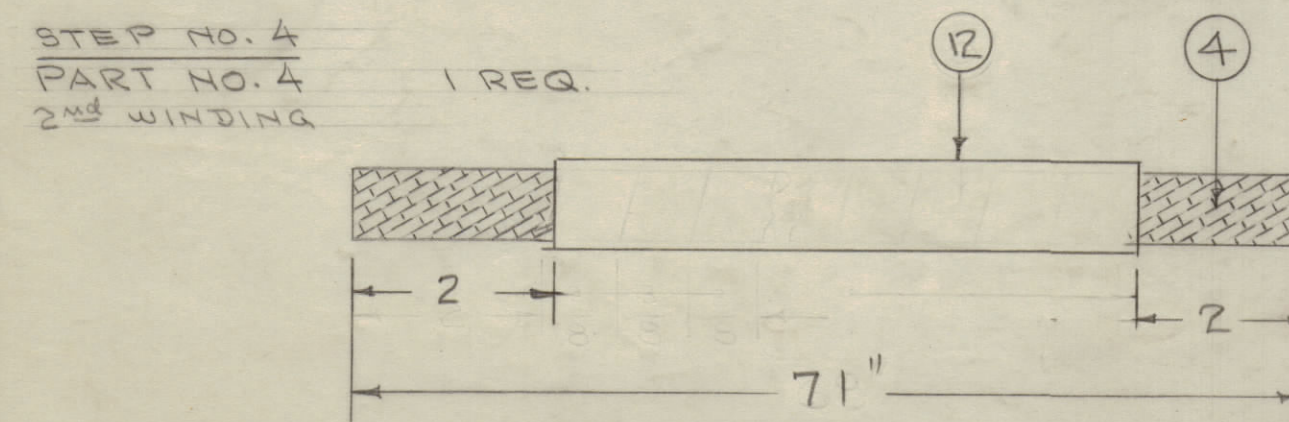
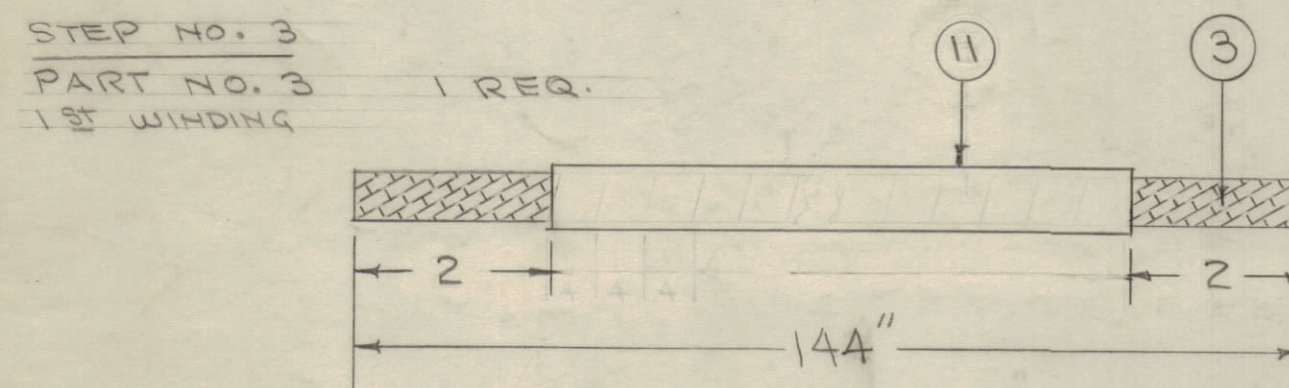
