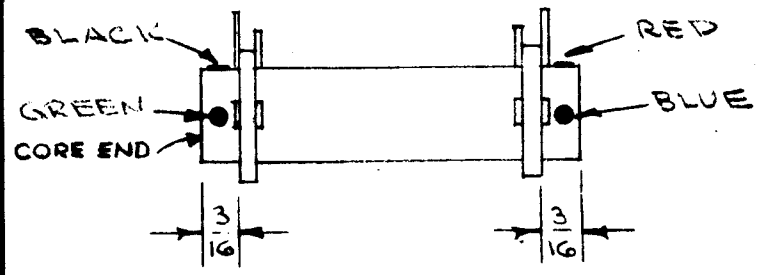


A-2468 C



**COIL FORM ASSY.**

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

**WINDING MACHINE DATA**

PINION GEAR 25  
RACK DRIVER GEAR 100

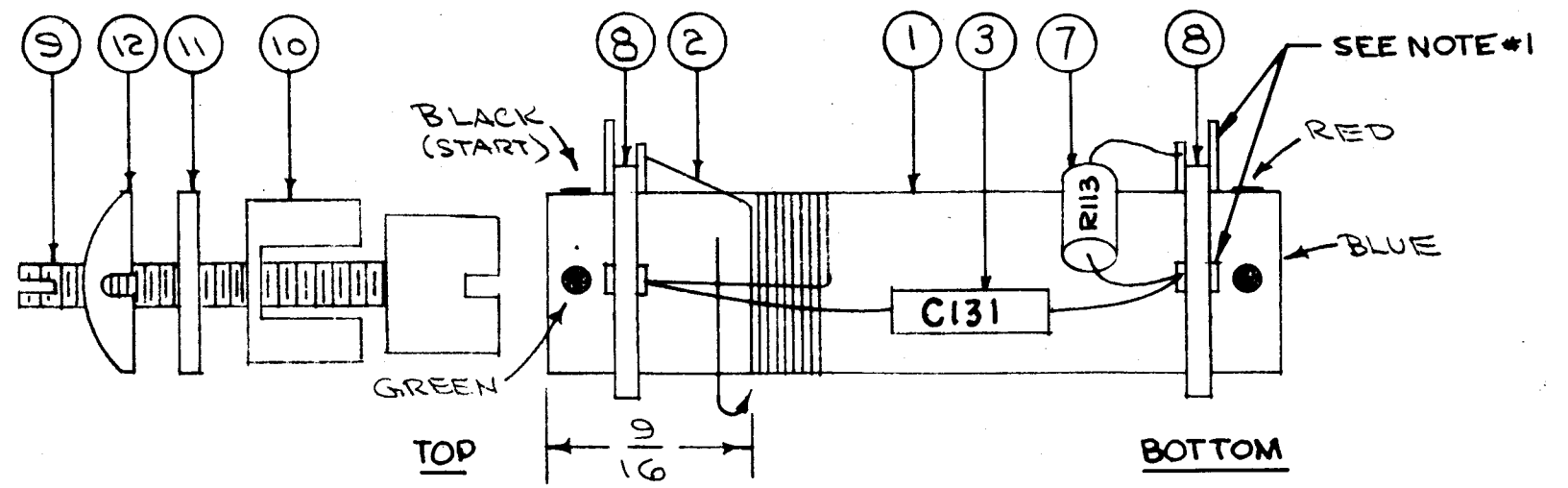
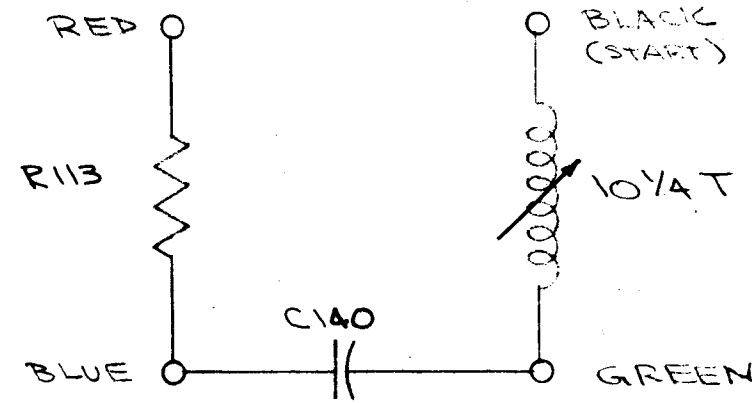
**WINDING DATA**

- 1- STARTING AT BLACK LUG, APPROX. 10 1/4 SPACE WOUND TURNS OF ITEM 2, ENDING AT GREEN LUG.
- 2- STAKE LEADS TO COIL FORM WITH ITEM 4. STRIP, TIN & SOLDER LEADS TO LUGS AS SHOWN.
- 3- BAKE FOR 1/2 HOUR AT 215° F.
- 4- COAT COIL WITH ITEM 5.
- 5- REPEAT STEP 3.
- 6- SOLDER TEST LEADS TO LUGS (APPROX. 1/4" #22 BUSS) TEST AS PER CHART BELOW. REMOVE TEST LEADS.
- 7- SOLDER CAPACITOR & RESISTOR IN PLACE AS SHOWN.

**TEST DATA W/O CORE**

L - 1.1 μh (1.04 - 1.16)  
Q - 110 OR GREATER  
F - 7.9 MC.

USE SCOTTON Q METER 160A OR EQUIVALENT.



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

FOR IDENTIFICATION, STAMP THE NUMBER AC153 ON THE TOP OF COIL FORM.

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

REQ. ITEM	PART NO.	STRUMER DESCRIPTION	SYMBOL
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	RC32GF223J	RESISTOR, FIXED	R113
X 6	BS-100	SOLDER, SOFT	
X 5	GL-102	Q MAX	
X 4	GL-103	CEMENT, DUCO	
1 3	CC21SLO50C	CAPACITOR, FIXED	C131
X 2	WI-107-5	WIRE, MAGNET #24 DSC	
1 1	CF-112	COIL FORM	

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFT.	CHECKER	ENG. APP.
C	ON IT. 3 - C131 WAS C140	1-2-66	15674	NLA	QCB	MMK
B	NOTES, WINDING DATA PICTORIAL CLARIFIED. NOTE #1 ADDED.	7-18-63	9515	AK	71	WFB
A	SYM. C140 WAS C121	1-19-63	8031			

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

REQ. PER UNIT	MODEL	PROJECT NO.	SYMBOL NO.	DATE
1	GPR-92		L103	6-1-62
USED ON				

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
AC-153 ASSY			
COIL, RF TUNED (2 <sup>ND</sup> RF)			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELC. DES. APP.	MECH. DES. APP.
		W.S.	J.P.
		BP	
		A-2468 C	