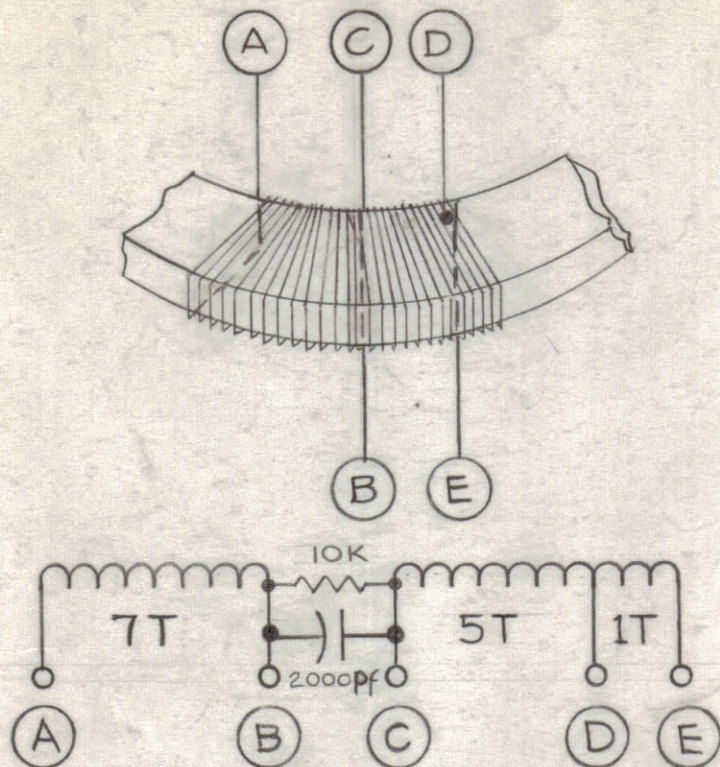


STEP 1 - WINDING INSTRUCTIONS

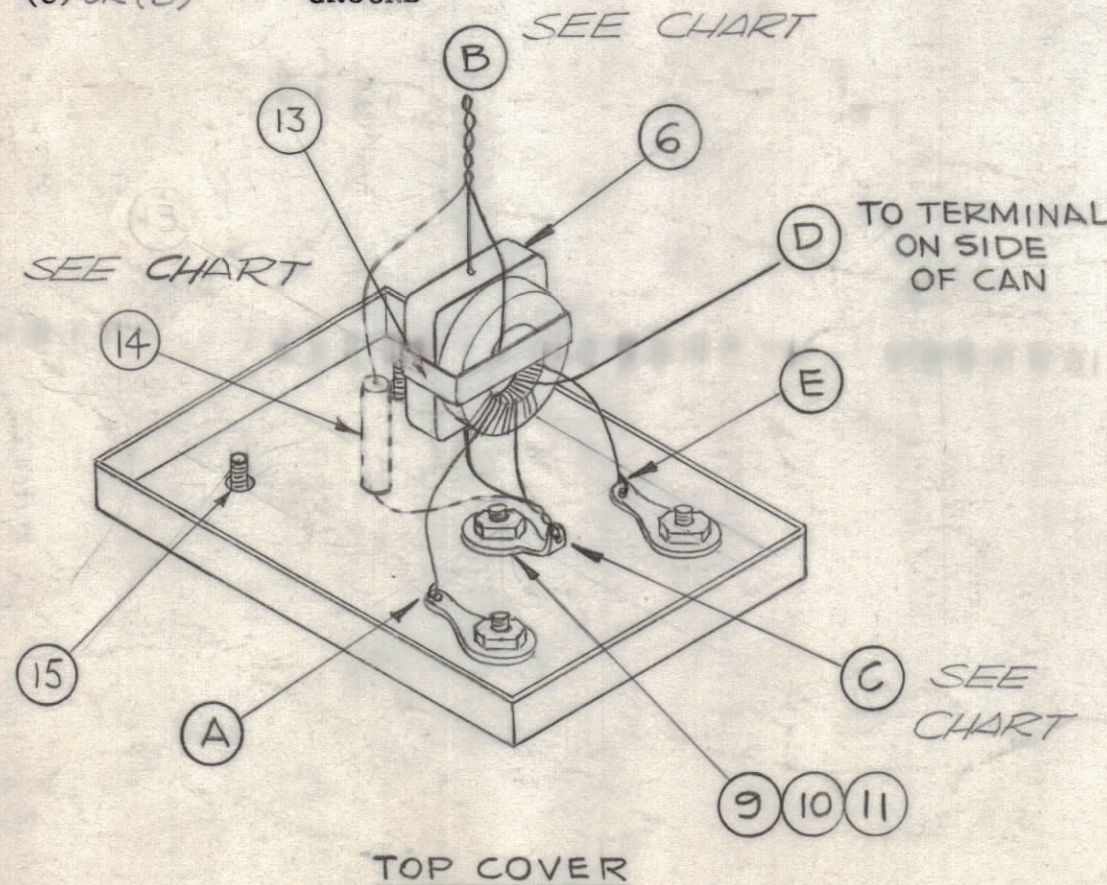


- A. CLOSE WIND AS SHOWN ABOVE, KEEPING WIRE TAUT AND TURNS AS CLOSE TO ONE ANOTHER AS POSSIBLE.
- B. SOLDER LEAD TO TAP "D" USING ITEM 4.
- C. LEAVE ALL LEADS APPROXIMATELY THREE INCHES LONG.
- D. STAKE WINDING AND LEADS TO CORE WITH CEMENT (ITEM 3).

