

CL-141

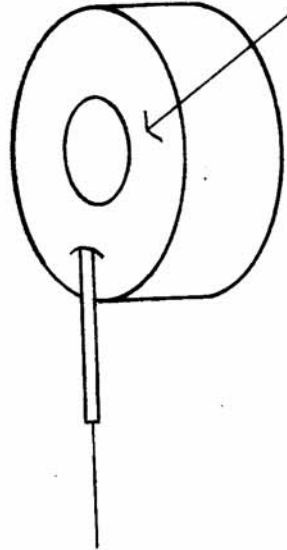
UNIT 1  
 MODEL A-1501  
 ASSY. N. DATE 11-11-58

WINDING MACHINE DATA  
 (Boesch Winding Machine)

1. Approximate Load Length - 65 Feet

WINDING PROCEDURE

1. Wind coil to 33.2 millihenries, in accordance with TMC Specification S-337.
2. After proper inductance has been reached and checked, (use Inductance Bridge - General Radio Model 650-A), bake coil for  $\frac{1}{2}$  hour at 215°F.
3. Submerge hot coil in GL-110 (item 3).
4. Resonate coil in accordance with TMC Specification S-400.



INDUCTANCE - 33.2 MILLIHENRIES  
 Q MUST BE 15 OR GREATER AT 1KC

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 5	LAC28(7)UO	Cable, Hook-Up	BLACK
X 4	PY-104-1-022	Insulation, Sleaving	S-337
X 3	GL-110	Wax, Impregnating	
X 2	WI-123-92	Wire, Magnet	
1 1	CI-103-34	Core	
THE TECHNICAL MATERIAL CORP. MAMARONECK, NEW YORK			
REACTOR, TOROIDAL			
33.2 MH			
J.C. BIELE	DRAWN	CHECKED	FINAL APPROVAL
TYPE & TEMPER		HEAT TREAT. SPEC.	
FINISH & SPEC. NO.		CL-141 A	

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	EN. APP.
A 1	ITEM(2) WAS WI-123-33	8-1-63	9684	AK.	J.M. Beld	

SCALE:  
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.  
 REMOVE ALL BURRS AND SHARP EDGES