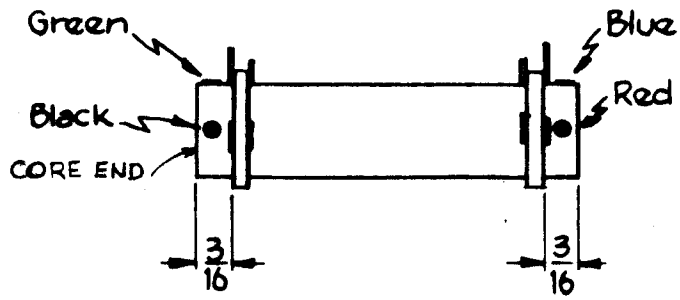


A-2464 C



COIL FORM ASSY

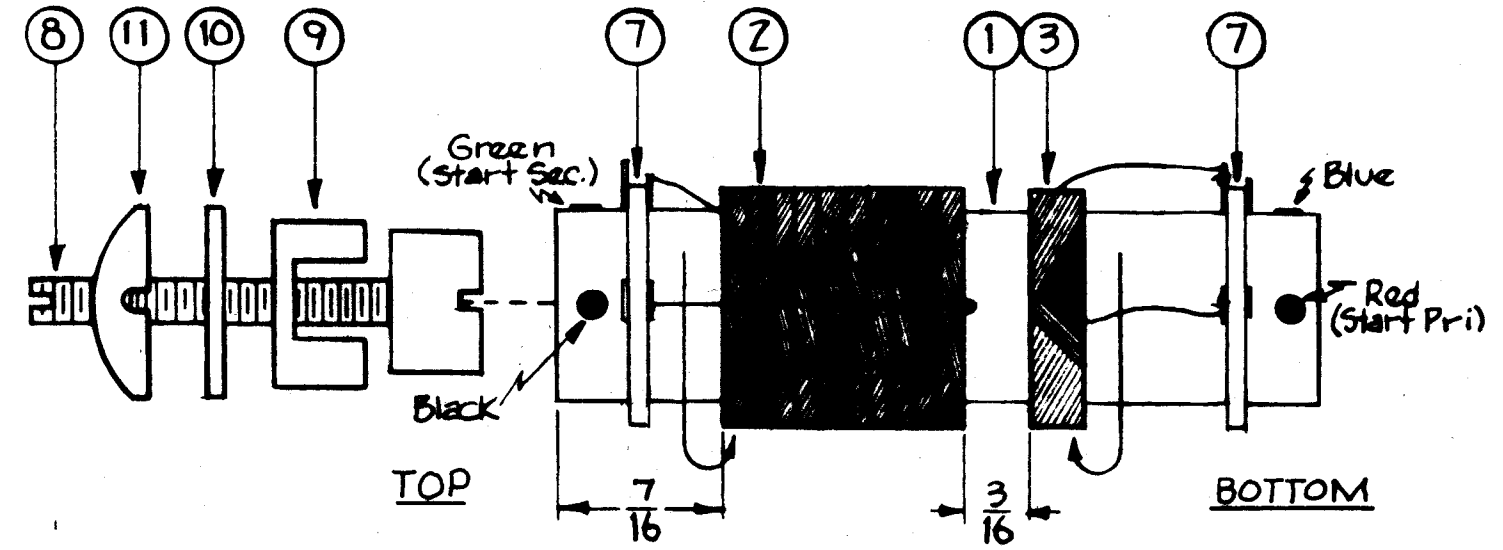
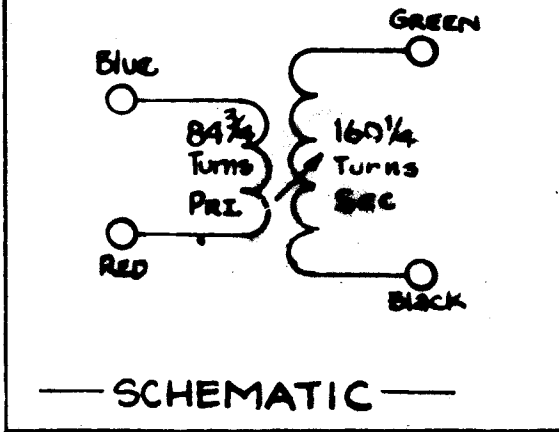
1. CEMENT TERMINAL RINGS TO COIL FORM WITH ITEM 4 IN POSITION SHOWN ABOVE.
2. COLOR CODE COIL FORM AS ABOVE.

