

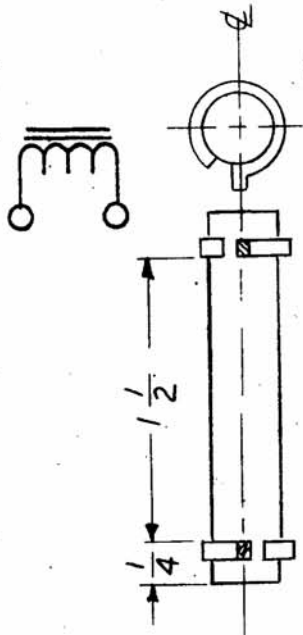
CORE AND TERMINAL RING ASSEMBLY:

1. Assembl Terminal Rings (Item 1) to Ferramic Core (Item 2), Maintaining 1-1/2" between Rings As Shown.
2. Apply GL-104-2 Around Terminal Rings (Item 1).
3. Bake for One-Half Hour at 215°F.

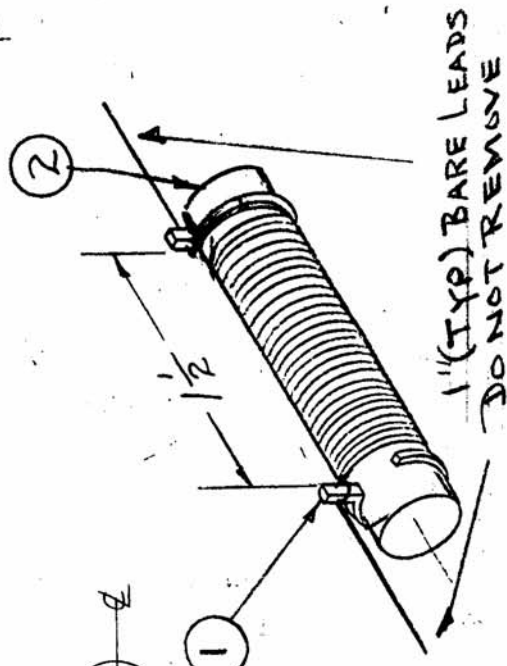
WINDING DATA:

1. Starting Close to Terminal Ring as Shown, Solenoid Wind 32 Turns of WI-123-18 (Item 4) onto Core Sub-Assembly Leaving Approximately 1" Bare Lead Lengths (Do Not Remove).
2. Stake Leads to Terminal Rings With BS-100 (Item 5).
3. Check Inductance.
4. Saturate Coil Assembly with GL-104-2 (Item 3).
5. Bake for One-Half Hour at 215°F.

SCHEMATIC



TOP VIEW
NOTE POSITION OF LUGS



| REQ. ITEM | PART NO. | DESCRIPTION | SYMBOL |
|-----------|--------------|------------------------------|--------|
| X 5 | BS-100 | SOLDER, SOFT | |
| X 4 | WI-123-18 | MAGNET WIRE, HEAVY | |
| X 3 | GL-104-2 | RESIN, SYNTHETIC | |
| 1 | CI112Q1-2R0F | CORE, FERRAMIC | |
| 2 | TE-153-2 | TERMINAL, RING CLIP | |
| | | GELLMAN | |
| | | THE TECHNICAL MATERIEL CORP. | |
| | | MAMARONECK, NEW YORK | |
| | | CL-292 ASSEMBLY | |
| | | MATERIAL | |
| | | TYPE & TEMPER | |
| | | HEATTREAT. SPEC. | |
| | | CHECKED | |
| | | DRAWN | |
| | | ELEC. DES. APP. | |
| | | MECH. DES. APP. | |
| | | FINISH & SPEC. NO. | |
| | | FINAL APPROVAL | |
| | | CL 292 | B |

| SYM | DESCRIPTION | DATE | CH. NO. | DRAFTS | CHECKER | ENG. APP. |
|-----|-------------------|---------|---------|--------|---------|-----------|
| B | REDRAWN & UPDATED | 4/18/71 | 20215 | CV | CV | Red |

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES ON
FRAC. ± 1/64 DEC. ± .005 ANGLES ± 1/2°

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