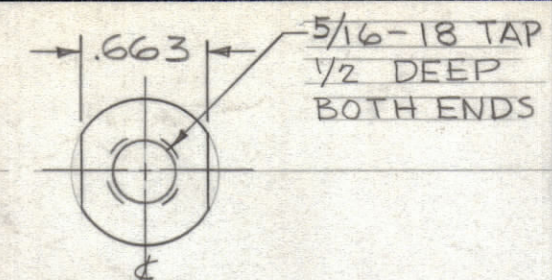


**COIL FORM JIG**

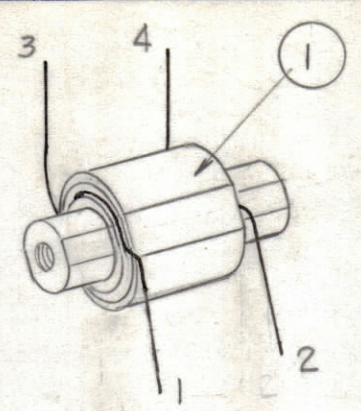
NOTE: COIL FORM JIG FOR WINDING TR-181 TRANSFORMER ONLY.

MATERIAL: PHENOLIC ROD .771 DIA.

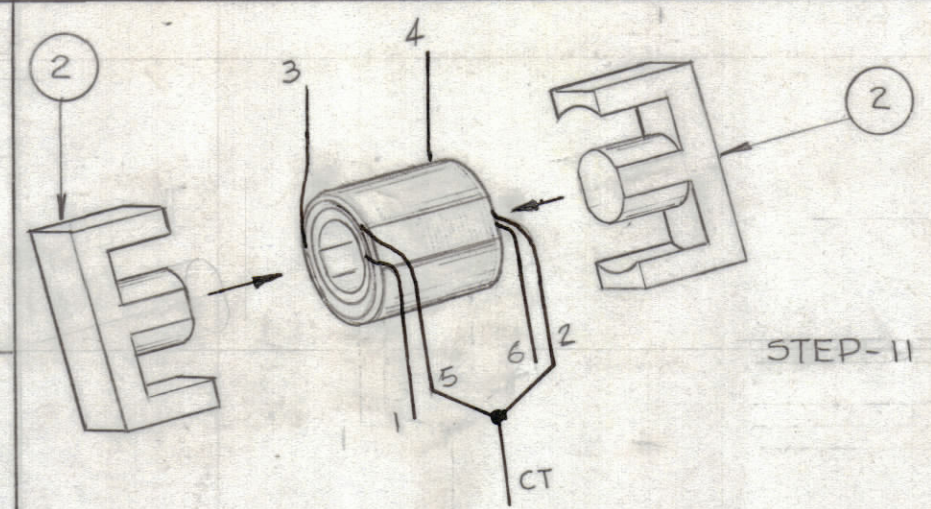


SCALE: 1:1

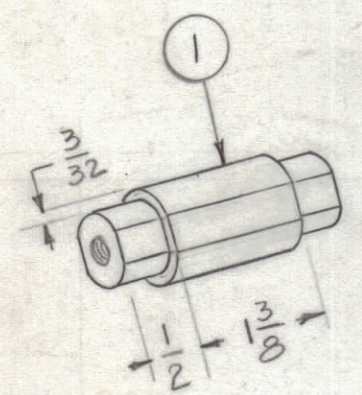
REVISIONS							
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD.
-	A	DWG UPDATED & CHANGED PER EMN. NO. 10197	10/1/63	10197			



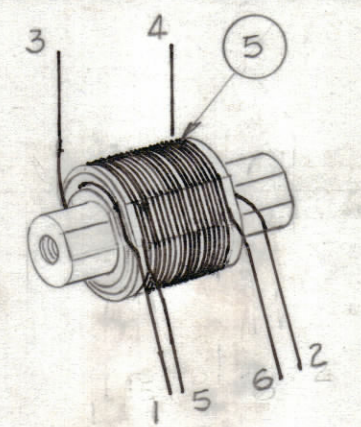
STEP-5 WRAP WINDING WITH MYLAR PAPER (ITEM 1) TO 3/32 THK. IN STEP-4



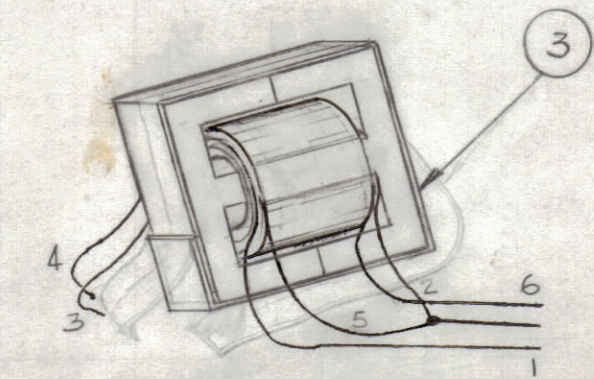
STEP-11 PLACE MATING CORE (ITEM 2), ON WINDING. FINISHED SURFACES OF CORES MUST BE FREE OF FOREIGN MATERIALS & FLUSH TO EACH OTHER



