

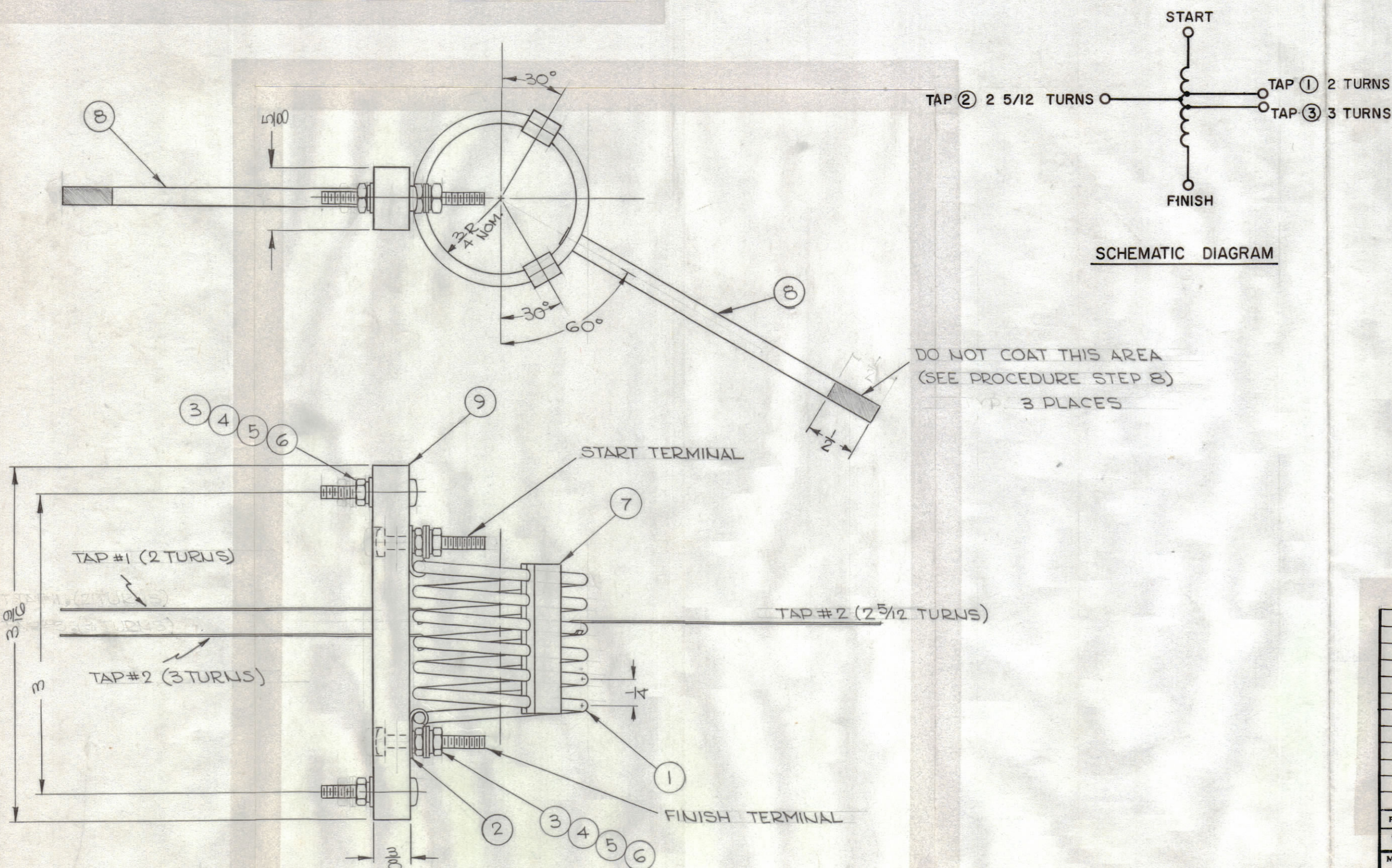
WINDING PROCEDURE

1. OBTAIN A CYLINDER OF SOME HARD MATERIAL SUCH AS ALUMINUM OR PHENOLIC, 1 1/2 INCHES IN DIAMETER AND AT LEAST 3 INCHES LONG.
2. LEFT HAND WIND 6 TURNS OF ITEM 1, SPACED 1/4 INCH APART, AROUND THE CYLINDRICAL FORM.
3. REMOVE THE INSULATION 1/2 INCH BACK FROM THE START AND FINISH ENDS AND SOLDER ITEM 2 AT EACH END.
4. MOUNT THE COIL ON ITEM 9 AND MARK AT 2, 2 5/12 AND 3 TURNS. REMOVE COIL AFTER MARKING.
5. REMOVE INSULATION 1/8 INCH EACH SIDE OF 2, 2 5/12 AND 3 TURNS. THE INSULATION SHOULD BE REMOVED FROM THE ENTIRE WIRE CIRCUMFERENCE WITHIN THE 1/4 INCH AREA AT THE TURNS SPECIFIED.
6. WRAP ONE END OF ITEM 8 AROUND ITEM 1 AT THE CENTER OF THE INSULATION FREE AREA AT 2 TURNS AND SOLDER IN PLACE. MAKE SURE THE SOLDER FLOWS FREELY BETWEEN THE STRAP (ITEM 8) AND COIL.
7. REPEAT STEP 6 AT 3 TURNS AND THEN AT 2 5/12 TURNS.
8. COAT THE ENTIRE SURFACE OF ITEM 8 EXCEPT FOR 1/2 INCH FROM UNSOLDERED END WITH ITEM 12. COAT SOLDER JOINTS WITH ITEM 12 BUT NOT THE SCREW MOUNTING SURFACE OF ITEM 2 AT THE START AND FINISH ENDS OF COIL.
9. MOUNT THE COIL TO ITEM 9 USING THE HARDWARE AS INDICATED. BE CAREFUL TO ALIGN THE STRAPS AT 2 AND 3 TURNS WITH THE CLEARANCE HOLES AND FEED THE STRAPS THROUGH THE HOLES BEFORE MOUNTING.
10. INSTALL THE COIL SPACING INSULATORS, ITEM 7, WITH THE HOLE SIDES BACK-TO-BACK TO PROVIDE TWO SUPPORT BARS AT THE LOCATIONS SHOWN IN THE DIAGRAM. CEMENT THE BACK-TO-BACK INSULATORS TOGETHER AND TO THE COIL WITH ITEM 10.
