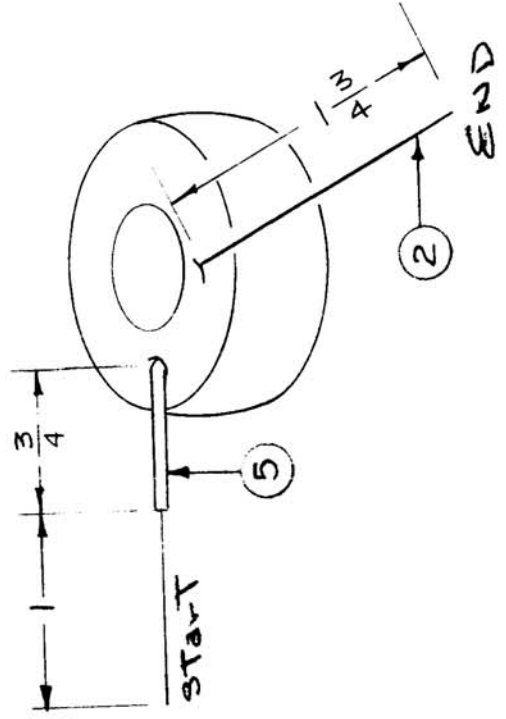


CL-128 A

REQ. PER UNIT	1 Each	MODEL	FX-153	USED ON	DATE
ASBY. NO.	A-1407				3-27-57

IMPEDANCE ohms	Q GREATER THAN	ITEM 2 WIRE	APPROX. LOAD TURNS
18.4	15	WI-123-31	47
13.3	15	WI-123-30	30
16.9	15	WI-123-30	35
13.3	15	WI-123-30	30
14.0	15	WI-123-30	31
13.3	15	WI-123-30	30
14.0	15	WI-123-30	31
18.4	15	WI-123-31	33



WINDING PROCEDURE

1. Wind all coils to inductance required, in accordance with TMC Specification S-337
2. Winding machine changes:
  - a. Remove top rubber tired wheel and replace with solid brass wheel.
  - b. Back off turns counter contact finger.
  - c. Connect ground end of impedance bridge to base of winding machine.
  - d. Connect hot end of impedance bridge to start lead on t roid.
3. Wind toroid in a back and forth motion checking induct. as it is being wound.
4. Bake for 1/2 hour at 215° F.
5. Submerge hot coil in GL-110.

REQ. ITEM	5	DESCRIPTION	Wire Hook-up #28	SYMBOL	Blk.
	4		Impregnating Wax		
	3		Insulation, Sleeving, Black		
	2		Wire, Magnet		
	1		Core, Molybdenum Permalloy Powder		
THE TECHNICAL MATERIEL CORP.					
MAMARONECK, NEW YORK					
REACTOR, TOROIDAL					
(FX-153)					
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	163-27-57	CHECKED	A. J. J.
FINISH & SPEC. NO.					CL-128
					A

ISSUE ITEM	2	CHANGED FROM	1	DATE	7-26-57	DRAFTS	CHECKER	ENG. APP.
TOLERANCES								
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.								
REMOVE ALL BURRS AND SHARP EDGES								
DEC. DIM. ±								
FRAC. DIM. ±								
ANGULAR DIM. ±								