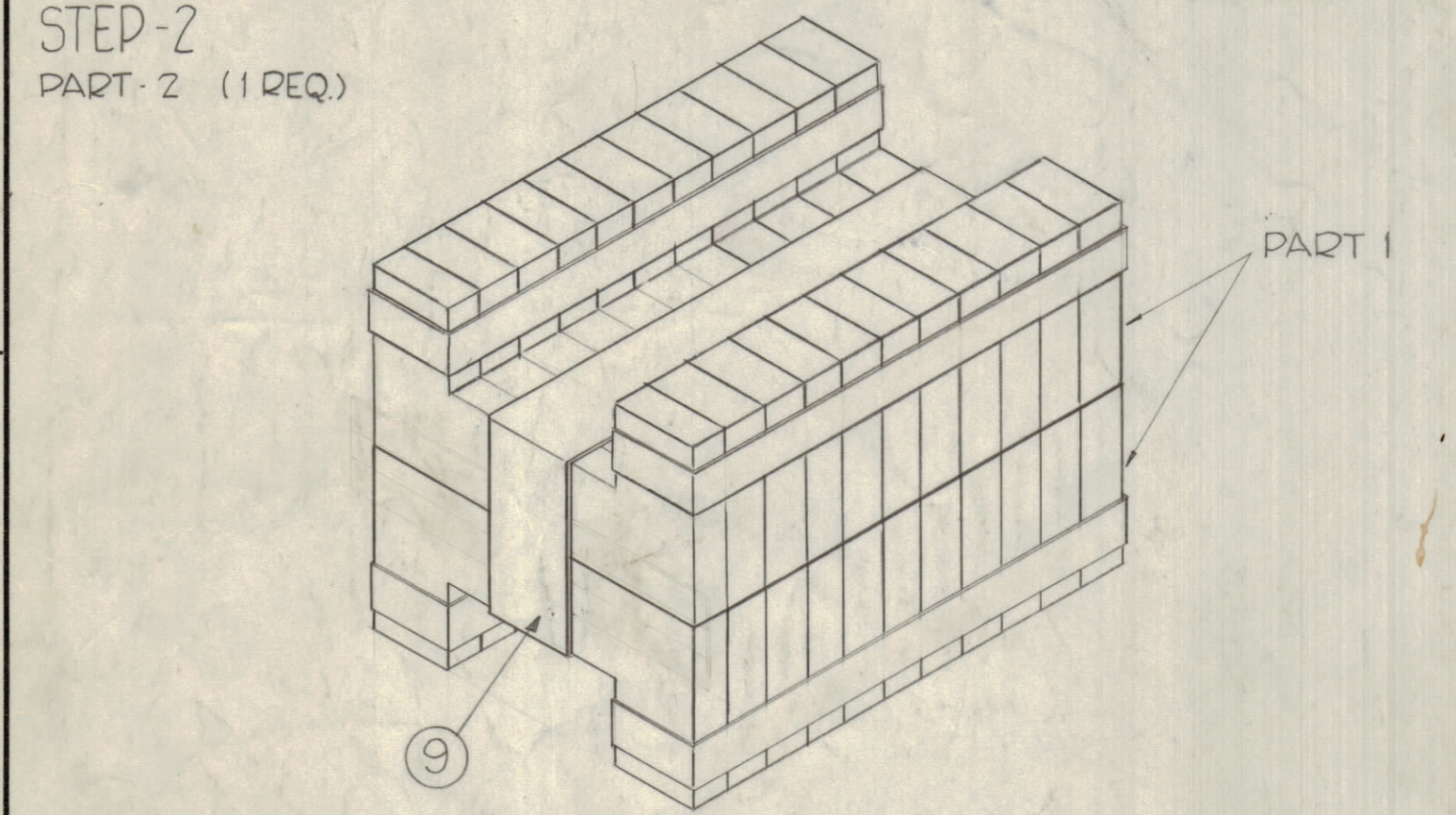
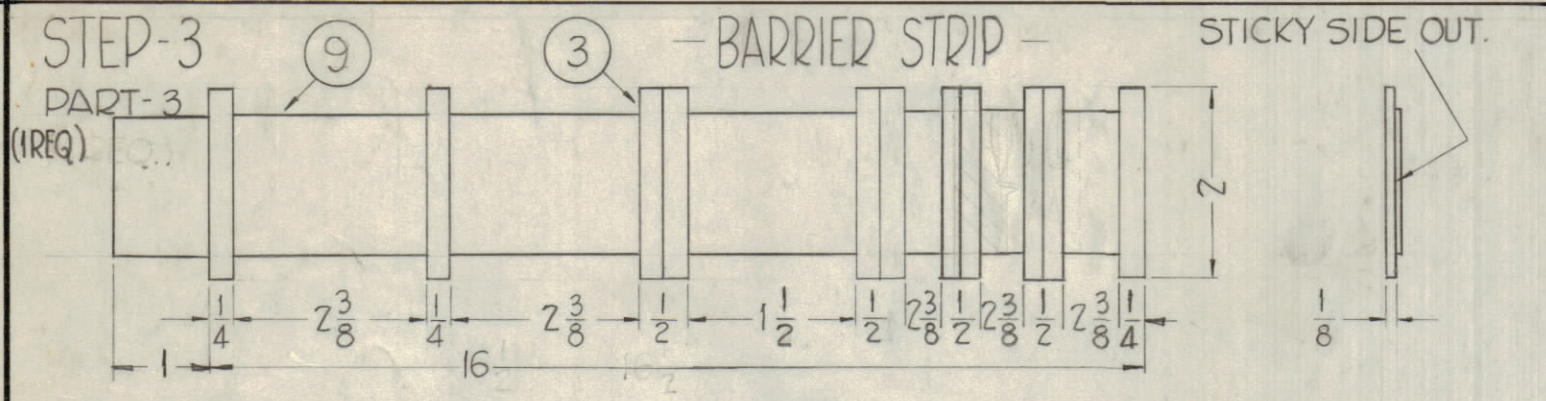


