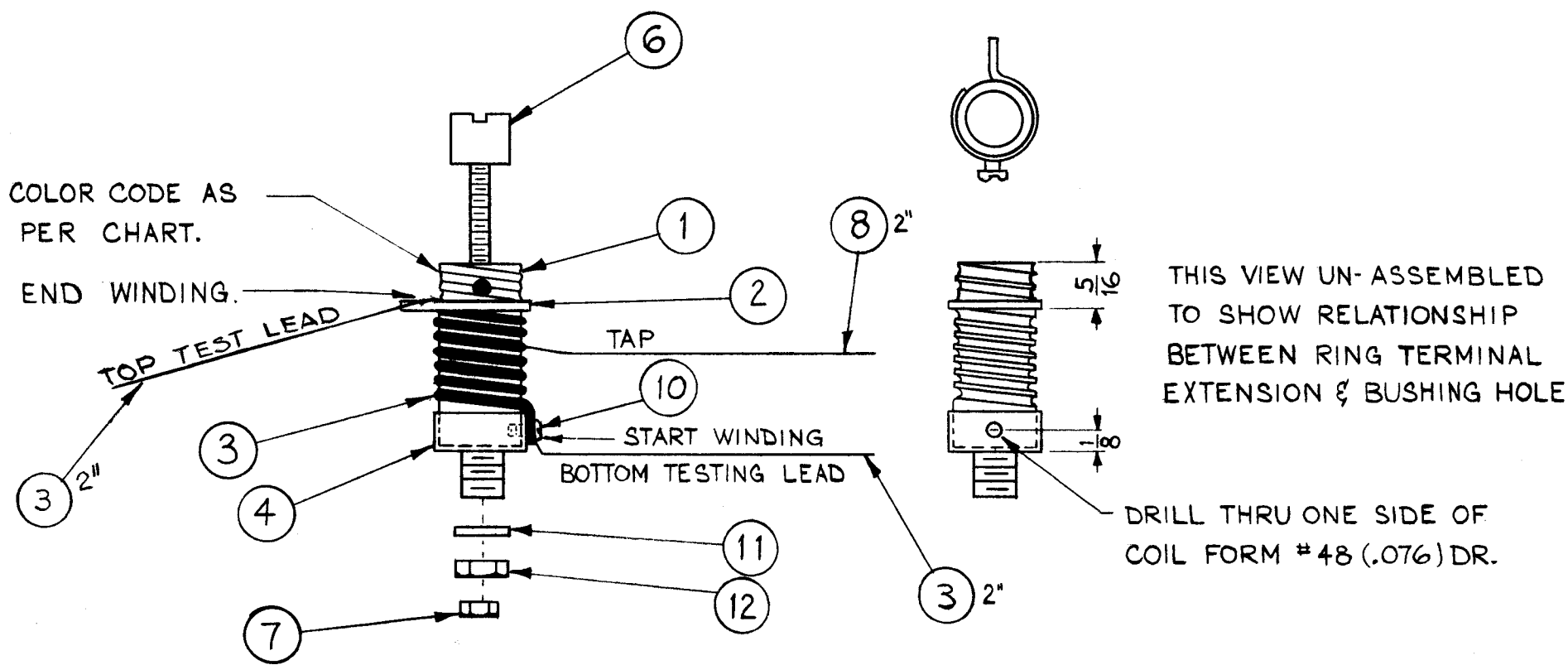


A-3022

TMC MFG. ASSY NO.	TMC PART NO.	SYMBOL	NO. OF TURNS	TAP INFORMATION	NOMINAL INDUCTANCE AT 25 Mcs. - W/O CORE (uhy)	Q AT .25 Mcs. MUST BE GREATER THAN	REQ. PER UNIT	COLOR CODE COIL FORM
A-3022	TT-139	T-6, T10	6 1/2	4 Turns From Bottom	.39 - .41	170	2	RED

PROCEDURE

- Secure Terminal Ring (Item 2) And Bushing (Item 4) To Coil Form (Item 1) With 9 (GL-104-2) As Shown. Bushing Hole Must Be Kept 180° From Terminal Ring Extension. Do Not Allow Insulex To Form On Terminal Tip or Top End Of Coil Form.
- Bake For 2 Hours At 250° F.
- Using Existing Bushing Pilot Hole, Drill Thru One Side Of Coil Form With #48 (.076) Drill.
- Wind 6-1/2 Turns ~~OF ITEM 3~~ On Coil Form As Shown. Crimp And Solder Wire To Terminal Ring As Shown. Wind In CLOCKWISE DIRECTION.
- Attach Wire, (Item 3) To Bushing Using Screw, (Item 10). Solder Joint With Item 5.
- Solder Tap to Coil As Per Chart And Pictorial.
- Coat Winding With Item 9 (GL-104-2).
- Bake Unit For 2 Hours At 250° F.
- Test Unit As Per Chart And Schematic Using Existing Terminal Leads. (NOTE: Use Boonton Q Meter Model 160 A or Equiv.)
- Cut ~~test~~ Leads Off After Testing.
- Assemble Items 6, 7, 11 and 12.



1	12	NTH2528BN14	NUT, HEX
1	11	LWI25MRN	LOCKWASHER, INTERNAL TOOTH
1	10	SFB0256SN3	SCREW, THREAD CUTTING
X	9	GL-104-2	INSULEX, U-85
2	8	WL-100-7	WIRE, BUSS
1	7	NTH0632BN8	NUT, HEX
1	6	CI-109-10	CORE, TUNING
X	5	BS-100	SOLDER, SOFT
1	4	SM-143-4	BUSHING, COIL FORM
X	3	WL-100-4	WIRE, BUSS
1	2	TE-153-3	TERMINAL, RING TYPE
1	1	CF-124-1.125	COIL, FORM

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	"PROCEDURE" CLARIFIED, REQ. ITEM B WAS ON PICT. BOTTOM TEST LEAD WAS ITEM B TOP TEST LEAD ITEM 3 ADDED	2-1-66	15686	G.D.L.	J.C.S.	[Signature]

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON
 FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°

SCALE: DO NOT 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	SECTION	ASS'Y. NO.	DATE
	GPE-1	R.F. SECTION		7-20-61
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
TT-139 ASS'Y. (TRANSFORMER RF TUNED)			
MATERIAL			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKER
		[Signature]	[Signature]
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
		[Signature]	[Signature]
			A-3022
			A