



**PROCEDURE**

1. ASSEMBLE COIL FORM ITEM 1 ON A .250 MANDREL CAPABLE OF MOLDING COIL FORM SECURE AND UNDAMAGED AGAINST WINDING TENSION OF 2.5 TO 3.0 INCH-POUNDS AS MEASURED ACROSS MANDREL WITH INCH-POUNDS SCALE.
2. WIND SECONDARY USING ITEM 3 IN START THREAD OF ITEM 1. SECURE START OF WINDING USING ITEM 2 SO THAT START THREAD IS VISIBLE. SET TENSION AT 2.5 TO 3.0 INCH-POUNDS AND HAND WIND REQUIRED TURNS ENDING IN LINE WITH START THREAD. TAPE END OF WINDING WITH ITEM 2 BEYOND LAST TURN. USING ITEM 4 WIND TIGHTLY IN SAME DIRECTION THE CORRECT NUMBER OF PRIMARY TURNS EVENLY SPACED AND SECURE WITH ITEM 2 SO THAT ALL TURNS ARE VISIBLE. BAKE AT 215°F FOR 1/2 HOUR TO REMOVE MOISTURE.
3. COAT EXPOSED COIL TURNS WITH ITEM 5. DO NOT COAT THE HOLDING TAPE OR MACHINED ENDS OF ITEM 1. BAKE AT 215°F FOR 1 HOUR.
4. CAREFULLY REMOVE HOLDING TAPE AT BOTH ENDS. APPLY NEW ITEM 2 DIRECTLY OVER COIL TURNS AND FLUSH WITH ENDS OF WINDING. SEAL WITH ITEM 5. TRIM ALL LEADS 2". STRIP AND TIN TO WITHIN 3/8" OF COIL FORM. TWIST AND SOLDER PRIMARY AND SECONDARY LEADS TOGETHER AT START THREAD. MARK WITH TMC P/N.

REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
	X1	REDRAWN WITH CHANG.	10/6/69		KH	
	0	ORIG RELEASE FOR PROD	4/6/70		CV	

PART NO.	ITEM 1	NO. OF TURNS SECONDARY	NO. OF TURNS PRIMARY	SYM. NO.
TT304-1	CF141-4	42	4	T1
TT304-2	CF141-3	30	3	T2

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
X	6	BS100	SOLDER, TIN ALLOY	
X	5	GL104-2	INSULEX, U85	
X	4	WI141-26-9	WIRE, ELEC., MAG., INS.	
X	3	WI141-22-9	WIRE, ELEC., MAG., INS.	
X	2	TA101-1	TAPE, FIBERGLASS	
1	1	SEE CHART	COIL FORM, THREADED	

**POSE LIST OF MATERIAL**

**THE TECHNICAL MATERIEL CORP.**  
MAMARONECK, NEW YORK

**TRANSFORMER, ANTENNA**

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	TT304	0
SCALE	SHEET		OF

1	HERR-4	AX5005
QTY / UNIT	MODEL USED ON	ASS'Y NO.
APPLICATION		
	CODE	

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES

DECIMALS: X ± .05, .XX ± .01, .XXX ± .005  
 FRACTIONS: 1/64  
 TOLS.: ANGLES 0°-30'

FINISH

FINAL APPROVAL: [Signature] DATE: 7-6-70  
 MECH. DES. DATE:  
 ELECT. DES. [Signature] DATE: 7-2-70  
 CHECKED: [Signature] DATE: 4/2/70  
 DRAWN: [Signature] DATE: 10/6/69