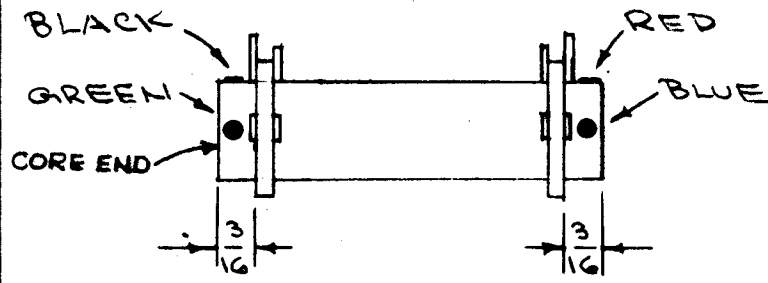


A-2467 C



COIL FORM ASSY.

- 1- CEMENT TERMINAL RINGS TO COIL FORM WITH ITEM 3 IN POSITION SHOWN ABOVE.
- 2- COLOR CODE COIL FORM AS ABOVE.

WINDING MACHINE DATA

RACK GEAR - 40
RACK DRIVER - 100

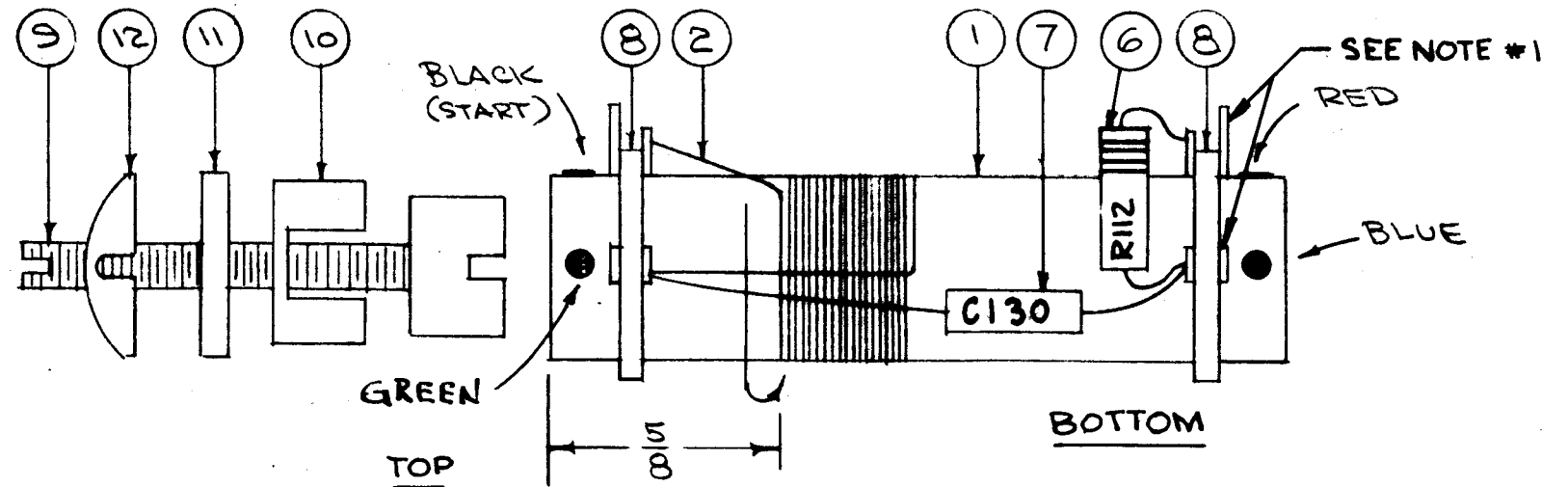
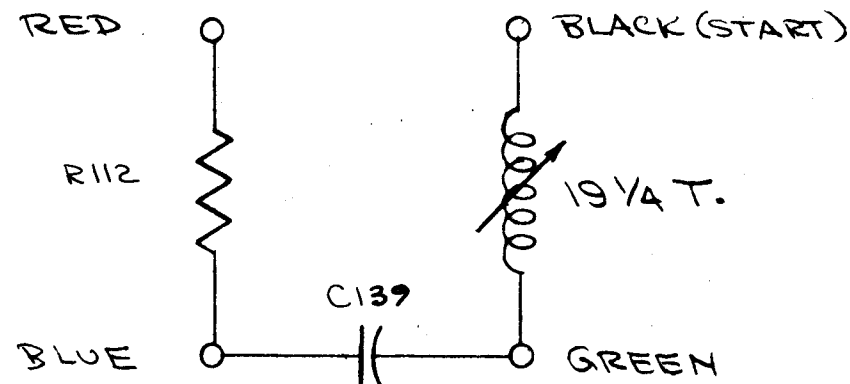
WINDING DATA

