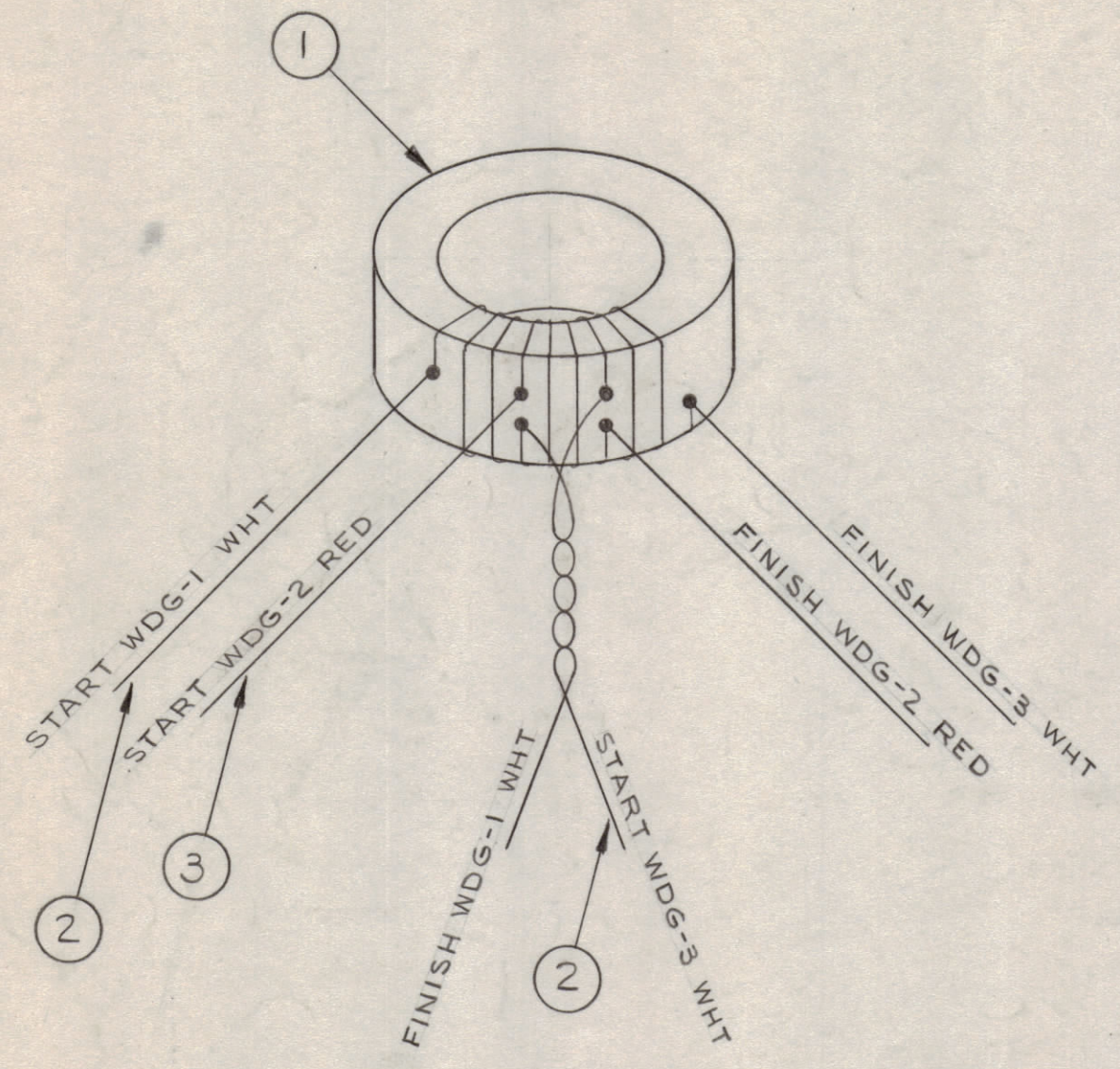


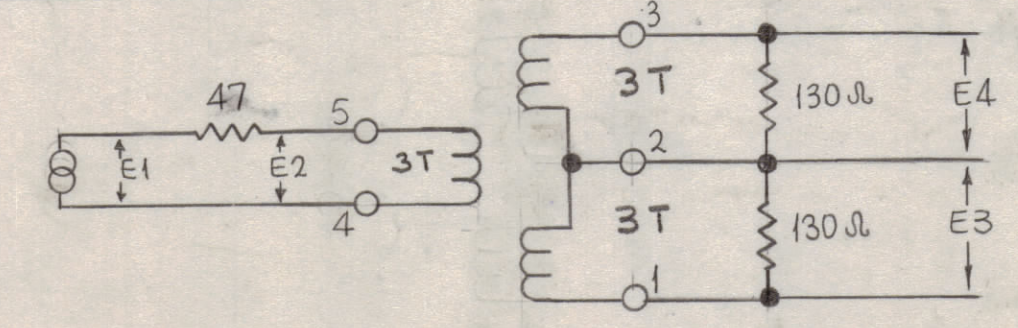
- WINDING PROCEDURE -

1. CLOSE WIND TWO (2) WINDINGS OF ITEM (2) AND ONE (1) WDG. OF ITEM (3) AT THREE (3) COMPLETE FULL TURNS EACH ONTO ITEM (1) IN SEQUENCE SHOWN, KEEPING WIRE FLAT AGAINST CORE SURFACES.
2. TACK STARTS AND FINISHES OF ALL WDG'S WITH ITEM (8).
3. TWIST TOGETHER FINISH WDG-1 AND START WDG-3 AND BRING OUT AS ONE LEAD AS SHOWN.
4. ALL LEADS TO BE 1 3/8 LONG, STRIPPED AND TINNED 1".
5. BAKE AT 215°F FOR 1/2 HOUR TO REMOVE MOISTURE.
6. COAT WINDINGS AND CORE WITH ITEM (4) AND BAKE AT 215°F FOR 1/2 HOUR.



REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD
X1		TEST SPECS ADDED	9-30-65	X1		
		ORIGINAL RELEASE FOR PRODUCTION	10/5/65			

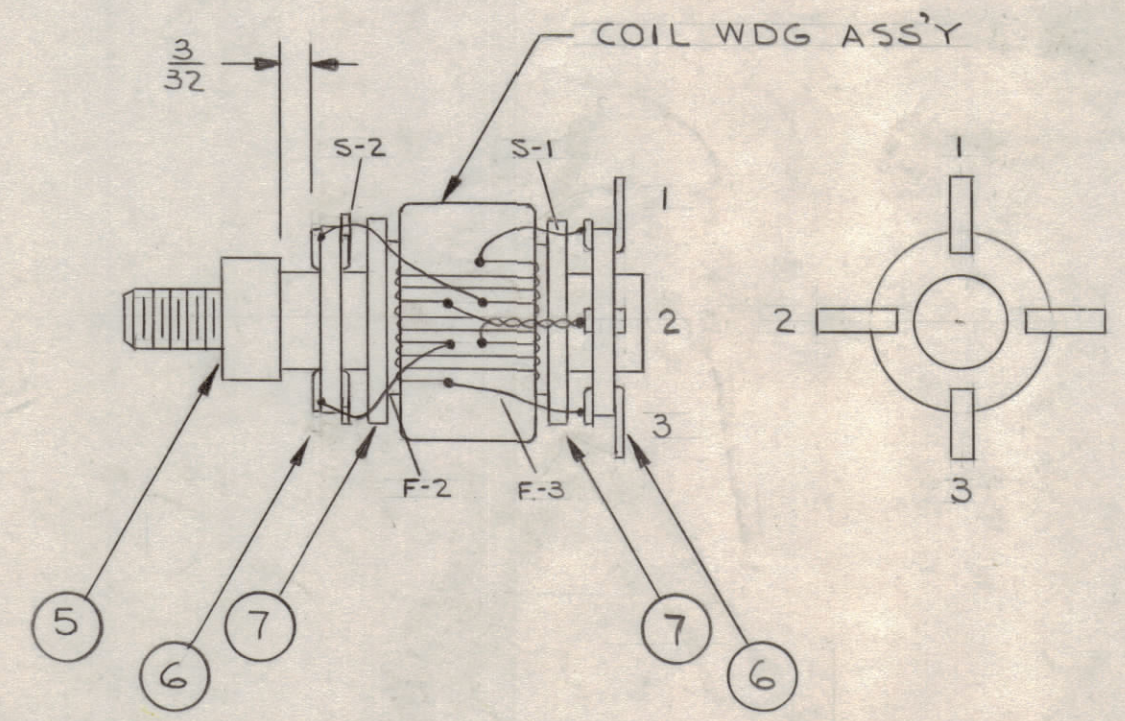
TEST SPECS:



FREQ. MC	E1	E2	E3	E4
2	.3V	.15V	.15V	.15V
16	.3V	.15V	.15V	.15V
30	.3V	.15V	.15V	.15V

SET SIG. GEN. TO READ E1
MEASURE WITH HP410C OR EQUIV. E2, E3, E4, ±20%

A4341



- ASSEMBLY PROCEDURE -

1. ASSEMBLE ITEMS (6,7) AND COIL WINDING ASSEMBLY ONTO ITEM (5). ORIENT RESPECTIVE PARTS AS SHOWN AND SECURE IN PLACE USING ITEM (8).
2. CONNECT ALL LEADS TO RESPECTIVE TERMINALS AS FOLLOWS BELOW AND SOLDER IN PLACE USING ITEM (9).

LEAD	CONNECTION
START WDG-1	TERMINAL-1
FINISH WDG-1, START WDG-3	TERMINAL-2
FINISH WDG-3	TERMINAL-3
START WDG-2	TERMINAL-4
FINISH WDG-2	TERMINAL-5

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	9	BS100	SOLDER, TIN ALLOY	
X	8	GL102	ADHESIVE, Q MAX.	
2	7	WA102-5	WASHER, SHOULDER	
2	6	TE181-4	TERMINAL, LUG-COLLAR	
1	5	CF110-N-1	COIL, FORM	
X	4	GL104-2	INSULATING VARN, ELEC	
X	3	WI102-9-2	WIRE, ELEC, MAG, EC	
X	2	WI102-9-9	WIRE, ELEC, MAG, EC	
1	1	CI115	CORE, TOROID	

ANGER LIST OF MATERIAL

MATERIAL THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK

FINISH TITLE TRI86 ASSEMBLY

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES

DECIMALS: X ± .05, .XX ± .01, .XXX ± .005
FRACTIONS: ± 1/64, ANGLES: ± 0° 30'

SCALE: NONE

QTY./UNIT: 1
MODEL USED ON: CHG-3
ASS'Y. NO.: A2945

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DRAWN: J. LESHINSKI
CHECKED: [Signature]
ELECT. DES.: Anger
MECH. DES.: [Signature]

DATE: 9/13/65
DATE: 10/5/65

FINAL APPROVAL: [Signature]
DATE: 10/5/65

REV. LTR. A4341

NOTES