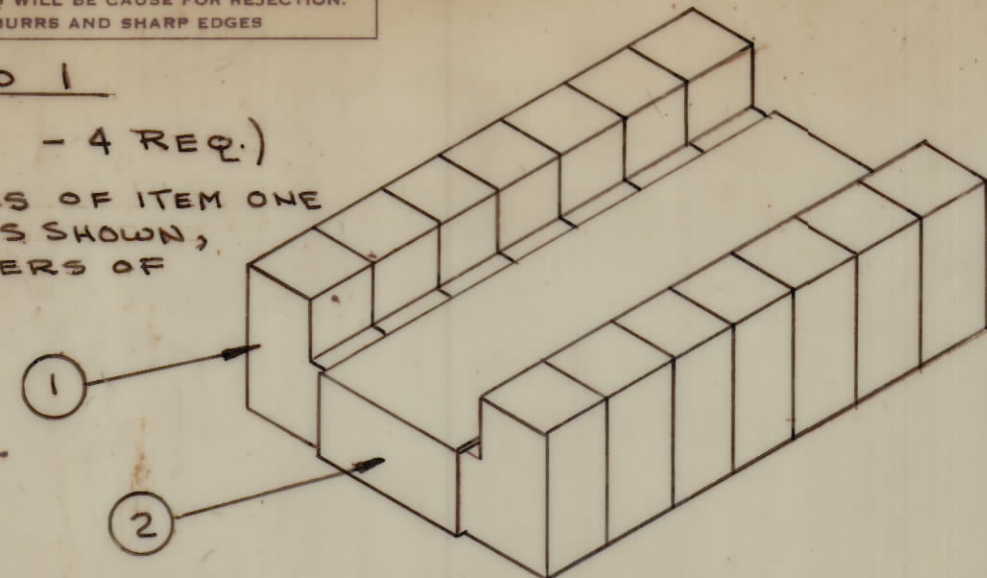


IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.  
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES.

**STEP NO 1**

(PART NO 1 - 4 REQ.)

TAPE 7 PCS OF ITEM ONE TO-GETHER AS SHOWN, WITH 2 LAYERS OF ITEM 2

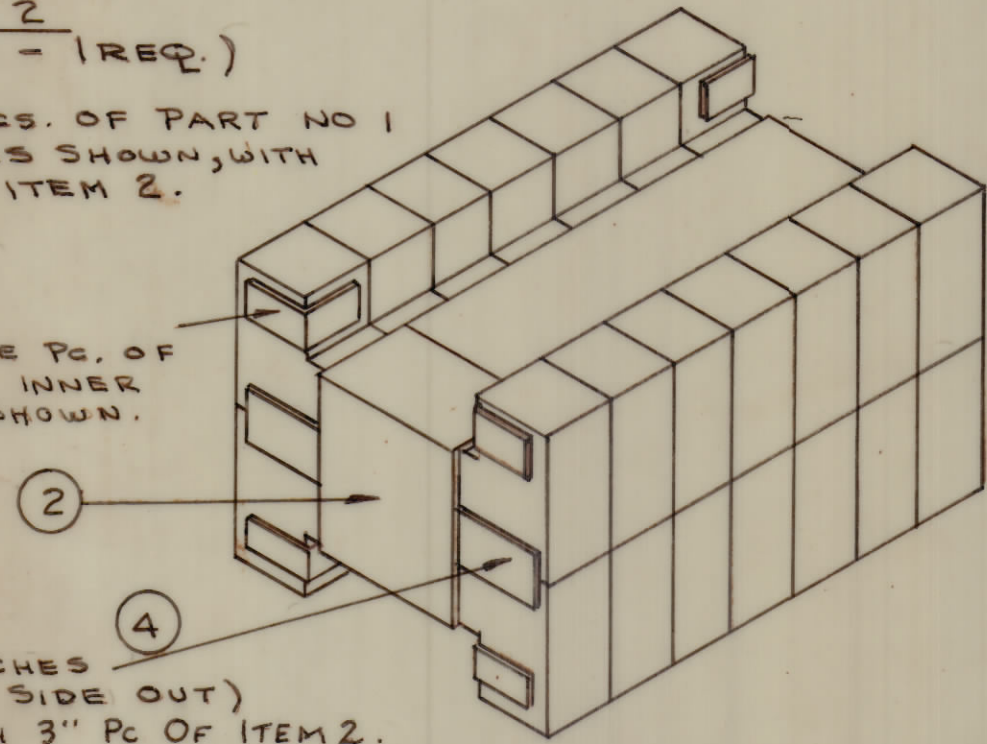


**STEP NO. 2**

(PART NO. 2 - 1 REQ.)