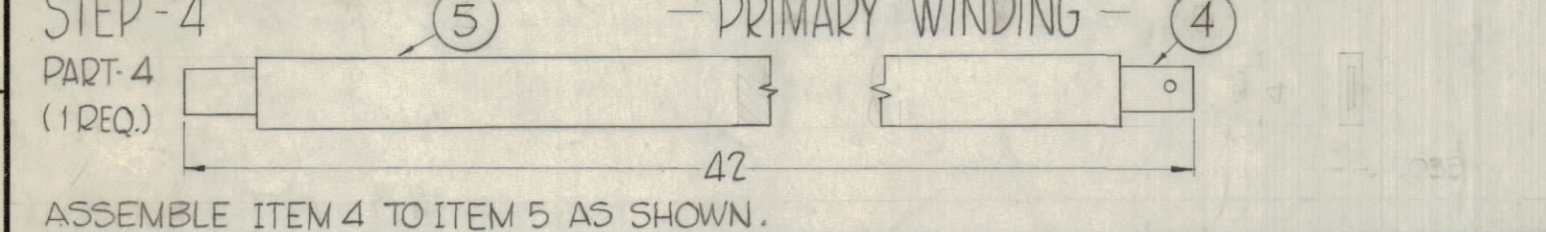
TAPE 11 PIECES OF ITEM 1, USING 2 LAYERS OF ITEM 2 AS SHOWN.



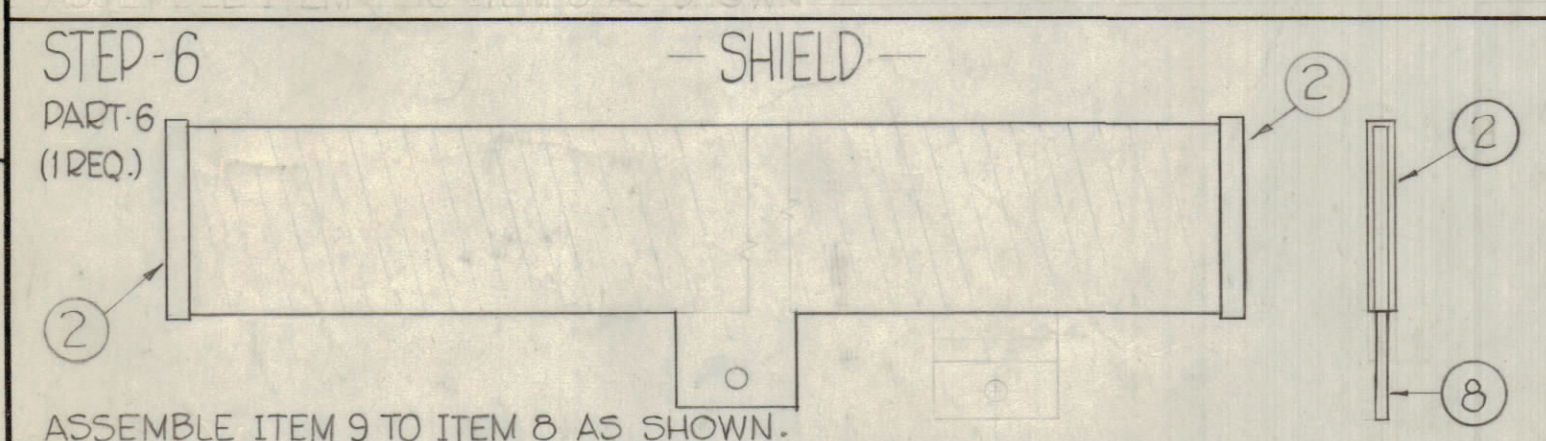
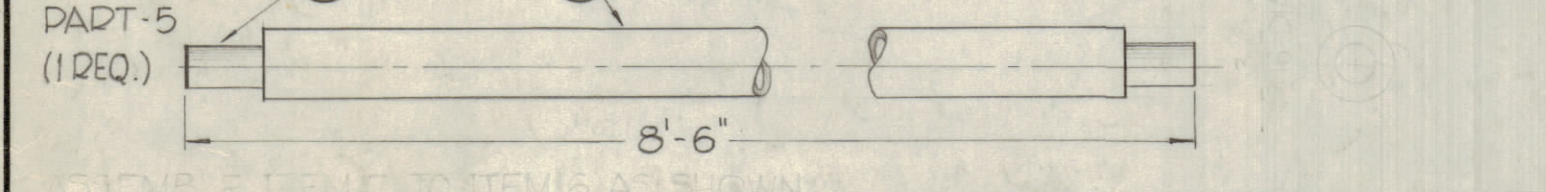
TAPE 2, PART 1 PIECES TOGETHER, USING 2 LAYERS OF ITEM 2, AS SHOWN.



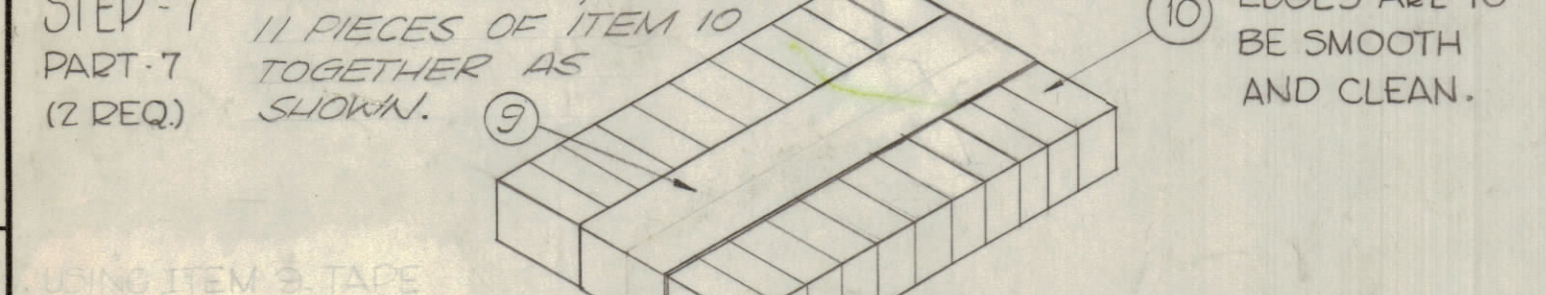
ATTACH ITEM 3 TO ITEM 2 (1 LAYER) AS SHOWN.



