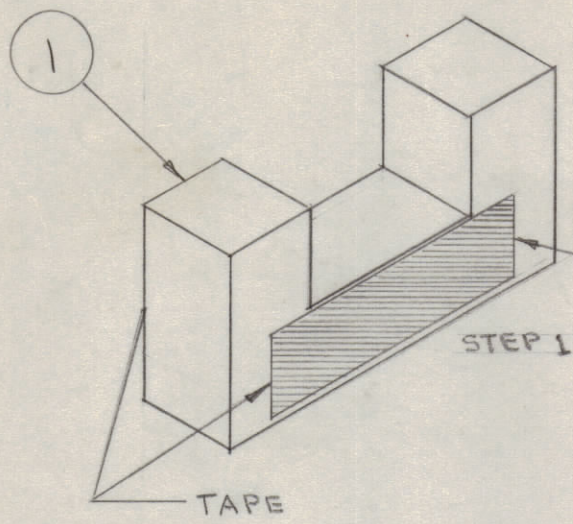


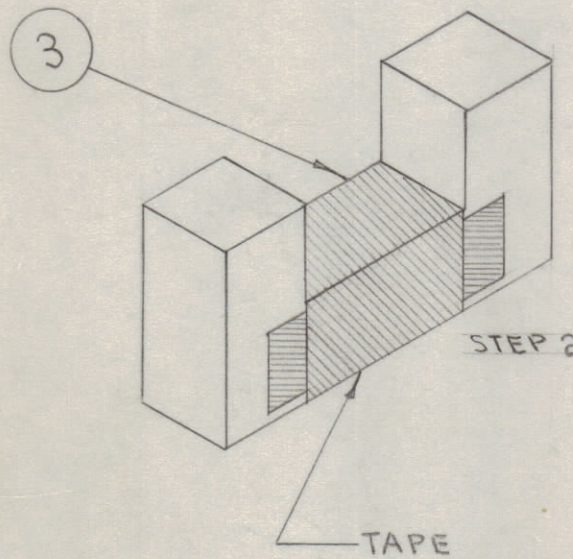
IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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

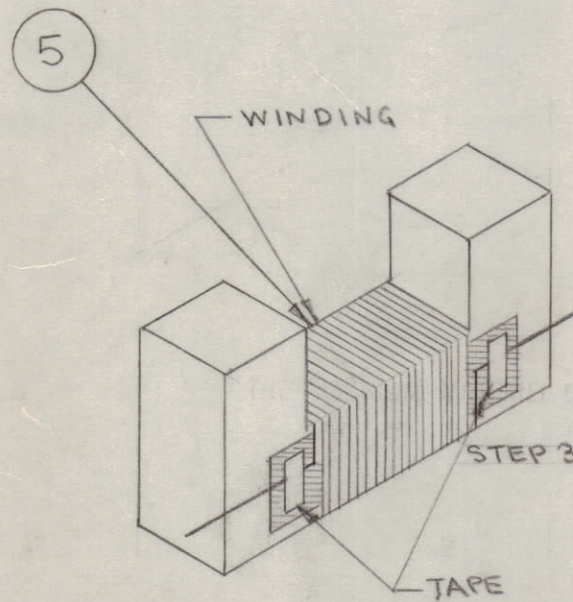
RELEASED



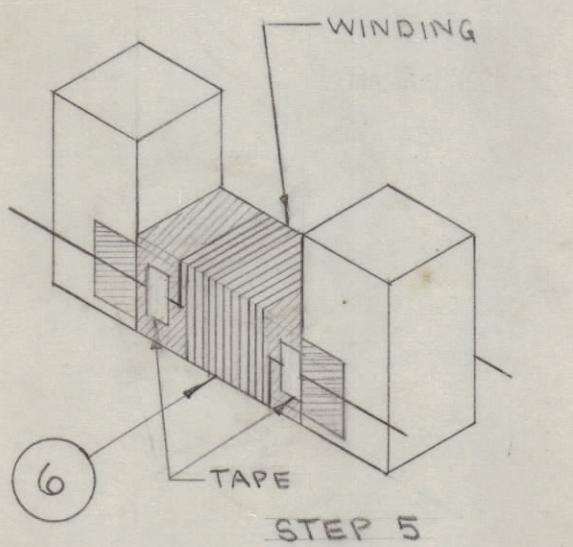
STEP 1.
MOUNT ON EACH SIDE OF CORE ONE (1) PIECE OF HALF INCH TAPE, TWO INCHES LONG.



