

DATE 10/6/55
SH. 1 OF 2

TMC SPECIFICATION NO. S - 274

COMPILED BY
P.L.K.

TITLE: COIL ASSEMBLY AND BAKING

JOB

APPROVED G.T.O. A

A. PURPOSE: To provide a uniform method of assembling and baking coils.

B. PROCEDURE:

1. Winding procedure:

a. Set up winding machine (if used) according to instructions found in coil print.

b. Wind on correct number of turns.

c. Stake end of coil with GL-103, Dupont "Duco" cement.

2. Assembly: Coils with one mounting bushing (SM-110).

a. Check bushing first with proper core to make sure core doesn't become bound in form.

b. Coat bushing end of coil form with "Duco" cement and let set.

c. Place bushing SM-110 upon end of coil form and press into place.

3. Assembly: Coils with two mounting bushings (SM-110).

a. Check bushing first with proper core to make sure core doesn't become bound in form.

b. Coat ends of coil form with "Duco" cement and let set.

c. Place bushing SM-110 with correct core in place on proper end of coil form and press it into place.

4. Drying:

a. Place in oven and bake at 215° F. for a half hour.

5. Varnishing:

a. Remove from oven and saturate coil with varnish called for on print. Coat coil form and end sealing bushing to form with same varnish.

b. Air dry for t n minutes before baking.

DATE 10/6/55
SH. 2 OF 2

TMC SPECIFICATION NO. S- 274

COMPILED BY
P.L.K.

TITLE: COIL ASSEMBLY AND BAKING

JOB

APPROVED G.T.O. | A

6. Baking: Replace in oven and bake as follows:

<u>Manufacturer</u>	<u>Varnish</u>	<u>Temp. °F.</u>	<u>Time</u>
Insul-X	U-85	215	2 hr.
	U-95	215	2 hr.
Q-Max	A-27	215	1/2 hr.
	A-28	215	1/2 hr.

7. Finished coil to have a hard solid coating of insulating varnish so that no holes appear between individual windings.

