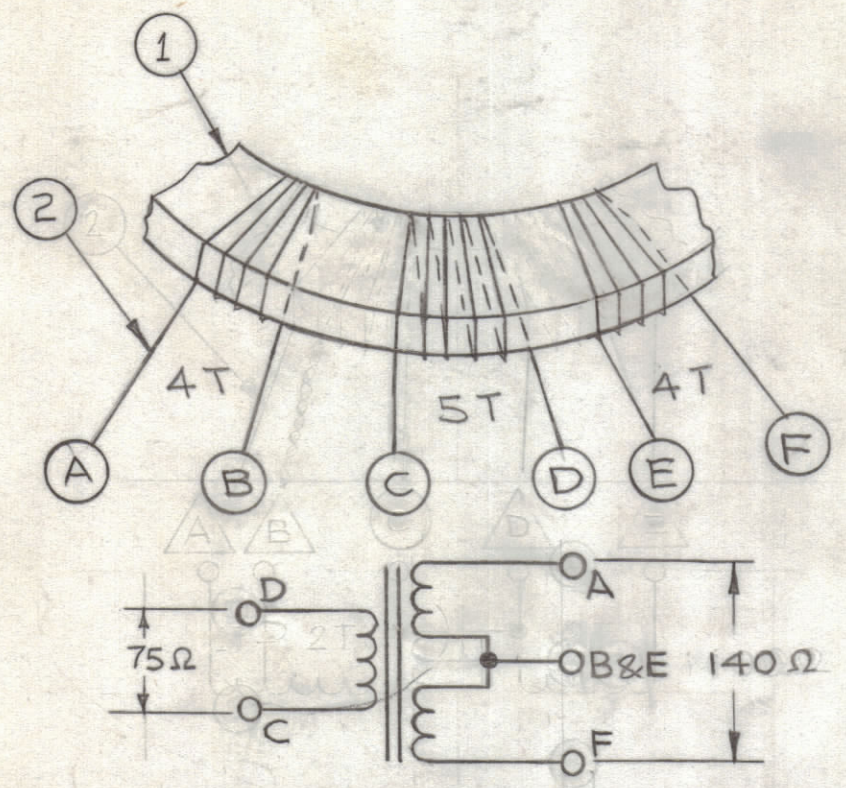


REVISIONS							
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD

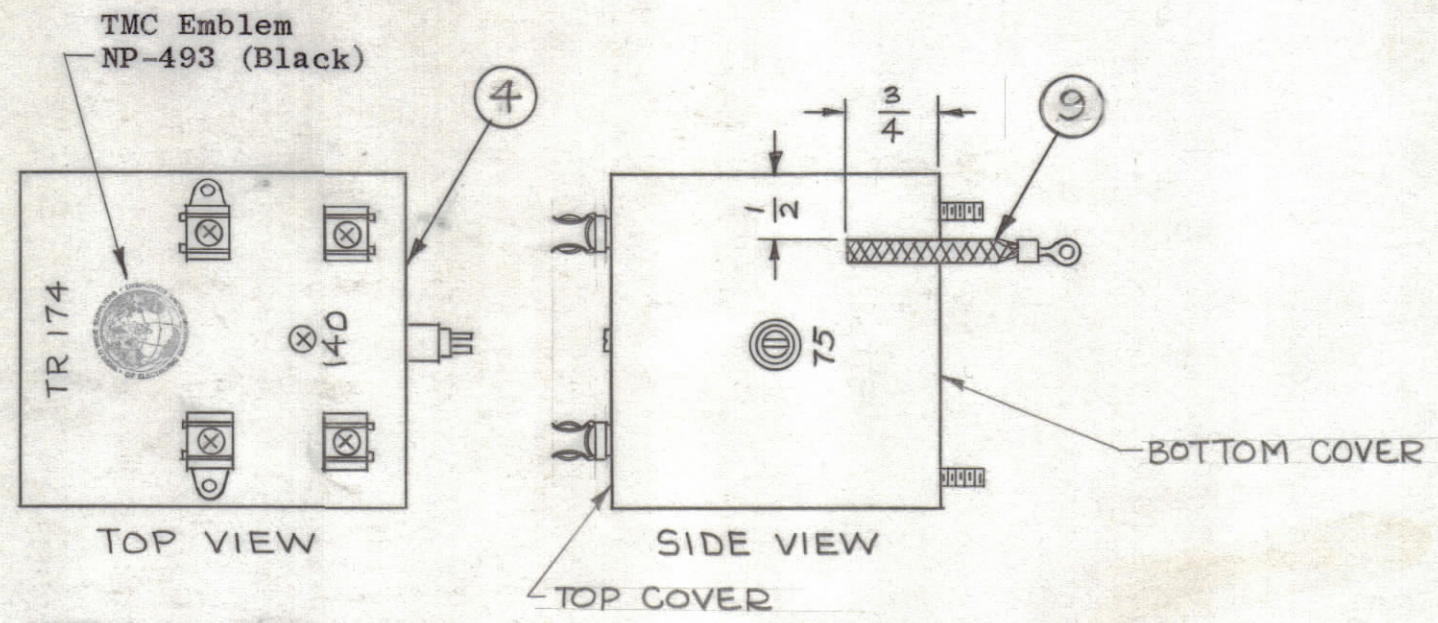
STEP 1 - WINDING INSTRUCTIONS

STEP 3 - POTTING AND FINISH

- A. Using GL-127 (Item 5), pot to within 3/8" of bottom.
- B. After curing, solder bottom in place with BS-100 (Item 6).
- C. Smooth All Seams.
- D. Scrape area clean and solder A-1473BN2.50 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 TMC specification S-727.



