

A-702-B

WINDING MACHINE DATA

DRIVER GEAR - 95  
 CAM GEAR - 49  
 CAM - .125

ASSEMBLY

AFFIX ITEM 2 ON END OF COIL FORM WITH ITEM 6. AIR DRY.

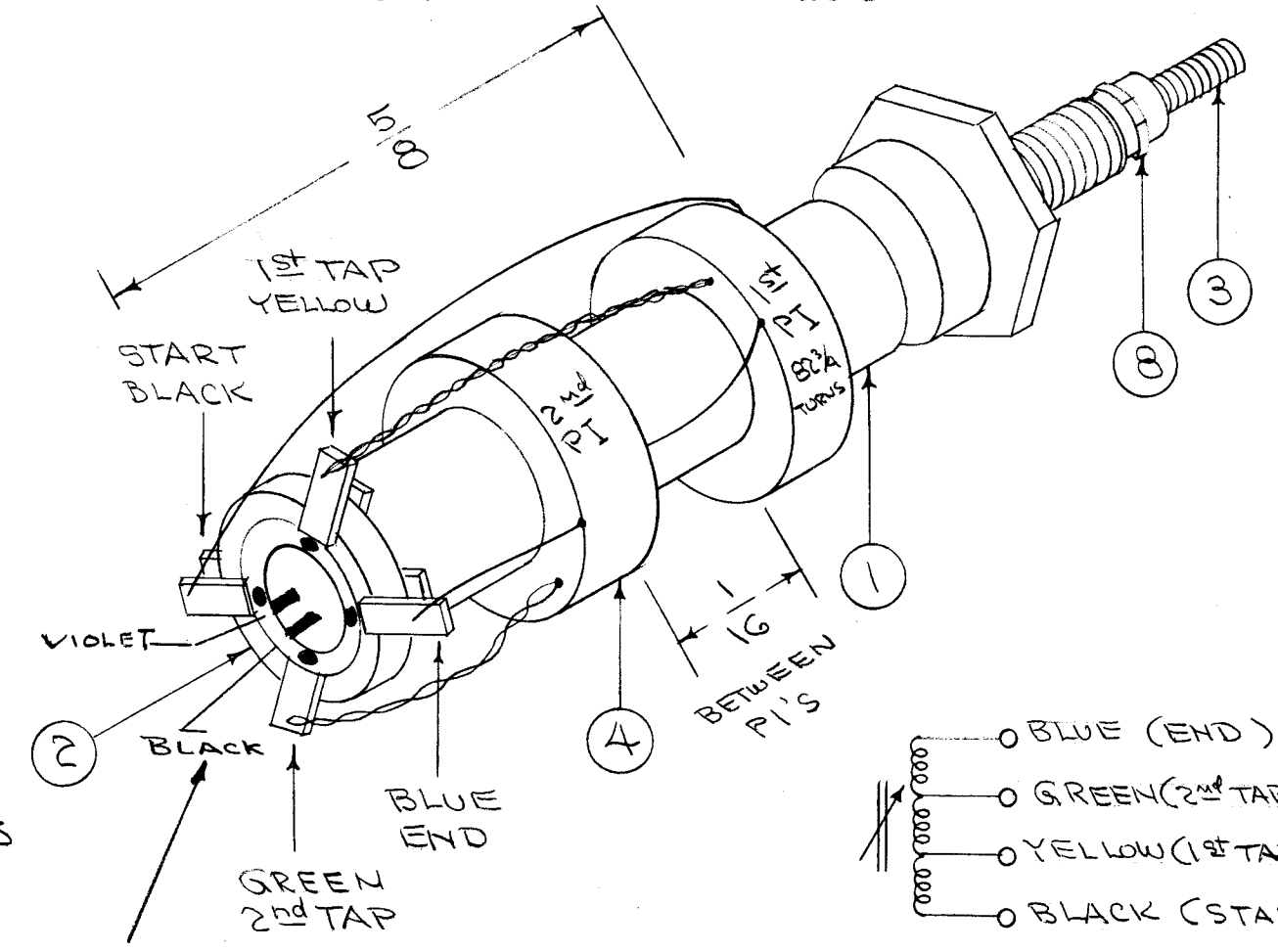
WINDING PROCEDURE

1. START WINDING 5/8" FROM LUG END OF COIL FORM AND IN LINE WITH BLACK LUG. (USE WINDING FINGER WITH WIRE GUIDE ON LEFT. START WINDING WITH FINGER IN EXTREME LEFT HAND POSITION OF TRAVEL.
2. TAP AS SHOWN IN SCHEMATIC, AT 53 3/4 T. & 104 1/4 T., END 1<sup>ST</sup> PI AT 82 3/4 T & 2<sup>ND</sup> PI AT 166 1/2 T
3. STAKE ENDS & TAPS TO COIL FORM WITH ITEM 6.
4. SOLDER CONNECT ENDS & TAPS AS SHOWN
5. BAKE FOR 1/2 HOUR AT 215° F. SATURATE COIL WITH ITEM 5 AND AIR DRY FOR 10 MIN. BAKE FOR 2 HOURS AT 215° F.

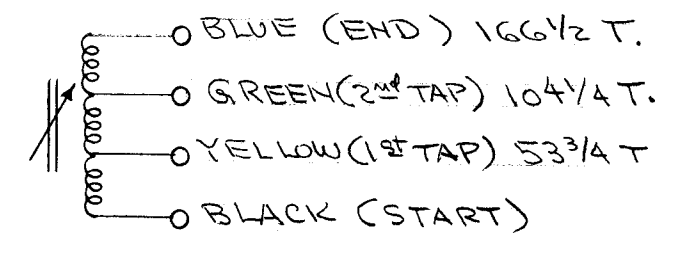
TEST PROCEDURE w/o CORE

USE BOONTON Q METER 160-A OR EQUIVALENT.

COLOR CODE COIL FORM AS BELOW



COLOR CODE AS SHOWN INSIDE OF COIL FORM (REF: CH-102)



SCHEMATIC DIAGRAM

	BLACK-BLUE	BLACK-GREEN	BLUE-YELLOW
L	360 μh (325 - 395)	162 μh (146 - 178)	194 μh (175 - 213)
Q	> 100	> 75	> 65
F	790 KC	790 KC	790 KC

MISC. TEST INFO.

OUT OF CAN, WITH CORE  
 L - MAX 1000 μh, Q - 105  
 L - MIN. 390 μh, Q - 105

IN CAN, WITH CORE  
 L - MAX. 820 μh, Q - 80  
 L - MIN. 360 μh, Q - 95

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
1 8	SP-102	LOCKING SPRING	
X 7	BS-100	SOLDER, SOFT	
X 6	GL-103	CEMENT, DUPONT	
X 5	GL-104-2	INSULEX, U-85	
X 4	WI-104-54IDSQS	WIRE 5/41 DS QS	
1 3	CT103DTB5	CORE	
1 2	TE-146-4	COLLAR & LUGS	
1 1	CF-114-3	COIL FORM	
<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK, NEW YORK			
BSC. COIL SUB ASSY.			
STOCK SIZE			
MATERIAL			
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	1	TEST DATA CHGD	6/4/56	2	JAW	P.L.X.	A.J.J.
A	1	COLOR CODE ADDED	5/31/56	1	JAW	P.L.X.	A.J.J.

TOLERANCES: DEC. DIM. ±, FRAC. DIM. ±, ANGULAR DIM. ±

SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	FFRD-2	E-458-P	A-703	4-10-56

USED ON

PLK 4/11/56  
 A.J.J.  
 A-702 B