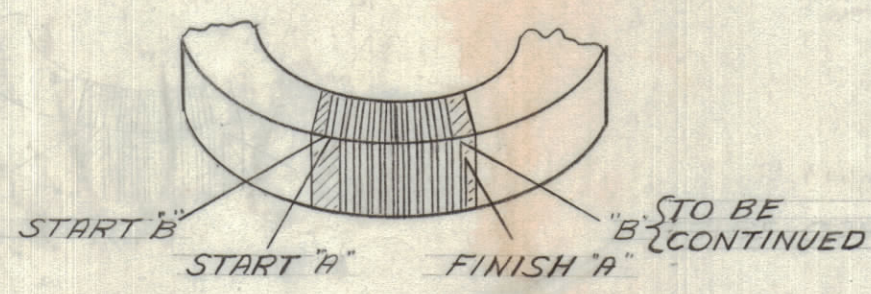


IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.		DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED					
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES.							
ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
A		IT WAS CM35F562603 IT WAS WI 102-9	4/15/64	15418	M.V.	J.P.	M.M.

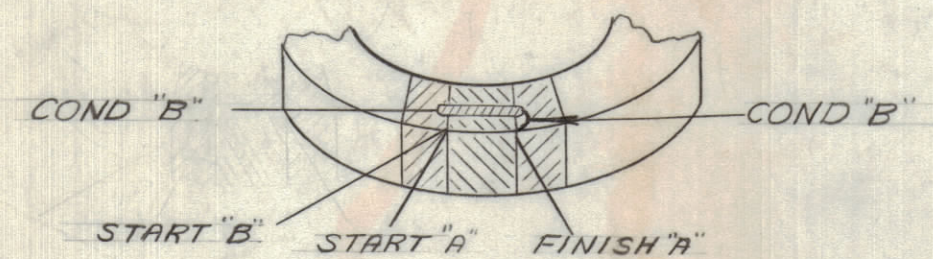
REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
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STEP 1 WINDING INSTRUCTIONS

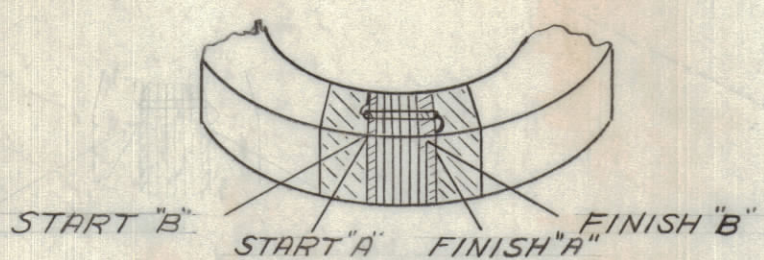
- A) Wind one layer of 1/2" masking tape (Item 9) over core. (Item 2).
- B) Using two strands of wire, (Item 7) close wind 10 turns bifilar over tape on core. Stake winding with cement, (Item 11).



- C) Wind one layer of 1/4" masking tape, (Item 8) over the winding of step (B).
- D) Bring conductor "B" across to the left of the winding. Fold a small piece of masking tape over the part of the wire lying across the previous turns.

