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A-2449

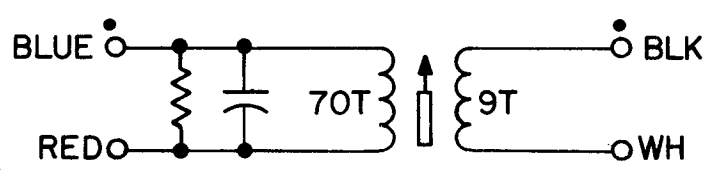
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COIL DATA		
SPECIFICATIONS	PRIMARY	SECONDARY
CAM	.250	TEST WITH OHMMETER FOR CONTINUITY ONLY.
CAM GEAR	95	
CAM DRIVER	90	
IND ± 2 μh	30.0 μh	
Q	60 OR GREATER	
TEST FREQ.	2.5 MC	
COND. μmf	30	
RES. Ω	27K	

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

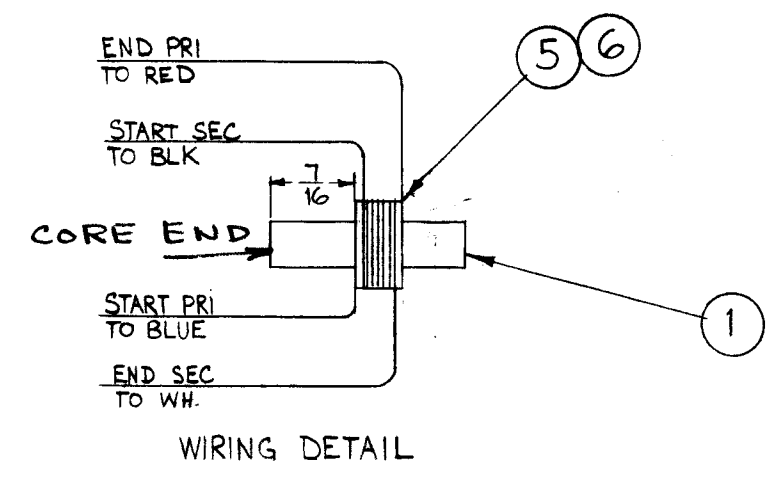
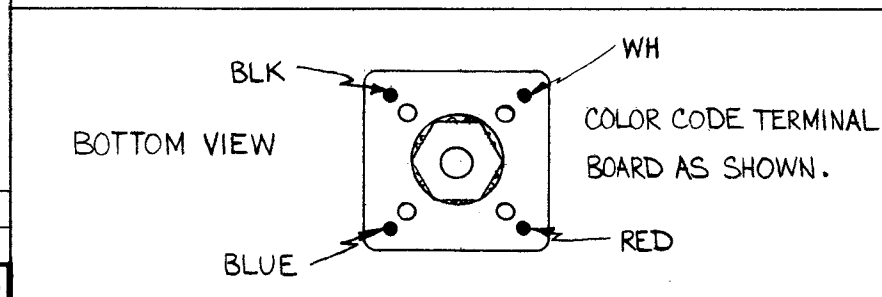
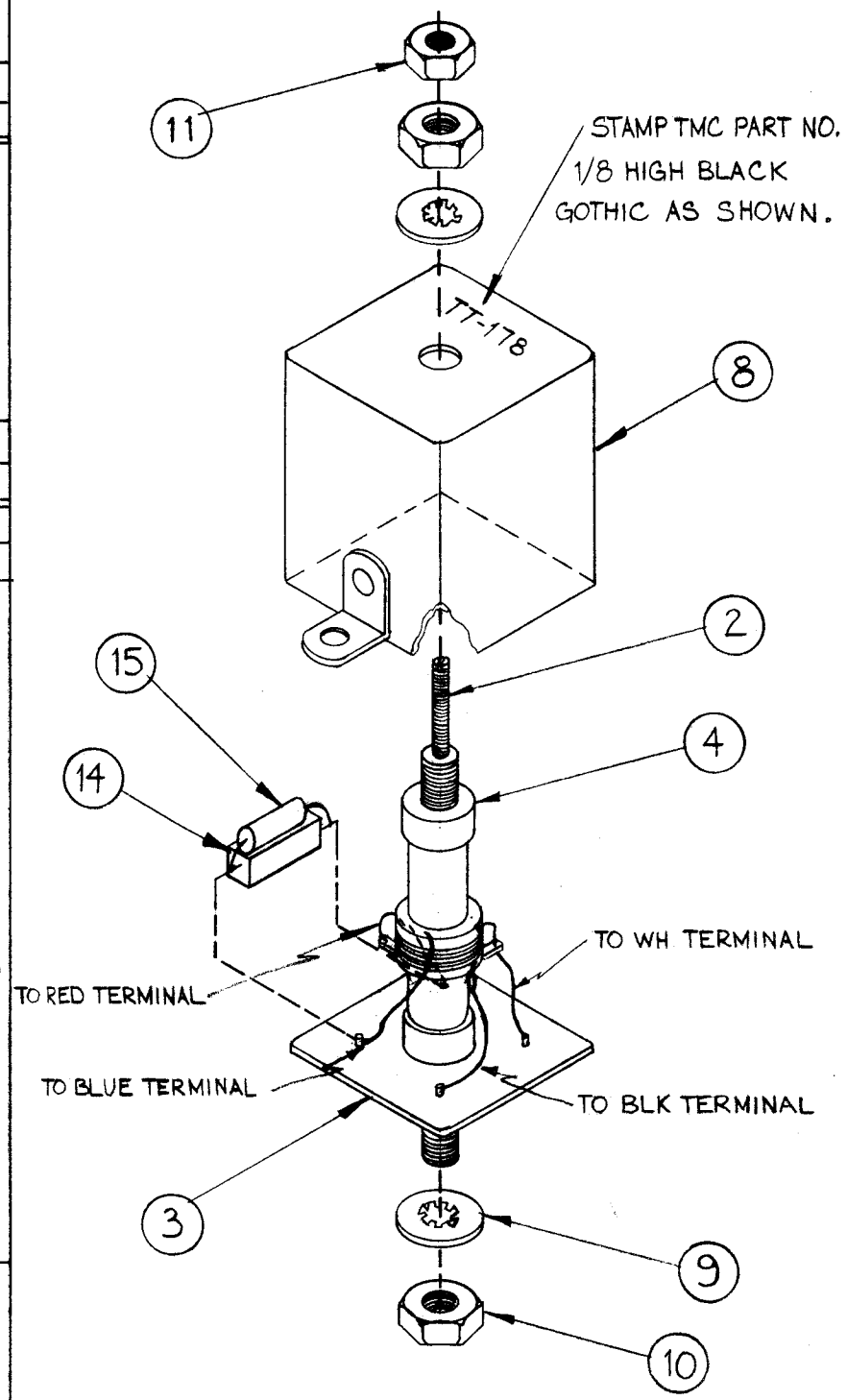
WINDING INSTRUCTIONS