TAPE TWO PCS. OF PART NO 1 TO-GETHER AS SHOWN, WITH 2 LAYERS OF ITEM 2.

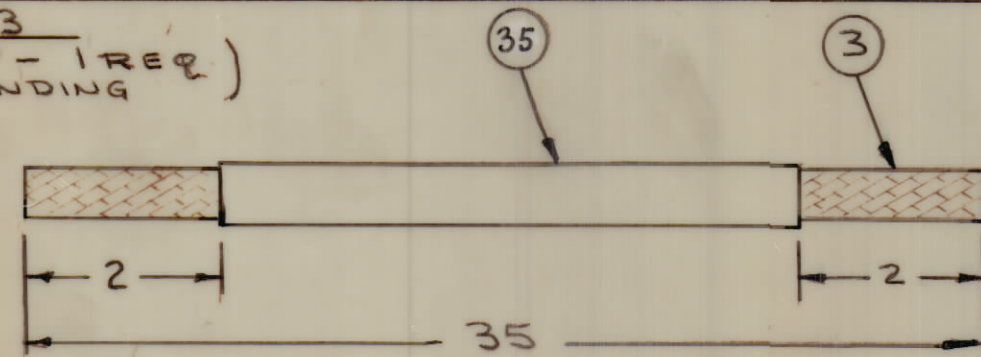
WRAP A 1/2" WIDE PC. OF ITEM 2 ON ALL INNER CORNERS AS SHOWN.



**STEP NO 3**

(PART NO 3 - 1 REQ.)

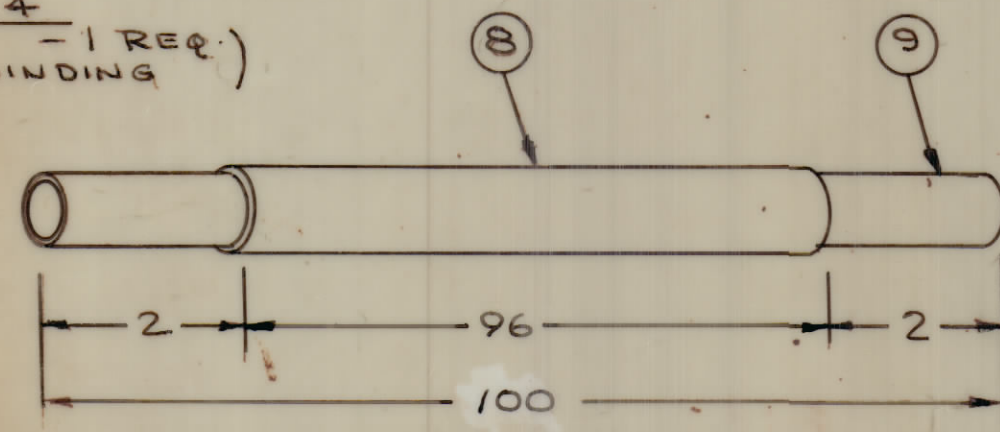
FIRST WINDING



**STEP NO 4**

(PART NO 4 - 1 REQ.)