ASSEMBLE ITEM 4 TO ITEM 5 AS SHOWN.



ASSEMBLE ITEM 9 TO ITEM 8 AS SHOWN.

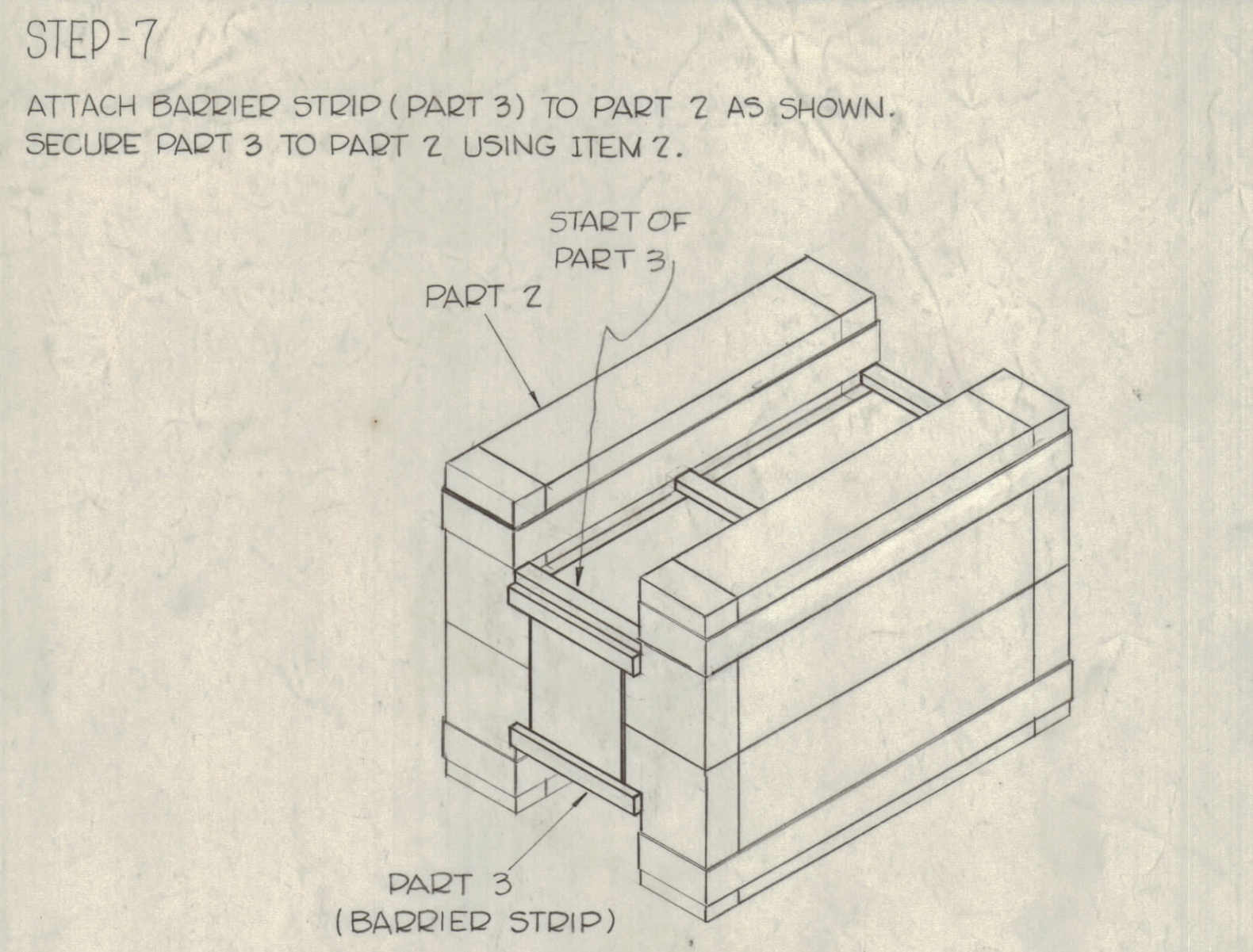


UNLESS OTHERWISE SPECIFIED: SCALE

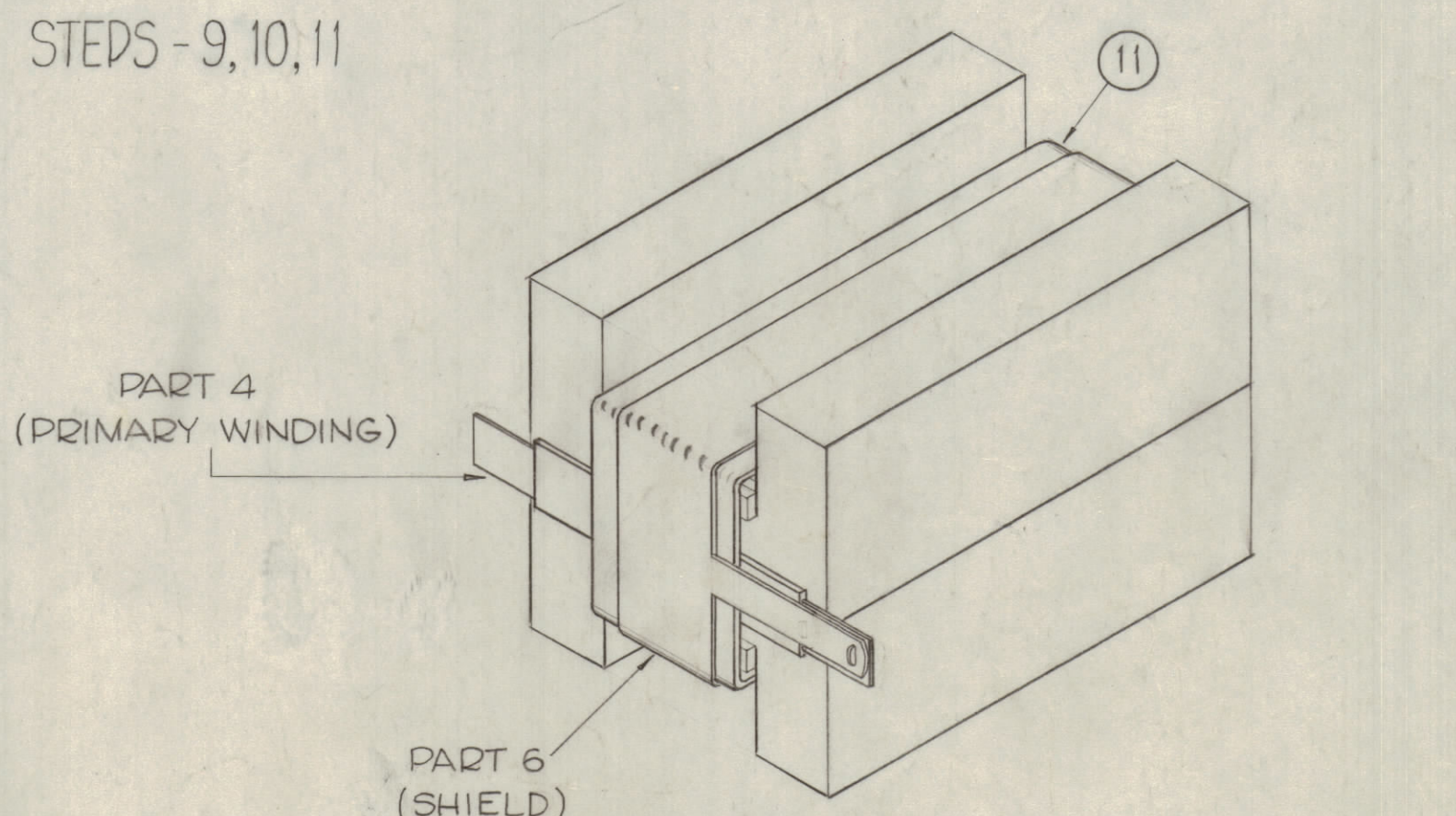
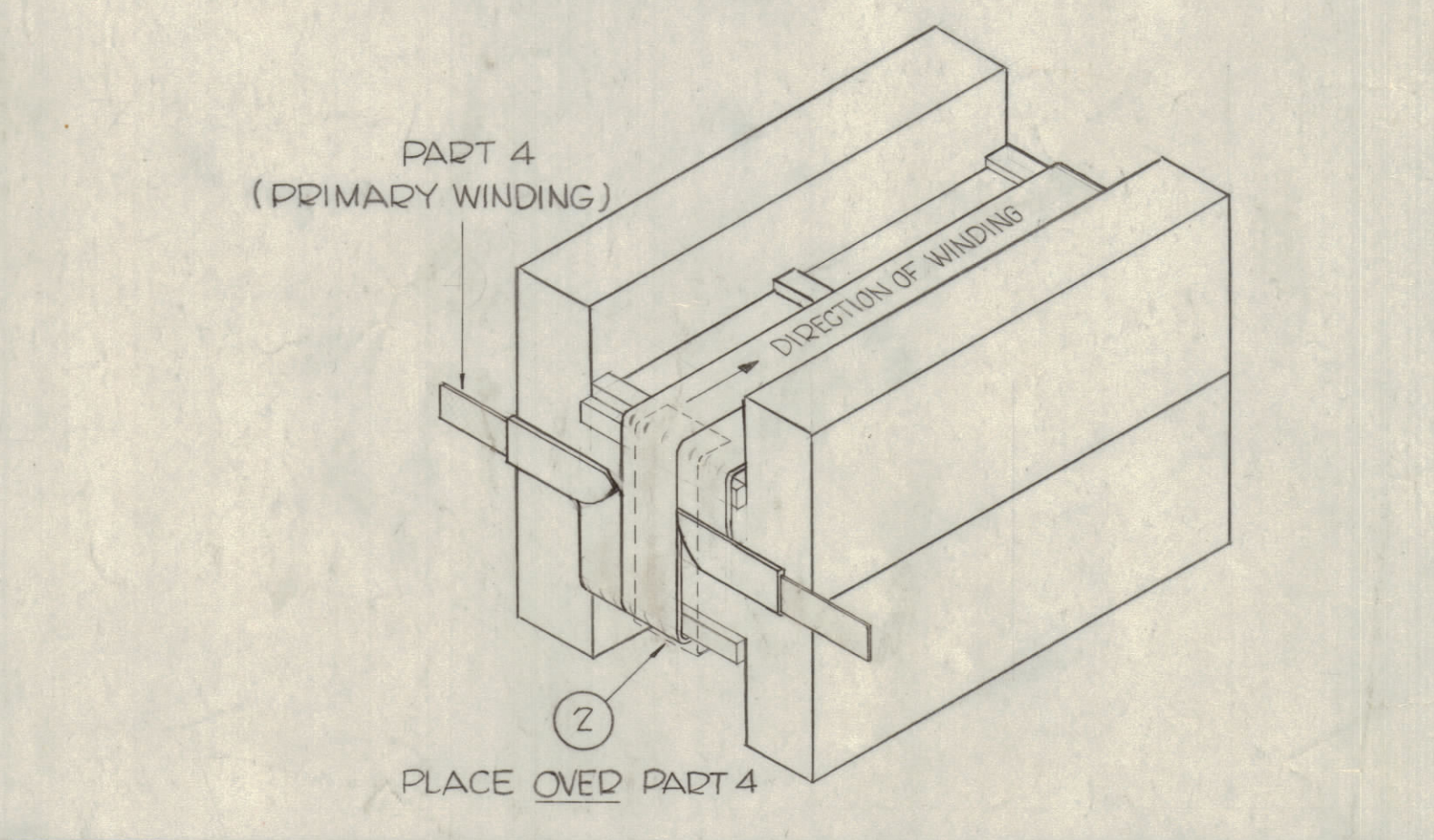
SYM	ZONE	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
F	REQ	ITEMS 26, 27 & NOTE ON STEP 12 ADD	5-22-61				
E	CHG.	ITEM 24 FROM WAS TE 178-6	10/6/70	15204	GE	(1)	FR
D	C2	ITEM 24 WAS TE 178-2	11/16/65	15208	TR		
C	B2	ITEM #16 WAS SCHH2520BN24	2-10-64	10863	AM	TR	
B	C2	ITEM (25) ADDED, ITEM (5) WAS PX-370-15-7	9-20-62	7234	SE		
A	C3	ITEM 21 WAS SCFP1032BN16	11-3-61	5812	LB		
	B3	ITEM 14 WAS SCB51032BN10					

