

STEP 1:

1-WIND 30 TURNS (BIFILAR) OF ITEMS ④ & ⑤ ON ITEM ①.
 2-STAKE WINDING WITH DUCO CEMENT ITEM ⑨.
 3-WRAP WINDING WITH ONE LAYER OF ITEM ⑦.
 4-TAG STARTS & FINISHES OF WINDING.

STEP 2:

1-WIND 3 TURNS (BIFILAR) OF ITEMS ④ & ⑤ ON STEP-1 ASSY.
 2-STAKE WINDING WITH DUCO CEMENT ITEM ⑨.
 3-WRAP WINDING WITH ONE LAYER OF ITEM ⑦.
 4-TAG STARTS & FINISHES OF WINDING.

STEP 3:

1-WIND 400 TURNS OF ITEM ⑥ ON STEP-2 ASSY, STRIP & TIN ENDS 1/2" & TAG START OF WINDING
 2-STAKE WINDING WITH DUCO CEMENT ITEM ⑨
 3-BAKE FOR 20 MINUTES AT 150° F.
 4-COAT THOROUGHLY WITH ITEM ⑧.

STEP 4:

1-TIE TOGETHER RED (START) & GRN (FINISH) OF 30 TURN WINDING. THIS IS THE CENTER TAP.
 2-TAG REMAINING GRN LEAD (START 30 TURNS).
 3-TIE TOGETHER RED (START) & GRN (FINISH) OF 4 TURN WINDING. THIS IS THE CENTER TAP.
 4-TAG REMAINING GRN LEAD (START 4 TURNS).

STEP 5:

1-APPLY ITEM ⑩ CAREFULLY ON BOTH HALVES OF ITEM ②
 2-INSERT STEP 4 ASSY INTO ITEM ②.
 3-HOLD BOTH HALVES OF ITEM ② TOGETHER FIRMLY & LET DRY. (APPROX. 3 MIN.)
 4-APPLY STRIP OF ITEM ⑦ ON BOTH ENDS OF ITEM ② IN APPROX. SAME POSITION AS TRANSFORMER LEADS.
 5-APPLY STRIP OF ITEM ⑪ AROUND ITEM ② & OVER LEADS OF TRANSFORMER.

STEP 6:

WIRE TERMINATION
 1-GRN LEAD 3 TURN WINDING TO PIN-D
 2-TWISTED LEADS 3 TURN WINDING TO PIN-F
 3-RED LEAD 3 TURN WINDING TO PIN-C
 4-GRN LEAD 30 TURN WINDING TO PIN-B
 5-TWISTED LEADS 30 TURN WINDING TO PIN-G
 6-RED LEAD 30 TURN WINDING TO PIN-E
 7-START 400 TURN WINDING TO PIN-H
 8-FINISH " " " " " " PIN-A
 9-STEP 5 ASSY MUST SIT EVEN WITH ITEM ③ ON TERMINAL PIN END.
 10-MARK PIN ③ FOR LOCATION

STEP 8:

1-ENCAPSULATE STEP 6 ASSY WITH COMPOUND, POTTING, ITEM ⑫ TO ABOVE DIMENSIONS.
 2-ADD DOT OPPOSITE PIN A

STEP 7:

1-CHECK CONTINUITY AND FOR SHORTS BETWEEN WINDINGS.
 2-CHECK XFMR PER TMC SPEC 5846

REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD
	X1	IN STEPS 6 & 7 ALL 3T WERE 4T	6-4-64	XI	A.M.	
	O	ORIGINAL RELEASE	7-27-64	#	G.D.L.	
E7, A5 B7, D5 B6	A	ON STEP 2, NOTE 1; WAS 4 TURNS, ON STEP 7; NOTE 2 ADD. ON STEP 4; 3 TURN WAS 4 TURN, ON STEP 6; NOTE 10 ADD ON STEP 8, NOTE 2 ADDED.	9.21.64	12410	ARB	
	B	13/16 WAS 7/8 (REF STEP 8)	9-7-67	18489	H.G.	

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
-	13	BS-100	SOLDER, TIN ALLOY	
-	12	GL 128-6	COMPOUND, POTTING	BLUE
-	11	TA 105	TAPE, PRESS. SENS	
-	10	GL 129	ADHESIVE, SETTING	
-	9	GL 103	ADHESIVE - N-CEL	
-	8	GL 130	ADHESIVE - Q-DOPE	
-	7	TA114-1	TAPE, PRESS. SENS	
-	6	WI 141-36-9	WIRE, MAGNET, ELECTRICAL, T.	NAT.
-	5	WI 141-31-5	WIRE, MAGNET, ELECTRICAL, T.	GRN
-	4	WI 141-31-2	WIRE, MAGNET, ELECTRICAL, T.	RED
1	3	TM 124-1	TERM. COLLAR	
2	2	CI 119-03-N	CORE, CUP	
1	1	CF 135-6	FORM, COIL, 2 FLG	

M. GELLMAN LIST OF MATERIAL			
MATERIAL	---	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH	---	TR 184 ASSEMBLY	
DRAWN	W. LESHINSKI	DATE	8/13/63
CHECKED	@	DATE	7-27-64
DECIMALS	.X ± .05	FRACTIONS	± 1/64
MECH. DES.	XX ± .01	TOLERANCES	ANGLES ± 0° 30'
ELECT. DES.	1/50	DATE	
MECH. DES.	J.P.B.	DATE	