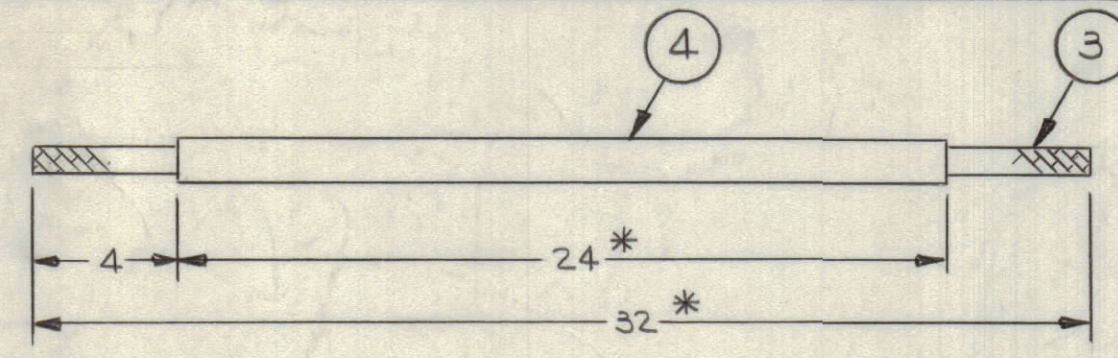
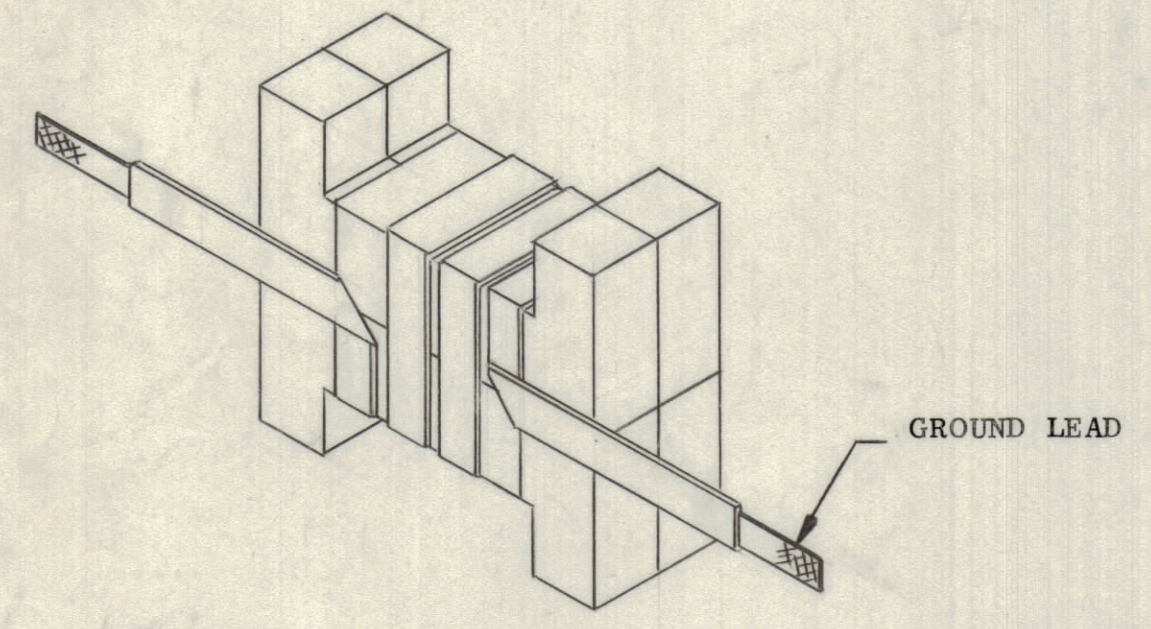