- 1- STARTING AT BLACK LUG, APPROX. 19 1/4 SPACE WOUND TURNS OF ITEM 2 ENDING ON GREEN LUG.
- 2- STAKE LEADS TO COIL FORM WITH ITEM 3.
- 3- SOLDER LEADS TO LUGS AS SHOWN.
- 3- BAKE FOR 1/2 HOUR AT 215° F.
- 4- SATURATE COIL WITH ITEM 4. BAKE FOR 1/2 HOUR AT 215° F.
- 5- REPEAT STEP 4.
- 6- SOLDER CONNECT CAPACITOR & RESISTOR AS SHOWN.
- 7- SOLDER CONNECT TEST LEADS TO LUG. (APPROX 1/4" #22 BUSS BAR). TEST AS BELOW. REMOVE TEST LEADS.

TEST DATA w/o CORE

L - 3.4 μ h (3.2 - 3.6)
Q - 120 OR GREATER
F - 7.9 MC

USE BOONTON Q METER 160A OR EQUIVALENT.



NOTE - COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 9-10-11-12 ARE CEMENTED TO COIL FORM WITH ITEM 13.

FOR IDENTIFICATION, STAMP THE NUMBER AC-152 ON THE TOP OF COIL FORM.

NOTE #1 COMPONENTS MAY BE ASSEMBLED TO EITHER END OF LUG (TE-146-2A).

X	13	GL-111	CEMENT, "INSA-LUTE"	
1	12	FS-112	FASTENER	
1	11	WA-125-2	WASHER, FIBER	
1	10	NT-112	NUT, SPEED	
1	9	CI-109-7	CORE	
2	8	TE-146-2A	TERMINAL RING	
1	7	CC215L050C	CAPACITOR, FIXED	C130
1	6	RC200F472J	RESISTOR, FIXED	R112
X	5	BS-100	SOLDER, SOFT	
X	4	GL-102	Q MAX	
X	3	GL-103	CEMENT, DUCO	
X	2	WI-107-11	WIRE, MAGNET #30DSC	
1	1	CF-112	COIL FORM	

REQ. ITEM	PART NO.	STRUMER DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK AC-152 ASSY COIL, RF, TUNED (2ND R.F.)			
MATERIAL			
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
FINISH & SPEC. NO.		MECH. DES. APP.	FINAL APPROVAL

C	ON IT. 7-C130 WAS C139	1-31-66	15674	HLA	JCF	MM
B	NOTES, WINDING DATA, PICTORIAL CLARIFIED. NOTE #1 ADDED	7-18-63	9515	AK	NO	JCF
A	SYM. C139 WAS C120	1-19-63	8031		JCF	JCF
ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES		SCALE:				
DEC. DIM. ±	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.					
FRAC. DIM. ±	REMOVE ALL BURRS AND SHARP EDGES					
ANGULAR DIM. ±						

1	GPR-92	L102	6-1-62
REQ. PER UNIT	MODEL	PROJECT NO.	DATE
USED ON			

WIS, JCF
 DRAWN: JCF
 CHECKED: JCF
 FINAL APPROVAL: BP
 A-2467 C