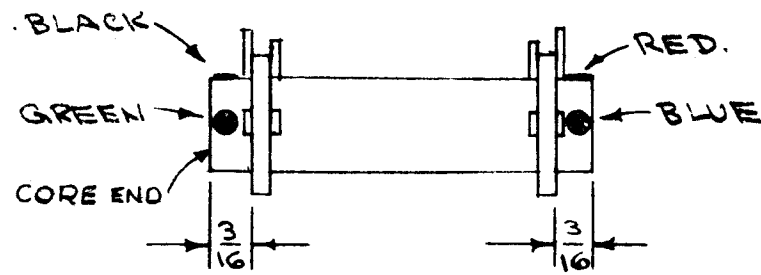


A-2474 B



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.

- PINION GEAR- 25
- RACK GEAR- 100
- DISENGAGE 1:1 IDLER GEAR FROM CAM GEAR.

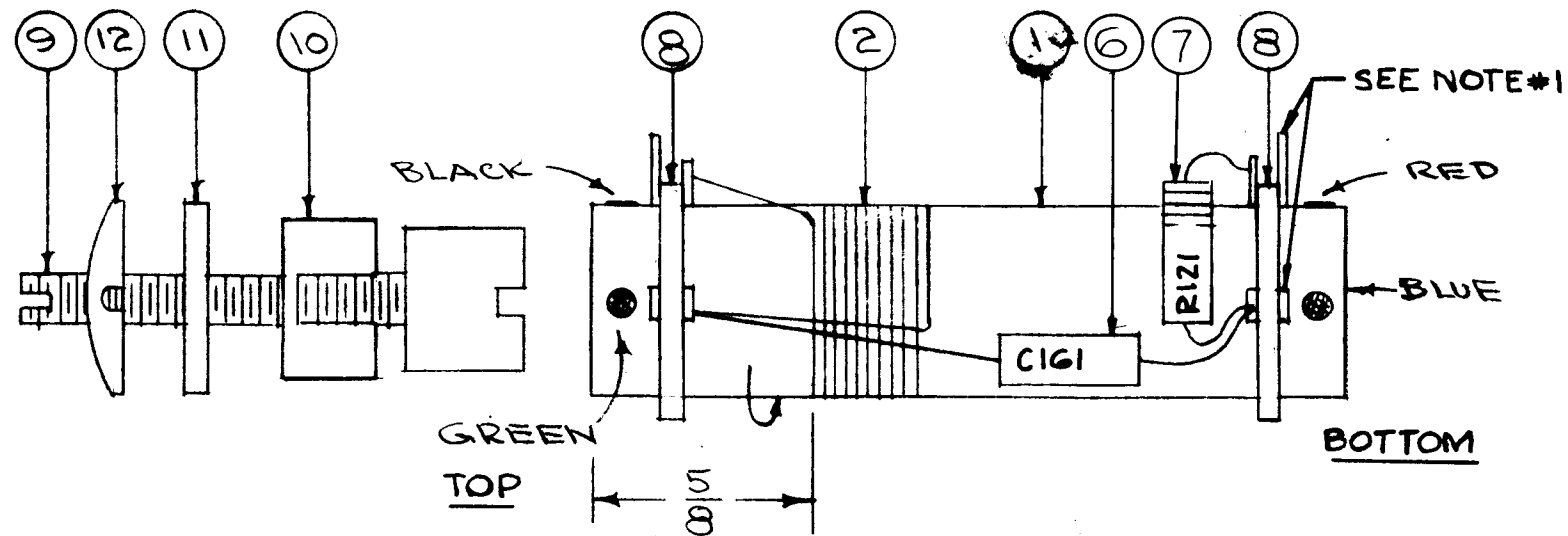
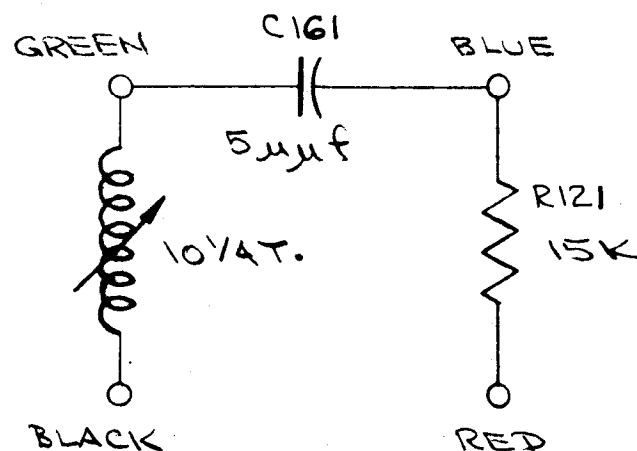
WINDING DATA.

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

TEST DATA w/o CORE

- L - 1.1 (1.04-1.16) μh
- Q - 115 OR GREATER
- F - 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 AC-154 ON 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 | FASTERER | |
| 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 | RC42GF153J | RESISTOR, FIXED | R1Z1 |
| 1 | 6 | CC215L050C | CAPACITOR, " | C1G1 |
| X | 5 | BS-100 | SOLDER, SOFT | |
| X | 4 | GL-102 | Q. MAX | |
| X | 3 | GL-103 | CEMENT | |
| X | 2 | WI-107-5 | WIRE, MAGNET 24DSC | |
| 1 | 1 | CF-112 | COIL FORM | |

| REG. ITEM | PART NO. | STRUMER DESCRIPTION | SYMBOL |
|--|----------|----------------------------|--------|
| THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK | | | |
| AC-154 ASSY | | | |
| COIL, RF, TUNED (1ST MIXER) | | | |
| MATERIAL | | W. S. [Signature] | |
| TYPE & TEMPER | | DRAWN [Signature] | |
| HEAT TREAT. SPEC. | | CHECKED [Signature] | |
| FINISH & SPEC. NO. | | FINAL APPROVAL [Signature] | |
| ELEC. DES. APP. | | MECH. DES. APP. | |
| A-2474 B | | | |

| B | 1 | NOTES, WINDING DATA & PICTORIAL CLARIFIED. NOTE (#1) ADDED | 7-18-63 | 9515 | AL | MP | W.S. |
|----------------|------|--|---|-------------|--------|---------|-----------|
| A | 1 | SYMBOLS, C1G1 WAS C139 R1Z1 WAS R122 | 1-19-63 | 8031 | | MP | W.S. |
| 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. ± | | | | | | | |
| REQ. PER UNIT | | GPR-92 | | L114 | | 6-4-62 | |
| | | MODEL | | PROJECT NO. | | DATE | |
| USED ON | | | | | | | |