STEP 2.
WRAP 1/4 TURNS OF 1/4 INCH TAPE AROUND MIDDLE OF CORE.

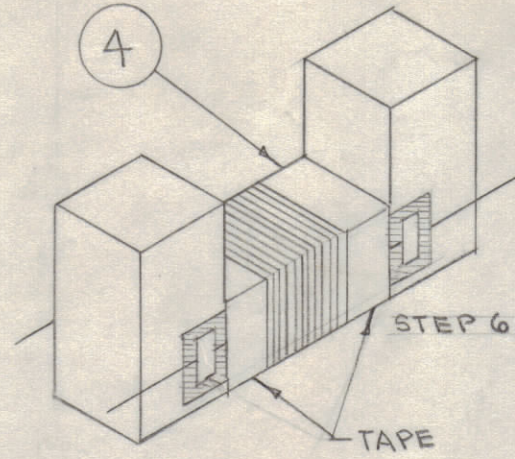


STEP 3.
FIRST WINDING SHALL BE 120 CLOSE WOUND TURNS OF NO. 36 DSC. FIRST TURN SHOULD START CLOSE TO INSIDE CORNER OF CORE AS WINDING WILL FILL SPACE. ALLOW 4 INCH LEADS. BRING ENDS STRAIGHT OUT AND SECURE WITH SMALL PIECES OF TAPE AS SHOWN.

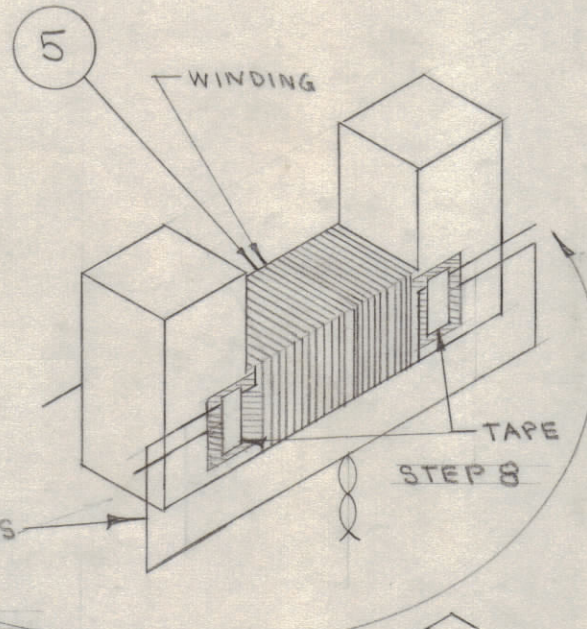


STEP 4.
WRAP 1/4 TURNS OF 1/4 INCH TAPE AROUND CENTER OF TO COVER FIRST WINDING.

STEP 5.
SECOND WINDING SHALL BE 21 CLOSE WOUND TURNS OF NO. 26 CEC. START WINDING 5/16 FROM INSIDE EDGE OF CORE. WIND IN SAME DIRECTION OF ROTATION AS FIRST WINDING. BRING LEADS OFF ON OPPOSITE SIDE FROM FIRST WINDING. ALLOW 4 INCH LEADS. BRING ENDS STRAIGHT OUT AND SECURE WITH SMALL PIECES OF TAPE AS SHOWN.