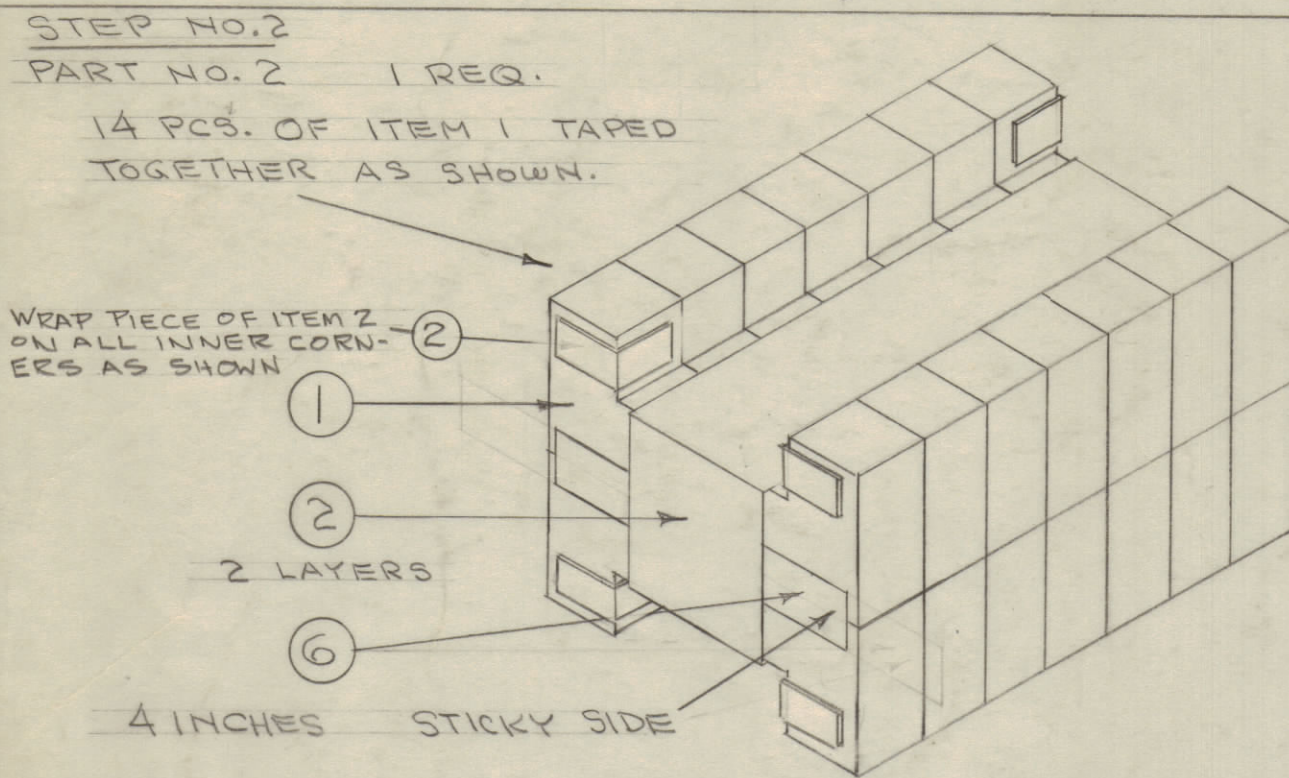
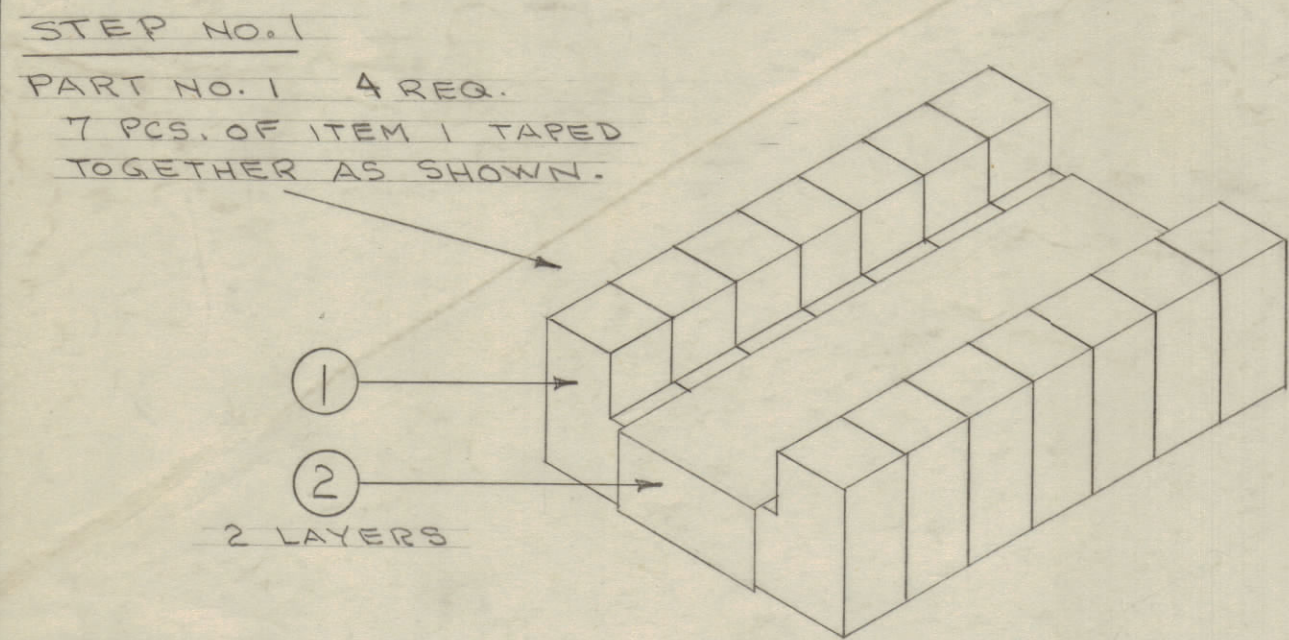
