

A-704

ASSEMBLY

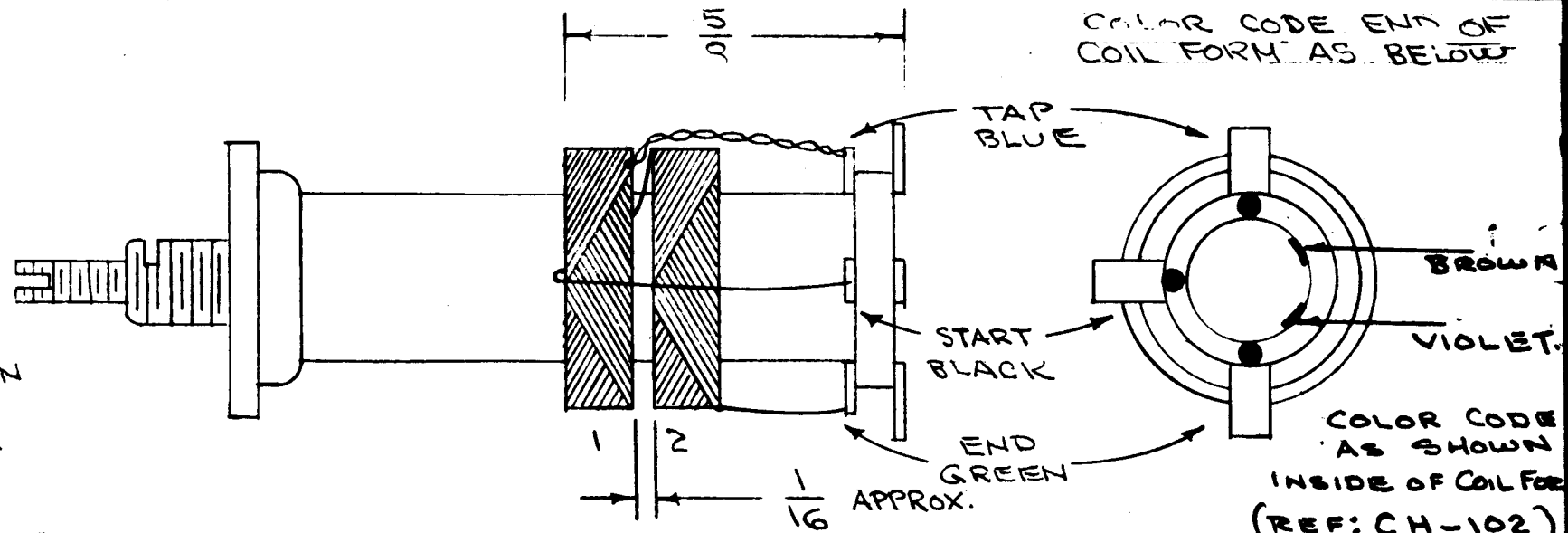
AFFIX COLLAR TO COIL FORM WITH ITEM 6 (CEMENT).
AIR DRY

WINDING MACHINE DATA

DRIVER GEAR - 90
 CAM GEAR - 87
 CAM - .156

WINDING PROCEDURE

- 1- START 1st PI 5/8" FROM LUG END OF COIL FORM AND IN LINE WITH BLACK LUG. USE WINDING FINGER WITH GUIDE ON LEFT. START WINDING WITH FINGER IN EXTREME LEFT HAND POSITION OF TRAVEL.
- 2- TAP 1st PI AT 12 3/4 TURNS ADJACENT TO BLUE LUG.
- 3- END 1st PI AT 245 TURNS
- 4- START 2nd PI 1/16" FROM 1st
- 5- END 2nd PI IN LINE WITH GREEN LUG AT 490 1/4 TURNS.
- 6- STAKE TAP & ENDS TO COIL FORM WITH ITEM 6. AIR DRY.
- 7- 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.



TAP 1st PI AT 12 3/4 TURNS FROM START
 END 1st PI AT 245 " " "
 END 2nd PI AT 490 1/4 " " "

TEST DATA w/o CORE

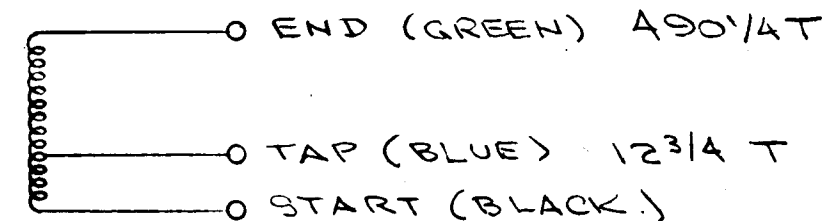
USE BOOTHOM Q METER 160A OR EQUIVALENT.

	GREEN - BLACK	GREEN - BLUE
L	2.85mh (2.7 - 3.0)	2.76mh (2.50 - 3.03)
Q	> 50	> 50
F	250 KC	250 KC

MISC. TEST DATA

OUT OF CAN WITH CORE L MAX. 7.8 mh Q 60
 L MIN. 3.1 mh Q 55

IN CAN WITH CORE L MAX. 6.0 mh Q 60
 L MIN. 2.7 mh Q 55



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
1	8	SP-102	SPRING LOCK
X	7	BS-100	SOLDER SOFT
X	6	GL-103	CEMENT
X	5	GL-104-2	INSULEX, U85
X	4	WI-120-15	WIRE #34 DSC
1	3	CI 03 D7 B5	CORE
1	2	TE-146-3	COLLAR & LUGS
1	1	CF-114-3	COIL FORM

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
ANTENNA COIL SUB ASSY.			
MATERIAL		T200 100-200 KC	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
		PLK 4/11/56	W.C.
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
		A-704	B

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	1	Test Data chgd	4/14/56	2	J.A.B.	P.J.K.	A.J.J.
A	1	COLOR CODE ADDED	5/3/56	1	J.A.B.	P.J.K.	A.J.J.

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

REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
1	FFRD-2	E-458-P	A-705	4-11-56
USED ON				