

COIL FORM ASSY.

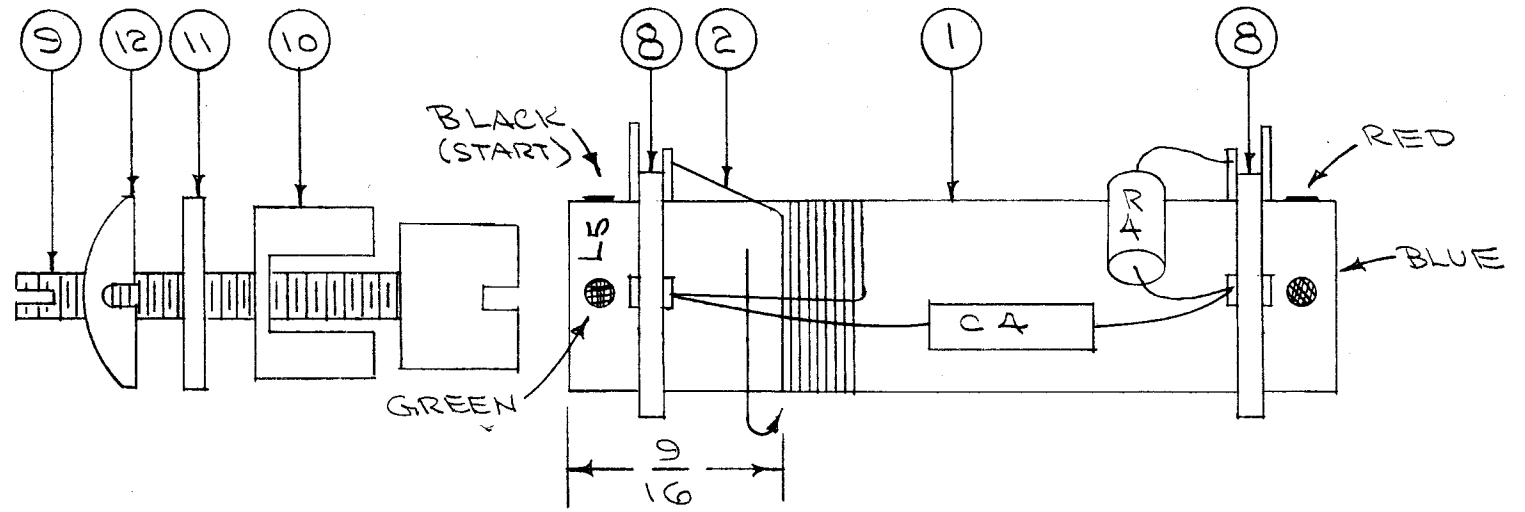
- 1- CEMENT TERMINAL RINGS TO COIL FORM WITH ITEM 4 IN POSITION SHOWN ABOVE.
- 2- COLOR CODE COIL FORM AS ABOVE.

WINDING MACHINE DATA

PINION GEAR 25
RACK DRIVER GEAR 100

WINDING DATA

- 1- STARTING AT BLACK LUG, 10 1/4 SPACE WOUND TURNS OF ITEM 2, ENDING AT GREEN LUG.
- 2- STAKE LEADS TO COIL FORM WITH ITEM 4. STRIP, TIN & SOLDER LEADS TO LUGS AS SHOWN.
- 3- BAKE FOR 1/2 HOUR AT 215° F.
- 4- COAT COIL WITH ITEM 5. BAKE FOR 1/2 HOUR AT 215° F.
- 5- REPEAT STEP 3.
- 6- SOLDER TEST LEADS TO LUGS (APPROX. 1/4" #22 BUSS) TEST AS PER CHART BELOW. REMOVE TEST LEADS.
- 7- SOLDER CAPACITOR & RESISTOR IN PLACE AS SHOWN.



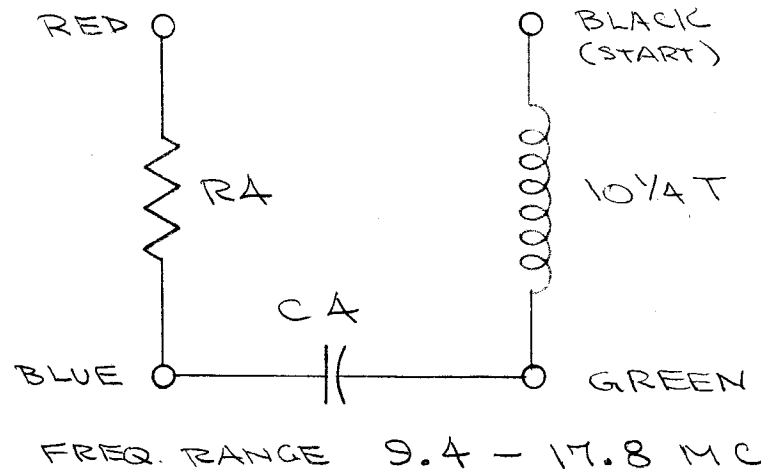
NOTE: COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 9-10-11-12 ARE CEMENTED TO COIL FORM WITH ITEM 13.

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

TEST DATA w/o CORE

L - 1.1 μh (1.04 - 1.16)
Q - 110 OR GREATER
F - 7.9 MC.

USE BOONTON Q METER 100A OR EQUIVALENT.



X	13	GL-111	CEMENT, "INSA-LUTE"	
1	12	FS-112	FASTENER	
1	11	WA-125-2	WASHER, FIBER	
1	10	NT-112	NUT, SPEED	
1	9	CI-109-9	CORE	
2	8	TE-146-2A	TERMINAL RING.	
1	7	RC32GF223J	RESISTOR, FIXED	RA
X	6	BS-100	SOLDER, SOFT	
X	5	GL-102	Q MAX	
X	4	GL-103	CEMENT, DUCO	
1	3	CM15C050J03YY	CAPACITOR, FIXED	CA
X	2	WI-107-5	WIRE, MAGNET #24 DSC	
1	1	CF-112	COIL FORM	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
TRANSFORMER, RF,			
MATERIAL			
TUNED, BAND 5			
		CDDB/1156	A.J.J.
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
			CHECKED
			FINAL APPROVAL
		P.L.K.	A 900 L
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

L		ITEM 3 WAS CC21SLO50C	3-30-67	18057	L.A.K.	JCB	
K		IT9 WAS CI109-7	6-20-66	16417	LHW	JCB	
J	2	ITEM 14 DELETED	5-20-60	2380	CY	JCB	
	1	STEP 8 DELETED.					
	4	CHANGE TITLE					
H	3	ITEM 7 WAS RC30GF153J	5-19	227	CY	JCB	
	2	NT-112 WAS NT-113					
	1	WA-125-2 WAS WA-125	60				
G	1	Item 14 & Note added.	4/3/59	737	J.C.B.		
F	1	Q of 110 WAS 125	1/15/56	6	LG	P.L.K.	A.J.J.
E	1	REDRAWN COMPLETE REVISION	8/1/56	5	000	P.L.K.	A.J.J.

ISSUE ITEM		CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES		SCALE:					
DEC. DIM. ±		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES					
FRAC. DIM. ±							
ANGULAR DIM. ±							

1	GPR-90-RXD		5-23-60
1	GPR-90	297	8-1-56
REQ. PER UNIT	MODEL	PROJECT NO.	SYMBOL NO.
			DATE
USED ON			