- A. Close wind as shown above, keeping wire taut and turns as close to one another as possible.
- B. Leave all leads two inches long.
- C. Coat coil with GL-104-2 (Item 3) and allow to dry.

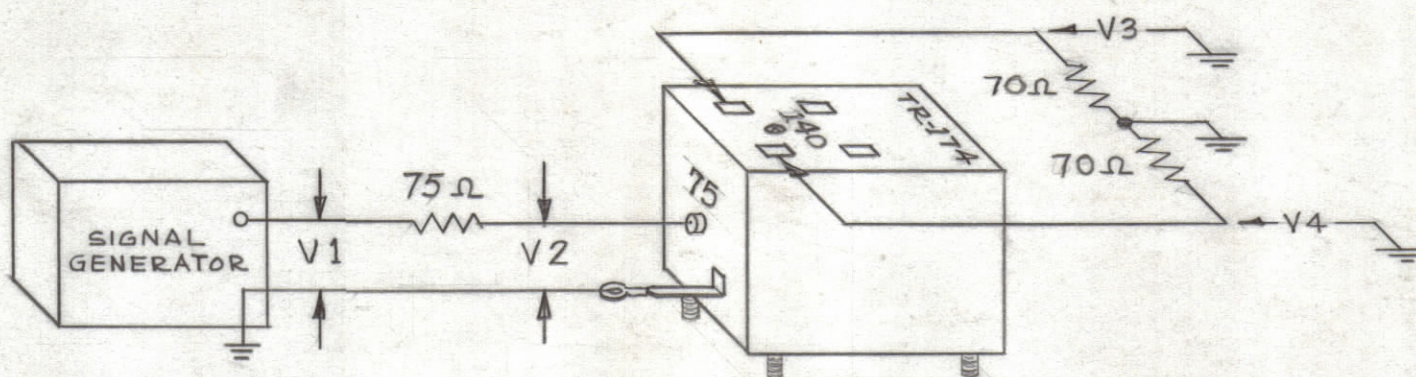


STEP 4 - TEST

- A. One R.F. VTVM (Hewlett Packard Model 410-B or equivalent).
- B. One R.F. Generator (Measurements Corporation Model 82 or equivalent).
- C. Two 70 Ohm 1/2 Watt Carbon Resistors.
- D. One 75 Ohm 1/2 Watt Carbon Resistor.