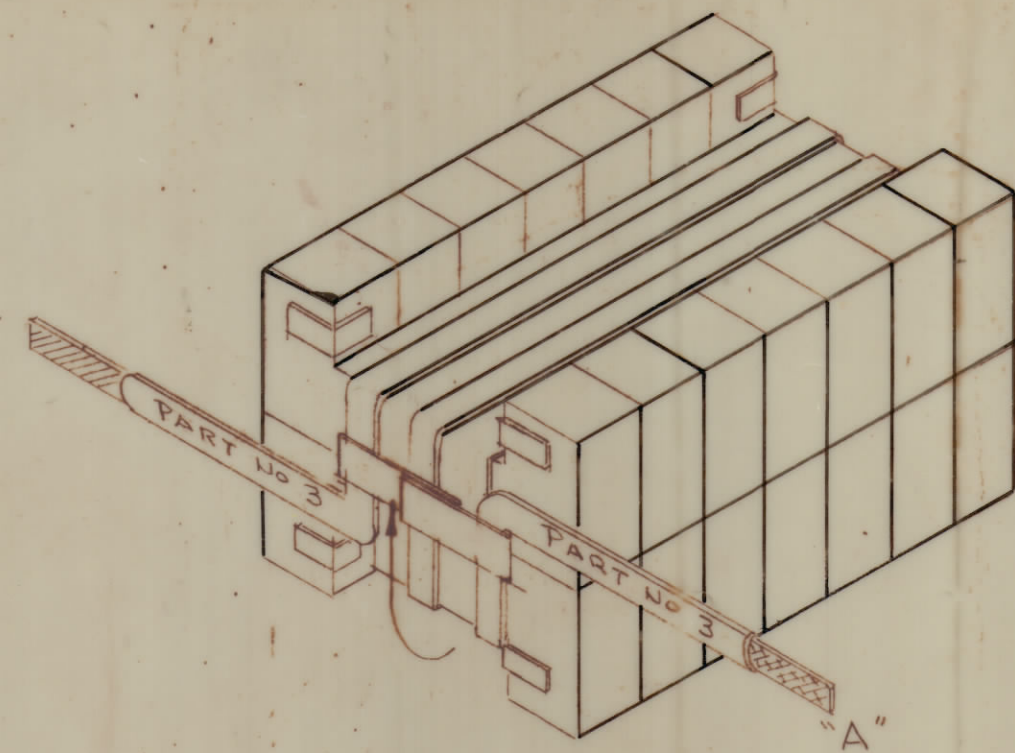
2ND WINDING



NOTE: INSERT TUBING THRU SLEEVING AS SHOWN.

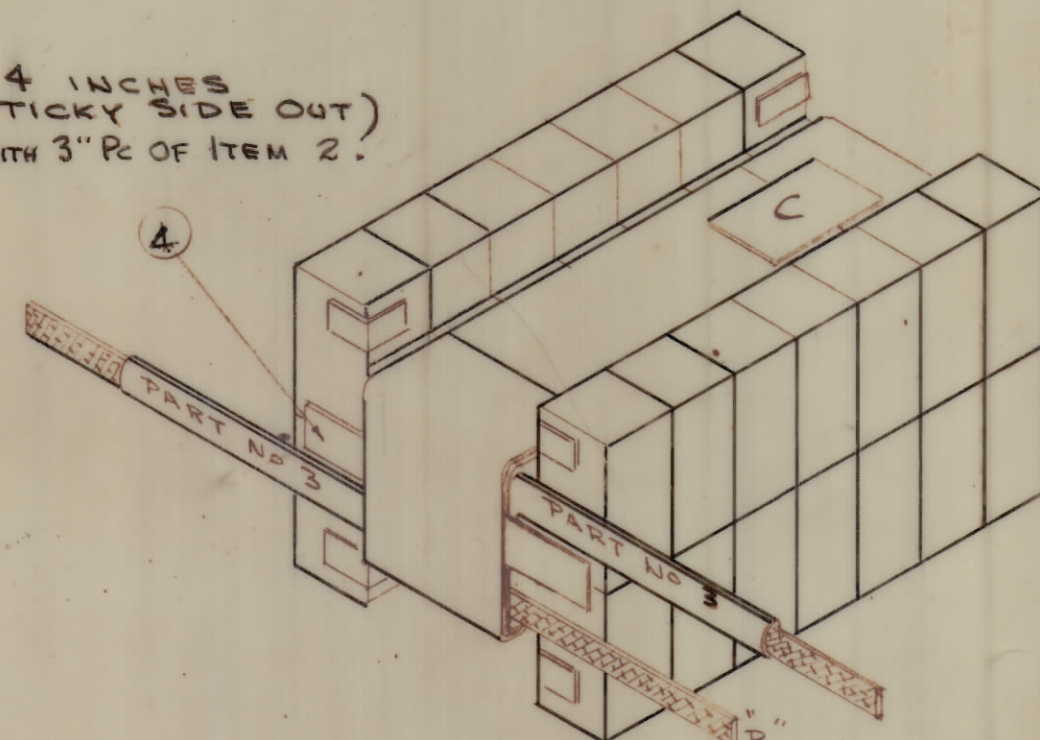
**STEP NO 5**

STARTING WITH CENTER OF PART NO 3 AT CENTER OF END SHOWN BY ARROW, WIND ON ONE TURN EQUALLY SPACED ON EACH SIDE SO THAT LEAD END UP AS SHOWN FOR A TOTAL OF TWO TURNS. NOTE: THAT END 'A' OF WINDING IS COUNTERCLOCK WISE. PULL WINDING TIGHT & FASTEN WITH LOOSE TABS OF TAPE.