DIMENSIONS ARE IN INCHES  
TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°

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



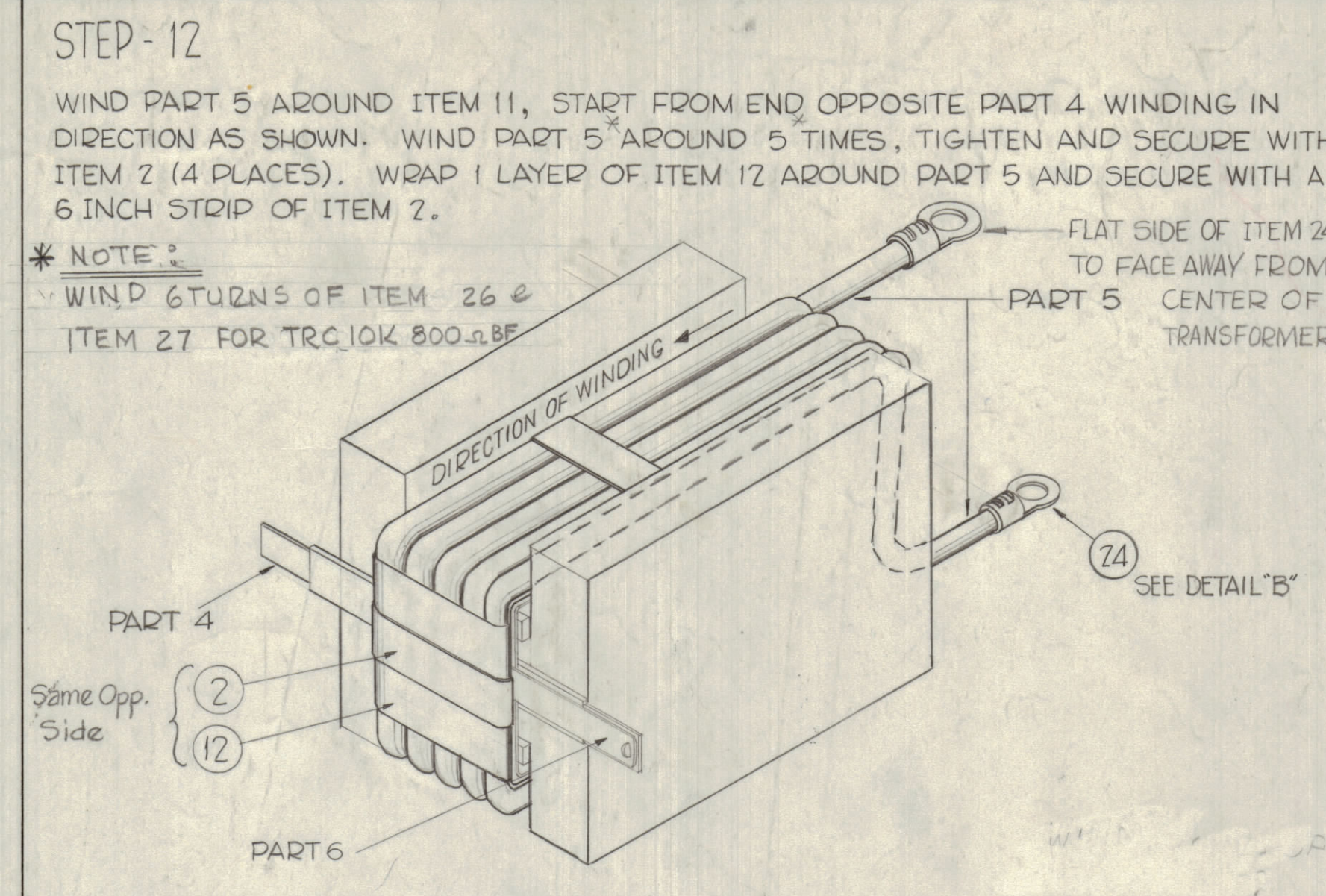
**STEP-8**  
BEGIN WITH PART 4 AT CENTER OF END OF PART 2. WIND 2 COMPLETE TURNS EQUALLY SPACED AS SHOWN. TIGHTEN AND SECURE PART 4 WITH A 6 INCH STRIP OF ITEM 2 APPLIED IN DIRECTION OF WINDING AS SHOWN.