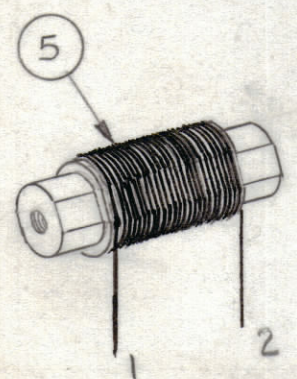
STEP-1 WRAP CENTER OF FORM WITH WRAP MYLAR PAPER (ITEM 1) TO 3/32 THICKNESS.



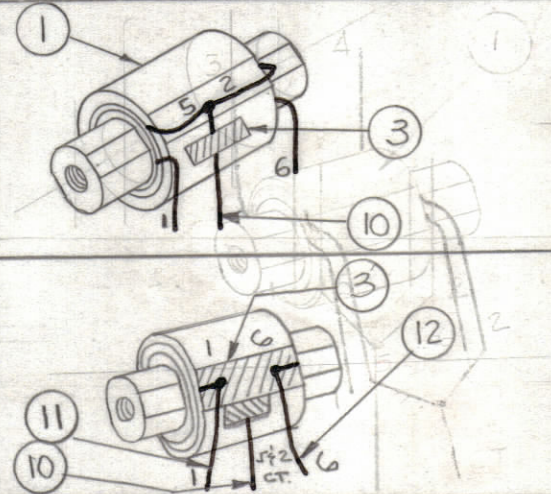
STEP-6 CLOSE WIND 200 TURNS OF #36 FORM VAR WIRE (ITEM 5) BRING LEAD OUT SAME SIDE AS LEADS OF FIRST WINDING. COAT WINDING WITH INSULEX U-35 (ITEM 9). WRAP WINDING WITH MYLAR PAPER (ITEM 1) TO 3/32 THKNESS.



STEP-12 HOLD WHOLE ASSY WITH FIBREGLASS TAPE (ITEM 3) BAKE FOR 1/2 HOUR AT 215°F. AND IMMEDIATELY PROCEED TO NEXT STEP



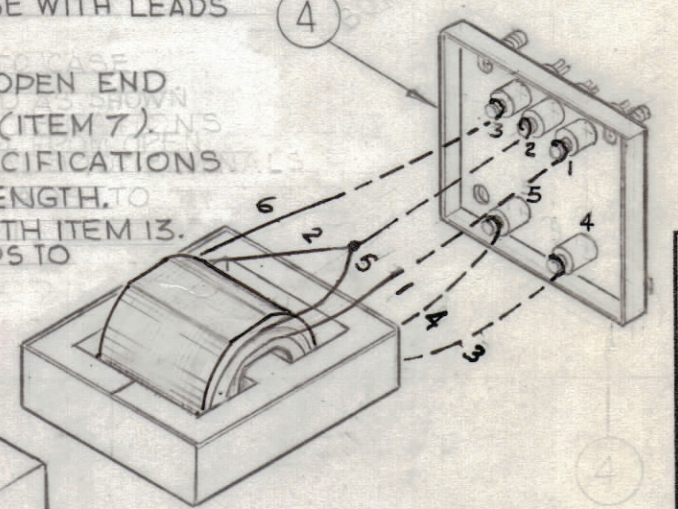
STEP-2 CLOSE WIND 200 TURNS OF #36 FORM VAR WIRE (ITEM 5) COAT WINDING WITH INSULEX U-35 (ITEM 9)



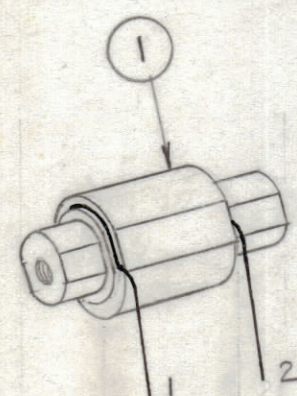
STEP-7 CONNECT LEAD #5 TO LEAD #2. SOLDER A SIX INCH LENGTH OF ITEM 10 TO LEADS #5 & #2. SECURE ITEM 10 WITH ITEM 3. INSULATE CONNECTION WITH ADDITIONAL PIECE OF ITEM 3

STEP-8 & 9 SOLDER SIX INCH LENGTH OF ITEM 11 TO LEAD #1 AND SECURE CONNECTION AS IN STEP-7. CONNECT TWO INCH LENGTH OF ITEM 12 TO LEAD #6 AND SECURE AS IN STEP-7.