**STEP NO 6**

4 INCHES (STICKY SIDE OUT) HELD WITH 3" PC OF ITEM 2.

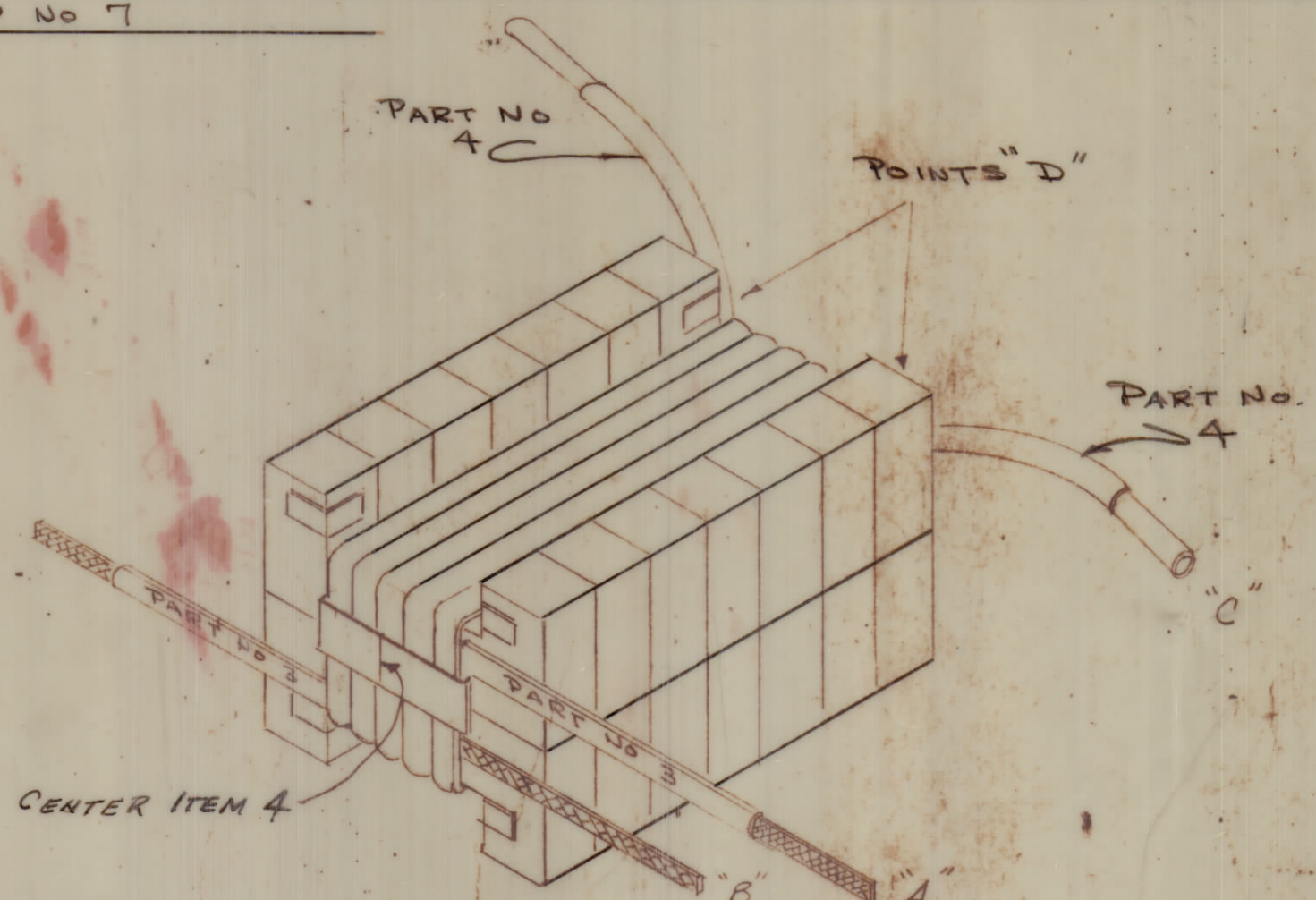


USING ITEM 6 (A-1199-1) AND ITEM 7 (IM-163-20) HELD TO-GETHER AS SHOWN.

