

A 2433

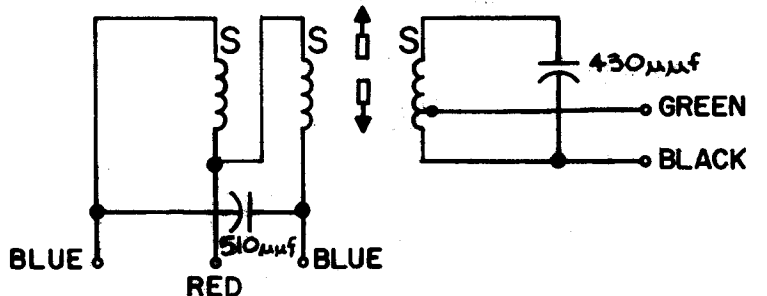
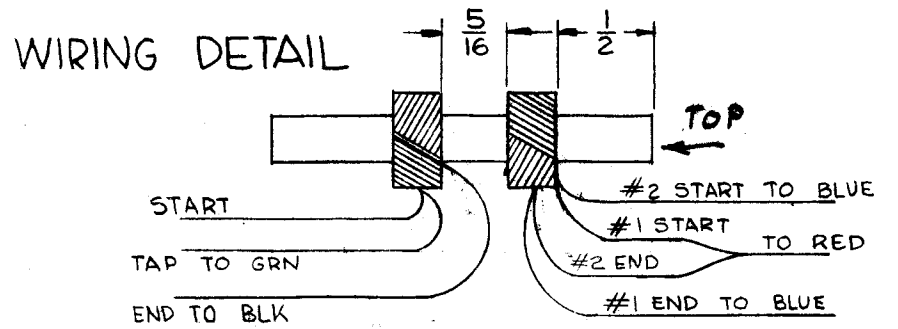
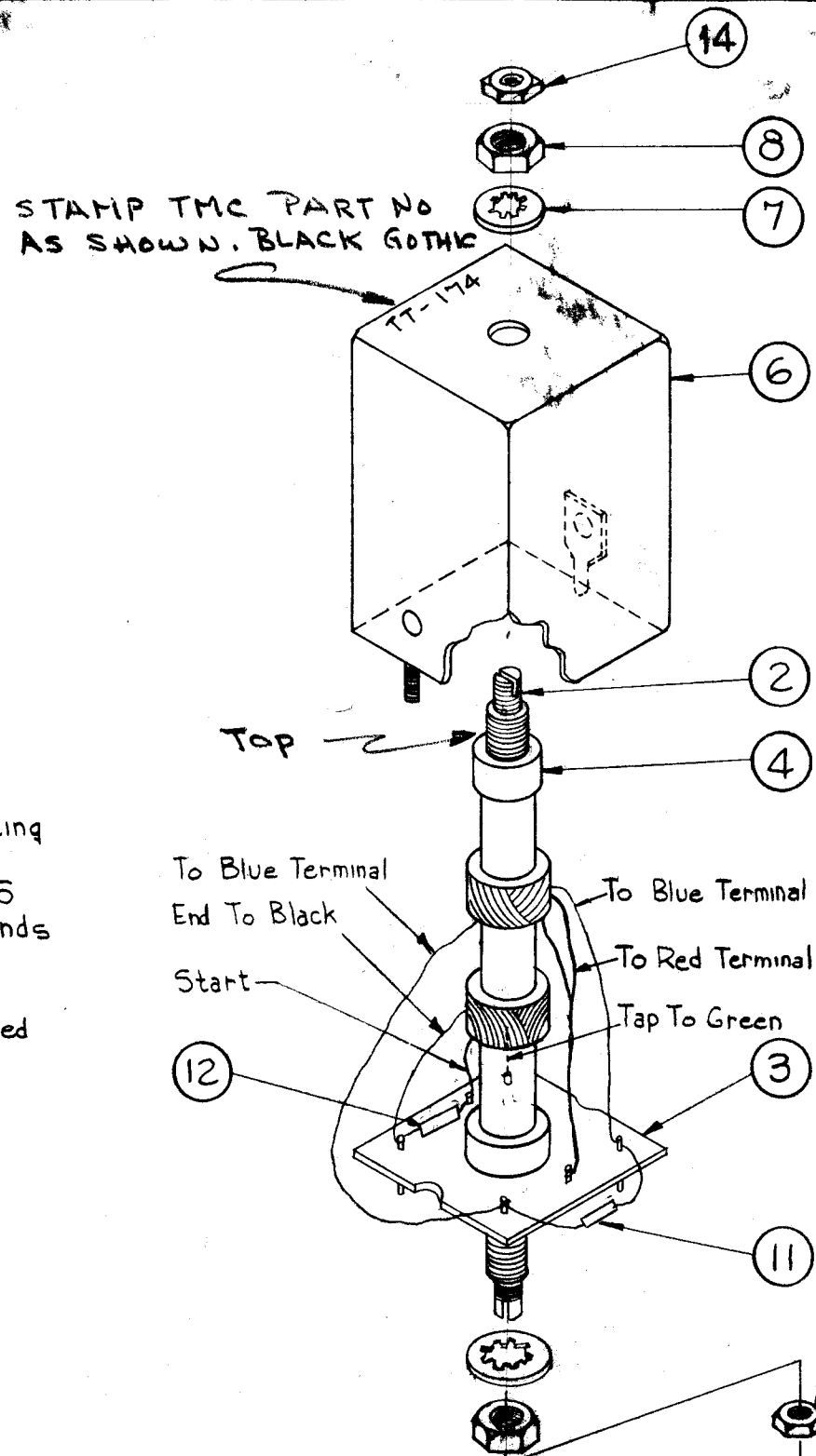
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COIL DATA		
SPECIFICATIONS	PRIMARY	SECONDARY
Cam	.250	.250
Cam Gear	69	72
Cam Driver	108	107
IND (uh)	11-13	11-12
Q	20-30	70-80
Coil Res. Ω	0.3	0.35
Freq. (MC)	7.9	2.5
Cond. (uuf)	510	430