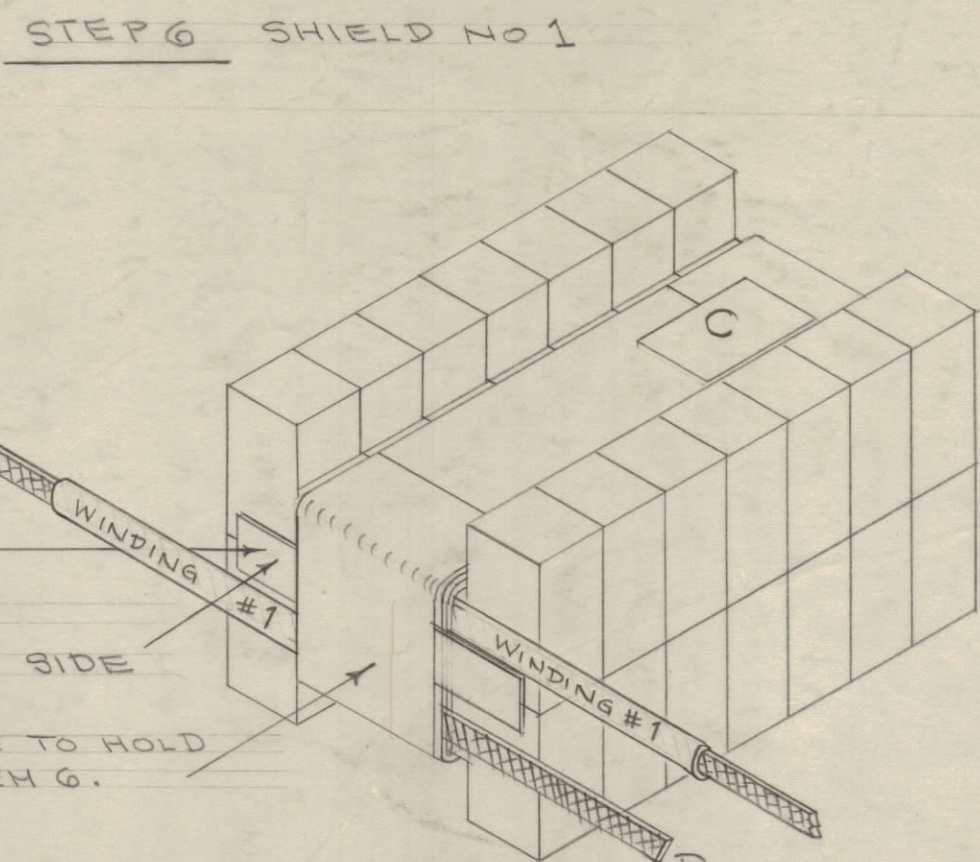
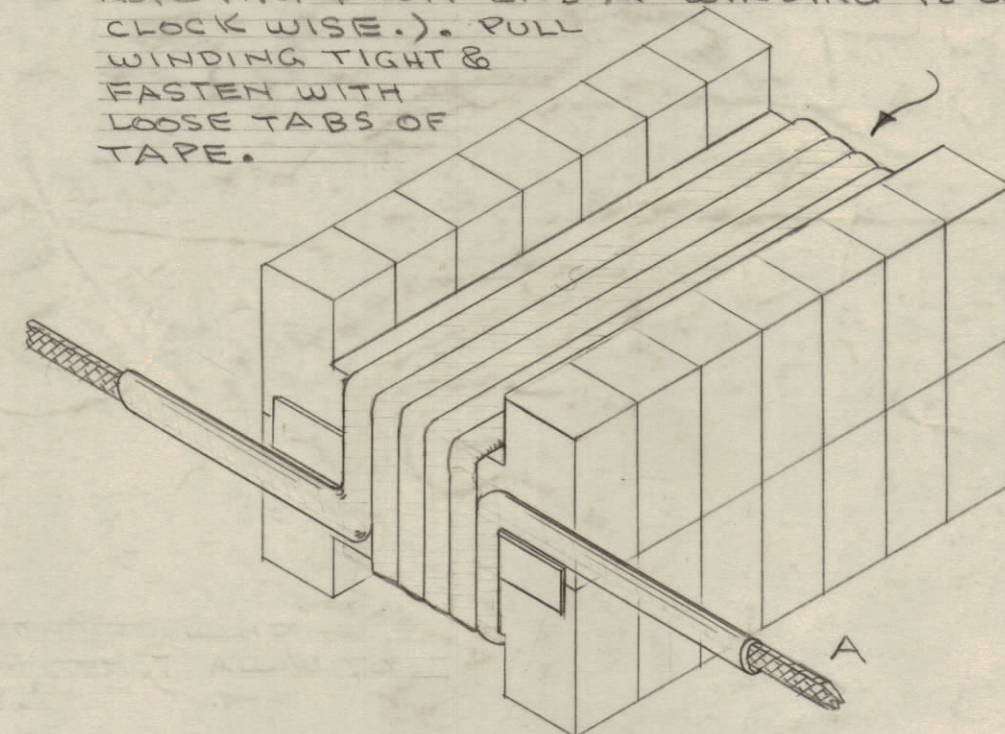


IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.  
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES



PARTS 3 & 4  
 INSERT SHIELDING THRU SLEEVING AS SHOWN

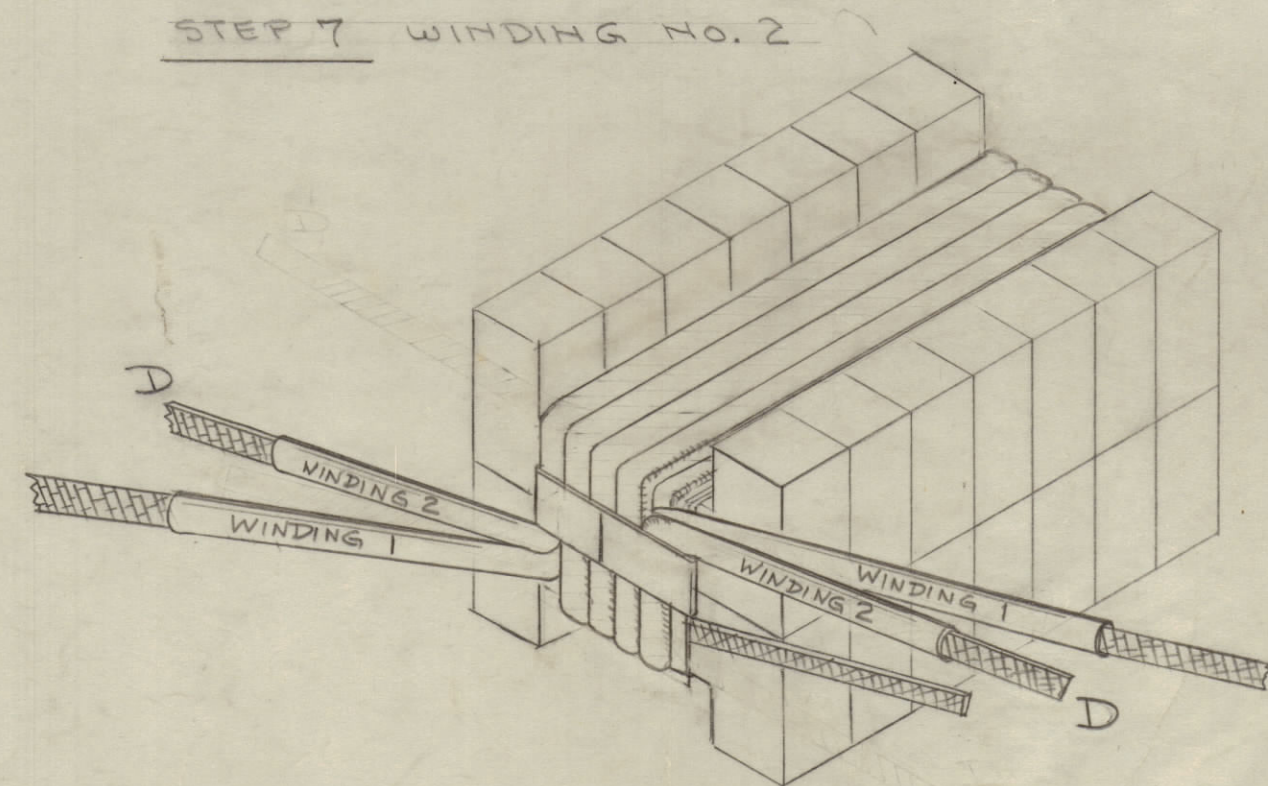
**STEP 5 WINDING NO. 1**  
 STARTING WITH CENTER OF PART 3 AT CENTER OF END SHOWN BY ARROW, WIND ON 2 1/2 TURNS EACH SIDE SO THAT LEADS END UP AS SHOWN FOR A TOTAL OF 5 TURNS. NOTE THAT FROM END 'A' WINDING IS COUNTER-CLOCKWISE. PULL WINDING TIGHT & FASTEN WITH LOOSE TABS OF TAPE.