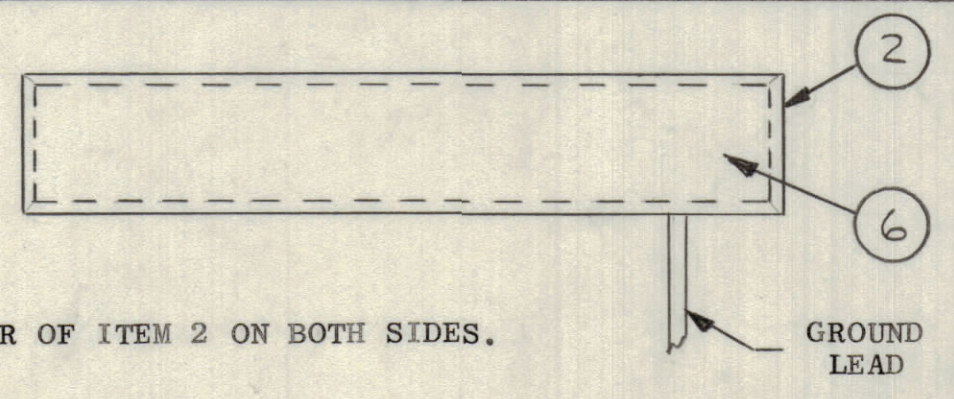
STEP 1
ITEM 1 & 2 REQ'D.
TAPE 4 PIECES OF ITEM 1 TOGETHER AS SHOWN WITH 1 LAYER OF ITEM 2.



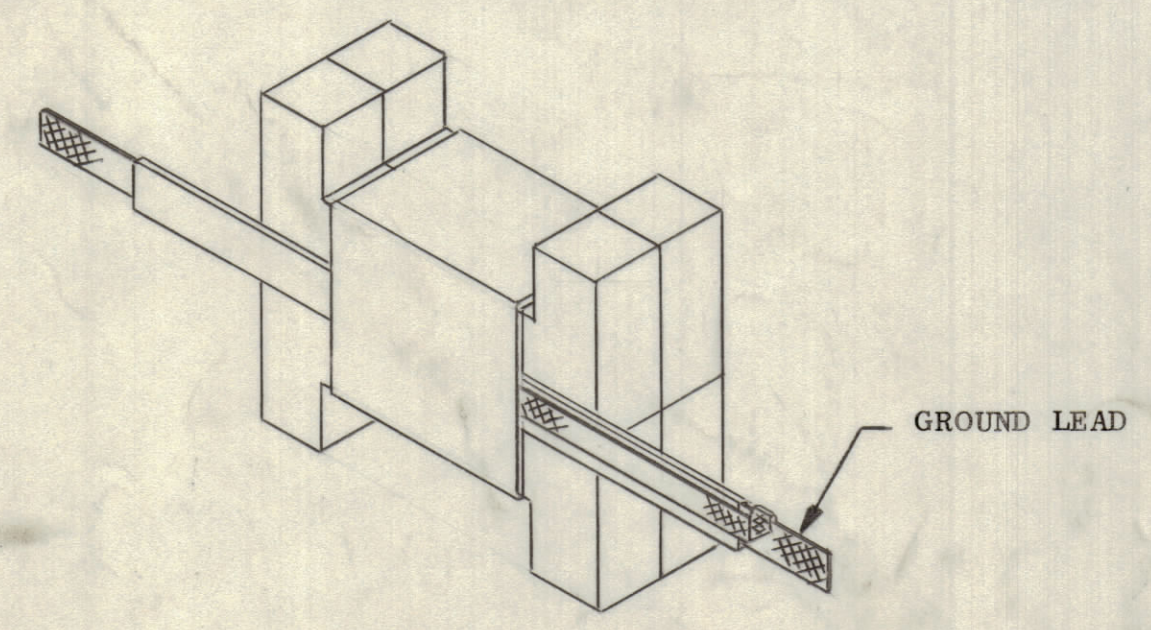
STEP 2 PRIMARY
ITEM 3 & 4 REQ'D
ASSEMBLY SHOULD BE AS FLAT AS POSSIBLE.
*ALLOWANCE HAS BEEN MADE FOR HANDLING AND TRIMMING.