COIL MACHINE DATA

SECONDARY		PRIMARY	
RACK GEAR	100	DRIVER GEAR	95
RACK DRIVER	40	CAM GEAR	49
CAM	.125	CAM	.125
CAM GEAR	49		
DRIVER GEAR	95		

WINDING DATA

1. SECONDARY (WIND ON BEFORE PRIMARY), STARTING AT GREEN LUG WIND ON APPROX 160 1/4 TURNS OF ITEM 2. (PROGRESSIVE UNIVERSAL WINDING). END AT BLACK LUG.
2. PRIMARY - STARTING AT RED LUG WIND ON APPROX. 84 3/4 TURNS OF ITEM 3 (UNIVERSAL WINDING) END AT BLUE LUG.
3. STAKE LEADS TO COIL FORM WITH ITEM 4. STRIP, TIN & SOLDER LEADS TO LUGS.
4. BAKE FOR 1/2 HOUR AT 215° F.
5. SATURATE COILS WITH ITEM 5. BAKE FOR 1/2 HOUR AT 215° F.
6. REPEAT STEP 5.
7. SOLDER CONNECT TEST LEADS TO LUGS (APPROX 1-1/4" #22 BUSS BAR). TEST AS BELOW. REMOVE TEST LEADS.



NOTE - COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 8-9-10-11 ARE CEMENTED TO COIL FORM WITH ITEM 12. FOR IDENTIFICATION, STAMP TMC PART NO TT-179 ON THE TOP OF COIL FORM.

TEST DATA % CORE

WINDING	* L uh	* Q	F	R & A
SEC.	195 (185-205)	60 or Greater	790 KC	10.0
PRI.	138 (130-148)	45 or Greater	790 KC	5.7

\* USE BOONTON Q METER 160A or EQUIVALENT  
 \*\* USE SIMPSON OHMETER 260 or EQUIVALENT

QTY	ITEM	PART NO.	DESCRIPTION	SYMBOL
X 12	GL-111		CEMENT, "INSA-LUTE"	
1	11	FS-112	FASTENER	
1	10	WA-125-2	WASHER, FIBER	
1	9	NT-112	NUT, SPEED	
1	8	CI-109-11	CORE, TUNING	
2	7	TE-146-2A	TERMINAL RING	
X 6	BS-100		SOLDER, SOFT	
X 5	GL-102		Q/MAX	
X 4	GL-103		CEMENT, DUCO	
X 3	WI-107-17		WIRE, MAGNET #36 DSC	
X 2	WI-104-341-SCQS		WIRE, LITZ 3/4" SC-QS	
1	1	CF-112	COIL FORM	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
C	3	CHG. ITEM 5 DESC.	3-16-64	11048	A.M.	@	MM
B	1	CLARIFICATION MADE ON NOTES & WINDING DATA PICTORIAL	7-17-63	9515	AK	J.P.	J.P.
A	1	ON PICTORIAL ITEM (7) WAS TE-146-3	1-25-63	8060	AK	J.P.	J.P.

TOLERANCES: DEC. DIM. ±, FRAC. DIM. ±, ANGULAR DIM. ±  
 SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

1	GPR-92	T109	6-1-62
REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.
			DATE

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
TT-179 ASSY			
TRANSFORMER, RF TUNED (2 <sup>ND</sup> RF)			
W.I.S.	J.P.	J.P.	BP
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	INDEXED
FINISH & SPEC. NO.	SEC. DES. APP.	MECH. DES. APP.	A-2464 C