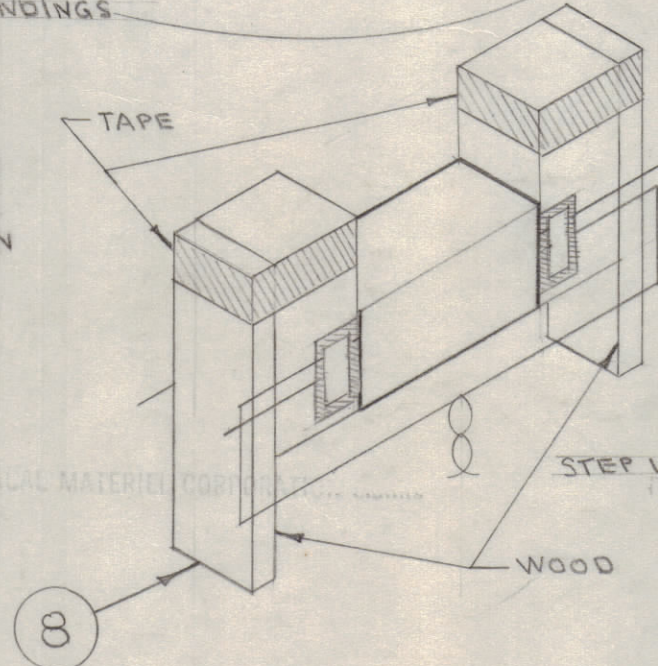


STEP 6.
WIND 3 OR 4 TURNS OF 1/4 INCH TAPE ON BOTH SIDES OF CORE TO ACT AS FILLER. THEN REPEAT STEP 1.



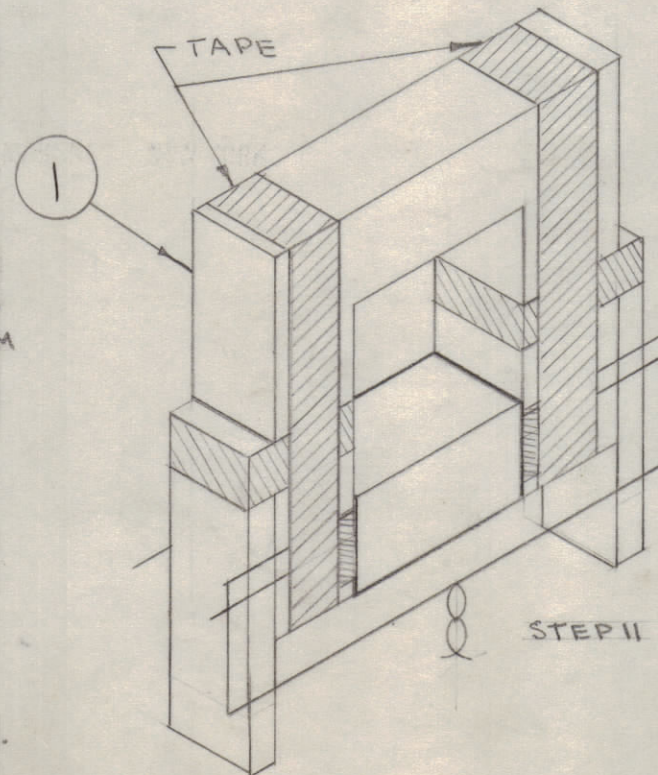
STEP 7.
WRAP 1/4 TURNS OF 1/4 INCH TAPE AROUND MIDDLE OF CORE TO COVER SECOND WINDING.

STEP 8
WINDING NO. 3. STARTING ON SAME SIDE AS FIRST WINDING, IN SAME DIRECTION OF ROTATION, WIND ON 120 TURNS OF NO. 36 DSC. ALLOW 4 INCH LEADS. BRING END STRAIGHT OUT AND SECURE WITH SMALL PIECES OF TAPE AS SHOWN. THEN TWIST BEGINNING OF 3RD WINDING WITH END OF 1ST WINDING.

