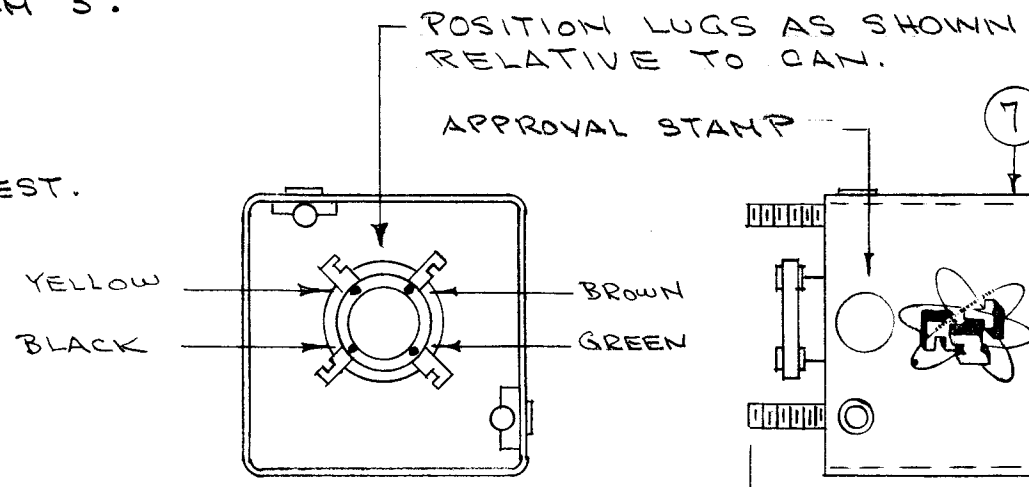
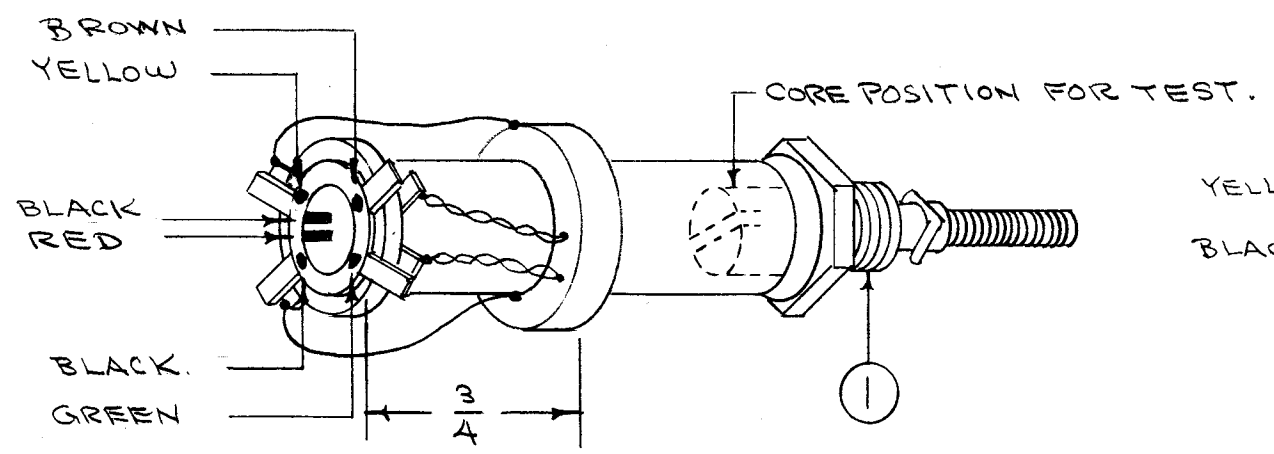
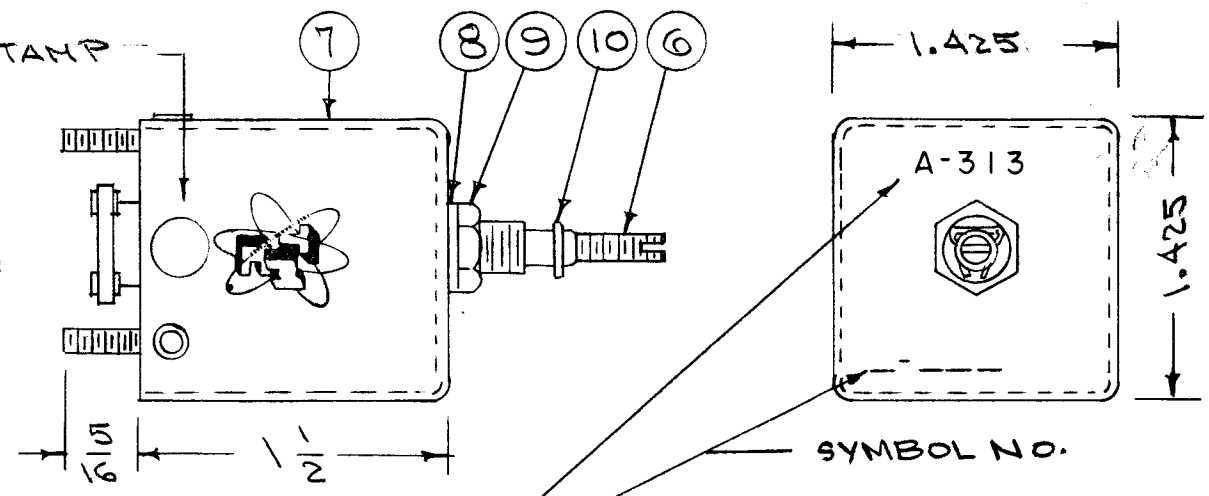