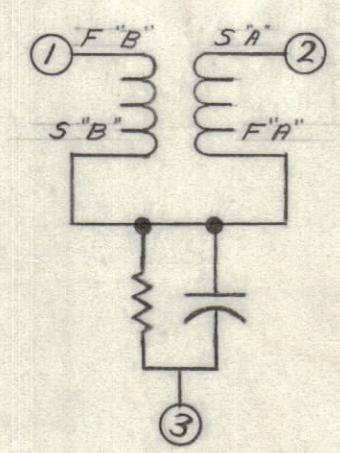
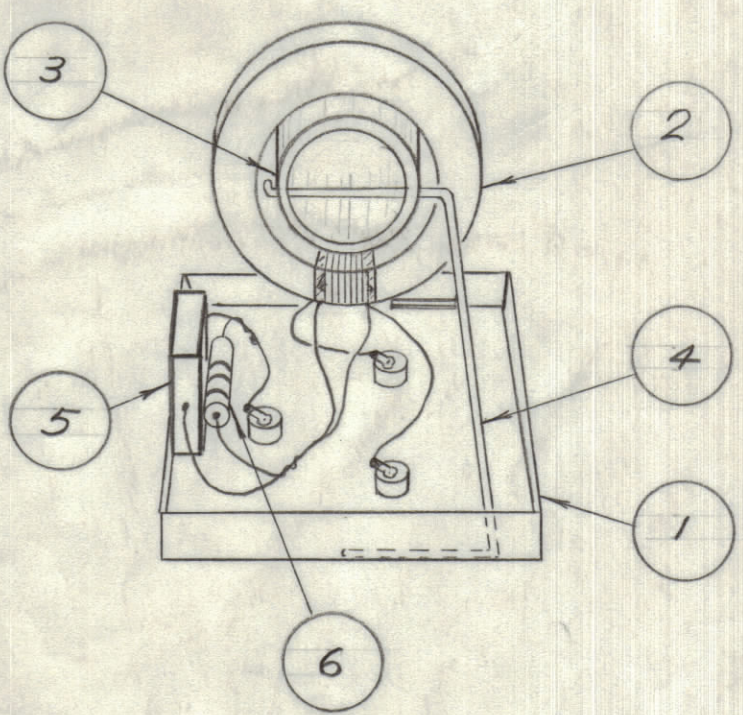


- E) Wind conductor "B" for 12 turns in same direction over the core and centered over the first winding. Stake with cement, (Item 11).



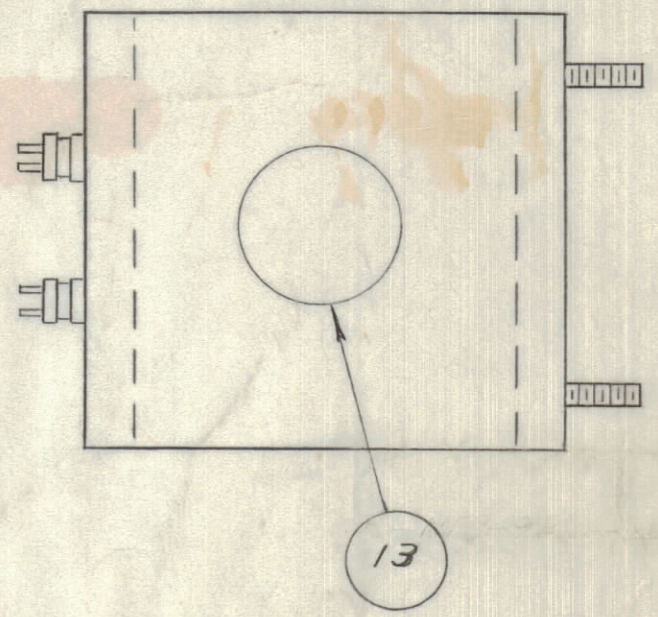
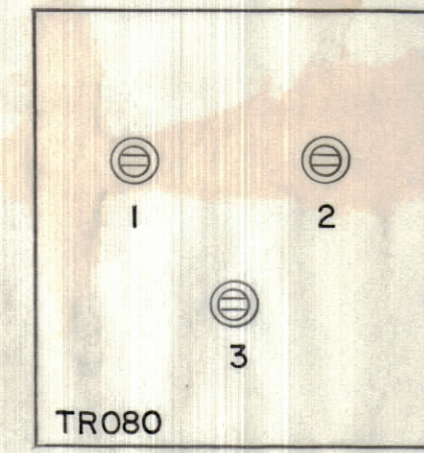
STEP 2 MOUNTING INSTRUCTIONS

- A) Wind sufficient tape (Item 9) 1/2" on coil form (Item 3) so that the core (with winding) fits snugly on the centre of the coil form.
- B) Insert wire stabilizers (MS10567) into the holes in the coil form and bend over the ends to secure in place.
- C) Mount transformer in place on the terminal cover (p/o Item 1) by soldering the stabilizers to the cover.
- D) Mount the resistor (Item 6) on the capacitor (Item 5) by twisting the resistor leads around the capacitor leads for a few turns and then soldering. Trim off excess lead length of resistor only.
- E) Mount capacitor as shown and solder one lead to the lug of terminal 3.
- F) Solder the "START B" and "FINISH A" leads of the transformer to the other lead of the capacitor.
- G) Solder the "FINISH B" lead to the lug of terminal 1. Also solder the "START A" lead to the lug of terminal 2.
- H) Insert terminal cover assembly into the case and pre-test according to STEP 4.