WINDING DATA		
Turns	20 (2 Wires)	45 (TAP AT 40th TURN)
Wire	12/43	12/43

WINDING INSTRUCTIONS

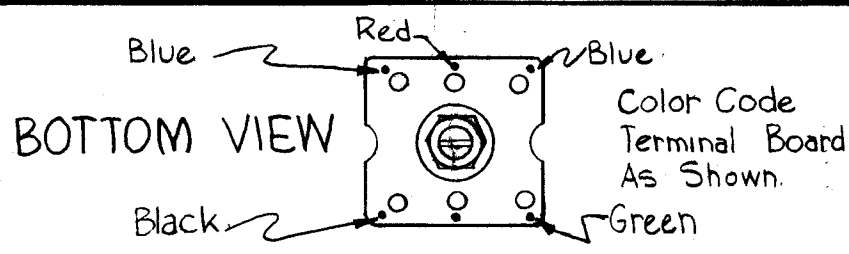
1. Wind primary first, bifilar, 20 turns of Item 5, starting 1/2" from end. Stake ends with Item 9.
2. Wind secondary, starting 5/16 from end of primary, 45 turns of Item 5, tapping at the 40th turn. Stake ends with Item 9.
3. Color code coil base as shown.
4. Strip & tin leads. Solder them to proper color coded terminals on base.
5. Measure Q, IND, & RES without the core.
6. Bake coil for 30 minutes at 210° F. Saturate coil with Item 10.
7. Solder component leads to terminals.
8. Assemble as per drawing & place in can.



SCHEMATIC DIAGRAM (S Indicates Start Of Winding)

2	14	NTH0348BNG	NUT, HEX.	
X	13	BS 100	Solder, Soft	
1	12	CM 15F431J03	Capacitor, Fixed, Mica	
1	11	CM 15F511J03	Capacitor, Fixed, Mica	
X	10	GL 102	Lacquer	
X	9	GL 103	Cement	
2	8	NTH0832BN8	Nut, Hex	
2	7	LW108MRN	Lockwasher, Internal	
1	6	A 3029-1	Can Assembly	
X	5	WI 104-1243SCQ5	Wire, Litz	
2	4	SM 140-2	Bushing, Coil Mounting	
1	3	PX 610-1	Term. Board, Transf. & Lugs	
2	2	CI-116-18	Core, Tuning	
1	1	CF-122-1.93	Coil Form .250 O.D.	

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
			GELMAN	



D	IT. 11 WAS CM15B511K, IT. 12 WAS CM15B431K	2-28-67	17844	MLP	CLD	
C	CHANGES IN COIL DATA SEE EMN10826	1/30/64	10826	MLP	T.R.	
B	ADDED ITEM 14 TO PICT. & CHART	11-13-63	10412	MLP		
A	IN CHART (PRI) 2.5 WAS 7.9	10-22-63	10256	MLP		
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON FRACTIONS $\pm 1/64$ DECIMALS $\pm .005$ ANGLES $\pm 1/2^\circ$

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

1	HFR-1/C			4-27-62
REQ. PER UNIT	MODEL	SECTION	ASSY. NO.	DATE

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
TT-174 ASSEMBLY			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
		EG	JLB
FINISH & SPEC. NO.		ELE. DES. APP.	MECH. DES. APP.
			BP
A 2433			D