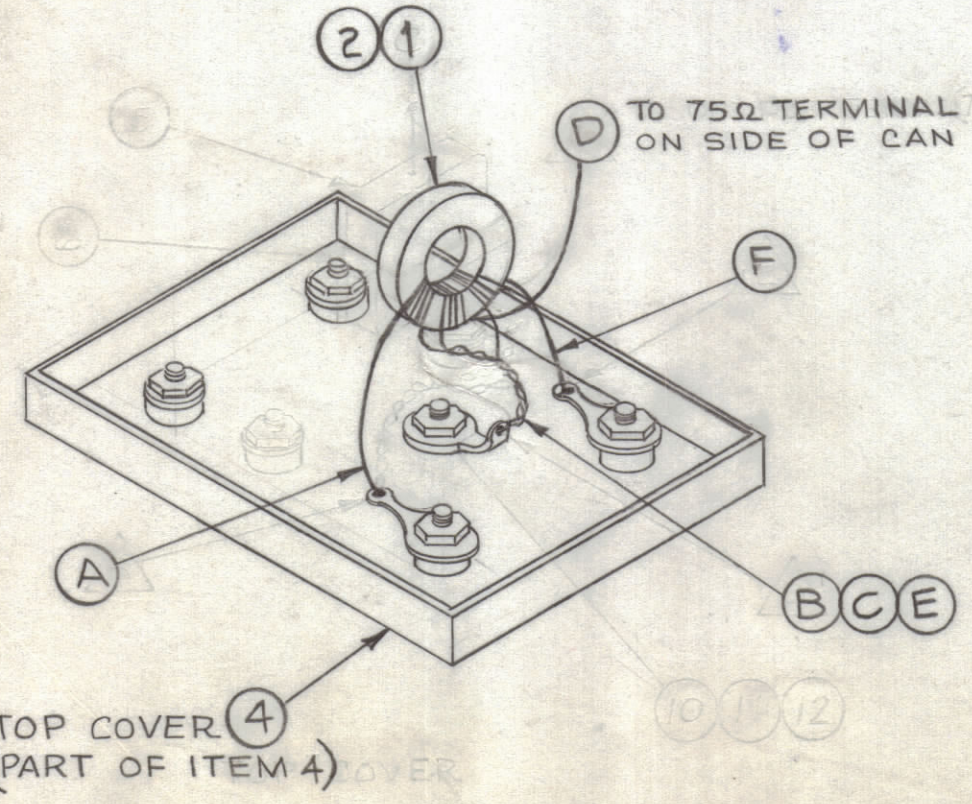
Set up equipment as shown below and record readings on Test Data Sheets. Readings are based on potted units. Readings for V2, V3 and V4 should fall between limits given.

TEST SET-UP



STEP 2 - CONNECTIONS

- A. Strip and tin leads. Solder "A" and "F" to 140 ohm terminals and "B," "C" and "E" to SCBP 0440 BN4 (Item 7) with BS-100 (Item 6) keeping coil approximately centered in the can.
- B. Place body of can in place and solder "D" to terminal on side of can with BS-100 (Item 6).
- C. Solder top cover in place with BS-100 (Item 6).



FREQUENCY	R.F. VOLTS (+10% TOLERANCE)				
	mc/s	V1	V2	V3	V4
4	1.0	.378-.462	.279-.341	.279-.341	
8	1.0	.378-.462	.270-.330	.270-.330	
15	1.0	.414-.506	.252-.308	.252-.308	

Readings from Prototype Potted Unit are given

FREQUENCY	R.F. VOLTS				
	mc/s	V1	V2	V3	V4
4	1.0	.38	.31		
8	1.0	.42	.30		
15	1.0	.46	.28		

NOT TO BE RELEASED W/O AUTHORIZATION
 AUTH. BY: _____
 DATE: 30 _____

NOTES

1	RAC-42	AX-381
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	

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REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
1	9	A-1473BN2.50	GROUND STRAP ASSEMBLY	
1	8	NTH0440BN6	NUT, HEX	
1	7	SCBP0440BN4	SCREW, MACHINE	
X	6	BS-100	SOLDER, SOFT	
X	5	GL-127	COMPOUND, POTTING	
1	4	BX-202	CASE AND COVER ASSEMBLY	
X	3	GL-104-2	RESIN, SYNTHETIC	
X	2	WI-102-7-9	MAGNET WIRE, #26 DCC	
1	1	CI-104	CORE, TOROIDAL	

STEIN		LIST OF MATERIAL	
MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH		TITLE TRANSFORMER ASSY TR-174	
DRAWN M J TANTILLO	DATE 4-3-63	FINAL APPROVAL BP	DATE
CHECKED	DATE 5-15-63		
ELECT. DES.	DATE	A-3142	
MECH. DES.	DATE 5/19/63	SHEET	REV. LTR.

A-3142