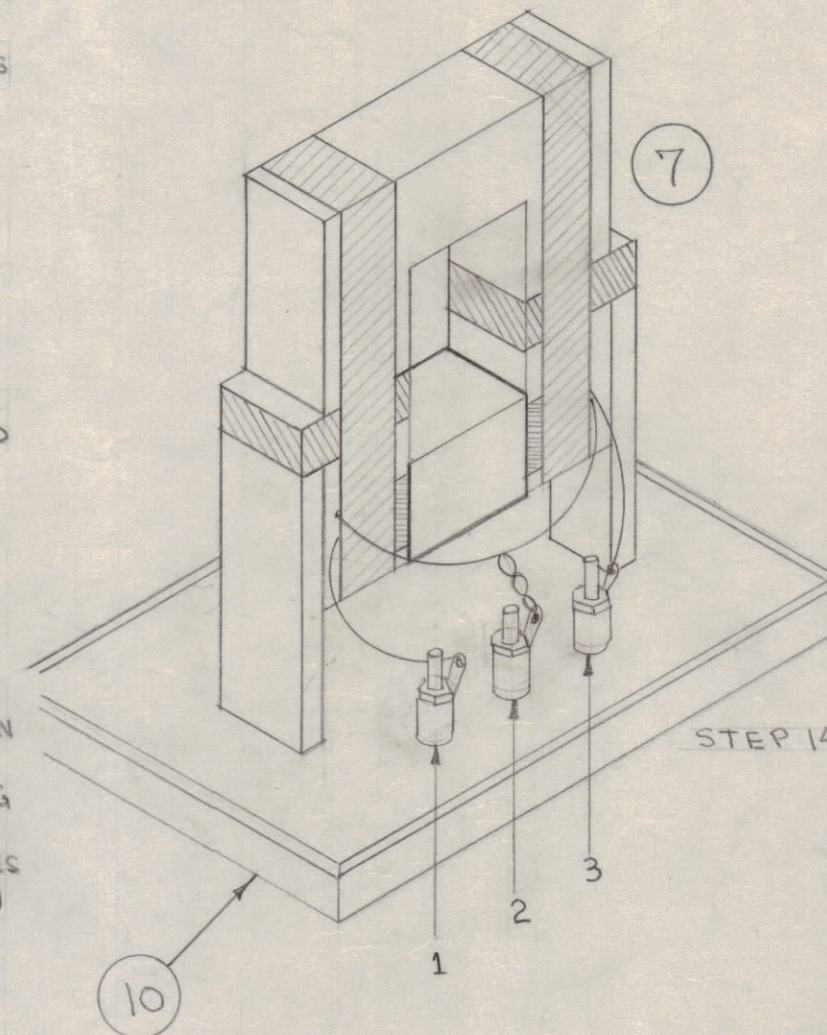


STEP 9.
WRAP 2 TURNS OF 1/4 INCH TAPE AROUND MIDDLE OF CORE TO COVER THIRD WINDING.

STEP 10.
USING THE 1/2 INCH TAPE, WRAP 2 TURNS AROUND ENDS OF POLES (CORE WITH WINDINGS) AND ENDS OF WOOD SPACER. MAKE SURE TAPE DOES NOT LAP OVER ON POLE FACES.



STEP 11.
TO JOIN TWO CORE PIECES (ONE BLANK AND ONE WITH WINDINGS), WRAP TOGETHER WITH 1/2 INCH TAPE, TWO TURNS AT EACH END. MAKE SURE NOTHING IS BETWEEN POLE FACES SO THEY WILL MEET SMOOTHLY AND TIGHTLY.