WIND ON TIGHTLY WITH ITEM 7 (INSULATION) ON BOTTOM. (NOTE THAT INSULATION IS LONG ENOUGH TO COMPLETELY COVER SCREENING ON BOTH SIDES). ATTACH 2 PCS. OF ITEM 10 WITH ITEM 4 AS SHOWN,

AND WIND ON TIGHTLY. SECURE INSULATION AT POINT 'C' WITH 3" PIECE OF TAPE (ITEM 4). LEAD FROM SCREENING MUST COME OUT AT POINT 'B'. THEN ADD 4" PC. OF ITEM 4 AS SHOWN ABOVE TO HOLD SECOND WINDING.

**STEP NO 7**



STARTING WITH CENTER OF PART #4 AT CENTER OF END SHOWN BY ARROW IN STEP #5, WIND ON 3 TURNS ON EACH SIDE FOR A TOTAL OF 6 TURNS. CENTER POINT OF PART #4 IS USED SO THAT EACH END OF WIND NO. 2 IS EQUAL IN LENGTH. LEADS SHOULD END UP AT POINTS 'D' AS SHOWN. END 'C' OF PART #4 SHOULD BE CLOCKWISE (OPPOSITE DIRECTION OF PART #3, POINT 'A') WHEN WINDING IS COMPLETED.

**STEP 8:**

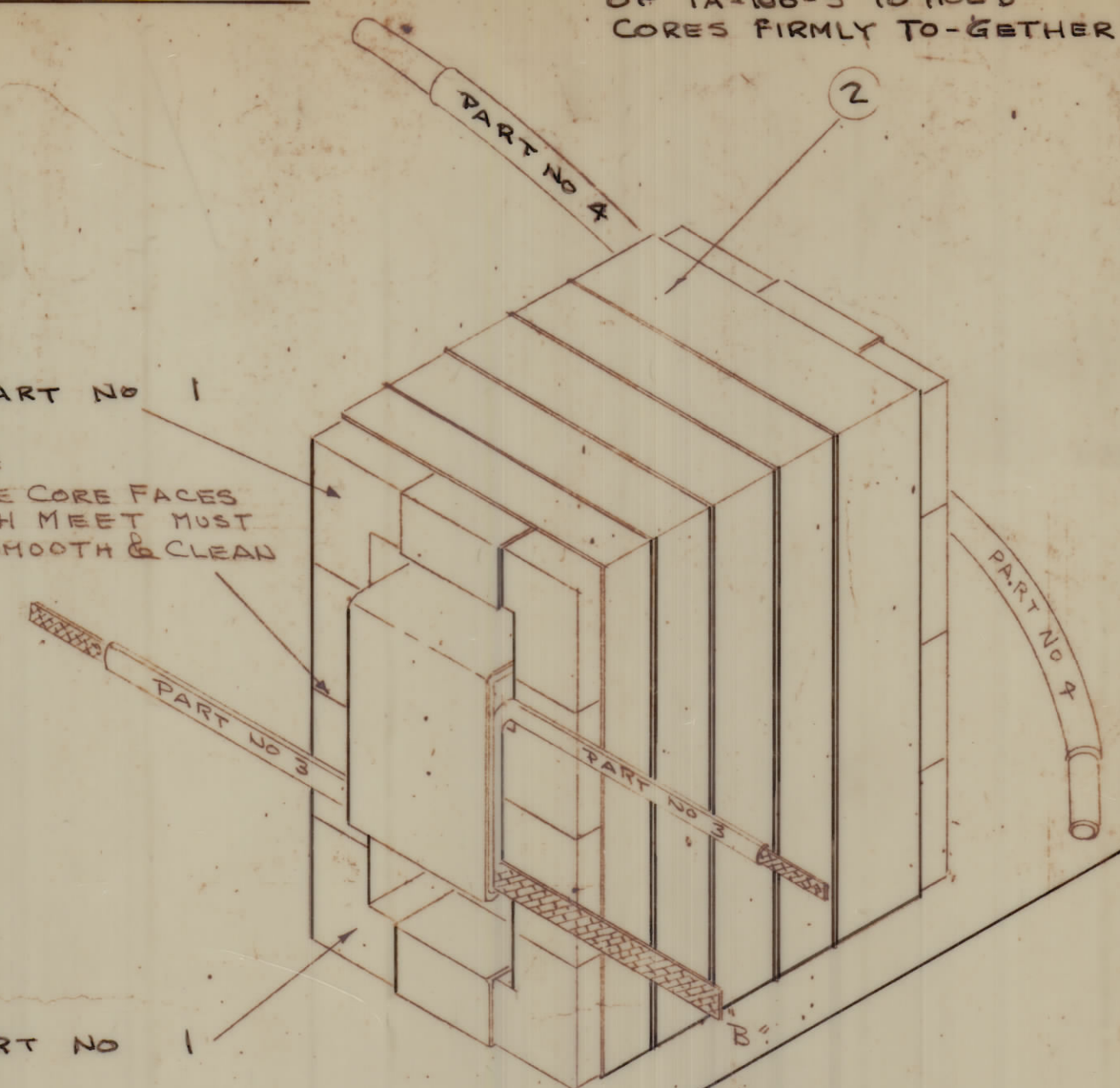
WIND ON 3 LAYERS OF ITEM 4 (TAPE)

