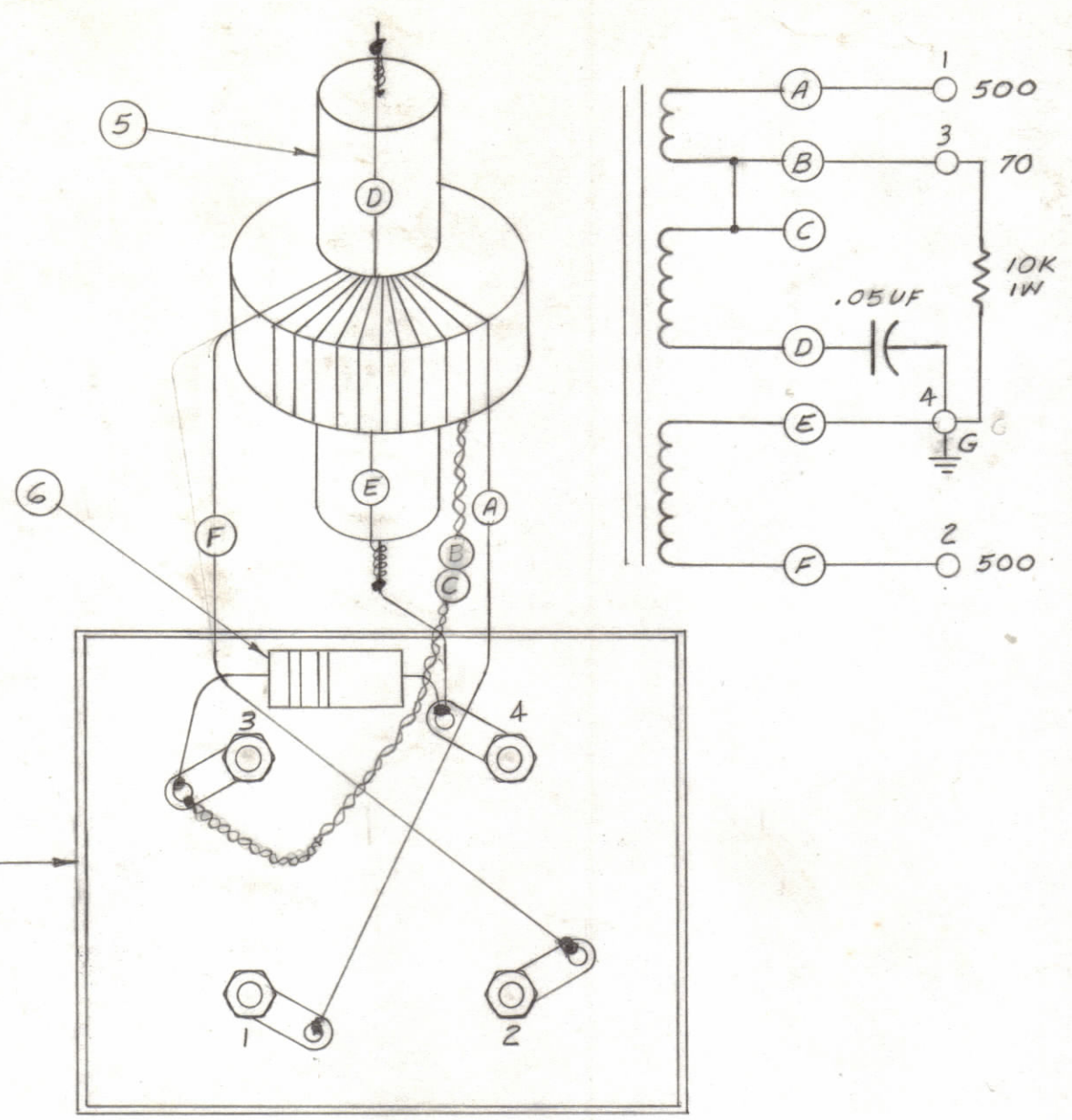


STEP I

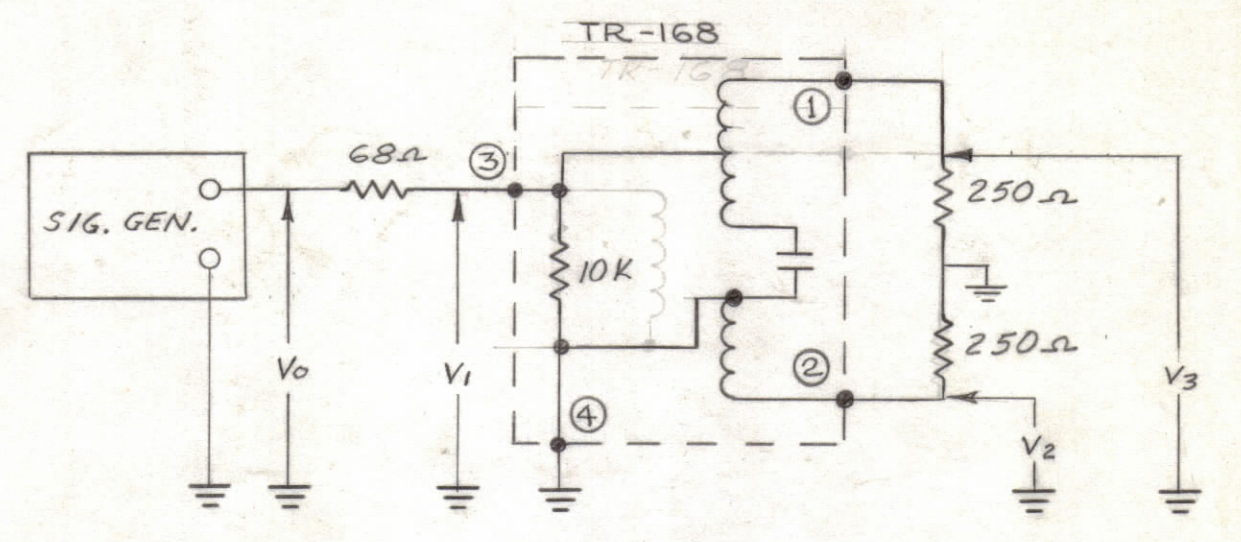
1. WINDING - AS ABOVE - CLOSE WOUND TURNS
2. ALL LEADS TO BE APPROX 2" LONG.
3. STAKE WINDING & LEADS TO COIL FORM WITH CEMENT (ITEM 3)
4. COAT COIL WITH U-85 (ITEM 4)
5. BAKE FOR 1 HOUR AT 150°C COOL AT ROOM TEMPERATURE (70°F)



STEP II

1. SLIP TOROID (ITEM 1) OVER CAPACITOR (ITEM 5) AS SHOWN. (ITEM 1) OVER CAPACITOR (ITEM 5)
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 USING CAPACITOR LEAD AS SUPPORT
4. SOLDER COVER IN PLACE
5. USING GL-106, (ITEM 6) POT TO WITHIN 1/4" OF TOP
6. ALLOW TO COOL TO ROOM TEMPERATURE (70°F)
7. SOLDER BOTTOM IN PLACE.
8. SMOOTH ALL SEAMS.
9. TEST FOR *RF VOLTS.

TEST DATA



NAMINAL DATA

FREQ	RF. VOLTS			
	V ₀	V ₁	V ₂	V ₃
2.0	1.0	0.54	0.63	0.62
8.0	1.0	0.53	0.63	0.63
30.0	1.0	0.51	0.60	0.64
*FREQUENCY RESPONSE			LESS 1.4	LESS 1.4

***NOTE 1**

RATIO OF HIGHEST TO LOWEST VOLTAGE FOR V₂ & V₃, TO BE LESS THEN 1.4 (3db)