STEP 2 - CONNECTIONS

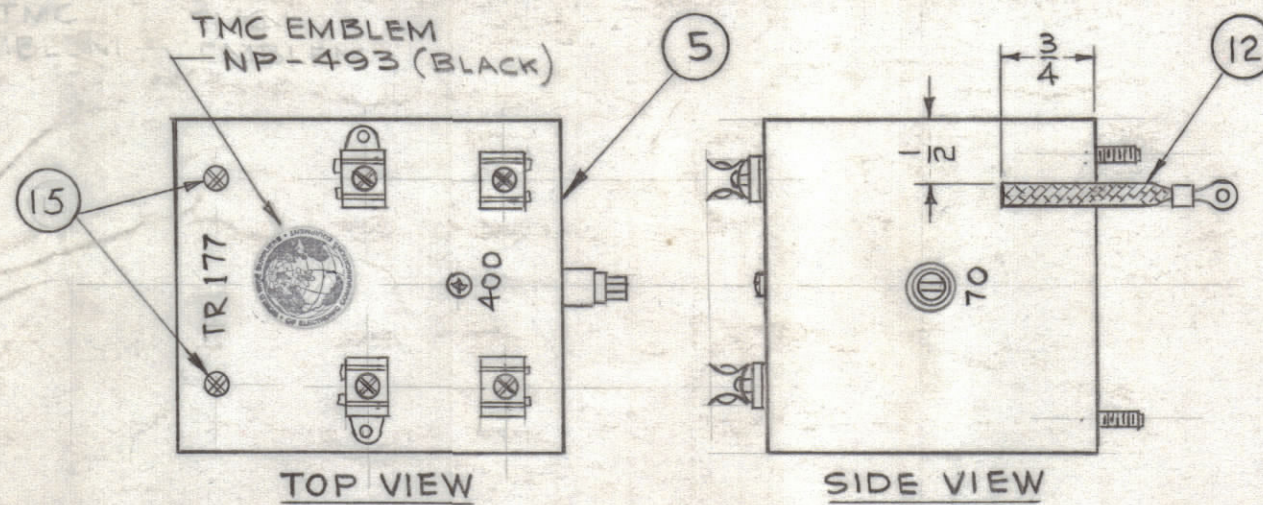
- A. CONNECT AS SHOWN.
- B. KEEP LEADS TO TERMINALS AS SHORT AS POSSIBLE.
- C. SOLDER ALL CONNECTIONS (ITEM 8).
- D. SOLDER ITEM 15 IN PLACE (ITEM 8).
- E. SOLDER TOP COVER IN PLACE (ITEM 8).
- F. SOLDER 70 OHM TAP "D" TO TERMINAL ON SIDE OF CAN.