A-313 B

CEMENT TERMINAL RING TO COIL FORM WITH ITEM 3.
 COLOR CODE END OF COIL FORM AS BELOW.



STAMP THE INSIGNIA ON SIDE OF CAN.



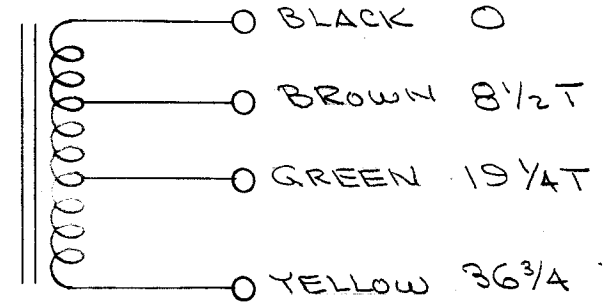
STAMP ASS'Y. NO. & SYMBOL NO. ON CAN AFTER CAN IS ASSEMBLED ON CHASSIS. (REF: LD-124)

WINDING MACHINE DATA

DRIVER GEAR	81
CAM GEAR	86
CAM	.093

WINDING DATA (UNIVERSAL WINDING)

- 1- START WINDING AT BLACK LUG.
- 2- 1ST TAP 8 1/2 TURNS FROM START TO BROWN LUG.
- 3- 2ND " 19 1/4 " " " " GREEN LUG.
- 4- END - 36 3/4 " " " " " YELLOW LUG.
- 5- STAKE ENDS & TAPS WITH ITEM 3
- 6- BAKE FOR 1/2 HOUR AT 215° F.
- 7- SATURATE COIL WITH ITEM 4.
- 8- BAKE FOR 1/2 HOUR AT 215° C.
- 9- REPEAT STEPS 7 AND 8.
- 10- STRIP, TIN & SOLDER LEADS TO LUGS.



FREQ. RANGE - 2.415 - 4.555 MC.

TEST DATA (SEE ABOVE FOR CORE POSITION)

TEST LEADS APPROX 1/4". NO CAN NEEDED FOR TEST.

	LUGS	LUGS	LUGS
	YELLOW/BLACK	BLACK/GREEN	YELLOW/BROWN
L _{μh}	27.7 (26.3-29.1)	15.8 (15.0-16.6)	17.4 (16.6-18.2)
Q	40 OR GREATER	35 OR GREATER	30 OR GREATER
f	2.5 MC	3.5 MC	2.5 MC

USE BOONTON Q METER
 160A OR EQUIV.

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	11	BS-100	SOLDER, SOFT	
1	10	SP-102	SPRING LOCK P/O CF-114	
1	9	NT-102	NUT, HEX P/O CF-114	
1	8	LWI25 LRC	WASHER, LOCK P/O CF-114	
1	7	A-173	CAN ASSEMBLY	
1	6	CI-109-19	CORE	
1	5	TE-146-4	COLLAR & LUGS	
X	4	GL-102	Q MAX A-27	
X	3	GL-103	CEMENT, DUCCO	
X	2	WI-107-15	WIRE, #34 DSC	
1	1	CF-114-3	COIL FORM	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	1	COMPLETE REVISION SUPERCEDES A-309	8/28/56	2		P.L.K.	AJT

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

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	FFRD-5	104	A-328	8-28-56

USED ON

TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
		P.L.K.		AJT

FINISH & SPEC. NO. ELEC. DES. APP. MECH. DES. APP. A-313 B