

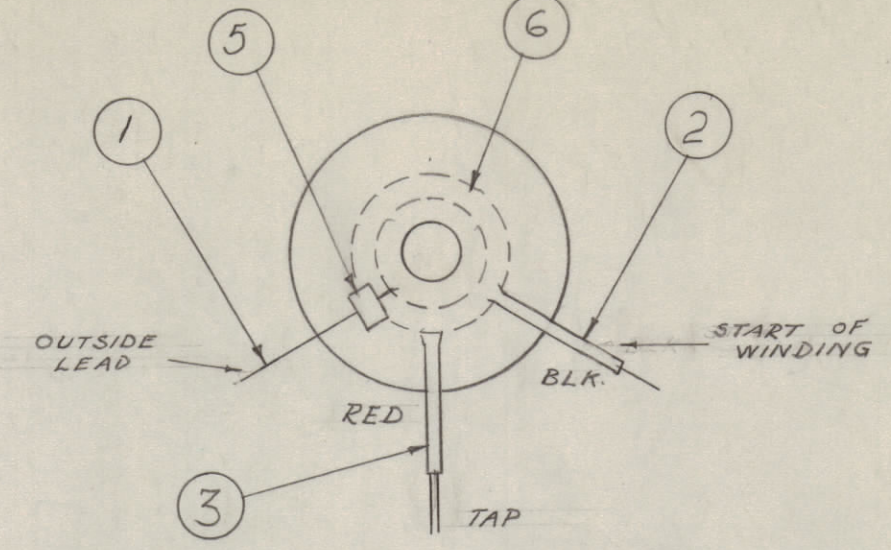
IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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

WINDING #1 WINDING #2

REV.	DATE	APR.	INDUCTANCE	WINDING #1		WINDING #2		ITEM 1 WIRE	MIN. Q.	ITEM 6 CORE
				LOAD	COIL	LOAD	COIL			
11-23			CL 201-369-TR41	15	215	88	1300	WI 122-51	55	CI-103-8
			-585-18R21	23	350	100	1600	WI 122-33	55	
			-605-10R64	18	260	105	1680	WI 122-34	55	
			-625-21R7	25	380	112	1700	WI 122-38	55	
			-655-15R62	21	320	114	1750	WI 122-38	55	
			-665-18R74	23	350	115	1780	WI 122-33	55	
			-675-6R29	14	200	116	1790	WI 122-33	60	
5-17-60			CL-201-125-000	65	920			WI-122-31	55	CI-103-7

TYPICAL INDUCTOR



- SPEC: INDUCTOR TO BE WOUND IN FOLLOWING MANNER:
- (1) STARTING WITH BLACK SLEEVING, WIND TURNS REQUIRED FOR PARTIAL INDUCTANCE; OVERWIND 5%. REMOVE INDUCTOR FROM MACHINE AND ADJUST INDUCTANCE TO SPECIFIED VALUE BY REMOVAL OF TURNS.
  - (2) MAKE CERTAIN THAT LEADS ARE SANDED CLEAN & TINNED WITH (ITEM 4)
  - (3) REPLACE INDUCTOR ON MACHINE, TWIST END OF FIRST WINDING WITH START OF SECOND WINDING; USING RED SLEEVING WIND TO VALUE SPECIFIED FOR TOTAL INDUCTANCE, MEASURED BETWEEN START OF WINDING (BLK.) AND OUTSIDE LEAD.
  - (4) INDUCTOR MADE UNDER THIS PROCESS SHALL BE CUT TO SIZE ACCORDING TO RESONANCE METHOD S-206 CAPACITANCE REQUIRED FOR RESONANCE & PROPER FREQUENCY OF RESONANCE ARE LISTED ON VALUE CHARTS, AND/OR ASSEMBLY PRINTS OF PARTICULAR UNITS WHERE TUNED CIRCUIT IS TO BE USED AS A SET.

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- NOTE:
- ALL INDUCTORS MADE ACCORDING TO THIS PROCESS SHALL BE TREATED IN FOLLOWING MANNER AFTER COMPLETION:
  - (1) HEAT IN OVEN AT 70°C FOR 1 Hr.
  - (2) COOL AT ROOM TEMP.
  - (3) SAME AS IN (1).
  - (4) IMMEDIATELY AFTER HEATCYCLING DIP IN ITEM 7 FOR 30 SECONDS.
  - (5) COOL AT ROOM TEMP.

REF. DWG-CL-201

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 7	GL110	IMPREGNATING WAX	
1 6	See Chart	CORE	
X 5	TA-102-1	TAPE, YELLOW FLAT BACK	
X 4	BS-100	SOLDER, SOFT	
X 3	PX-104-3-034	INSULATION, SLEEVING RED	
X 2	PX-104-1-034	INSULATION, SLEEVING BLK.	
X 1	SEE CHART	MAGNET WIRE, SINGLE	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
TOROIDAL INDUCTOR ASSY.			
MATERIAL		WEIGHT PER PC.	
TYPE & TEMPER		RD. 11-9-54	WZ
HEAT TREAT. SPEC.		JAS	A.J.S.
FINISH & SPEC. NO.		CHECKED	FINAL APPROVAL
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B	CHG'D IT1 TO SEE CHART# IT2 WAS PX-104-1-022. IT3 WAS PX-104-3-022. ADD IT7. NOTE 4 WAS COMPOUND GL110. CHG'D WIRING SIZE TO "IT1 WIRING" IN TABLE	10-19-66	17049	RME	JAS		
A	CL-201-125-000 ADDED	5-17-60					
ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES		SCALE:					
ALL OTHERS	DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±	DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.					

MODEL	PROJECT NO.	ASS'Y. NO.	DATE
USED ON			