

**COIL FORM ASSY.**  
 1- CEMENT TERMINAL RINGS TO COIL FORM WITH ITEM 4 IN POSITION SHOWN ABOVE.  
 2- COLOR CODE COIL FORM AS ABOVE.

**WINDING MACHINE DATA**

SECONDARY		PRIMARY	
RACK GEAR	100	DRIVER GEAR	95
RACK DRIVER	36	CAM GEAR	49
CAM	.187	CAM	.125
CAM GEAR	66		
DRIVER GEAR	63		

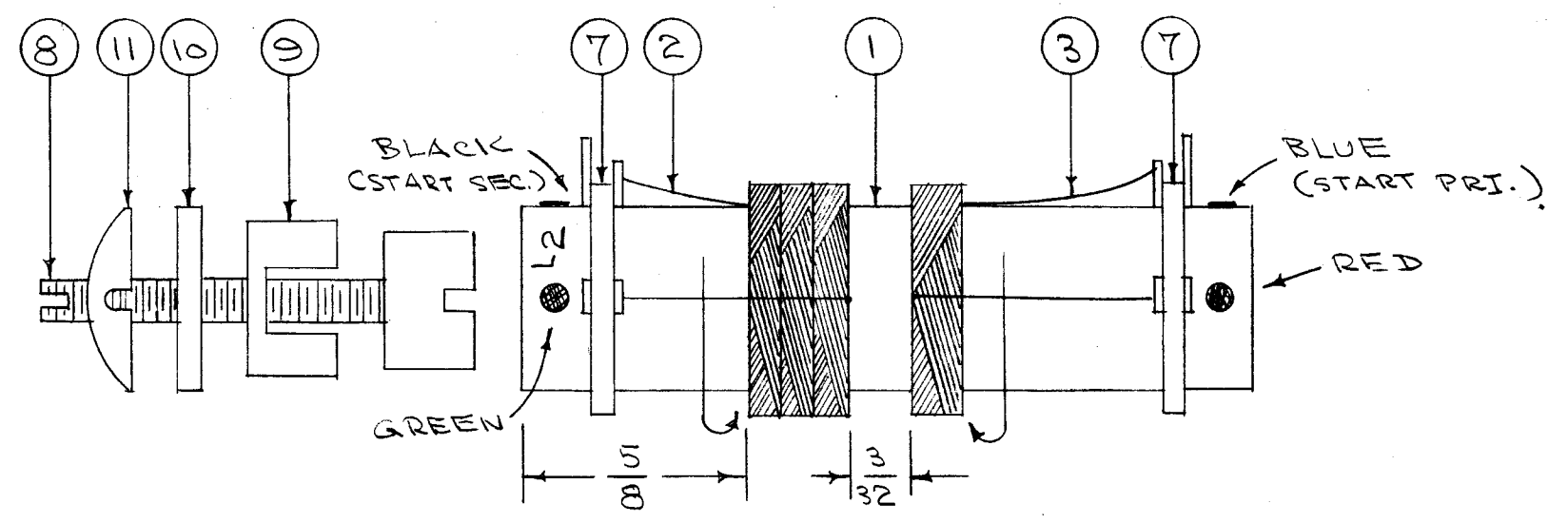
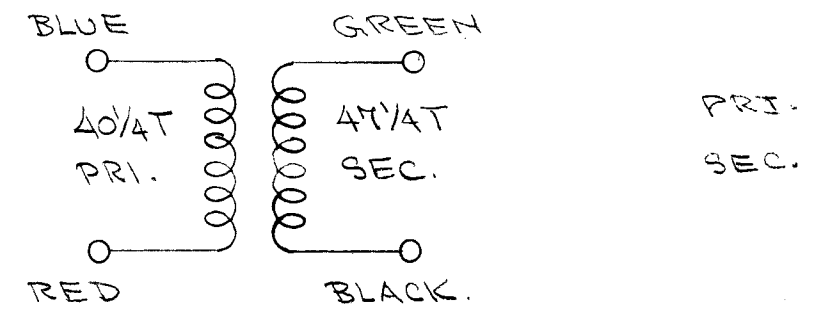
**WINDING DATA**

- SECONDARY (WIND ON BEFORE PRIMARY). STARTING AT BLACK LUG WIND ON 47 1/4 TURNS OF ITEM 2 (PROGRESSIVE UNIVERSAL WINDING), END ON GREEN LUG.
- PRIMARY - STARTING AT BLUE LUG 40 1/4 TURNS OF ITEM 3 (UNIVERSAL WINDING). END ON RED LUG.
- STAKE LEADS TO COIL FORM WITH ITEM 4. STRIP, TIN AND SOLDER LEADS TO LUGS AS SHOWN.
- BAKE FOR 1/2 HOUR AT 215° F.
- SATURATE COILS WITH ITEM 5. BAKE FOR 1/2 HOUR AT 215° F.
- REPEAT STEP 5.
- SOLDER TEST LEADS (APPROX. 1/4" #22 BUSS BAR) TO LUGS. TEST AS BELOW. REMOVE TEST LEADS.

**TEST DATA w/o CORE**

WINDING	* L μH	* Q	f	** R <sub>L</sub> APPROX.
SEC.	27.5 (26.1-28.9)	90 OR GREATER	2.5 MC	1.9
PRI.	32.5 (30.9-34.1)	40 " "	2.5 MC	2.6

\* USE BOONTON Q METER 160A OR EQUIV.  
 \*\* " SIMPSON OHMMETER 260 " " "



NOTE: COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 8-9-10-11 ARE CEMENTED TO COIL FORM WITH ITEM 12.

FOR IDENTIFICATION, STAMP THE NUMBER L2 ON THE COIL FORM IN ANY CONVENIENT SPOT.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 12	GL-111	CEMENT, "	
1 11	FS-112	FASTER	
1 10	WA-125-2	WASHER, FIBER	
1 9	NT-112	NUT, SPEED	
1 8	CI-109-7	CORE	
2 7	TE-146-2A	TERMINAL RING	
X 6	BS-100	SOLDER, SOFT	
X 5	GL-102	Q MAX	
X 4	GL-103	CEMENT, DUCO	
X 3	WI-67-17	WIRE, MAGNET #36 DSC	
X 2	WI-104-541-SN-QS	" , LITZ 5/41 SN, QS	
1 1	CF-112	COIL FORM	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
J	1	ITEM 2 WAS WI-104-541	2/5/64	10847	A.M.	T.R.	<i>[Signature]</i>
H	4	CHANGE TITLE	5/19/60	227	Cy	<i>[Signature]</i>	<i>[Signature]</i>
H	3	ITEM 7 WASTE-146-2					
H	2	ITEM 9 WAS NT-113					
H	1	ITEM 10 WAS WA-125					
G	2	Q OF 40 WAS 45	11/5/56	7	LG	P.L.K.	A.J.J.
G	1	Q OF 90 WAS 45					
F	1	REDRAWN COMPLETE REVISION	8/1/56	6	edd	P.L.K.	A.J.J.

TOLERANCES	SCALE:	1	6PR-90-RX0	5-23-60
DEC. DIM. ±	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES	1	6PR-90	297
FRAC. DIM. ±		REQ. PER UNIT	MODEL	PROJECT NO.
ANGULAR DIM. ±				

REQ. PER UNIT	MODEL	PROJECT NO.	SYMBOL NO.	DATE
1	6PR-90	297	L2	8-1-56
USED ON				

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
TRANSFORMER, RF TUNED, BAND 2			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
		P.L.K.	<i>[Signature]</i>
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

A.J.J.  
A-897 J