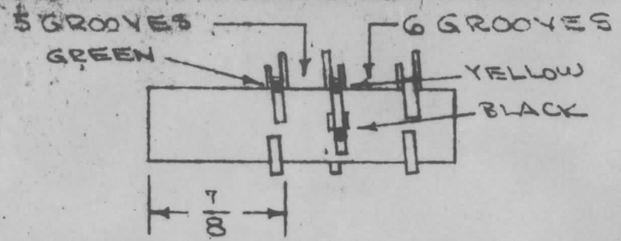
I

A-904



COIL FORM ASSEMBLY

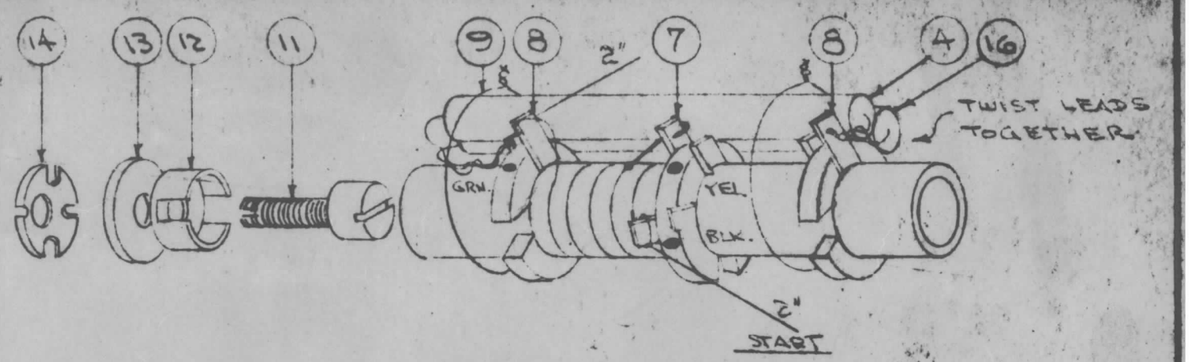
1- SPLIT THE TERMINAL RINGS.
2- CEMENT THE TERMINAL RINGS TO COIL FORM WITH ITEM 5. (NOTE THAT RINGS FOLLOW COIL FORM GROOVES.)
3- LUGS & GROOVED AREAS BETWEEN RING MUST BE FREE OF LUGS.
4- BAKE FOR ONE HOUR AT 300° F. ALLOW TO COOL AT ROOM TEMPERATURE.
5- COLOR CODE RINGS AS ABOVE.

WINDING DATA.

NOTE- KINKS MUST BE REMOVED FROM ALL WIRE USED.
1- WRAP AROUND BLACK LUG. WIND ON TIGHTLY IN GROOVES 4¼ TURNS OF ITEM 2. (ALLOW 2" LEAD EACH END FOR TEST PURPOSES). END WINDING ON GREEN LUG.
2- WRAP ITEM 3 AROUND YELLOW LUG. SOLDER TAP TO COIL AT 1¼ TURNS FROM START.
3- COAT WINDING, TAP & RINGS WITH ITEM 5. (LUGS AND WIRE ON LUGS MUST BE FREE OF U-95).
4- BAKE FOR ONE HOUR AT 300° F. COOL AT ROOM TEMPERATURE.
5- MAKE SOLDER CONNECTIONS ON LUGS.
6- SOLDER CONNECT CAPACITORS IN PLACE AS SHOWN. (TWIST CAP. LEADS TOGETHER.)
7- TIE CAPACITORS TO COIL FORM WITH ITEM 9. SEAL KNOTS WITH ITEM 10.

TEST DATA W/O CORE
USE BOONTON Q METER 160 A OR EQUIVALENT.
L- .25 μh (.22-.28)
Q- 145 OR GREATER
F- 25 M.C.
TEST LEADS TO BE 1¼" OVERALL

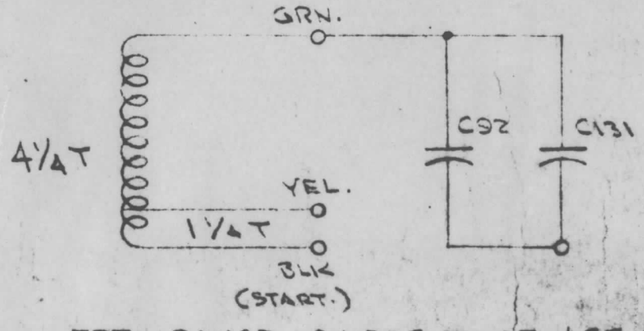
USE FOR MARK I SERIES ONLY



NOTE: KEEP CAPACITOR LEADS SHORT BUT DO NOT ALLOW CAP. TO TOUCH A LUG.

COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 11-12-13-14 ARE CEMENTED TO COIL FORM WITH ITEM 15.

FOR IDENTIFICATION STAMP THE NUMBER L18 ON THE COIL FORM IN ANY CONVENIENT SPOT.



FREQ. RANGE 21.255 TO 35.455 MC
MARK I

ITEM	QTY	PART NO.	DESCRIPTION	SYMBOL
16	1	CC45SH391J	CAPACITOR, FIXED	C131
15	X	GL-111	CEMENT, "INSA-LUTE"	
14	1	FS-112	FASTENER	
13	1	WA-125	WASHER, FIBER	
12	1	NT-113	NUT, SPEED	
11	1	CI-109-7	CORE	
10	X	GL-103	CEMENT, DUCO	
9	X	SD-101-3-MW	LACING CORD	
8	2	TE-146-1	RING, TERMINAL	
7	1	TE-146-2A	" " "	
6	X	BS-100	SOLDER, SOFT	
5	X	GL-104-2	INSULEX, U-95	
4	1	CC45SH391J	CAPACITOR, FIXED	C92
3	X	WL-100-7	WIRE, BUSS BAR #22	
2	X	WL-100-6	" " " " #20	
1	1	PX-323	COIL FORM	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
H	1	REDRAWN & REVISED	10/31/56	8	JNR	P.L.X	AJJ

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	GPR-90	297		7-30-56

USED ON

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL

STOCK SIZE
MATERIAL
TYPE & TEMPER HEAT TREAT SPEC.
FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

OSCILLATOR COIL ASSY. L18
BAND 6 GPR-90

DRAWN	CHECKED	FINAL APPROVAL
P.L.X		A.J.J

ELEC. DES. APP. MECH. DES. APP.

A-904 H