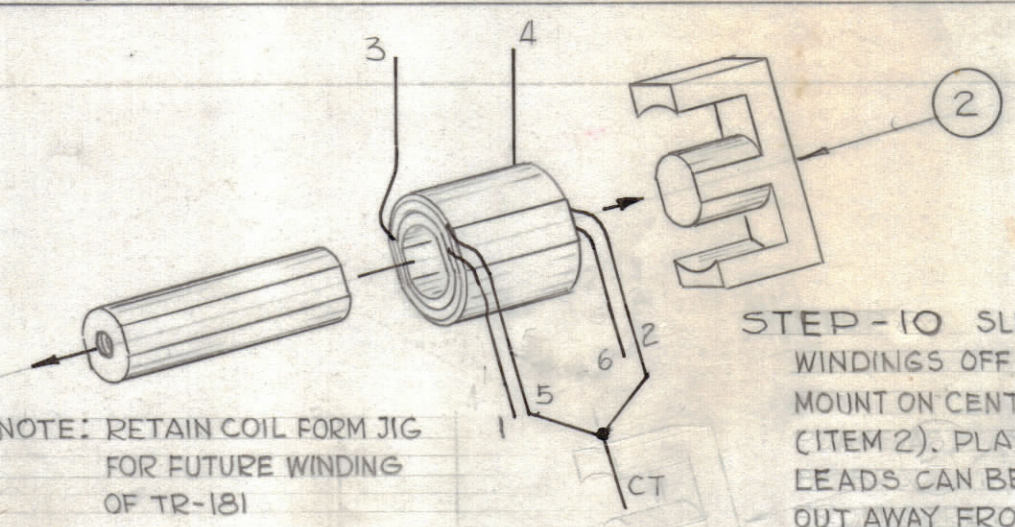
STEP-13 INSERT FISH PAPER (ITEM 8) INTO CASE. INSERT COIL ASSY INTO CASE WITH LEADS EXTENDED AS SHOWN. FILL CASE WITH 1/4" FROM OPEN END WITH POTTING COMPOUND (ITEM 7). CURE AS PER GL-113 SPECIFICATIONS. TRIM LEADS TO CORRECT LENGTH. INSULATE LEADS WITH ITEM 13. CONNECT & SOLDER LEADS TO TERMINALS AS PER CHART.



LEADS No	TERM. No
1	1
2 & 5	2
6	3
3	4
4	5

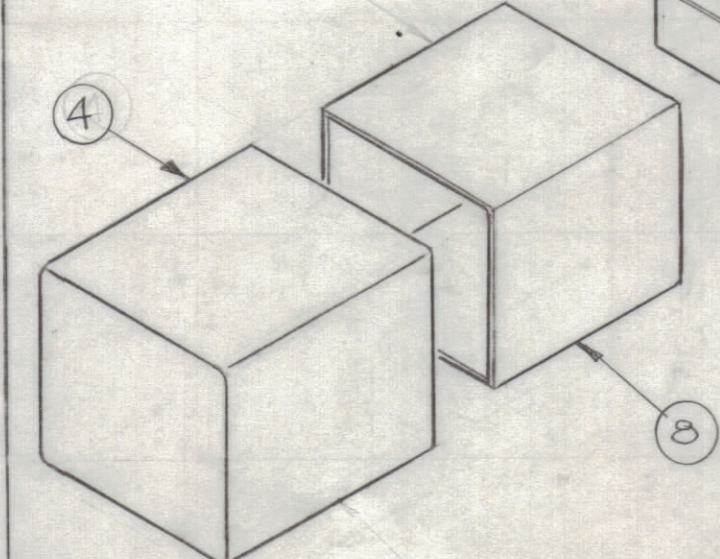


STEP-3 WRAP WINDING WITH MYLAR PAPER (ITEM 1) TO 3/32 THK. IN STEP-1

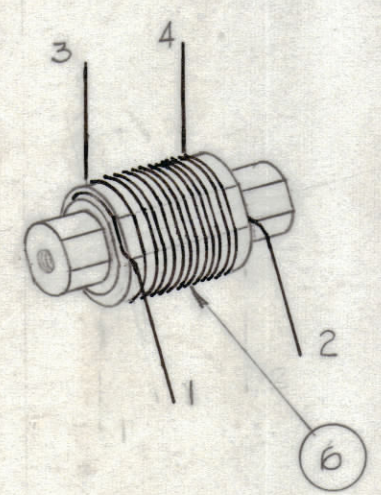


STEP-10 SLIP COMPLETED WINDINGS OFF FORM AND MOUNT ON CENTER OF CORE (ITEM 2). PLACE ASSY SO LEADS CAN BE BROUGHT OUT AWAY FROM CORE.