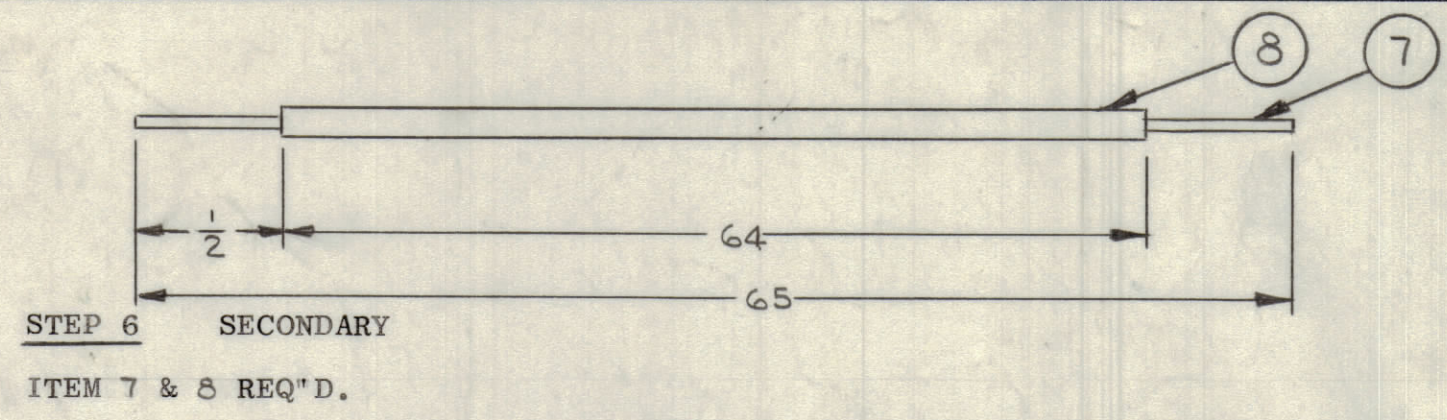
STEP 3 PRIMARY WINDING
WIND ON 3 TURNS OF ITEM 3 AND 4 ASSEMBLY IN A COUNTER CLOCKWISE DIRECTION AS SHOWN, SECURING ENDS WITH PIECES OF ITEM 5.



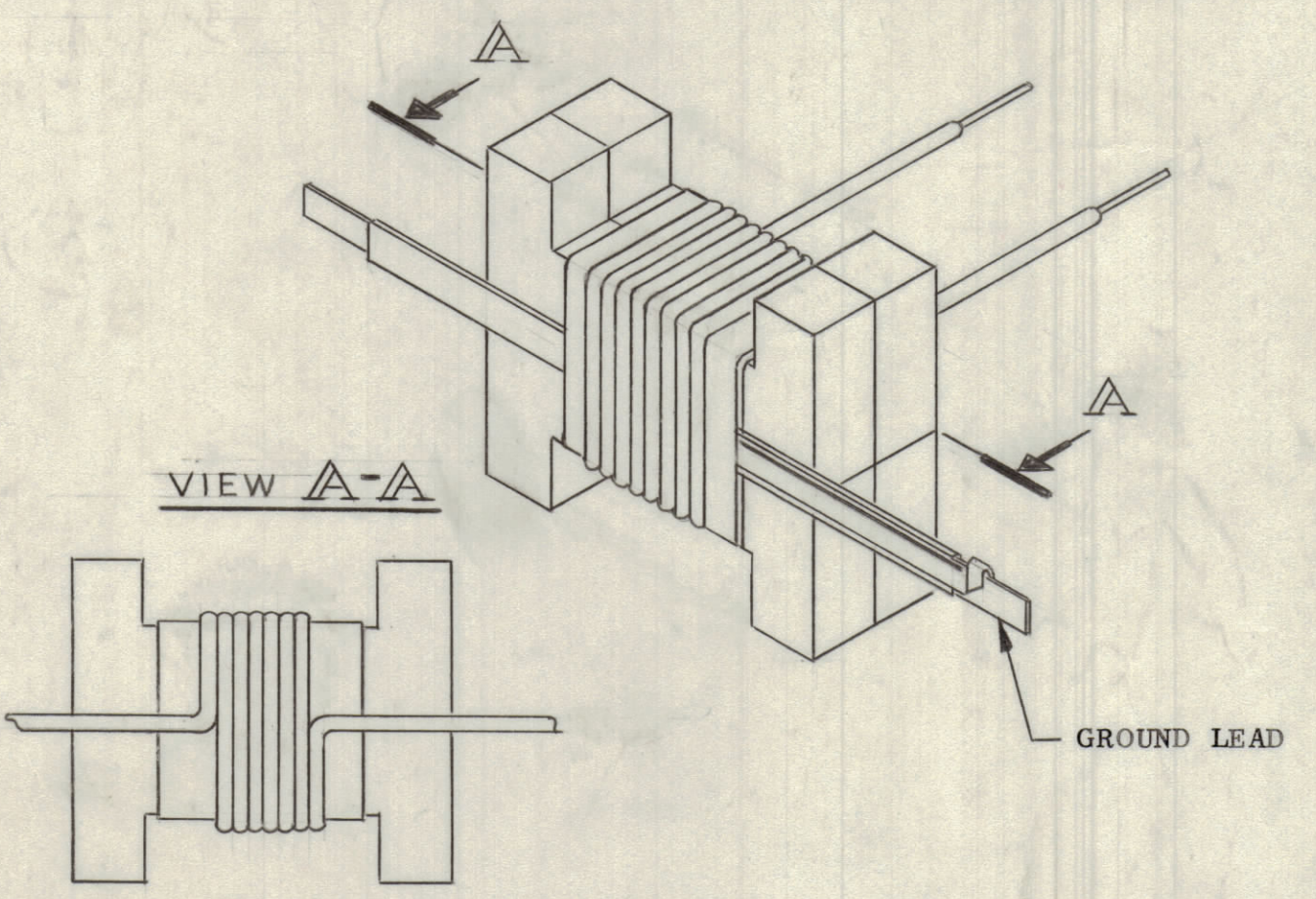
STEP 4 R.F. SHIELD
COVER ITEM 6 WITH ONE LAYER OF ITEM 2 ON BOTH SIDES. ALLOW OVERLAP AT ENDS.