- 1-WIND PRIMARY 70 TURNS (ITEM 6) STARTING 7/16 FROM END OF COIL FORM. STAKE ENDS WITH GL-103 (ITEM 12).
- 2-WIND ONE LAYER OF ELECTRICAL TAPE (ITEM 5) OVER PRIMARY.
- 3-WIND SECONDARY 9 TURNS (ITEM 6) CLOSE WOUND OVER TAPED PRIMARY APPROX. 1/16 FROM EDGE OF TAPE. STAKE ENDS WITH GL-103 (ITEM 12).
- 4-STRIP & TIN LEADS. SOLDER THEM TO PROPER COLOR-CODED TERMINALS ON BASE.
- 5- MEASURE Q & IND. W/O CORE
- 6- BAKE FOR 1/2 HOUR AT 215°F. SATURATE COILS WITH GL-104-2 (ITEM 13)
- 7- BAKE HARD AT 215°F FOR 1/2 HOUR.
- 8- SOLDER COMPONENT LEADS TO TERMINALS.
- 9- ASSEMBLE AS PER ASSEMBLY DRAWING. PLACE IN CAN.



SCHEMATIC DIAGRAM

• INDICATES START OF WINDING.



NOTE:  
USE BOONTON CORP. Q-METER MODEL 160 A OR EQUIV.

REQ.	ITEM	PART NO.	STRUMER DESCRIPTION	SYMBOL
1	15	RC20GF273K	RESISTOR, FIXED COMPOSITION	
1	14	CM15C300J03	CAPACITOR, FIXED MICA	
X	13	GL-104-2	INSULEX, U85	
X	12	GL-103	DUCO	
1	11	NTH0348BN6	NUT, HEX	
2	10	NTH0832BN8	NUT, HEX	
2	9	LW108MRN	LOCKWASHER, INTERNAL	
1	8	A-1950-4	CAN ASS'Y.	
	7			
X	6	WI-104-1243-SCQS	WIRE, LITZ	
X	5	TA-113-1-.250	TAPE, ELECTRICAL	
2	4	SM-140-2	BUSHING, COIL MTG.	
1	3	PX-585-1	TERMINAL BOARD, TRANSF. 4 LUGS	
1	2	CI-116-6	CORE, TUNING	
1	1	CF-122-1.00	COIL FORM, .250 O.D.	

B	IT-14 P/NW CM15B300K	8/24/62	20799	CE	CP	CP
A	ITEM (7) DELETED (TE 181-4)	11/14/64	10753	RD	JLW	WTS
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

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

SCALE: DO NOT SCALE  
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.  
REMOVE ALL BURRS AND SHARP EDGES

1	HFS-1	3500	8-15-62
REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.
			DATE
			USED ON

REQ.	ITEM	PART NO.	STRUMER DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
TT-178 ASS'Y (TRANSFORMER, RT TUNED, 3500 DECK).				
MATERIAL				
TYPE & TEMPER HEAT TREAT. SPEC.				
FINISH & SPEC. NO.				
DRAWN			CHECKED	
MECH. DES. APP.			MECH. DES. APP.	
A-2449			B	