**STEP NO 9**

USE APPROX 5 LAYERS OF TA-108-9 TO HOLD CORES FIRMLY TO-GETHER

PART NO 1

NOTE: THOSE CORE FACES WHICH MEET MUST BE SMOOTH & CLEAN

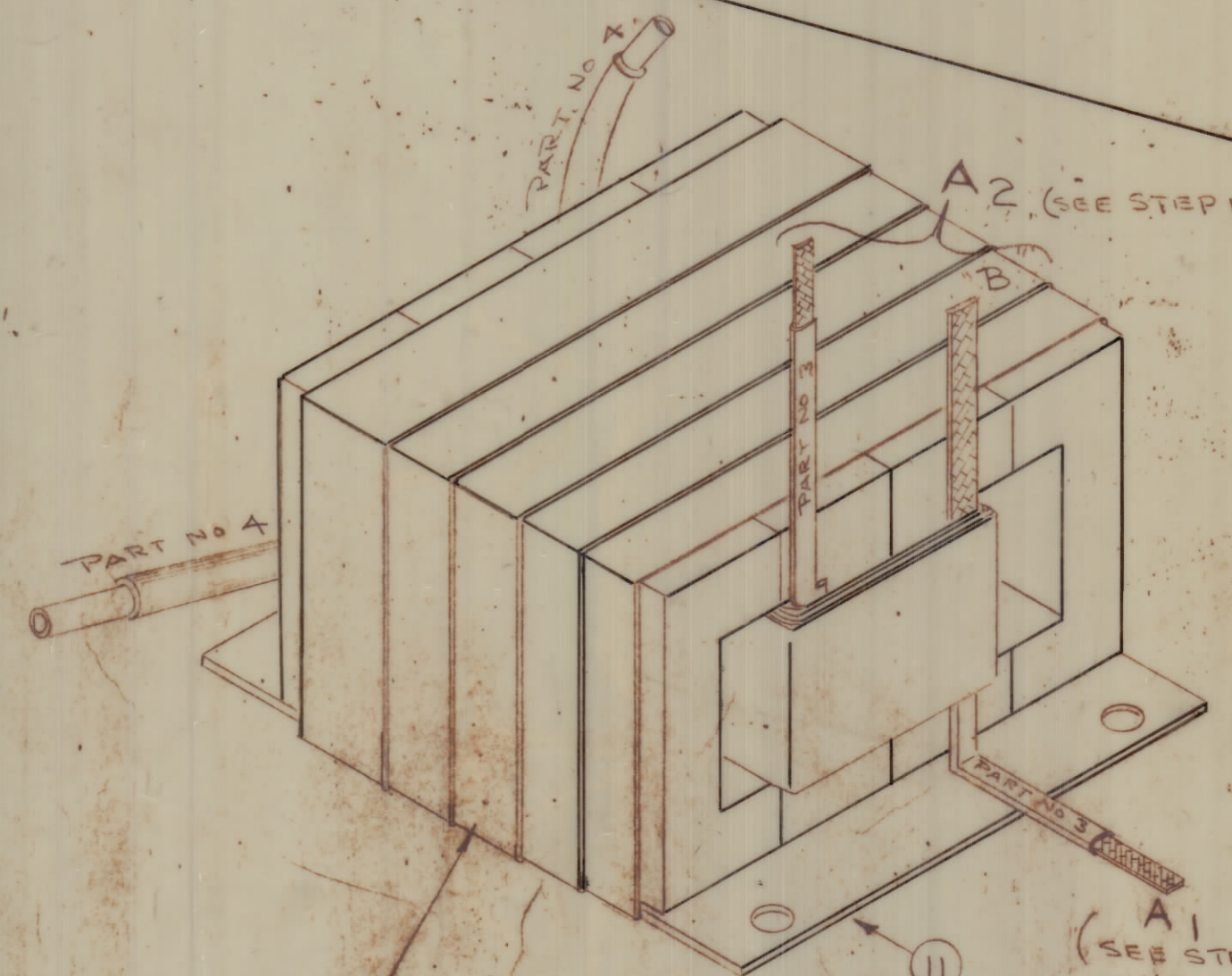


**STEP 11**

1. MAKE SOLDER CONNECTIONS AS SHOWN.
2. SOLDER ONE END IN PLACE.
3. SOLDER OTHER ENDS IN PLACE.
4. SMOOTH ALL SEAMS.
5. FINISH (SEE NOTE BELOW).

FINISH: DEGREASE S-114 ZINC CHROMATE PRIMER. S-115 SMOOTH GRAY ENAMEL. DO NOT PAINT MFG STUDS, INSULATORS, OR GROUND STRAPS.

**STEP 10**



NOTE: TRANSFORMER MUST BE TAPED SECURELY TO CENTER OF PLATE ITEM 11.

NOT TO BE RELEASED W/O AUTHORIZATION

AUTH BY: DATE:

31	35	PX370-75-7	INSULATION, SLEEVING
1	34	PX-437	GLAND (TEFLON)
2	33	PX-287	GLAND (TEFLON)
1	32	NP356	NAMEPLATE (FOL CAL)
2	31	GA-118	GASKET, CORK
1	30	SCBS2520EN2	SCREW, MACHINE
3	29	GA-114	GASKET, NEOPRENE
1	28	GA-117	GASKET, CORR
3	27	FW25 HSS	WASHER, FLAT
2	26	FW10 HSS	WASHER, FLAT
	25		
2	24	NTH1024EN2	NOT, HEX
2	23	LWE10HRN	LOCKWASHER, EXT.
2	22	TE-141-3	LUG

