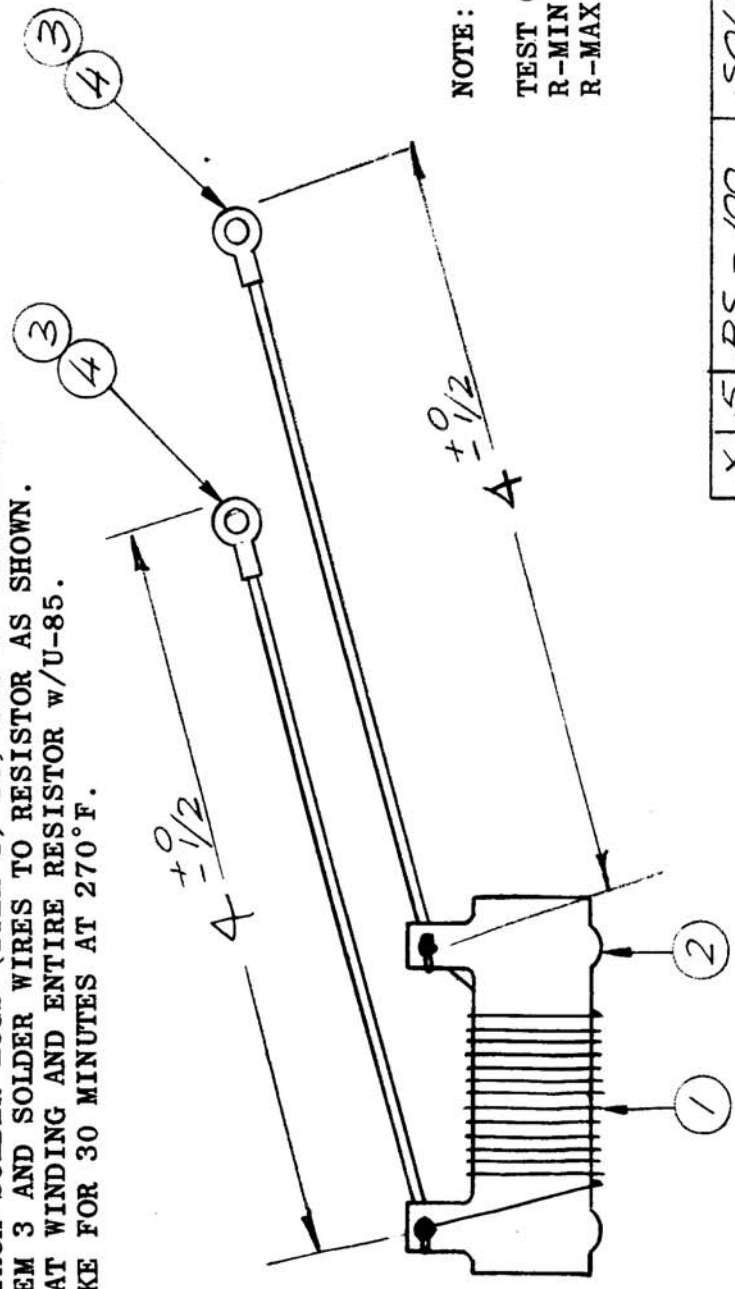


AR-111 A

REQ. PER UNIT	M DEL	USED ON
2	PS-4	ASST. NO. PAL-1K
		DATE 8-6-59

PROCEDURE

1. WIND 13 TURNS OF WIRE (ITEM 1) ON RESISTOR (ITEM 2), CLOSE WOUND.
2. ATTACH SOLDER LUGS (ITEM 4) TO, TWO 4" PIECES OF ITEM 3 AND SOLDER WIRES TO RESISTOR AS SHOWN.
3. COAT WINDING AND ENTIRE RESISTOR w/U-85.
4. BAKE FOR 30 MINUTES AT 270°F.



NOTE:

TEST ONE UNIT OF 100
 R-MIN 0.008 Ω
 R-MAX 0.010 Ω

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 5	BS - 100	SOLDER, SOFT	
2	TE-155-34170	TERMINAL, SOLDERLESS	
X 3	MWC12(19)UO	CABLE, INSULATED	BLACK
1	RW-109-28	RESISTOR, WIREWOUND	
X 1	WI-108-2	WIRE, CEROC (HI TEMP)	
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
RESISTOR, SHUNT ASSY			
MATERIAL		J.C. Biele	
STOCK SIZE		DRAWN	
TYPE TEMPER		CHECKED	
HEAT TREAT. SPEC.		FINAL APPR VAL	
FINISH & SPEC. N.		AR-111 A	

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	COMPLETELY REV.	12/27/68	19144	CV	J.C. Biele	E.F.H.
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						