

A-1258 C

ASSEMBLY

AFFIX COLLAR TO COIL FORM WITH ITEM 6 (CEMENT).
AIR DRY.

WINDING MACHINE DATA

DRIVER GEAR - 87
CAM GEAR - 90
CAM - .156

WINDING PROCEDURE

- 1- START 1ST PI $\frac{3}{16}$ " FROM END OF COIL FORM AND ADJACENT TO GREEN LUG. (USE WINDING FINGER WITH GUIDE ON RIGHT. START WINDING WITH FINGER IN EXTREME RIGHT HAND POSITION OF TRAVEL).
- 2- END PI WITH FINGER IN EXTREME LEFT HAND POSITION.
- 3- SPOT END OF PI WITH ITEM 6 (CEMENT)
- 4- ROTATE SPINDLE & COIL FORM 180° IN DIRECTION COIL IS WOUND, SO WINDING FINGER IS AGAIN IN EXTREME RIGHT HAND POSITION. PERMIT LOOSE END OF WIRE TO FALL OFF OF PI. DRESS WIRE CLOSE AGAINST BASE OF PI.
- 5- USING RACK FEED KNOB, POSITION COIL FORM SO THAT WINDING FINGER GUIDE JUST TOUCHES LEFT SIDE OF PI. THIS GIVES SPACING BETWEEN PIS OF APPROX. $\frac{1}{16}$ ".
- 6- REPEAT ABOVE STEPS FOR PIS 2-3-4 & 5. (NOTE THAT PI 5 HAS A TAP AT 127 $\frac{3}{4}$ TURNS.)
- 7- SECURE COIL END WITH ITEM 6. AIR DRY.
- 8- MAKE SOLDER CONNECTIONS TO PROPER LUGS.
- 9 - BAKE FOR $\frac{1}{2}$ HR. AT 215°F. SATURATE COILS WITH ITEM 5 AND AIR DRY FOR 10 MIN.
BAKE FOR 2 HRS. AT 215°F.

