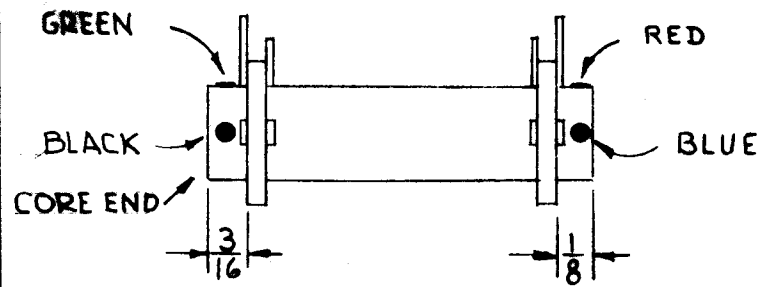


A-2472 B



COIL FORM ASS'Y

- 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	48
RACK DRIVER	80
CAM	.125
CAM GEAR	49
DRIVER GEAR	95

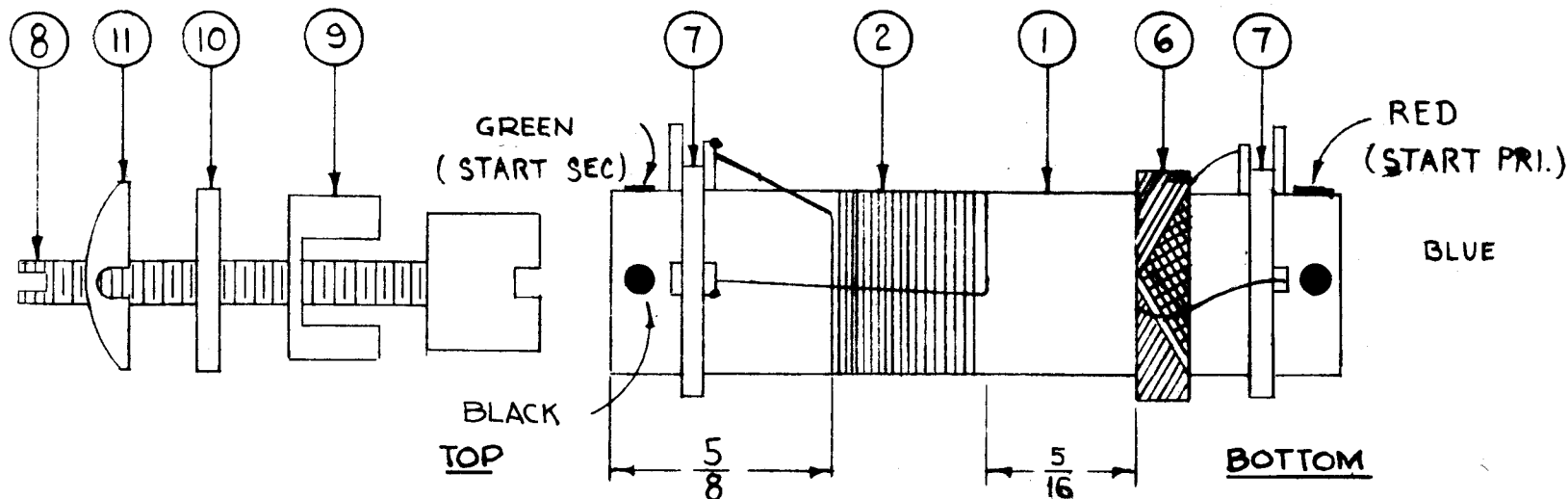
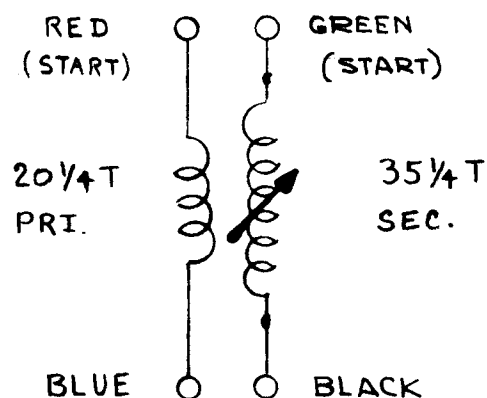
WINDING DATA

- 1- SECONDARY - STARTING AT GREEN LUG, CLOSE WIND APPROX. 35 1/4 TURNS OF ITEM 2, END AT BLACK LUG.
- 2- PRIMARY - STARTING AT RED LUG, UNIVERSAL WIND APPROX. 20 1/4 TURNS OF ITEM 6, END AT BLUE LUG.
- 3- STAKE LEADS TO COIL FORM WITH ITEM 3. STRIP TIN & SOLDER CONNECT LEADS AS SHOWN
- 4- BAKE FOR 1/2 HOUR AT 215° F.
- 5- SATURATE COILS WITH ITEM 4. BAKE FOR 1/2 HOUR AT 215° F.
- 6- REPEAT STEP 5
- 7- SOLDER TEST LEADS (APPROX. 1/4" # 22 BUSS BAR) TO LUGS. TEST AS BELOW. REMOVE TEST LEADS.

TEST DATA % CORE

WINDING	* L uh	* Q	F
PRI.	9.0 (8.5-9.5)	55 OR GREATER	7.9 MC
SEC.	9.7 (9.2-10.2)	85 " "	2.5 MC

* USE BOONTON Q METER 160 A OR EQUIVALENT.



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

FOR IDENTIFICATION STAMP NUMBER TT-185 ON TOP OF COIL FORM.

QTY	ITEM	PART NO.	DESCRIPTION	SYMBOL
X 12	GL-111		CEMENT "INSALUTE"	
1	11	FS-112	FASTENER	
1	10	WA-125-2	WASHER, FIBER	
1	9	NT-112	NUT, SPEED	
1	8	CI-109-9	CORE	
2	7	TE-146-2A	TERMINAL RING	
X 6	WI-107-17		WIRE, MAGNET # 36 DSC	
X 5	BS-100		SOLDED, SOFT	
X 4	GL-102		Q-MAX.	
X 3	GL-103		CEMENT, DUCO	
X 2	WI-107-11		WIRE, MAGNET # 30 DSC	
1	1	CF-112	COIL FORM	

STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL		TT-185 ASSY	
		TRANSFORMER, RF, TUNED (1ST MIXER)	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.	ELC. DES. APP.	MECH. DES. APP.	FINAL APPROVAL

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	1	IN BUILDUP CI-109-9 WAS CI-109-10	10/9/63	10150	AK	MP	WPS
A	1	NOTES, WINDING DATA & PICTORIAL CLARIFIED	7-18-63	9515	AK	MP	WPS

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. ±	

MODEL	PROJECT NO.	SYMBOL	DATE
GPR-92	TT15	6-4-62	
USED ON			