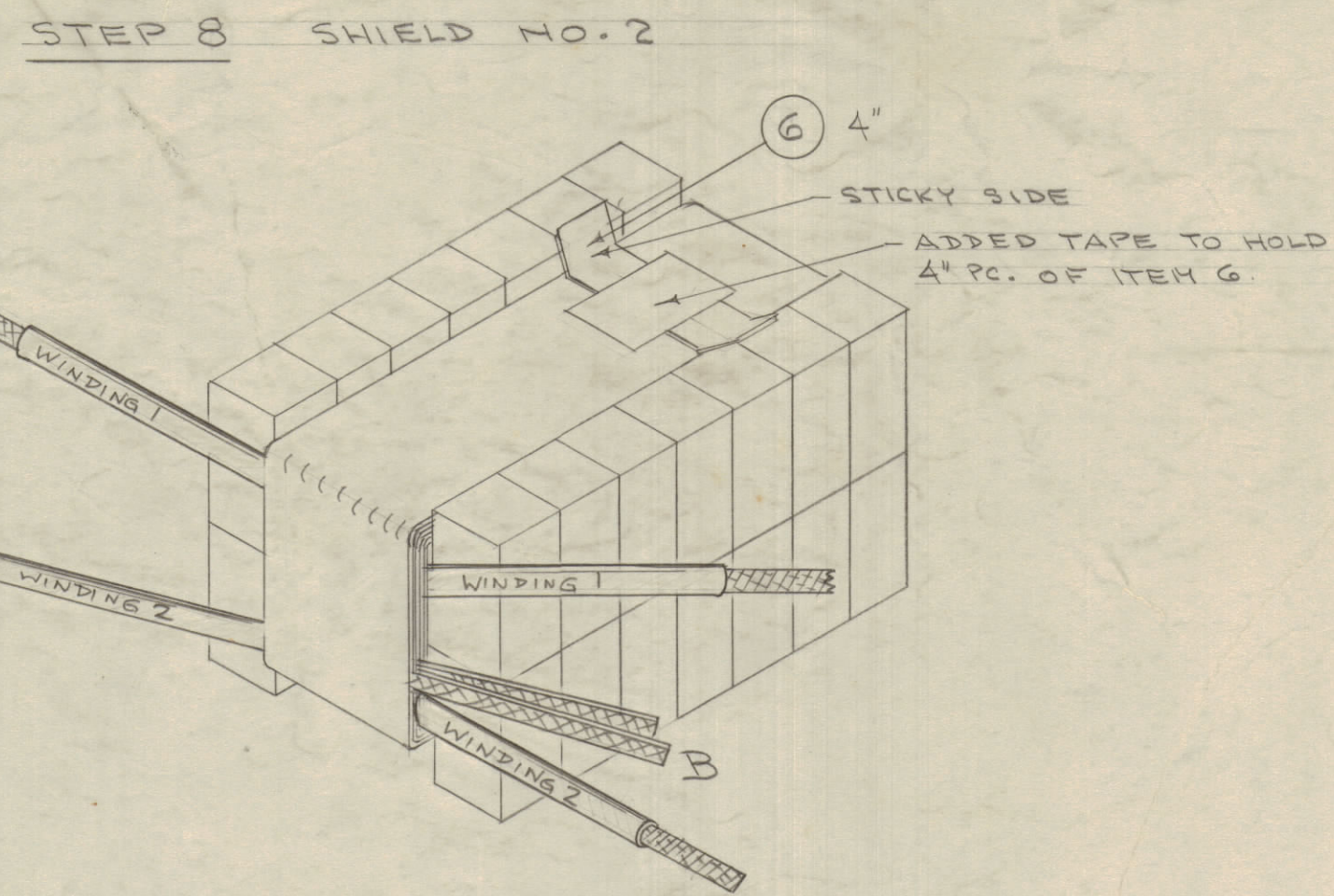
USING ITEM 8 (A-1199-1) AND ITEM 9 (IM-163) HELD TOGETHER AS SHOWN BELOW.

