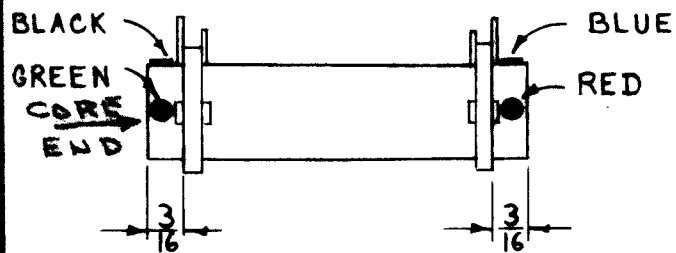


A-2471E



**COIL FORM ASS'Y.**

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

**WINDING MACHINE DATA**

SECONDARY		PRIMARY	
RACK GEAR	100	DRIVER GEAR	95
RACK DRIVER	56	CAM GEAR	49
CAM	.187	CAM	.125
CAM GEAR	66		
DRIVER GEAR	63		

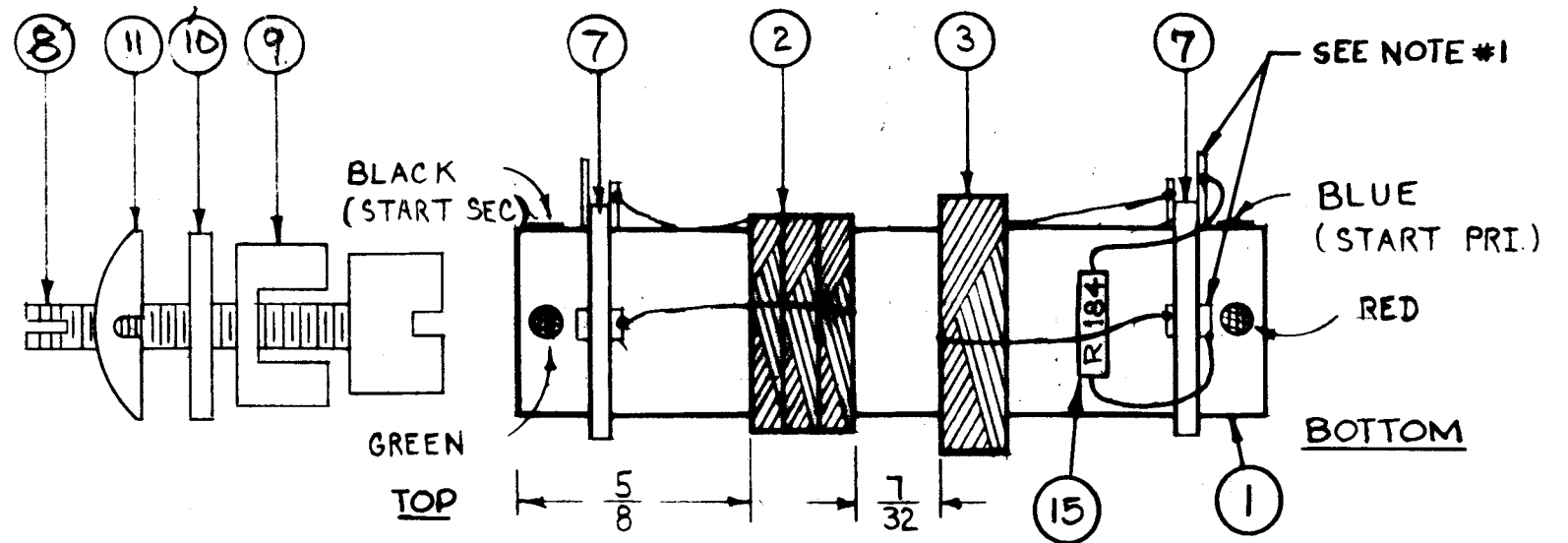
**WINDING DATA**

- 1- SECONDARY (WIND ON BEFORE PRIMARY). STARTING AT BLACK LUG APPROX 47/4 TURNS OF ITEM 2, (PROGRESSIVE UNIVERSAL WINDING) ENDING ON GREEN LUG.
- 2- PRIMARY - STARTING ON BLUE LUG, APPROX 70/4 TURNS OF ITEM 3 (UNIVERSAL WINDING) END ON RED LUG.
- 3- STAKE LEADS TO COIL FORM WITH ITEM 4. STRIP, TIN & SOLDER LEADS TO LUGS AS SHOWN.
- 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. 1/4" OF #22 BUSS BAR). TEST AS BELOW. REMOVE TEST LEADS.) ADD ITEM 15

**TEST DATA W/O CORE**

WINDING	* L μh	* Q	F	** R Ω APPROX
SEC.	27.5 (26.1-28.9)	90 OR GREATER	2.5 MC	2.0
PRI.	94 (89-99)	40 " "	790 KC	5.0

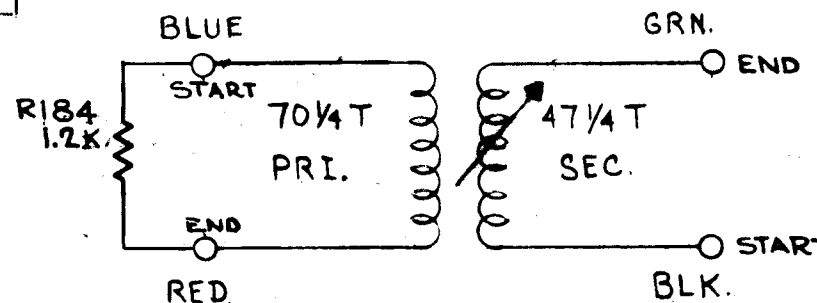
\* USE BOONTON Q METER 160A OR EQUIV.  
 \*\* " SIMPSON OHMMETER 260 " "



NOTE: COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 8, 10 & 11 ARE CEMENTED TO COIL FORM WITH ITEM 12.

FOR IDENTIFICATION, STAMP THE NUMBER TT-184 ON TOP OF THE COIL FORM.

