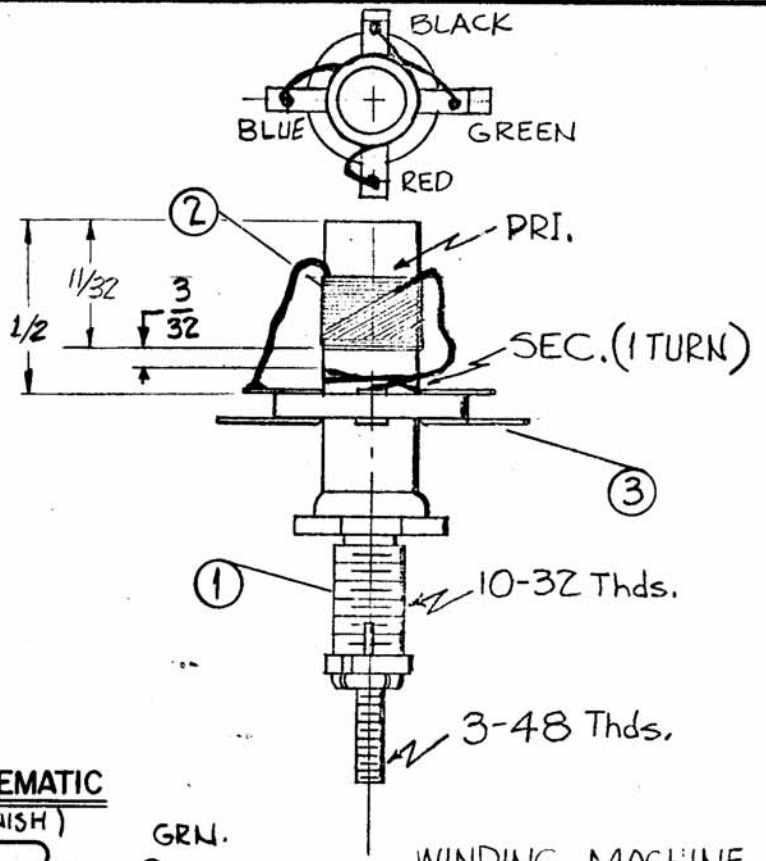
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.

REQ. PER UNIT	USED ON MODEL	ASS'Y. NO.	DATE
1	HFR-1/T	A-2522	6-27-62

A-3040 D



WINDING DATA

1- SECURE TERMINAL COLLAR TO COIL FORM WITH Q-MAX.

2- WIND 19 TURNS ON FORM AS SHOWN FOR PRIMARY.

3- STRIP ENDS SOLDER TO TERMINALS AS SHOWN

4- WIND 1 TURN ON COIL FORM AS SHOWN FOR SECONDARY, CAUTION: OBSERVE 3/32 SPACING BETWEEN PRIMARY & SECONDARY. STAKE WIRE TO FORM WITH Q-MAX.

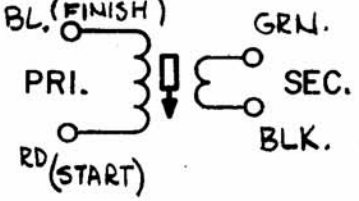
5- STRIP ENDS SOLDER TO TERMINALS

6- BAKE FOR 1/2 HOUR AT 215° F TO REMOVE MOISTURE.

7- COAT COIL WITH Q-MAX AND BAKE FOR 1/2 HOUR AT 215° F.

1)- TEST FREQ - 7.9 MC
2) AT MIN., INDUCTANCE = 2.45 uh ± .12 uh
3)- Q = 32 MIN. (4)- DIST. CAPACITY - APPROX 2.5 uuf (FOR REF. ONLY)

SCHEMATIC



WINDING MACHINE DATA

CAM GEAR 90
DRIVER GEAR 94
CAM .250

	REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	5		BS-100	SOLDER, SOFT	
X	4		GL-102	Q-MAX	
1	3		TE-195	TERMINAL, COLLAR (.265 ID)	
X	2		WI-104-4044-SSP-QS	LITZ, SIZE 40/44	
1	1		CF-134-5E	FORM, COIL	

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
D	"L" WAS 2.45uh ± .04uh	7-27-66	16656	RME		

STOCK SIZE

MATERIAL

TYPE & TEMPER | HEAT TREAT. SPEC.

FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

TT-194 ASS'Y

DRAWN	CHECKED	FINAL APPROVAL
RUZZO		BP

ELEC. DES. APP.	MECH. DES. APP.	
J. ANGER		A-3040 D

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES ON
FRAC. ± 1/64 DEC. ± .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