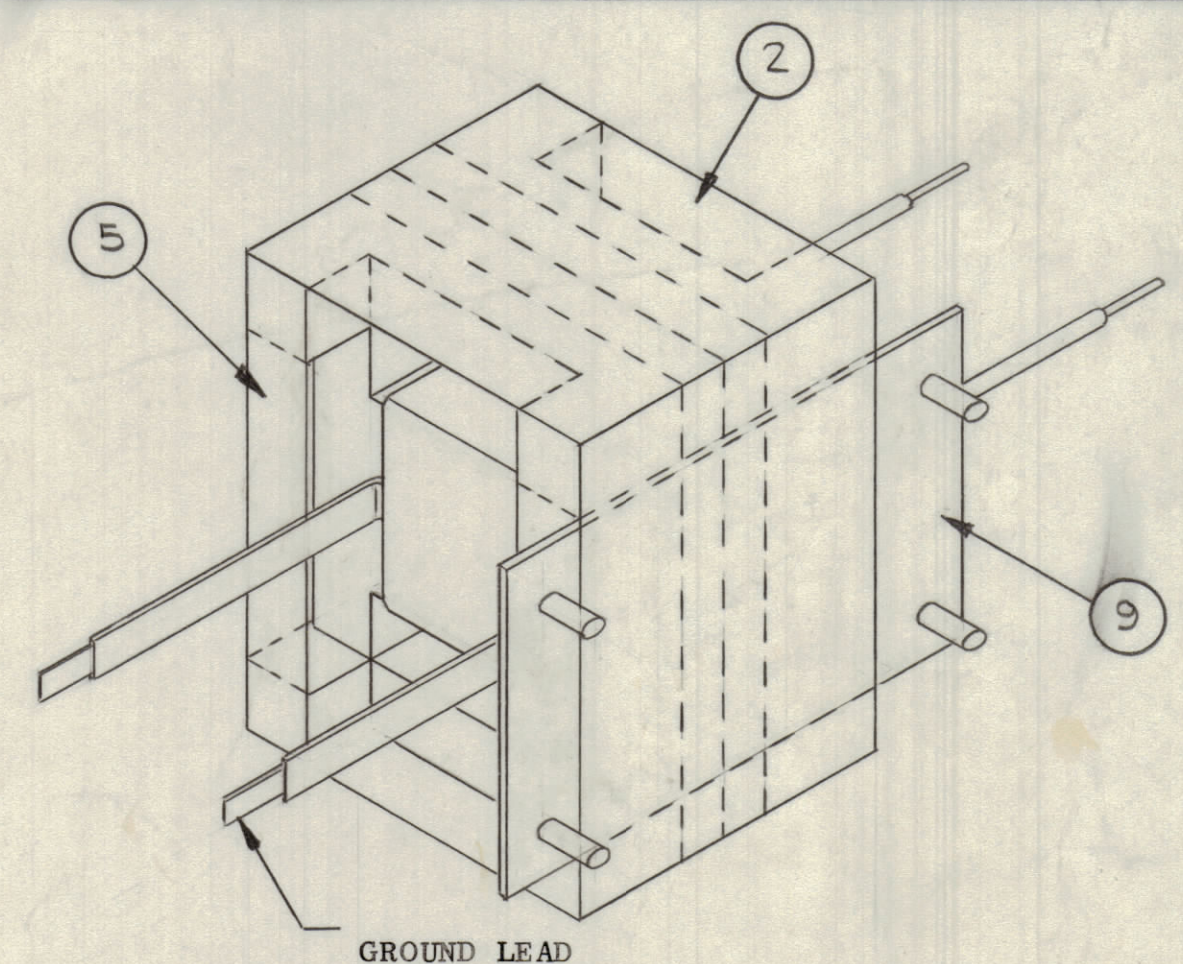
STEP 5 R.F. SHIELD TO GROUND TERMINATION
WIND ON SHIELD ASSEMBLY, ITEM 6, DIRECTLY OVER STEP 3. ALLOWING 1/8" SPACE ON BUTT ENDS, COVER WITH ONE LAYER OF ITEM 2. SOLDER LEAD OF SHIELD ASSEMBLY TO PRIMARY WINDING, STEP 3, AS SHOWN.