- (A) AND (E) - 400 OHM TERMINALS
- (D) - 70 OHM TERMINAL
- (C) OR (B) - GROUND



STEP 3 - POTTING AND FINISH

- A. USING GL-127 (ITEM 7), POT UNIT TO WITHIN 3/8" OF BOTTOM.
- B. SOLDER BOTTOM IN PLACE.
- C. SMOOTH ALL SEAMS.
- D. SCRAPE AREA CLEAN AND SOLDER GROUND STRAP (ITEM 12) IN PLACE AS SHOWN.
- E. PRIME CASE WITH S-114 ZINC CHROMATE AND FINISH TOP AND SIDES ONLY WITH S-115 SMOOTH GRAY ENAMEL.
- F. STAMP TOP AND SIDE AS SHOWN WITH 1/8" BLACK GOTHIC. MARKING PROCESS PER T M C SPECIFICATION S-727.



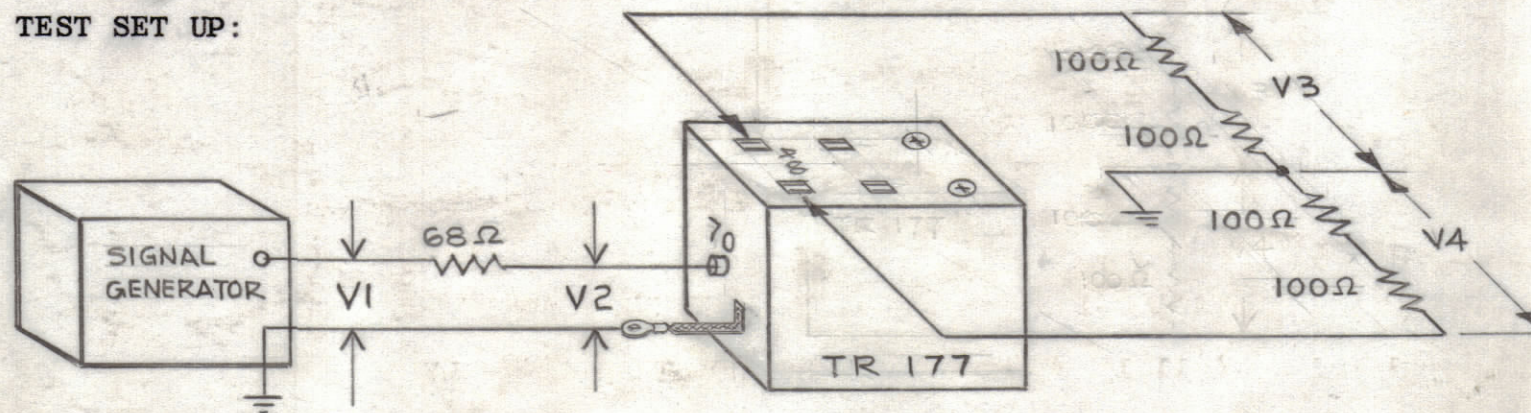
STEP 4 - TEST

TEST EQUIPMENT REQUIRED:

1. ONE RF VTVM (HEWLETT PACKARD MODEL 410-B OR EQUIVALENT).
2. ONE RF GENERATOR (MEASUREMENTS CORPORATION MODEL 82 OR EQUIVALENT).
3. FOUR 100 OHM 1/2 WATT CARBON RESISTORS.
4. ONE 68 OHM 1/2 WATT CARBON RESISTOR.

SET UP EQUIPMENT AS SHOWN BELOW AND RECORD READINGS ON TEST DATA SHEET. READINGS ARE BASED ON POTTED UNIT.

