

A-2448

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COIL DATA		
SPECIFICATIONS	PRIMARY	SECONDARY
CAM	.250	TEST WITH OHMMETER FOR CONTINUITY ONLY.
CAM GEAR	95	
CAM DRIVER	90	
IND. $\pm 2\mu h$	$30.0 \pm 2\mu h$	
Q	60 OR GREATER	
TEST FREQ.	2.5 MC	

WINDING DATA		
TURNS	70	9
WIRE	WI-104-1243-SCQS	WI-104-1243-SCQS.

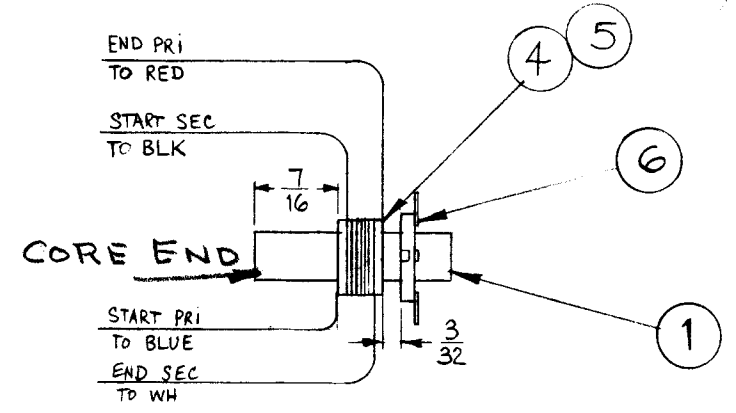
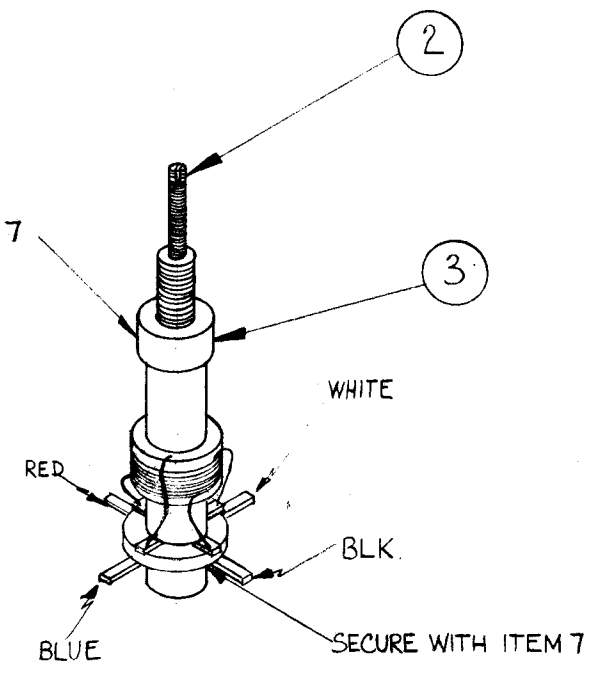
WINDING INSTRUCTIONS

- 1~ WIND PRIMARY 70 TURNS (ITEM 5) STARTING 7/16 FROM END OF COIL FORM. STAKE ENDS WITH GL-103 (ITEM 7).
- 2~ WIND ONE LAYER OF ELECTRICAL TAPE (ITEM 4) OVER PRIMARY.
- 3~ WIND SECONDARY 9 TURNS (ITEM 5) CLOSE WOUND OVER TAPED PRIMARY APPROX. 1/16 FROM EDGE OF TAPE. STAKE ENDS WITH GL-103 (ITEM 7).
- 4~ PAINT PROPER COLORS ON FIBER GLASS COLLAR.
- 5~ STRIP & TIN LEADS. SOLDER THEM TO PROPER COLOR-CODED TERMINALS ON COLLAR.
- 6~ MEASURE Q, & IND. W/O CORE.
- 7~ BAKE FOR 1/2 HOUR AT 215°F. SATURATE COILS WITH GL-104-2 (ITEM 8).
- 8~ BAKE HARD AT 215°F FOR 1/2 HOUR.

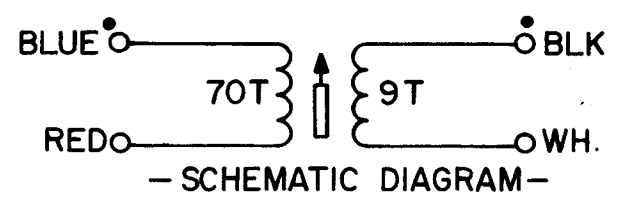
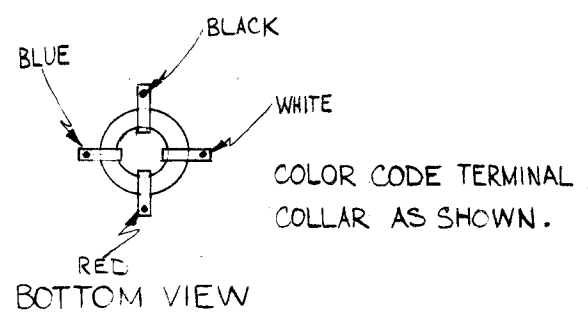
NOTE:

USE BOONTON CORP. Q METER MODEL 160 A OR EQUIV.

SECURE WITH ITEM 7



WIRING DETAIL



• INDICATES START OF WINDING.

REQ.	ITEM	PART NO.	STRUMER DESCRIPTION	SYMBOL
X	8	GL-104-2	INSULEX, U85	
X	7	GL-103	DUCO	
1	6	TE-181-4	TERMINAL, COLLAR	
X	5	WI-104-1243-SCQS	WIRE, LITZ	
X	4	TA-113-1-.250	TAPE, ELECTRICAL	
1	3	SM-140-2	BUSHING, COIL MTG.	
1	2	CI-116-6	CORE, TUNING	
1	1	CF-122-1.0	COIL FORM, .250 O.D	

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
TT-177 ASS'Y (TRANSFORMER, RF TUNED) 3400 DECK			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
		<i>WAF</i>	<i>D. Mann</i>
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
		<i>WAF</i>	<i>WAF</i>
A-2448			A

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	ON COIL DATA, IND PRIMARY WAS 39.0 $\mu h$	11-20-62	7693	<i>WAF</i>	<i>WAF</i>	<i>WAF</i>

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

SCALE: DO NOT 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	HFS-1	3400		8-15-62