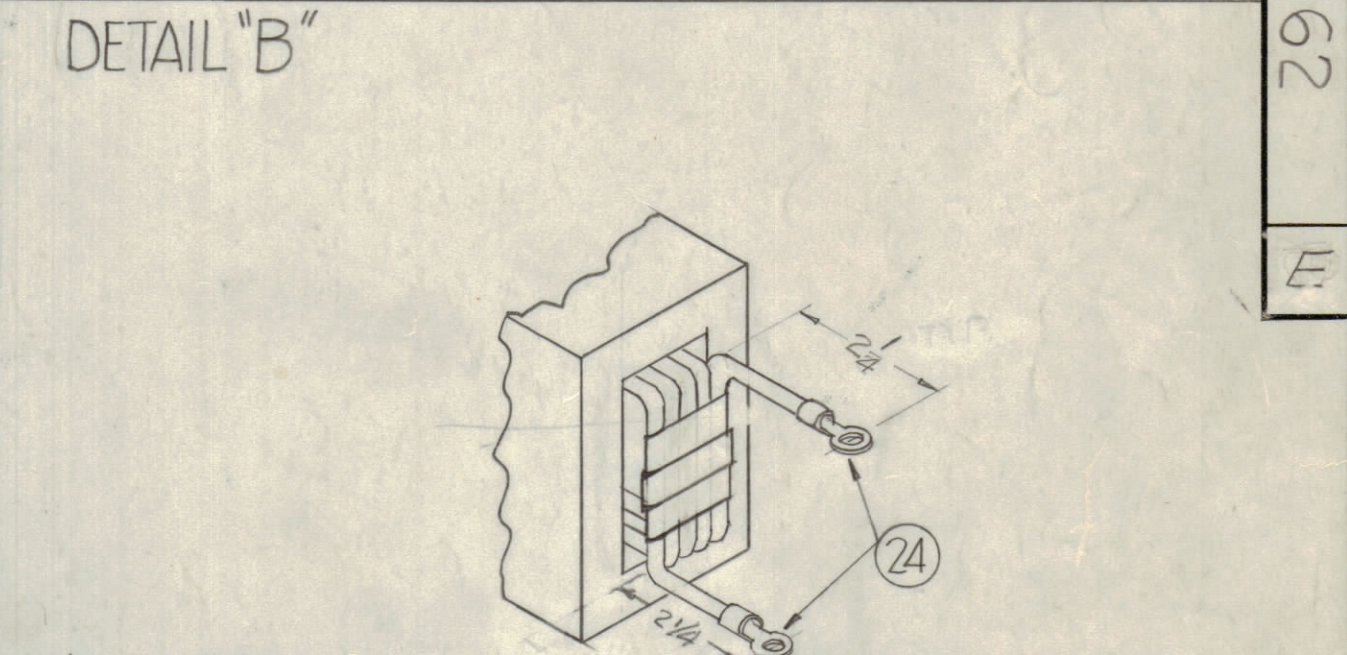
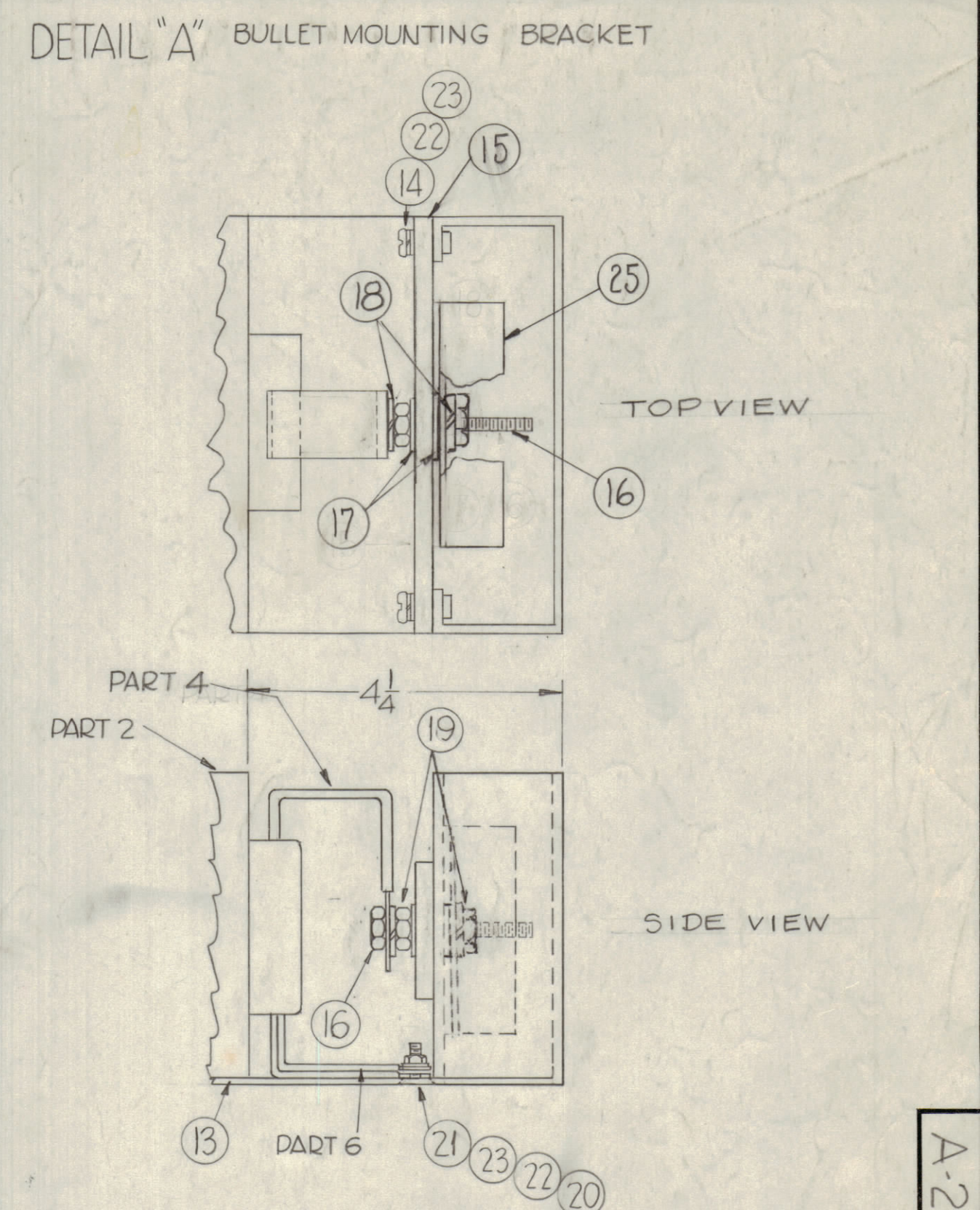
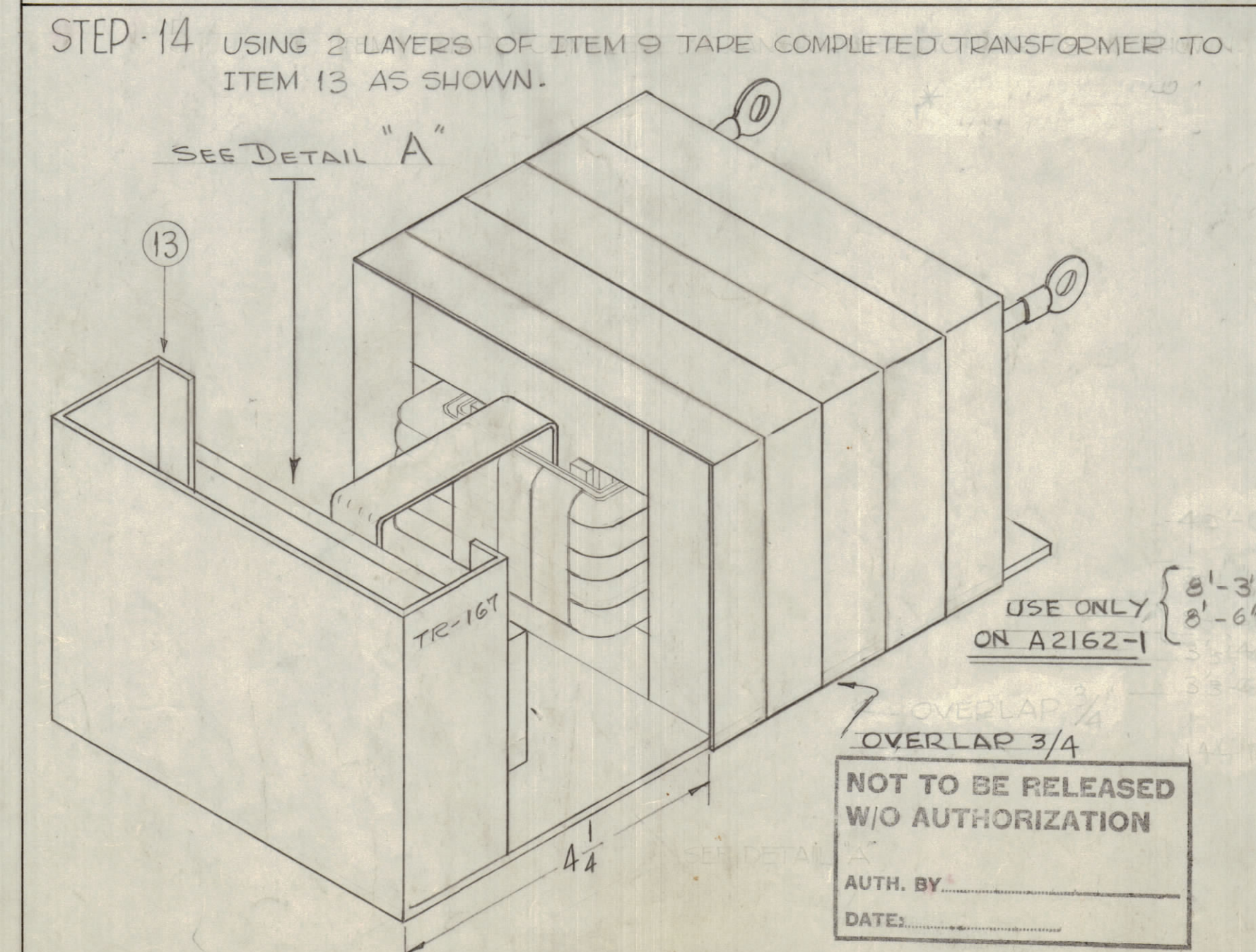