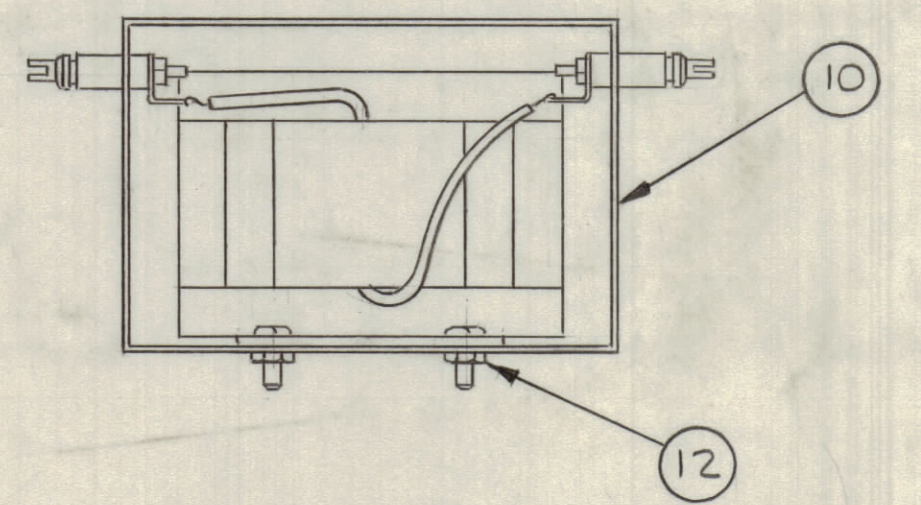
STEP 6 SECONDARY
ITEM 7 & 8 REQ'D.



