

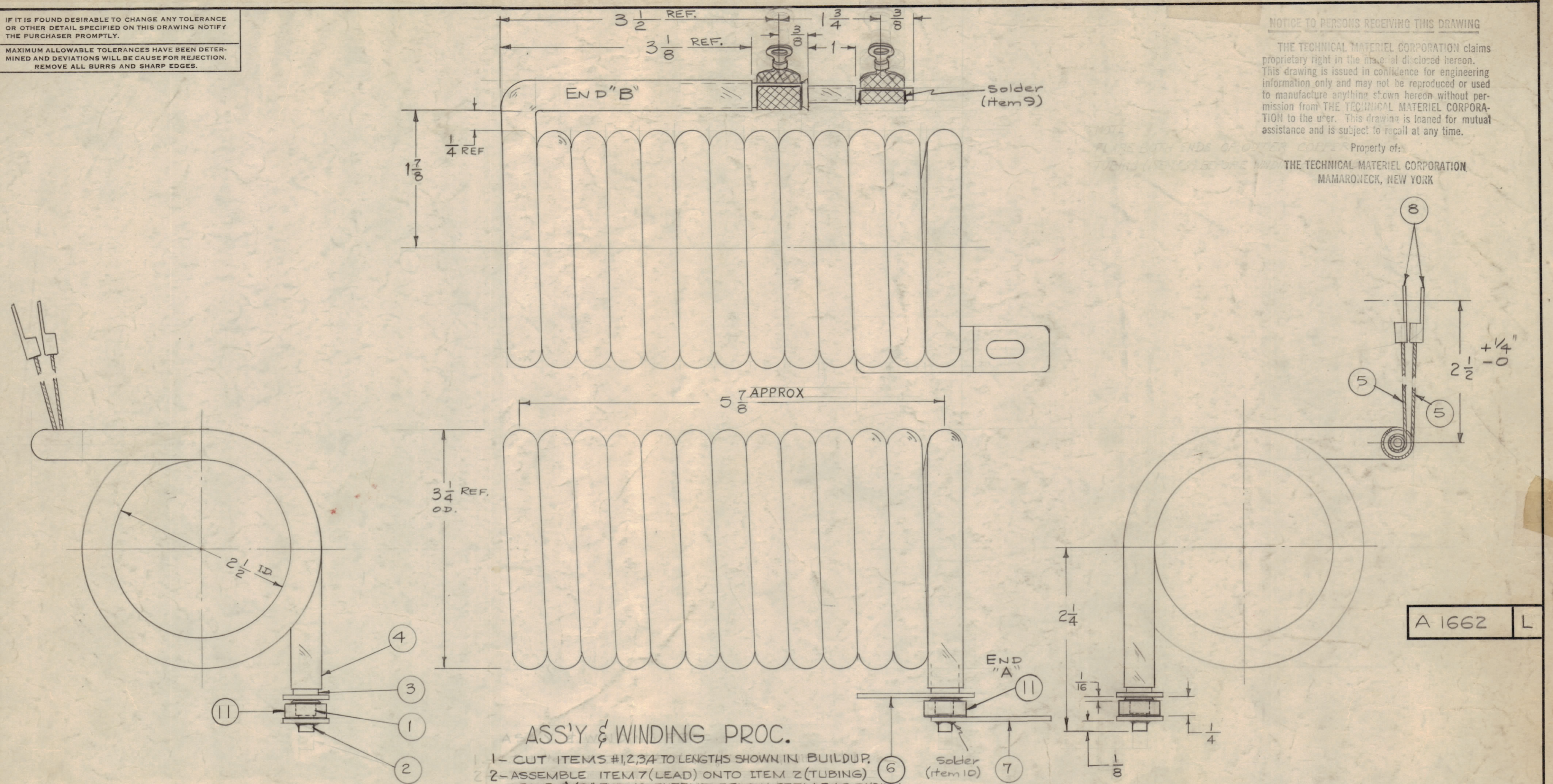
IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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

NOTICE TO PERSONS RECEIVING THIS DRAWING

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MAMARONECK, NEW YORK



6 - SHRINK IT 4 AS PER 5825 BEGINNING AT IT 6 END.

