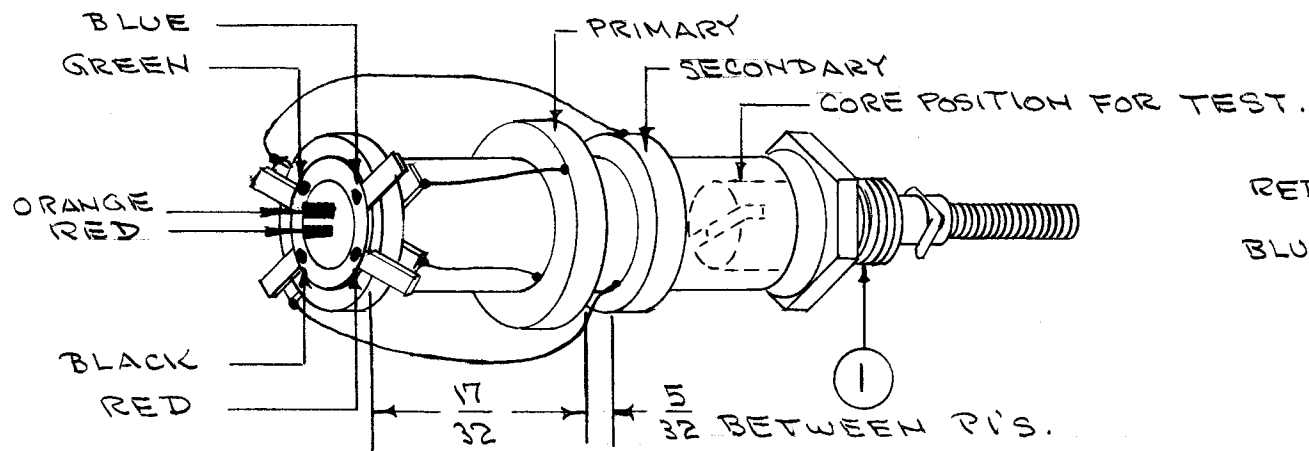


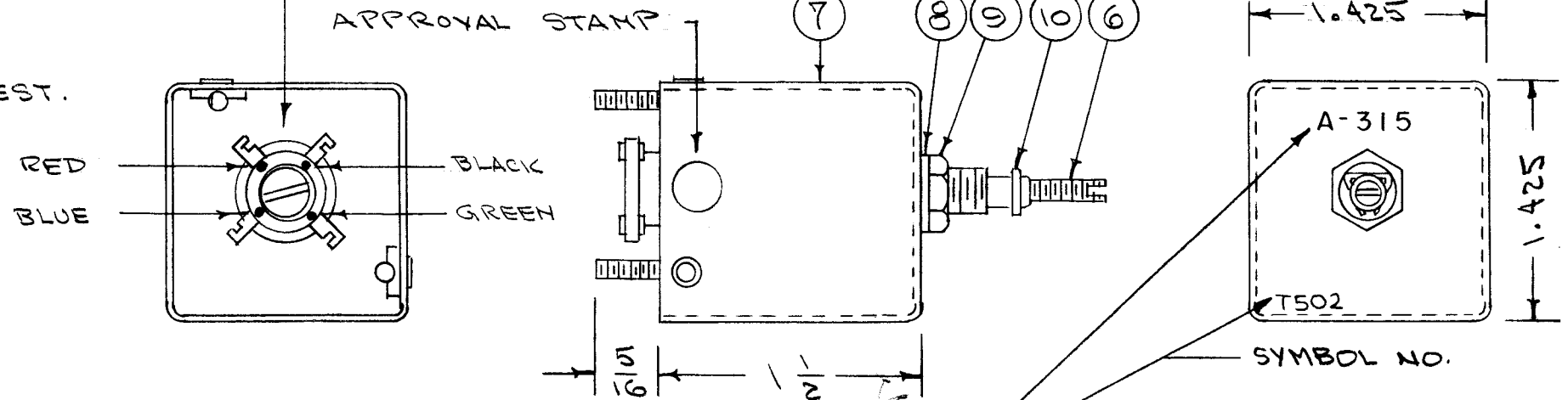
B
A-315

CEMENT ITEM 5 (COLLAR) TO COIL FORM WITH ITEM 3.
COLOR CODE END OF COIL FORM AS BELOW.



POSITION LUGS AS SHOWN
RELATIVE TO CAN.

STAMP TMC INSIGNIA ON SIDE OF CAN.



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

WINDING MACHINE DATA

DRIVER GEAR	81
CAM GEAR	86
CAM	.093

WINDING DATA (UNIVERSAL WINDING)

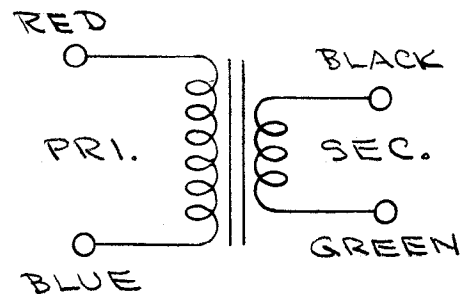
- 1- PRIMARY - STARTING AT RED LUG WIND ON $100\frac{1}{4}$ TURNS OF ITEM 2 ENDING AT BLUE LUG.
- 2- SECONDARY - STARTING AT BLACK LUG WIND ON $45\frac{3}{4}$ TURNS OF ITEM 2 ENDING AT GREEN LUG.
- 3- STAKE COIL ENDS WITH ITEM 3.
- 4- BAKE FOR 1/2 HOUR AT 215° F.
- 5- SATURATE COILS WITH ITEM 4. (Q MAX.)
- 6- BAKE FOR 1/2 HOUR AT 215° F.
- 7- REPEAT STEPS 5 AND 6.
- 8- STRIP, TIN & SOLDER CONNECT LEADS TO LUGS AS ABOVE.

TEST DATA (SEE ABOVE FOR CORE POSITION.)

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

	PRIMARY	SECONDARY
	BLUE/RED	GREEN/BLACK
L _{μh}	200 (190-210)	42 (39.9 - 44.1)
Q	35 OR GREATER	30 OR GREATER
f	790 KC	2.5 MC

USE BOONTON Q METER 160A OR EQUIV.



FREQ. RANGE 1.95 - 4.1 MC

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	11	BS-100	SOLDER, SOFT	
1	10	SP-102	SPRING LOCK P/O CF-114	
1	9	HT-102	NUT, HEX P/O CF-114	
1	8	LW125 LRC	WASHER, LOCK P/O CF-114	
1	7	A-173	CAN ASSY.	
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		TMC INSIGNIA DEL SYM ADDED; WINDING SECONDARY WAS 45 3/4	10.18.66	17062	WHO	RS	JJ
A	1	COMPLETE REVISION SUPERCEDES A-311	8/27/56	1	CSO	P.L.X.	A.J.J.

1	FFRD-5	104	A-328	8/27/56
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
USED ON				

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
TRANSFORMER ASSY. MIXER T502 BAND 5				
DRAWN: P.L.X. CHECKED: [Signature] FINAL APPROVAL: A.J.J.				
TYPE & TEMPER HEAT TREAT. SPEC. FINISH & SPEC. NO. ELEC. DES. APP. MECH. DES. APP.				
A-315 B				