2	21	NS-118-5	INSULATOR, MODIFIED
1	20	NS-119-1	INSULATOR, FEED THRU
2	19	LWE25MRN	LOCKWASHER, EXT.
2	18	TE-141-4	LUG
4	17	NTH2520EN4	NUT, HEX.
4	16	NTH0832EN2	NUT, HEX
4	15	LWE08MRN	LOCKWASHER, EXT.
4	14	SCBS0832EN8	SCREW, MACHINE
1	13	BK-1G4	CASE & COVERS
X	12	BS100	SOLDER, TIN ALLOY
1	11	MS-717	PLATE SUPPORT XFORMER
2	10	IM-163-20	INSULATION, FIBER GLAS
82	9	TU-100-2-U	TUBING, COPPER
96	8	PX-370-G-7	INSULATION, SLEEVING, TEFLON (NATURAL)
1	7	IM-163-34	INSULATION, FIBERGLAS
1	6	A-1199-1	SHIELD, ASSEMBLY
X	5	GL-112	VARNISH
X	4	TA-108-7	TAPE (1" WIDE)
117	3	UL-103-7	SHIELD, FLEXIBLE
X	2	TA-108-9	TAPE (1/2" WIDE)
28	1	CI-101-3-Q	CORE

THE TECHNICAL MATERIEL CORP. MANARONECK, NEW YORK  
 TRANSFORMER, SUB-ASSY  
 TR-108

ORIGINAL RELEASE FOR PRODUCTION	13067	LAK
ISSUE ITEM	CHANGED FROM	DATE CN. NO. DRAFTS CHECKED ENG. APP.
TOLERANCES	SCALE:	
ALL DEC. DIM. ±	DRILL PUNCH COMMERCIAL STOCK	
OTHERS ANGULAR DIM. ±	SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.	

A4556

A4556