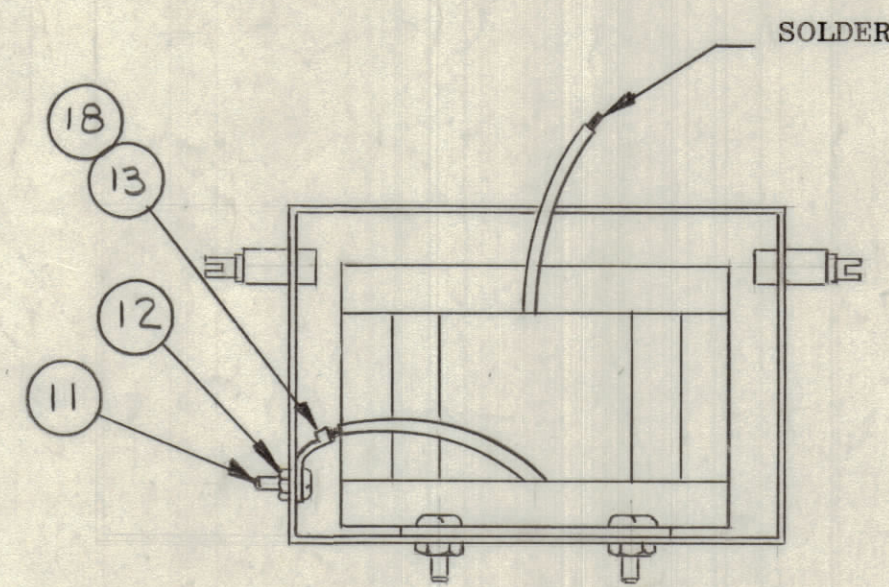
STEP 7 SECONDARY WINDING
WRAP ONE LAYER OF ITEM 5 (STICKY SIDE OUT) OVER STEP 5. WIND 7 TURNS OF STEP 6 AS SHOWN. THIS SECONDARY WINDING SHOULD BE CLOSE SPACED AND WOUND IN A CLOCKWISE DIRECTION, CENTERED ON STEP 1. WRAP A LAYER OF ITEM 2 OVER THE SECONDARY WINDING.



STEP 8 COMPLETE CORE AND MOUNTING PLATE ASSEMBLY
PLACE THE REMAINING PIECES OF ITEM 1 AS SHOWN AND WRAP WITH ITEM 2 & 5, AND SECURE ITEM 9 IN POSITION AND WRAP WITH ITEM 2.



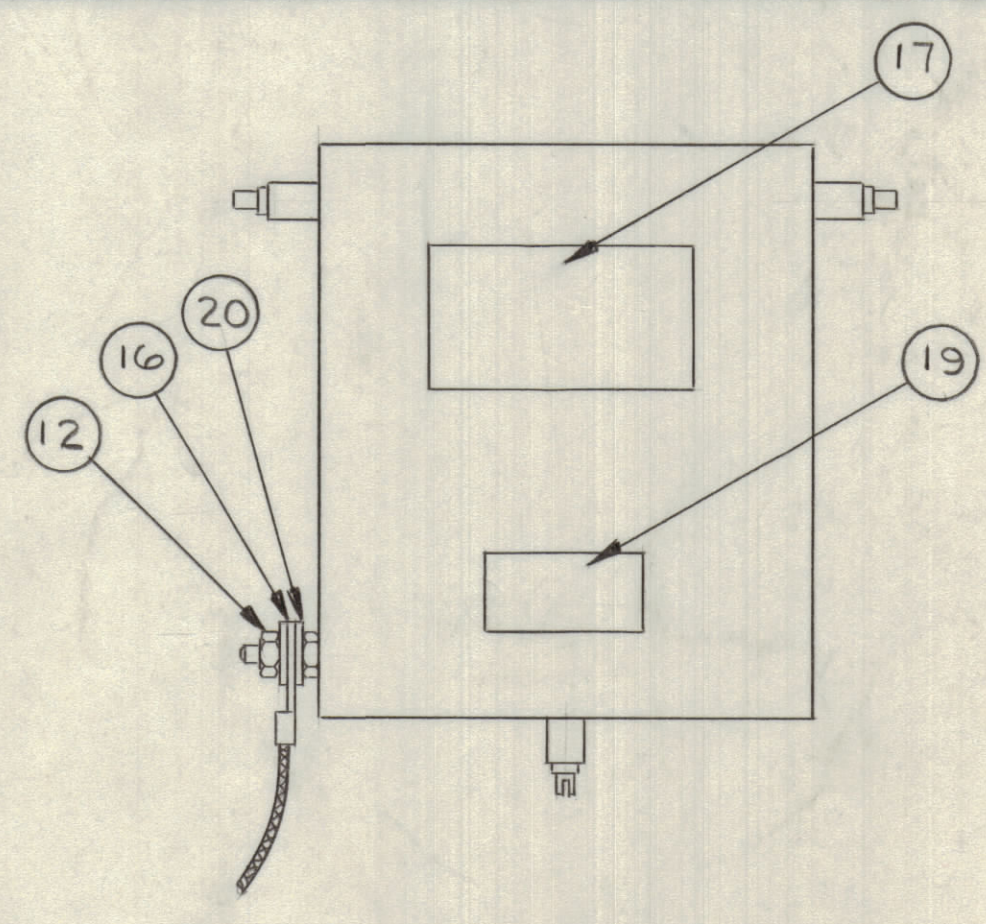
STEP 9 SECONDARY TERMINATIONS
INSERT ENTIRE ASSEMBLY STEP 8 INTO ITEM 10 AND SECURE. SOLDER LEADS OF SECONDARY (AS SHOWN) SHORT AS POSSIBLE. INSERT BOTTOM COVER AND SECURE BY SOLDER TACK ONLY.