STEP 3 POTTING AND FINISH

- A) After pretest, solder terminal cover into case.
 - B) Using potting compound (Item 12) pot to within 1/2 inch of the top of the case.
 - C) When the compound has hardened, solder the remaining cover in place.
 - D) Smooth all seams.
 - E) Prime with S114 zinc chromate primer and finish with S115 smooth grey enamel.
 - F) Stamp TMC Part No. as shown in 1/8" black gothic per S727.
- Also stick TMC Emblem NP493 as shown.

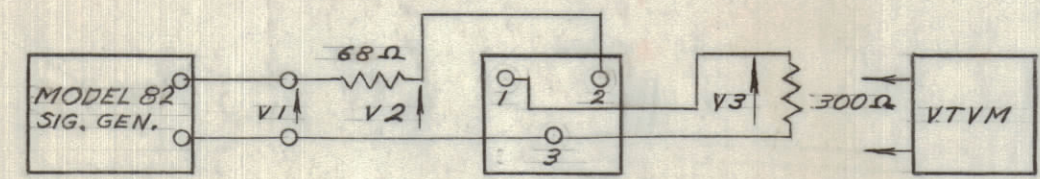


NOT TO BE RELEASED W/O AUTHORIZATION

AUTH. BY: _____

DATE: _____

STEP 4 TEST



EQUIPMENT

Measurements Model 82 Signal Generator or equivalent.
 Hewlett-Packard 410-B V.T.V.M. or equivalent.
 68 ohm Resistor (1)
 300 ohm Resistor (1)
 500 uuf Capacitor 2% Tol. (1)

TEST 1

FREQ.	APPROX. R.F. VOLTS		
	V ₁	V ₂	V ₃
100 kc	1.0	.97	.1 approx.
250 kc	1.0	.90	.54
500 kc	1.0	.76	.76
1 mc	1.0	.60	.93
2 mc	1.0	.51	.99
4 mc	1.0	.47	1.00
8 mc	1.0	.45	.99
16 mc	1.0	.39	.95
30 mc	1.0	.36	.92

TEST 2

Tune Signal Generator for peak indication on V. T. V. M.
 Frequency of peak should occur at 120 kc. approximately.

TRO80		28-4-64	
MODEL	PROJECT NO.	ASS'Y. NO.	DATE
USED ON			

REQ	ITEM	PART NO.	DESCRIPTION	SYM
1	13	NP 493	EMBLEM, TMC, CIRCULAR	
X	12	GL10002	COMPOUND, POTTING	
X	11	GL10001	CEMENT	
X	10	BS100	SOLDER, SOFT	
X	9	TA10001-2	TAPE, 1/2" MASKING	
X	8	TA10001-5	TAPE, 1/4" MASKING	
X	7	WI102-9-9	MAGNET WIRE, ENAMELLED D.C.C.	
1	6	RC20GF103K	RESISTOR, FIXED COMPOSITE	
1	5	CM35F562603	CAPACITOR, FIXED MICA	
2	4	MS10567	STABILIZER, TRANSFORMER	
1	3	CF127-1.625	FORM, COIL	
1	2	CT10009	CORE, TOROIDAL	
1	1	BX120	CASE & COVER	
REQ	ITEM	PART NO.	DESCRIPTION	SYM
TMC (Canada) LIMITED OTTAWA ONTARIO ASSEMBLY OF TRO80				
STOCK SIZE				
MATERIAL		WEIGHT PER PC.		
TYPE & TEMPER		R.D. H.H.		
		DRAWN		
		ELEC. DES. APP.		
		MECH. DES. APP.		
HEAT TREAT. SPEC.		CHECKED		
		FINAL APPROVAL		
FINISH & SPEC. NO.		A10349 A		