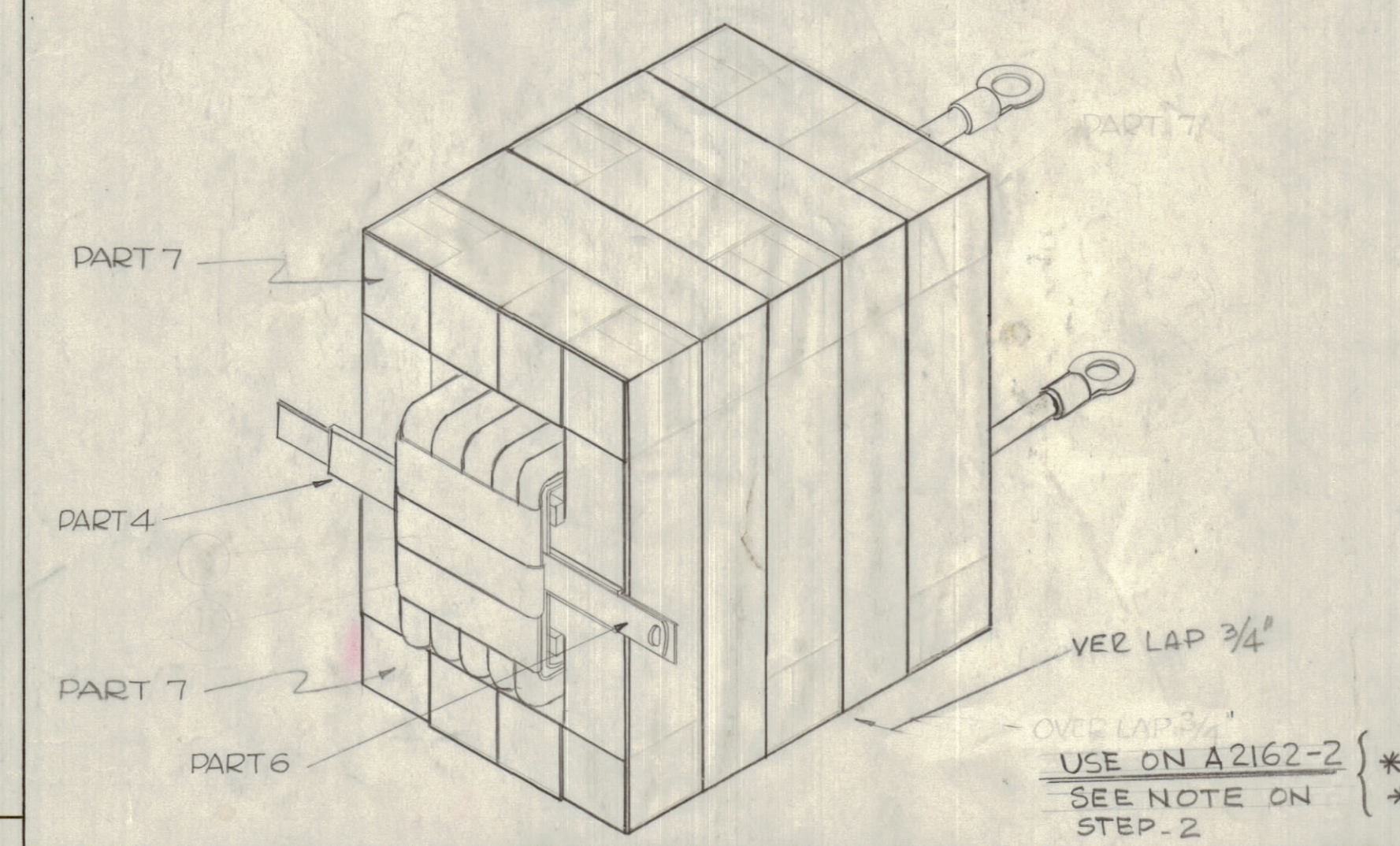
**STEP-9**  
WRAP 24 INCHES OF ITEM 11 AROUND PART 4. TIGHTEN, AND SECURE ITEM 11 WITH A 6 INCH STRIP OF ITEM 2.

