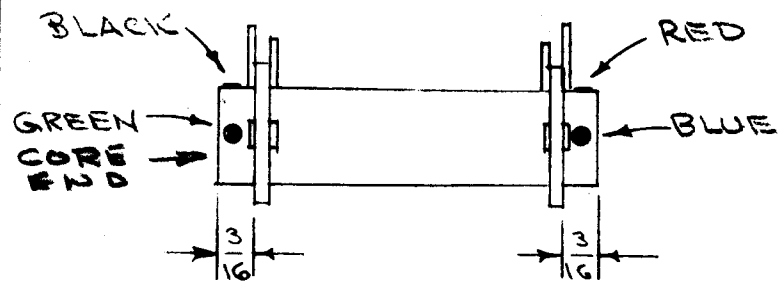


A-2473 B



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

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

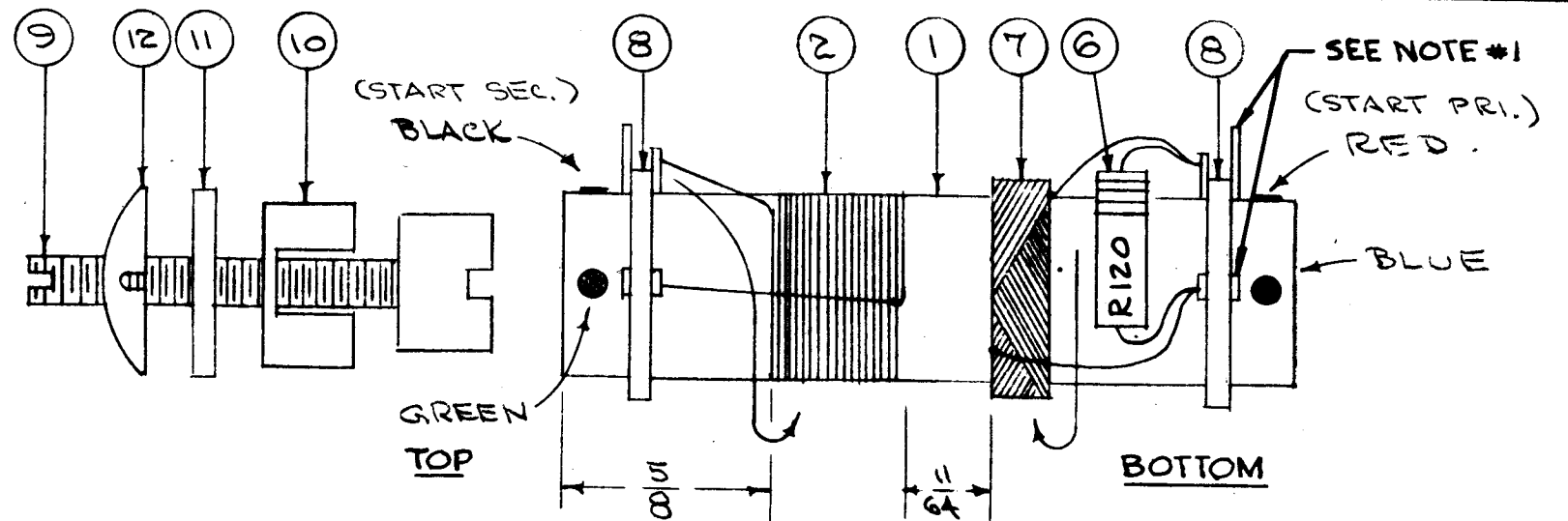
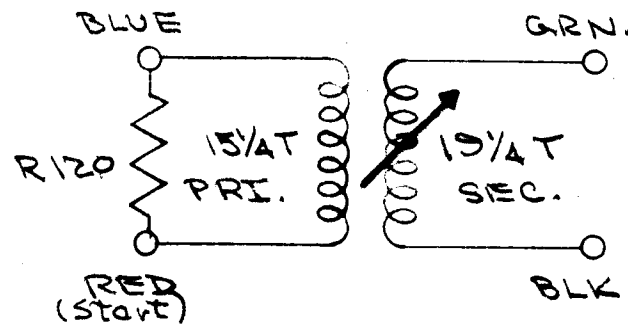
WINDING DATA

- 1- SECONDARY - (WIND ON BEFORE PRIMARY). STARTING AT BLACK LUG SPACE WIND APPROX. 19 1/4 TURNS OF ITEM 2, ENDING ON GREEN LUG.
- 2- PRIMARY - START AT RED LUG APPROX. 15 1/4 TURNS OF ITEM 7, UNIVERSAL WOUND. END ON BLUE LUG.
- 3- STAKE LEADS TO COIL FORM WITH ITEM 3.
- 4- STRIP, TIN & SOLDER CONNECT LEADS AS SHOWN.
- 5- BAKE FOR 1/2 HOUR AT 215°F.
- 6- SATURATE COILS WITH ITEM 4, BAKE FOR 1/2 HOUR AT 215°F.
- 7- REPEAT STEP 6.
- 8- SOLDER CONNECT TEST LEADS (APPROX. 1/4" #22 GA. BUSS.) TEST AS BELOW. REMOVE TEST LEADS.
- 9- SOLDER RESISTOR IN PLACE.

TEST DATA w/o CORE

WINDING	* L μH	* Q	F
PRI.	5.0 (4.7-5.2)	62 OR GREATER	7.9 MC
SEC.	3.4 (3.2-3.6)	120 " "	7.9 MC

* USE BOONTON Q METER 160 A 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 NUMBER TT-186 ON TOP OF COIL FORM.

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

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 13	GL-111	CEMENT, "INSA-LTE"	
1 12	FS-112	FASTENER	
1 11	WA-125-2	WASHER, FIBER	
1 10	NT-112	NUT, SPEED	
1 9	CI-109-9	CORE	
2 8	TE-146-2A	RING, TERMINAL	
X 7	WI-107-17	WIRE, MAGNET #36 DSC	
1 6	RC20GF102K	RESISTOR, FIXED	R120
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 #30 DSC	
1 1	CF-112	COIL FORM	

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B 1	NOTES, WINDING DATA, PICTORIAL CLARIFIED, NOTE (*) ADDED	7-18-63	9515	AK	JP	JP
A 1	SYM. R120 WAS R121	1-19-63	8031	JP	JP	JP

TOLERANCES	SCALE:	REQ. PER UNIT	MODEL	PROJECT NO.	SYMBOL NO.	DATE
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES	1	GPR-92		TI16	10-16-62

STOCK SIZE	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
	TT-186 ASSY	
	TRANSFORMER, RF, TUNED (1 ST MIXER)	
	W.S.	JP
	DR. APP.	TECH. DES. APP.
	A-2473 B	