⑧  
 ⑨

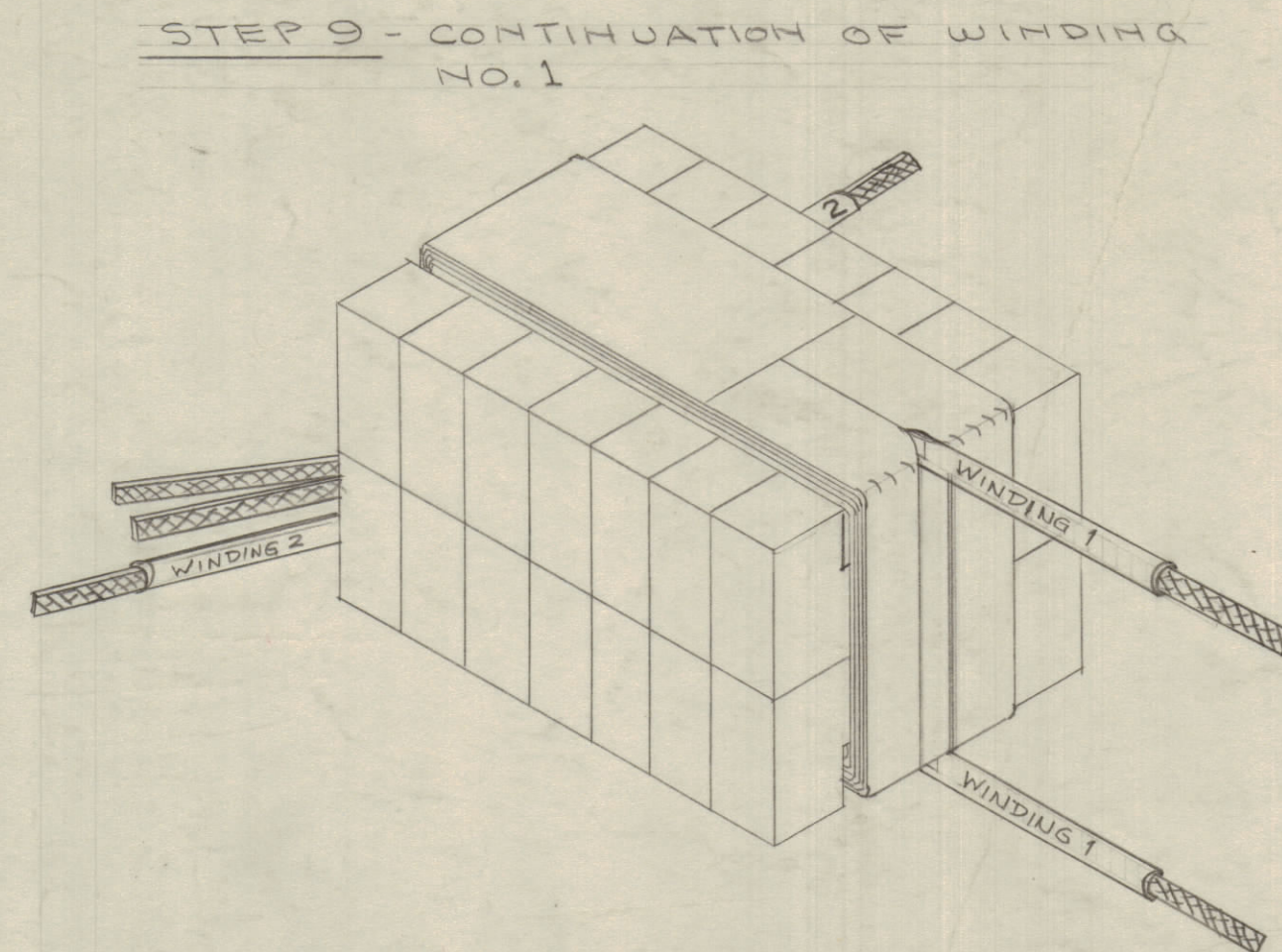
WIND ON TIGHTLY WITH ITEM 9 (INSULATION) ON BOTTOM. (NOTE THAT INSULATION IS LONG ENOUGH TO COMPLETELY COVER SCREENING ON BOTH SIDES). LEAD FROM SCREENING MUST COME OUT AT POINT 'B'. SECURE INSULATION AT POINT 'C' WITH 3" PIECE OF TAPE (ITEM 6). THEN ADD 4" PIECE OF ITEM 6 AS SHOWN ABOVE TO HOLD 2<sup>ND</sup> WINDING.