**STEP-10**  
PLACE PART 6 SO POSITION OF TAB IS OVER ONE END OF PART 4, WRAP REMAINDER AROUND ITEM 11. TIGHTEN AND SECURE PART 6 WITH A 6 INCH STRIP OF ITEM 2.

**STEP-11**  
WRAP 24 INCHES OF ITEM 11 AROUND PART 6. TIGHTEN, AND SECURE ITEM 6 WITH A 6 INCH STRIP OF ITEM 2.



**STEP-13** ATTACH PART 7 TO PART 2 USING 2 LAYERS OF (9) AS SHOWN. BOLT SHIELD TO PRIMARY (PART 6 TO PART 4)



ITEM	QTY	PART NO.	DESCRIPTION	SYMB
10.3"	27	PX-370-4-7	TEFLON TUBING (8'-3")	
10.6"	26	TU-100-3-5	COPPER TUBING (8'-6")	
1	25	A-3081	Assembly, R.F. Shield	
2	24	TE 158-30661	Terminal, Lug	
5	23	LWS10MRN	Lockwasher, Split	
5	22	FW10HBN	Washer, Flat	
1	21	SCFP1032BN6	Screw, Flat Head	
1	20	NTH1032BN12	Nut, Hex.	
2	19	NTH2520BN14	Nut, Hex.	
2	18	LWS25MRN	Lockwasher, Split	
2	17	FW25HBN	Washer, Flat	
1	16	SCHH2520BN24F	Bolt, Hex.	
1	15	PX-614	Contact Support	
4	14	SCBPI032BN10	Screw, Machine	
1	13	MS-2649	Transformer, Mtg. Plate	
2	12	PX-397-2	Teflon Sheet, 2x5	
2	11	PX-397-3	Teflon Sheet, 2x24	
22	10	CI-125-1-Q1	"I" Core	
40.6	9	TA-108-9	Tape, Glass (40'-0")	
1	8	MS-2689	Shield, Transformer	
	7	PX-370-2-7	Teflon Tubing (8'-3")	
	6	TU-100-45	Copper Tubing (8'-6")	
3/4"	5	PX-370-59-7	Teflon, Tubing (3'-4")	
3/8"	4	MS-783-12336-5	Strap, Copper (3'-6")	
10	3	PX-615-1	Spacers, Teflon	
4.7"	2	TA-108-5	Tape, Glass (14'-7")	
22	1	CI-101-5-Q1	"C" Cores	

REQ.	ITEM	PART NO.	DESCRIPTION	SYMB
THE TECHNICAL MATERIEL CORP.				
MAMARONECK, NEW YORK				
TR-167, FINAL ASSEMBLY				
MATERIAL				
DRAWN: _____ CHECKED: _____ FINAL APPROVAL: _____				
TYPE & TEMPER HEAT TREAT. SPEC. aa				
FINISH & SPEC. NO. ELEC. DES. APP. MECH. DES. APP. SHEET OF				

REQ. PER UNIT	MODEL	SECTION	ASSY. NO.	DATE
1	TRC-5K			9-18-61
USED ON				

A-2162 E