11. MOUNT ADDITIONAL HARDWARE AND BAKE FOR 2 HOURS AT 85°C.
12. TEST AS INDICATED IN SPECIFICATIONS. MAINTAIN THE SHORTEST POSSIBLE LEAD LENGTH BETWEEN THE COIL AND "Q"-METER.

REVISIONS					
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT
F6	A	ON SPECS. #2, 280 WAS 375	11.17.64	12948	AKB

SPECIFICATIONS

1. TOTAL INDUCTANCE (START TO FINISH): 1.21 uhy ± .12 uhy
2. "Q" AT TEST FREQUENCY: GREATER THAN 280
3. TEST FREQUENCY: 7.9 MC
4. ALL MEASUREMENTS TAKEN USING BOONTON 260A "Q" METER



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	12	GL-104-2	ADHESIVE, U85	
X	11	BS-100	SOLDER, SOFT	
X	10	GL-130	ADHESIVE, Q-DOPE	
1	9	PX-833	SUPPORT, COIL	
3	8	MS-2495-1-3,75	LEAD, ELECTRICAL	
4	7	PX-832	INSULATOR, COIL SPACING	
6	6	NTH0632BN8	NUT, HEXAGONAL	
6	5	FW06HBN	WASHER, FLAT	
4	4	LW106MRN	WASHER, LOCK, INTERNAL	
4	3	SCBP0632BN14	SCREW, MACHINE	
2	2	TE-116-2	TERMINAL LUG	
X	1	WI-122-8	WIRE ELECTRICAL, MAGNET; SIZE 8	

LIST OF MATERIAL			
MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH		TITLE TZ-123 ASSY TRANSFORMER, R.F., P.A., IG-32 MC	
DRAWN <i>Chiu</i>	DATE 10-23-63	FINAL APPROVAL <i>BP</i>	DATE
CHECKED <i>AKB</i>	DATE 11/6/63		
ELECT. DES. RKOHN	DATE 11-7-63	A-3210	A
MECH. DES. RKOHN	DATE 11-7-63	SHEET	REV. LTR.

1	TTRA-4	A-2715
Q'TY./UNIT	MODEL USED ON	ASSY. NO.
DO NOT SCALE	CODE A	S401-47

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NOTES

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