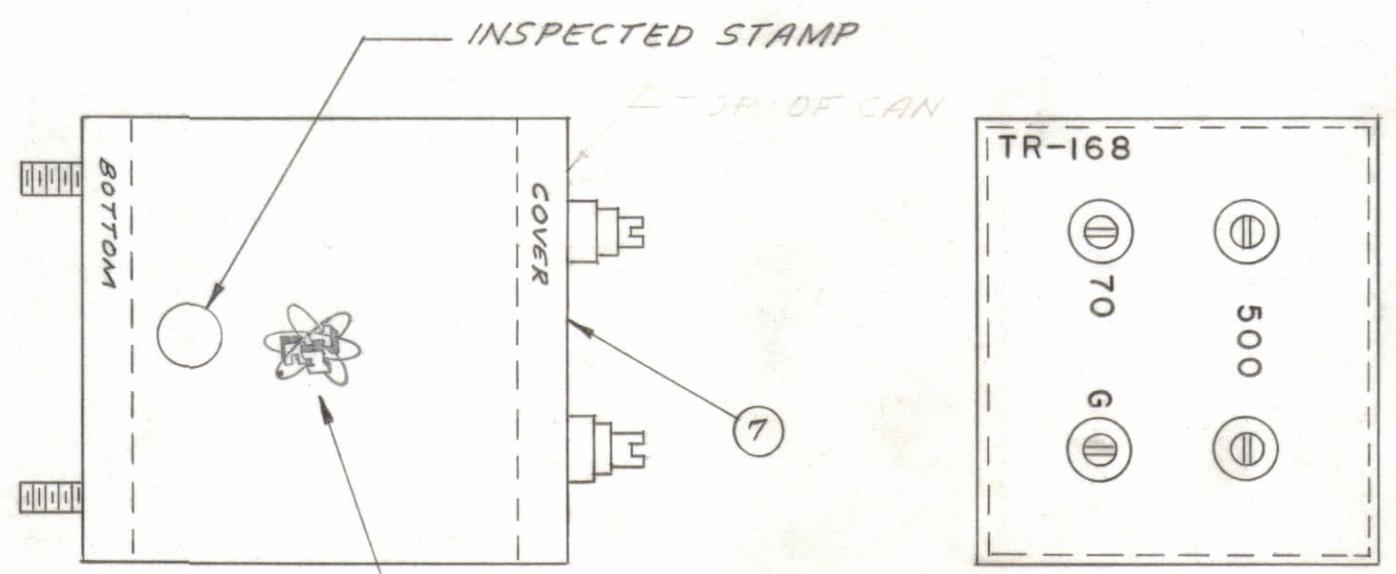
NOTE 2

ACTUAL VOLTAGE MUST BE WITHIN ±10% OF NOMINAL CHART.

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

STEP III

1. CLEAN CASE. FINISH TOP & SIDES WITH T.M.C. S-115 SMOOTH GRAY ENAMEL. (DO NOT PAINT STUD END)
2. AFTER PAINTING, STAMP TOP & SIDE AS SHOWN. 1/8 HIGH BLACK GOTHIC



STAMP TMC INSIGNIA AS SHOWN

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	9	BS-100	SOLDER, SOFT	
X	8	GL-106	COMPOUND, POTTING	
1	7	BX-106	CASE, TRANSFORMER	
1	6	RC326F103K	RESISTOR, FIXED	
1	5	CN-100-3	CAPACITOR, FIXED	
X	4	GL-104-2	INSULEX, U-85	
X	3	GL-103	CEMENT	
1	2	WI-102-9-0	MAGNET WIRE, COPPER-ENAMELED S.C.C.	
1	1	CI-104	CORE, TOROIDAL	

SYM	ZONE	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	GH,2,1	TEST DATA SCHEMATIC REVISED & TERM.# ADD.	8.4.64	12041	WB		
A	B2	Item (6) was RC30GF103K	12-1-61	5976	E.S.		

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

SCALE: TR-168
 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-13			10-13-61

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
STOCK SIZE				
TRANSFORMER ASS'Y				
MATERIAL				
TR-168				
TYPE & TEMPER		HEAT TREAT. SPEC.		
FINISH & SPEC. NO.		ELEC. DES. APP.		MECH. DES. APP.
A-2207				B