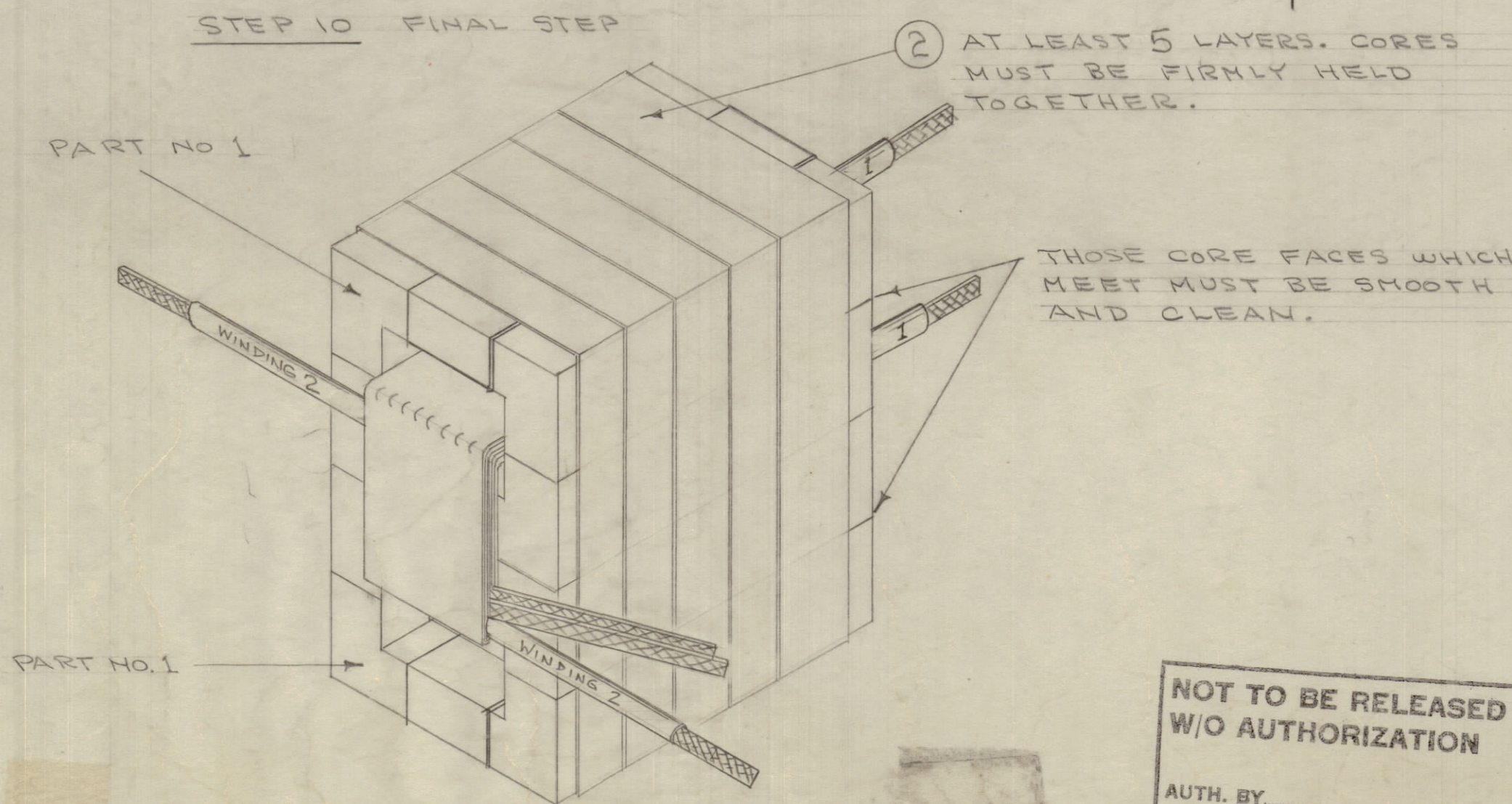
USING PART NO. 4 WIND ON 4 TURNS. USE PROCEDURE AS IN STEP 5. BRING LEADS OUT AT POINTS 'D' AS SHOWN.