STEP 10 PRIMARY AND GROUND TERMINATIONS
ASSEMBLE GROUND LUG, ITEM 13 WITH ITEM 11 AND 12. SOLDER GROUND INPUT OF PRIMARY SHORT AS POSSIBLE TO ITEM 13, AND INPUT LEAD OF PRIMARY TO LUG OF TERMINAL ON COVER. INSERT COVER AND TACK SOLDER.

STEP 11
ELECTRICAL TEST AND MECHANICAL INSPECTION TO SPEC S-861.

STEP 12 POTTING
SOLDER COVER ON INPUT SIDE OF CASE, POT WITH ITEM 14. CURE FOR 4 HOURS AT 60° C (140°F). SOLDER COVER ON OUTPUT SIDE AND CLEAN ALL SOLDERED JOINTS PRIOR TO PAINTING. (S114 AND S115)



STEP 13 FINAL ASSEMBLY
PLACE ITEM 17 AND SERIAL NUMBER DECAL (ITEM 19) AS SHOWN, AND ATTACH ITEM 16 USING ITEMS 12 & 20.

REVISIONS						
ZONE	BY	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD
X2		COMPLETELY REDRAWN & REVISED	2/15/66		JL	
Ø		ORIGINAL RELEASE FOR PRODUCTION	2/16/66		Jc	
A		IT 5 WAS TA 108-9, IT 20 WAS FW108BN	3-10-66	15927	WWS	
B		IT 4 WAS PX 370-2-7	3-29-66	16165		

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
2	20	FW108BN	FLAT WASHER	
1	19	NP-492	IDENTIFICATION, PLATE, MFRG.	
X	18	BS-100	SOLDER, SOFT	
1	17	NP-774	PLATE, IDENTIFICATION	
1	16	CA-409-95-2.25	STRAP, GROUND	
X	15		DELETED	
X	14	GL-103	POTTING COMPOUND	
1	13	TE-141-2	TERMINAL, LUG	
6	12	NTH0832BN10	NUT, HEX MACHINE	
1	11	SCBP0832BN8	SCREW, MACHINE	
1	10	A-1217-2	CASE AND COVER	
1	9	A-1215	CORE MOUNTING ASSEMBLY	
64"	8	PX-370-16-7	INS. SLEEVING, TEFLON	
65"	7	WI-125-1	WIRE, ELEC. MAG.	
1	6	A-4192	SHIELD ASSEMBLY	
X	5	TA-108-5	INS. TAPE, EL. GL 3/4	
24"	4	PX-370-5-7	INS. SLEEVING, TEFLON	
32"	3	WL-103-5	BRAID, WIRE, FLAT	
X	2	TA-108-9	INS. TAPE, EL. GL. 1 1/2	
8	1	CI-101-3Q	CORE, TRANSFORMER	

LIST OF MATERIAL			
MATERIAL	---		
FINISH	---		
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		TITLE TR185 ASSEMBLY	
SCALE	---	DATE	2/15/66
QTY./UNIT	---	CHECKED	2-16-66
MODEL USED ON	---	DATE	2-16-66
ASSY. NO.	---	DATE	2-16-66
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN J. LESHINSKI	
DECIMALS	± .05	FRACTIONS	± 1/64
ANGLES	± .01	ANGLES	± 0' 30"
XXX ± .005			
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.		ELECT. DES. DATE MECH. DES. DATE	
		DATE 2-16-66	
		SHEET	
		REV. LTR.	

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

NOTES

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