L	TO 5 7/8 DIM. ADD. "APPROX"	3-27-67	18323	L.A.			
K	ADD "REF." TO 3-1/2 & 3-1/8 DIM. ADD -1 TO IT. 3	3-1-67	17871	RME			
J	IT. 1 WAS (PX370-4-7) IT. 2 & 3 DECC. UPDATED. ASSY. & WIRING PRAC. NEW STEP 5 ADD. EXISTING STEPS 51012 ARE NOW 6 & 13.	4-14-65	13835	SL	JCB		
H	3 STEP 6 ADD. TO ASSY PROC. IT. 4 WAS PX-370-43-7 IT. 2 WAS 10"5", IT. 3 WAS 10"1"	7-9-64	11747	SL	JCB		
G	PROC #2 WAS 3/8 TUBING EXT. PICT. CHANGED TO AGREE. MODEL GPT-40K(1)3 & GPT-10K(1)5 ADDED	8-19-63	9796	AL	JCB		
F	Item 11 Added; Notes Revised	12-5-61	5988	A.L.	JCB		
E	1 Req. on Item 3 was 10"11"	8/1/61	5347	DPM	RH		
D	4 ITEM 4 WAS PX-370-7 3 ITEMS 1, 2, 3, 4 Length was 12"0" 2 WINDING PROCEDURE REVISED 1 FLARE NOTE DELETED	7-6-61	5176	60V	RH		
C	1 TUBING NOTE ADDED 2 ITEM 5 WAS WL-103-7. (TOO BIG)	11-4-60	3374	SL	JCB		
B	1 ITEM 8 WAS TE-141-3 (TOO SMALL FOR SHIELD) 2 END "A" & "B" REVERSED	5/15/59	1026	16	JCB		
A	1 PROCEDURE CHANGED. ITEMS 6 & 7 to be Ass'd before winding.	4/17/59		16	JCB		

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES				SCALE: FULL			
ALL OTHERS	DEC. DIM. ±	FRAC. DIM. ± 1/16	ANGULAR DIM. ±	DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.			

### ASS'Y & WINDING PROC.

- 1- CUT ITEMS #1, 2, 3, 4 TO LENGTHS SHOWN IN BUILDUP.
- 2- ASSEMBLE ITEM 7 (LEAD) ONTO ITEM 2 (TUBING) LEAVE 1/8" TUBING EXTEND BELOW ITEM 7 AS SHOWN SILVER SOLDER (ITEM 10) ITEM 7 TO ITEM 2
- 3- ASSEMBLE IT. 6 (LEAD) ONTO ITEM 3 (TUBING). LEAVE 1/16" OF TUBING EXTENDED BELOW ITEM 6 AS SHOWN. FLARE END OF TUBING. SILVER ITEM 6 TO ITEM 3.
- 4- SLIP ITEM 1 OVER ITEM 2 ASSY. UNTIL ITEM 1 TOUCHES ITEM 7 END.
- 5- SHRINK ITEM 1 AS PER 5825 BEGINNING AT IT. 7 END.
- 6- SLIP ITEM 4 OVER ITEM 3 ASSY UNTIL ITEM 4 TOUCHES ITEM 6.
- 7- SHRINK IT. 4 AS PER 5825 BEGINNING AT IT. 6 END.
- 8- SLIDE ITEM 11 ONTO ITEM 1 & 2 UNTIL WIDER END TOUCHES ITEM 7
- 9- SLIP ITEM 3 & 4 ASSEMBLY OVER ITEM 1 & 2 UNTIL FLARE COMPLETELY COVERS NECK ON ITEM 11
- 10- USING A 2-1/2 O.D. FORM, CLOSE WIND 12-1/4 TURNS (CLOCKWISE).
- 11- BEND "END B" AS SHOWN.
- 12- CUT INSULATION & TUBING AS SHOWN ON END "B"
- 13- ASSEMBLE SHIELD & TERMINAL AS SHOWN. SOLDER CONNECTIONS WITH SOFT SOLDER.

IMPORTANT: Insulation Must Not be Matted or Broken when Winding or Soldering.

REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
1	GPT-40K(1)3	AX-238		
1	GPT-10K(1)5	AX-236		
1	GPT-10K	AX-137		4-9-59

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
1	11	PX-642	Spacer - PA Filament Coil	
X	10	BS-101	Solder, Silver	
X	9	BS-100-1	Solder, Soft	
2	8	TE-158-31134	Terminal	
1	7	MS-1714-1	Lead, Connecting	
1	6	MS-1714-2	Lead, Connecting	
7	5	WL-103-6	Shield, Flexible, 1/2 wide	
9 5/8"	4	PX-845-375	SLEEVING, TEFLON, SHRINKABLE	5825
9 11/16"	3	TU-100-6-N	Tubing, Copper 0.375 OD	
10 2 1/2"	2	TU-100-3-N	Tubing, Copper 0.1875 OD	
9 9 1/2"	1	PX-845-190	SLEEVING, TEFLON, SHRINKABLE	5825

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