TEST SET UP:



VOLTAGE LIMITS FOR TEST DATA SHEET

| FREQUENCY | RF VOLTS | | | | |
|-----------|----------|-----------|-----------|-----------|----|
| | MC/S | V1 | V2 | V3 | V4 |
| 2 | 1.0 | .405-.495 | .540-.660 | .486-.594 | |
| 8 | 1.0 | .405-.495 | .552-.638 | .477-.583 | |
| 16 | 1.0 | .432-.528 | .495-.605 | .495-.605 | |
| 32 | 1.0 | .486-.594 | .432-.528 | .549-.671 | |

READINGS OF TYPICAL TRANSFORMER

| FREQUENCY | RF VOLTS | | | | |
|-----------|----------|-----|-----|-----|----|
| | MC/S | V1 | V2 | V3 | V4 |
| 2 | 1.0 | .46 | .60 | .54 | |
| 8 | 1.0 | .45 | .58 | .53 | |
| 16 | 1.0 | .48 | .55 | .58 | |
| 32 | 1.0 | .54 | .48 | .62 | |

NOT TO BE RELEASED W/O AUTHORIZATION

AUTH. BY: _____
DATE: _____

NOTES

NOTICE TO PERSONS RECEIVING THIS DRAWING

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MAMARONECK, NEW YORK

REVISIONS

| ZONE | SYM | DESCRIPTION | DATE | E.M.N. NO. | DRAFT | CHKD | APPD |
|------|-----|---|----------|------------|-------|------|------|
| A | | IT.12 WAS A-1151, IT.14 ADDED | 7.6.64 | 11677 | ASB | @ | AMM |
| B | | IT.15 ADDED TO B/M, STEPS 2 & 3 & PICT. STEP (1) SCH., 2000 Pf. WAS 2000mf. STEP (2) "E" WAS "D"; "F" WAS "E"; "D" ADDED. | 11.19.64 | 12960 | SP | JL | AMM |
| C | | IT. NO. 4 WAS WI-100-9 | 12.29.64 | 15418 | RVA | SP | AMM |
| D | | SHOW IT. 14 AS DOTTED LINE ADD CHT. | 5.4.70 | 19838 | GE | JL | AMM |

| TMC P/N | ITEM 14 | GROUND |
|----------|--------------|--------|
| TR 177 | RC 20 GF103T | TERM C |
| TR 177-2 | N/A | " B |

| REQ'D. | ITEM | PART NUMBER | DESCRIPTION | SYMBOL |
|--------|------|---------------|------------------------------|--------|
| 2 | 15 | SCBPI032BN3 | SCREW, MACHINE | |
| 1 | 14 | SEE CHART | RESISTOR, FIXED, COMPOSITION | |
| X | 13 | TA-100-1 | TAPE, VINYL PLASTIC | |
| 1 | 12 | CA409-88-2.25 | GROUND STRAP ASSEMBLY | |
| 1 | 11 | TE-104-1 | LUG, LOCKING | |
| 1 | 10 | NTH0440BN6 | NUT, HEX | |
| 1 | 9 | SCBP0440BN4 | SCREW, MACHINE | |
| X | 8 | BS-100 | SOLDER, SOFT | |
| X | 7 | GL-127 | COMPOUND, POTTING | |
| 1 | 6 | CM35C202J | CAPACITOR, FIXED | |
| 1 | 5 | BX-202 | CASE AND COVERS | |
| X | 4 | WL-100-9 | WIRE, TINNED, #26 | |
| X | 3 | GL-103 | CEMENT | |
| X | 2 | WI-102-7-9 | WIRE #26 COTENAMEL | |
| 1 | 1 | CI-104 | CORE, TOROIDAL | |

| PRITCHARD LIST OF MATERIAL | | THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK | |
|---|--------------------|---|----------------|
| MATERIAL | TITLE | TRANSFORMER ASSEMBLY, TR-177 | |
| FINISH | DATE | FINAL APPROVAL | DATE |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES | DRAWN: <i>WJ</i> | DATE: 12-19-63 | DATE: 12-19-63 |
| DECIMALS: .X ± .05, .XX ± .01, .XXX ± .005 | CHECKED: <i>HQ</i> | DATE: 12-19-63 | DATE: 12-19-63 |
| FRACTIONS: ± 1/64, ANGLES: ± 0° 30' | ELECT. DES. | DATE | DATE |
| TOLERANCES | MECH. DES. | DATE | DATE |
| | | A-3110 | D |
| | | SHEET | REV. LTR. |