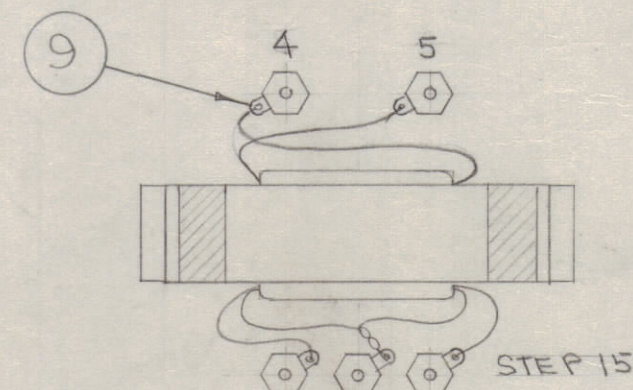
STEP 12.
BAKE IN OVEN FOR 2 HOURS AT 250° F.

STEP 13.
WHEN COOL MAKE TESTS. (S-130) CONTINUE OPERATIONS AS SOON AS POSSIBLE SO TRANSFORMER WILL HAVE LEAST CHANCE TO ABSORB MOISTURE.

STEP 14.
STAND TRANSFORMER ON BOTTOM OF CAN ALIGNING WITH TERMINALS AS SHOWN.

STEP 15.
SOLDER WIRES TO TERMINALS. TWISTED PAIR TO CENTER TERMINAL NO. 2. OTHER PRIMARY LEADS (36 DSC) TO TERMINALS 1 AND 3. SECONDARY LEADS (26 CEC) TO TERMINALS 4 AND 5. (START TO 5 - END TO 4)

STEP 16.
SOLDER TERMINAL COVER TO CASE. FILL VOID WITH ITEM 7



DO NOT PLACE TO PERSONS RECEIVING THIS DRAWING

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THE TECHNICAL MATERIEL CORPORATION
MAMARONECK, NEW YORK

TO WITHIN 1/16 OF OPENING. PUT TOP IN PLACE. ALLOW TO COOL FOR MINIMUM OF 2 HOURS. SOLDER TOP IN PLACE AND ALLOW TO COOL TO ROOM TEMPERATURE. CLEAN OFF EXCESS SOLDER, FLUX AND FOREIGN MATTER. APPLY S-114 AND S-115 TO ALL SURFACES EXCEPT TERMINAL LUGS AND BOTTOM. STEP 17. TEST AS PER S-130.

A-149 B

B	3	WAS LD-113	11-12-51	7	C.O.D.	OK	OK
A	2	WAS TA-100-1-2-5	11-9-51	1	C.O.D.	OK	OK
	1	WAS 1	11-7-51	1	C.O.D.	OK	OK
ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES		SCALE:					
ALL OTHERS	DEC. DIM. ±	DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.					
	FRAC. DIM. ±						
	ANGULAR DIM. ±						

NOT TO BE RELEASED W/O AUTHORIZATION

AUTH. BY: _____

DATE: _____

LFA	109	A-201	10-21-51
MODEL	PROJECT NO.	ASS'Y. NO.	DATE
USED ON			

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
1	11	LD-112	LETTER STAMPING	
1	10	A-148	CASE + TERM., SUB ASSY.	
X	9	BS-100	SOLDER, SOFT	
2	8	WD-110	BRACE	
X	7	GL-100	POTTING COMPOUND	
X	6	WI-102-7	#26 WIRE CEC	
X	5	WI-107-17	#36 WIRE DSC	
X	4	TA-101-1	TAPE, 1/4" WIDE	
X	3	TA-101-5	TAPE, 1/4" WIDE	
X	2	TA-101-2	TAPE, 1/2" WIDE	
2	1	CI-101-1	CORE, TRANSFORMER	
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
TRANSFORMER, R.F. OUTPUT				
SUB ASSEMBLY (TR-019)				
TYPE & TEMPER		CAP. 9-18-52 A. J. J. M.H.S.		
MATERIAL		DRAWN ELEC. DES. APP. MECH. DES. APP.		
HEAT TREAT. SPEC.		M.H.S. CHECKED FINAL APPROVAL		
FINISH & SPEC. NO.		A-149 B		