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



QTY	ITEM	PART NO.	DESCRIPTION	SYMBOL
1	15	RC20GF12ZK	RESISTOR, FIXED	R184
-	14		DELETED	
-	13		DELETED	
X	12	GL-111	CEMENT, "INSALUTE"	
1	11	FS-112	FASTENER	
1	10	WA-125	WASHER, FIBER	
1	9	NT-112	NUT, SPEED	
1	8	CI-109-9	CORE	
2	7	TE-146-2A	TERMINAL RING	
X	6	BS-100	SOLDER, SOFT	
X	5	GL-102	Q. MAX.	
X	4	GL-103	CEMENT, DUCCO	
X	3	WI-107-17	WIRE, MAGNET #36 DSC	
X	2	WI-104-541SN-QS	WIRE, LITZ 5/41 SN, QS	
1	1	CF-112	COIL FORM	

REQ. ITEM	PART NO.	GELLMAN	DESCRIPTION	SYMBOL
<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK, NEW YORK				
<b>TT-184 ASSY</b>				
<b>TRANSFORMER, RF TUNED (1ST MIXER)</b>				
STOCK SIZE		MATERIAL		
TYPE & TEMPER		HEAT TREAT. SPEC.		
FINISH & SPEC. NO.		ELEC. DES. APP. MECH. DES. APP.		

E	1	ITEM 2 WAS WI-104-541SN	2-5-64	10830	A.M.	T.R.	
D	1	SYM. FOR ITEM #15 R184 WAS R225	11/20/63	10460			
C	1	NOTES, WINDING DATA & PICTORIAL CLARIFIED. NOTE #1 ADDED.	7-18-63	9515	AK.	J.P.	
B	7		6-5-63	9175			
A	1	ITEMS (13) & (14) ADDED	1-10-63	7981			

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES						
SCALE:						
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES						

1	GPR-92	T114	10-16-62
REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.
USED ON			