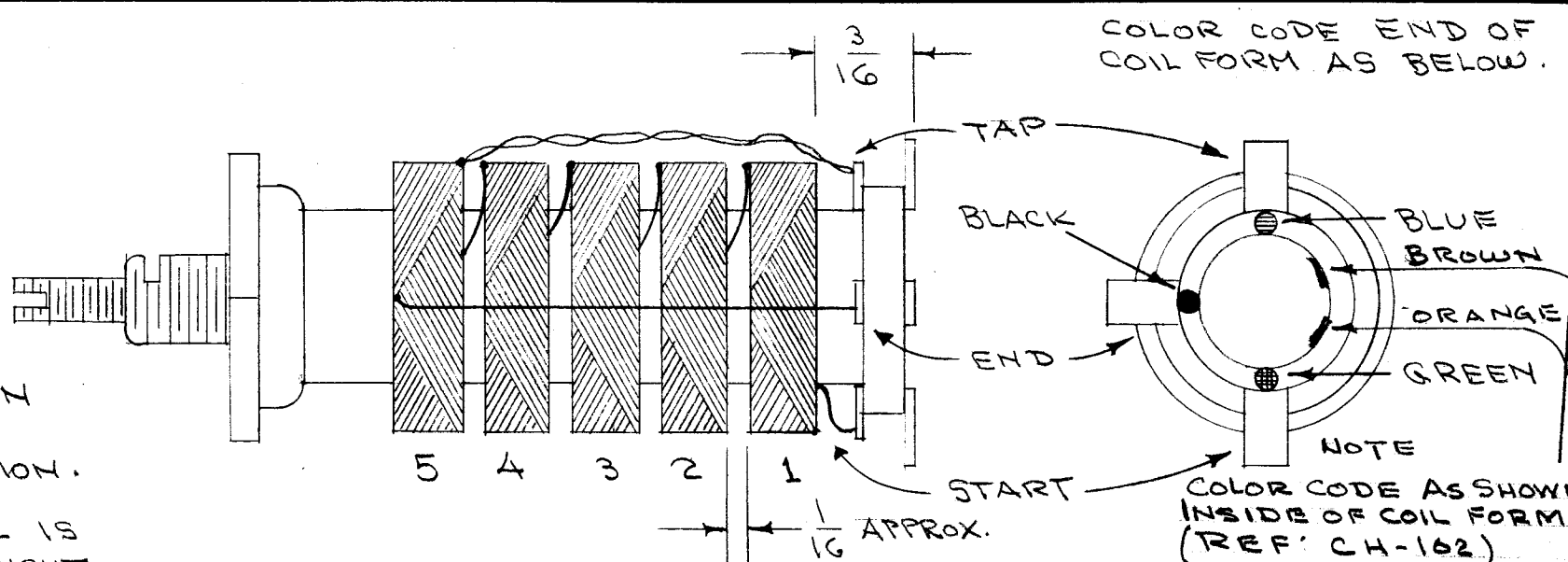
TEST DATA w/o CORE

USE BOONTON Q METER 160 A OR EQUIVALENT.

	GRN/BLACK	GRN/BLUE
L	11.0 mh (10.4-11.6)	10.7 mh (10.0-11.4)
Q	> 40	> 50
F	79 KC	79 KC

MISC. TEST INFO.

IN CAN WITH CORE L MAX 24.5 mh.
 L MIN 18.5 mh.
OUT OF CAN WITH CORE L MAX 30.5 mh
 L MIN 21.7 mh



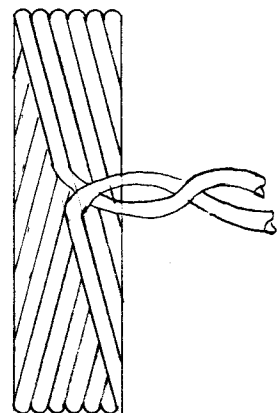
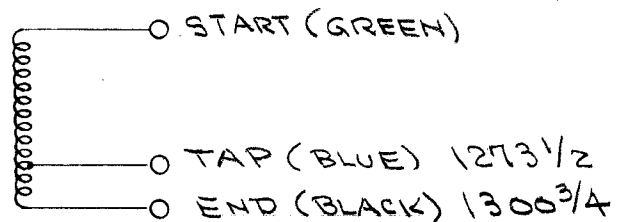
END 1ST PI 260 $\frac{1}{4}$ TURNS FROM START
 " 2ND PI 519 $\frac{3}{4}$ " " "
 " 3RD PI 779 $\frac{1}{2}$ " " "
 " 4TH PI 1040 $\frac{1}{2}$ " " "
 TAP 5TH PI 1273 $\frac{1}{2}$ " "
 END 5TH PI 1300 $\frac{3}{4}$ " "

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MAMARONECK, NEW YORK



TAP DETAIL
TWIST WIRE & LAY IT OVER OTHER TURNS AS SHOWN.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
1	8	SP-102	SPRING LOCK
X	7	BS-100	SOLDER, SOFT
X	6	GL-103	CEMENT
X	5	GL-104-2	INSULEX, U-85
X	4	WI-120-15	WIRE #34 DSC
1	3	CTI03D7B3	CORE
1	2	TE-146-3	COLLAR & LUGS
1	1	CF-114-3	COIL FORM

STOCK SIZE	MATERIAL	TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
				PLKA/10/56	[Signature]	A.J.J.
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK						
ANTENNA COIL ASSY. T-100						
FINISH & SPEC. NO. ELEC. DES. APP. MECH. DES. APP.						

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
C	1	ITEM 3 WAS C1103D7B5	4/9/56	3	[Signature]	[Signature]	AJJ
B	1	Test Data Chgd	6/14/56	2	[Signature]	[Signature]	AJJ
A	1	COLOR CODE ADDED	5/31/56	1	[Signature]	[Signature]	AJJ

DEC. DIM. ±
FRAC. DIM. ±
ANGULAR DIM. ±

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

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	FFRD-1	E-458-P	A-1262	3-21-56

USED ON

A-1258 C