

STEP 1.
 PART 1 - CUP CORE ITEM ①, NOTCHES TO BE LOCATED AS SHOWN.
 PART 2 - CUP CORE ITEM ①, NOTCHES TO BE LOCATED 90° FROM TERMINAL LUG ITEM ③

1- CEMENT TERMINAL LUG ITEM ③ TO CUP CORE ITEM ① WITH CEMENT, ITEM ②. NOTCHES ON ITEM ① TO BE LOCATED IN POSITION SHOWN.
 2- ALLOW ITEM ② TO DRY FIRMLY.

STEP 2.

1- WIND 68 TURNS OF ITEM ⑤ ON ITEM ④ AS SHOWN
 2- STAKE START AND FINISH OF WINDING WITH DUCO CEMENT ITEM ⑥.
 3- TRIM LEADS TO APPROX. 1 INCH IN LENGTH.
 4- CHECK L AND Q.

STEP 3.

1- WIND 5 TURNS (BIFILAR) OF WIRE ITEMS ⑦ AND ⑧ ON STEP 2 ASSEMBLY, WITH START AND FINISH LOCATED APPROX. 90° FROM CENTER OF LEADS OF STEP 2 WINDING.
 2- STAKE START AND FINISH LEADS WITH DUCO CEMENT ITEM ⑥.
 3- TRIM LEADS TO APPROX. 3" IN LENGTH.

STEP 4.

1- TWIST START GREEN LEAD OF ITEM ⑦ AND FINISH RED LEAD OF ITEM ⑧ TOGETHER AND SOLDER. BRING OUT AS CENTER TAP, IN APPROX. THE CENTER OF COIL LENGTH AS SHOWN.
 2- CHECK L AND Q.
 3- CUT LEADS 1 1/4" LONG. STRIP & TIN 1/2" FROM END.

STEP 5.

1- COAT STEP 4 ASSY WITH Q DOPE ITEM ⑨ ON OUTSIDE OF WINDINGS, AND PLACE INSIDE STEP 1, PART 2 ASSY. TAKE CARE TO KEEP SURFACE "X" FREE OF ITEM ⑨.
 2- STEP 4 LEADS TO BE LOCATED AT SIDE NOTCH OF STEP 1 PART 2 ASSY, WITH STEP 2 LEADS AT THE BOTTOM IN CENTER OF COIL OPPOSITE STEP 1 TERMINAL LUG.
 3- BAKE FOR 20 MINUTES AT 150° F.

STEP 6.

1- COAT STEP 1 ASSEMBLY SURFACE "X" WITH ITEM ②.
 2- LINE UP LUGS ON STEP 1 AND STEP 3 ASSEMBLIES AND IMMEDIATELY JOIN BOTH ASSEMBLIES TOGETHER.
 3- CEMENT ITEM ⑩ FLUSH AGAINST LUGS ON STEP 1 ASSY WITH ITEM ②.
 4- CEMENT ITEM ⑪ OVER ITEM ④ FLUSH AGAINST ITEM ⑩ WITH ITEM ②.

STEP 7.

1- SOLDER START AND FINISH LEADS TO LUGS WITH ITEM ⑫ AS SHOWN.
 2- REMOVE, USING RAZOR BLADE APPROX. 3/32" FROM EACH END OF ITEM ④.
 3- CLEAN INSIDE THREADS OF ITEM ④ WITH NO. 8-32 NC-2 TAP.
 4- THREAD ITEM ⑬ IN PLACE.

REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD
+	X	OR ORIGINAL RELEASE FOR PRODUCTION	7-27-64	Φ	G.D.L.	
#	A	STEP 4, NOTE #1 REVISED, NOTE #3 ADD.	12-11-64	13106	g.f.	
	B	INDUCTANCE NOTE ADDED	5-14-65	14086	QL	JL
	C	WI 104-541-50QS WAS - SCP-QS	8/1/65	14572	H.V.V.	

PRI.	SEC. (S.T. BIFILAR)	INDUCTANCE *	'Q'	D.C. RESISTANCE	FREQUENCY
68	10	14.2 mh ± 10%	50	1.2-1.4	2.5 MC

*NOTE:
 INDUCTANCE MEASURED BEFORE WINDING IS PLACED IN CUP CORE OR FERRITE SLUG INSERTED.

STEP: 8
 A - MACHINE SET UP FOR WINDING, SHOWN IN CHART BELOW.

CAM	GEARS	
	FRONT	REAR
.250	DR. #88	DR. #81
	DN. #44	DN. #83

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
1	13	CI 121-2	CORE, THREADED, FERRITE	
X	12	BS 100	SOLDER, SOFT	
2	11	CF 130-1	FORM, COIL	
2	10	WA 109-51	WASHER, FIBER	
X	9	GL 130	CEMENT, "Q" DOPE	
X	8	WI 141-34-2	WIRE, MAGNET, ELECTRICAL RED	
X	7	WI 141-34-5	WIRE, MAGNET, ELECTRICAL GRN	
X	6	GL 103	DUCO CEMENT	
X	5	WI 104-541-50QS	WIRE, LITZ	
1	4	CF 132-1.000-M-0832	FORM, COIL	
2	3	TE 201	TERMINAL LUG	
X	2	GL 129	CEMENT,	
2	1	CI 134-Q1-B	CORE, CUP	

M. GELLMAN LIST OF MATERIAL

THE TECHNICAL MATERIEL CORP.
 MAMARONECK, NEW YORK

TITLE: TT 200 ASSEMBLY

DRAWN: <i>G. Green</i>	DATE: 10-25-63	FINAL APPROVAL: <i>Rie</i>	DATE:
CHECKED: <i>Q</i>	DATE: 7-29-64		
ELECT. DES.:	DATE:	A 3361	
MECH. DES.:	DATE:	SHEET:	REV. LTR.

QTY./UNIT		LFS-1		ASSY. NO.
SCALE: NONE	MODEL USED ON: A			
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NOTES

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