USING ITEMS 10 (A-1199-2) AND ITEM 9 (IM-163) WIND AS SHOWN IN STEP 6. BRING LEAD OUT AT POINT 'B'. THEN ADD 2 PCS. OF ITEM 6 ONE ON TOP AS SHOWN, OTHER ON OPPOSITE SIDE IN SAME POSITION



CONTINUE WINDING NO. 1 IN COUNTER-CLOCKWISE DIRECTION 2 1/2 TURNS EACH SIDE FROM OUTSIDE TO CENTER OF CORE TO BRING LEADS OUT AS SHOWN. PULL TIGHT AND SECURE WITH TAPE TABS SHOWN IN STEP 8. ADD 2 LAYERS OF ITEM 2 SPLIT AS SHOWN TO ALLOW LEADS TO COME OUT.



NOT TO BE RELEASED W/O AUTHORIZATION  
 AUTH. BY: \_\_\_\_\_  
 DATE: \_\_\_\_\_

**STEP 11**  
 COAT ENTIRE WINDING WITH GL-112 (ITEM 7). BAKE FOR ONE HOUR AT 400° F.

use TR-149 for sheet replace

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 MAMARONECK, NEW YORK

D	1	ITEM 4 WAS 66" NEW IS 71"	4/23/58	4	16		
C	3	ITEM 9 WAS IM-163	6/1/57	3	16	AR	A.S.S.
C	2	ITEMS 11 & 12 ADDED					
	1	ITEMS TA-101-CB-1.0 DELE					
A	1	ITEM 5 WAS TA-101-AB-1.0	4/24/58	2	16	ADD	ONE
B	2	STEP 3 LENGTH WAS 142"	4/24/58	1	16	ADD	ONE
A	1	STEP 7 PICTORIAL CHANGED	4/23/58	1	16	ADD	ONE
ISSUE	ITEM	CHANGED FROM	DATE	DN. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES				SCALE:			
ALL DEC. DIM. ±		FRAC. DIM. ±		ANGULAR DIM. ±		DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.	

1	TR-138	PROJECT NO.	ASSY. NO.	1-5-56	DATE
REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE	USED ON

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
6'	12	PX-370-4-7	INSULATION, SLEEVING, TEFLON	Natural
12'	6	PX-370-6-7	INSULATION, SLEEVING, TEFLON	Natural
1	10	A-1199-2	SHIELD ASSEMBLY	
2	9	IM-163-34	INSULATION, FIBERGLAS	
1	8	A-1199-1	SHIELD ASSEMBLY	
X	7	GL-112	VARNISH	
X	6	TA-108-7	TAPE 1"	
-	5	-	DELETED.	
71"	4	WL-103-5	SHIELD, FLEXIBLE	
142"	3	WL-103-4	SHIELD, FLEXIBLE	
X	2	TA-108-9	TAPE 1 1/2"	
28	1	CI-101-3-Q	CORE	
REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
TRANSFORMER SUB ASSEMBLY				
TR-138				
TYPE & TEMPER				
DRAWN: JAWB ELEC. DES. APP. MECH. DES. APP. DATE: 1-5-56				
HEAT TREAT. SPEC. CHECKED: JAWB FINAL APPROVAL: APP. H.J.J.				
FINISH & SPEC. NO. A-1200 D				

A-1200 D