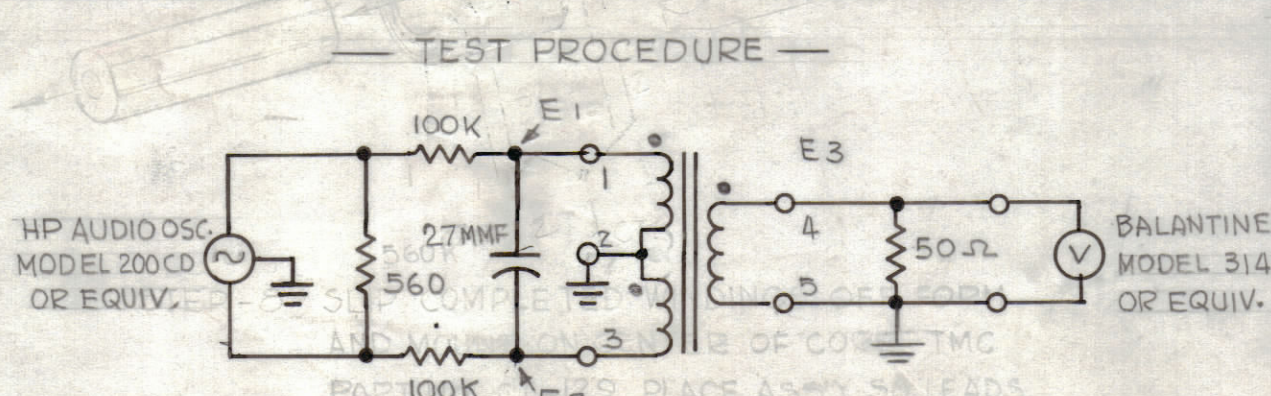
NOTE: RETAIN COIL FORM JIG FOR FUTURE WINDING OF TR-181



INSERT BOTTOM OF CAN TO CASE & SOLDER



STEP-4 CLOSE WIND 28 TURNS OF #24 FORM VAR WIRE (ITEM 6) AND BRING LEADS OUT 180° FROM LEADS OF FIRST WINDING. COAT WINDING WITH INSULEX U-35 (ITEM 9).



TEST PROCEDURE

1- USE BALANCED OUTPUT OF AUDIO OSC. E1 SHOULD EQUAL E2 FOR ALL FREQ. E3 OUTPUT VOLTAGE SHOULD EQUAL 1/7 OF E1 OR E2.  
2- FREQUENCY RANGE: 5 KC TO 600 KC  
300 KC. 3DB DOWN AT 1 FLAT ± 1.5 db AT 600 KC

NOT TO BE RELEASED W/O AUTHORIZATION

AUTH. BY: 2 OF 2 FOR TEST PROCEDURE  
DATE:

NOTES

Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
1	LFA-4	
SCALE: 1:2		

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
	13	PX-104-1-034	INSULATION SLEEVING	
	12	MWC-22 (7) U0	WIRE, STRANDED	BLK
	11	MWC-22 (7) U5	WIRE, STRANDED	GRN
	10	MWC-22 (7) U6	WIRE, STRANDED	BLU
X	9	GL-104-4	INSULEX, U-35	
X	8	IM-179-8	FISH PAPER	
X	7	GL-113	POTTING COMPOUND	
X	6	WI-122-24	#24 FORM VAR WIRE	
X	5	WI-122-36	#36 FORM VAR WIRE	
1	4	BX-207	CASE & COVER TRANSFORMER	
X	3	TA-101-2	FIBREGLASS TAPE	
2	2	CI-129	CORE, TRANSFORMER	
X	1	IM-215	MYLAR PAPER	

LIST OF MATERIAL			
MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
FINISH	TITLE TR-181 ASSEMBLY		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN: G.D.L.	DATE: 5-28-63
DECIMALS: .X ± .05, .XX ± .01, .XXX ± .005		CHECKED: H.D.	DATE: 6-11-63
FRACTIONS: ± 1/64, ANGLES: ± 0° 30'		ELECT. DES.:	DATE:
TOLERANCES:		MECH. DES.:	DATE:
		FINAL APPROVAL: YFH	
		DATE: 6-14-63	
		SHEET: A-3170	
		REV. LTR.:	