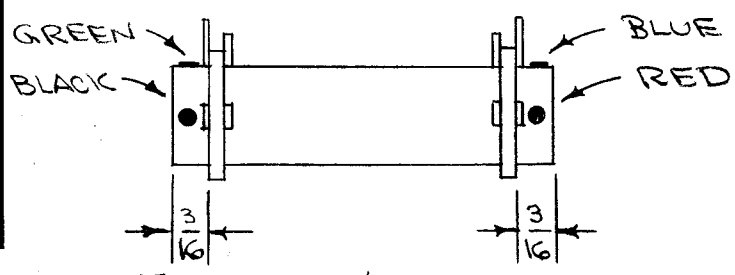


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**COIL FORM ASSY.**

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

**WINDING MACHINE DATA**

SECONDARY		PRIMARY	
RACK GEAR	100	DRIVER GEAR	95
RACK DRIVER	40	CAM GEAR	49
CAM	.125	CAM	.125
CAM GEAR	49		
DRIVER GEAR	95		

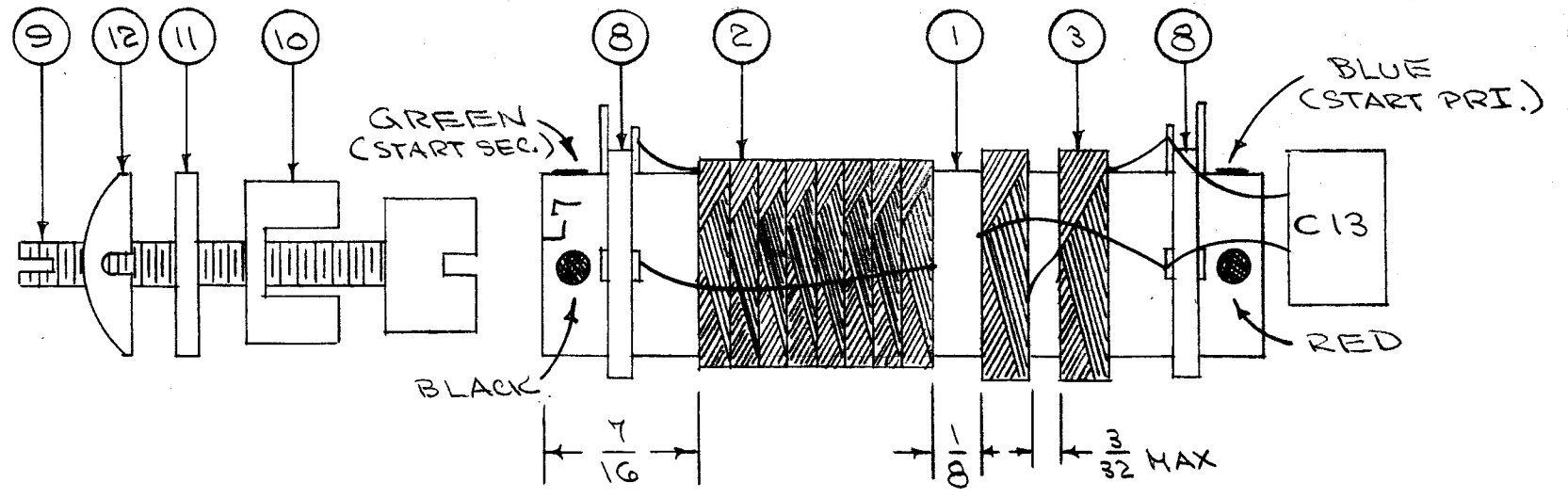
**WINDING DATA**

- 1- SECONDARY (WIND ON BEFORE PRIMARY). STARTING AT GREEN LUG, 160 1/4 TURNS OF ITEM 2. (PROGRESSIVE UNIVERSAL WINDING). END ON BLACK LUG.
- 2- PRIMARY - STARTING AT BLUE LUG, 2 Pi OF 75 TURNS EACH OF ITEM 3. END AT RED LUG.
- 3- STAKE LEADS TO COIL FORM WITH ITEM 4. BAKE FOR 1/2 HOUR AT 215° F.
- 4- STRIP, TIN & SOLDER CONNECT LEADS AS SHOWN.
- 5- SATURATE COILS WITH ITEM 5. BAKE FOR 1/2 HOUR AT 215° F.
- 6- REPEAT STEP 5.
- 7- SOLDER TEST LEADS TO LUGS (APPROX. 1/4" #22 BUSS) TEST AS PER CHART BELOW. REMOVE TEST LEADS.
- 8- SOLDER CAPACITOR IN PLACE AS SHOWN.

**TEST DATA w/o CORE**

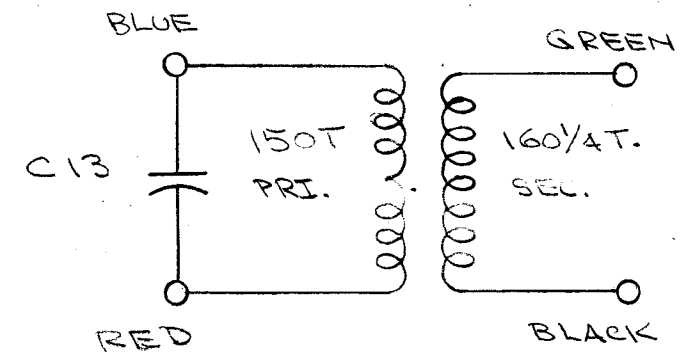
WINDING	* L uh	* Q	F	RD APPROX.
SEC	195 (185-205)	60 OR GREATER	790 KC	11.2
PRI	280 (266-294)	50 " "	790 KC	10.0

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



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 L7 ON THE COIL FORM IN ANY CONVENIENT SPOT.



FREQ. RANGE .535 - 1.45 MC.

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	CE-109-11	CORE	
2	8	TE-146-2A	TERMINAL RING	
1	7	CM100-11	CAPACITOR, FIXED	C13
X	6	BS-100	SOLDER, SOFT	
X	5	GL-102	Q MAX	
X	4	GL-103	CEMENT, DUCO	
X	3	WI-107-17	WIRE, MAGNET #36 DSC.	
X	2	WI-104-341-SC-QS	WIRE, LITZ 3/41 SC, QS	
1	1	CF-112	COIL FORM	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK. NEW YORK			
STOCK SIZE			
TRANSFORMER, RF, TUNED, BAND I			
MATERIAL			
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
L	1	IT.7 WAS CM20D162F	9/28/66	16893	HUA	[Signature]	
K	2	ITEM 2 WAS WI-104-341-SC-QS	2/5/64	10847	A.M	TR	[Signature]

REQ. PER UNIT	MODEL	PROJECT NO.	SYMBOL NO.	DATE
1	GPR-90	297	L7	5-23-60
	GPR-90			8-2-56

USED ON

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

500 2 1/2 [Signature]  
 [Signature] [Signature]  
 A. J. J.  
 FINAL APPROVAL  
 P. L. K.  
 A-961 L