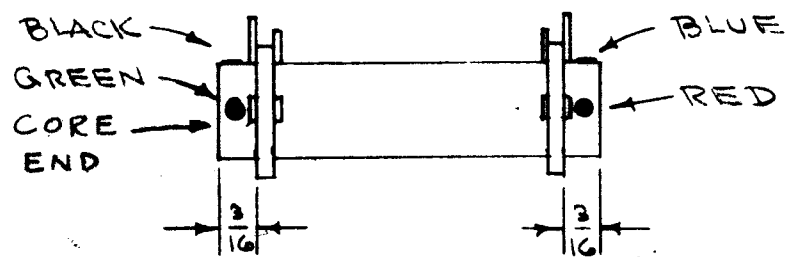


A-2465 D



COIL FORM ASSY.

- 1- CEMENT TERMINAL RINGS TO COIL FORM WITH ITEM 4 IN POSITION SHOWN ABOVE.
- 2- COLOR CODE COIL FORM AS ABOVE.

WINDING MACHINE DATA

SECONDARY		PRIMARY	
RACK GEAR	100	DRIVER GEAR	95
RACK DRIVER	36	CAM GEAR	49
CAM	.187	CAM	.125
CAM GEAR	66		
DRIVER GEAR	63		

WINDING DATA

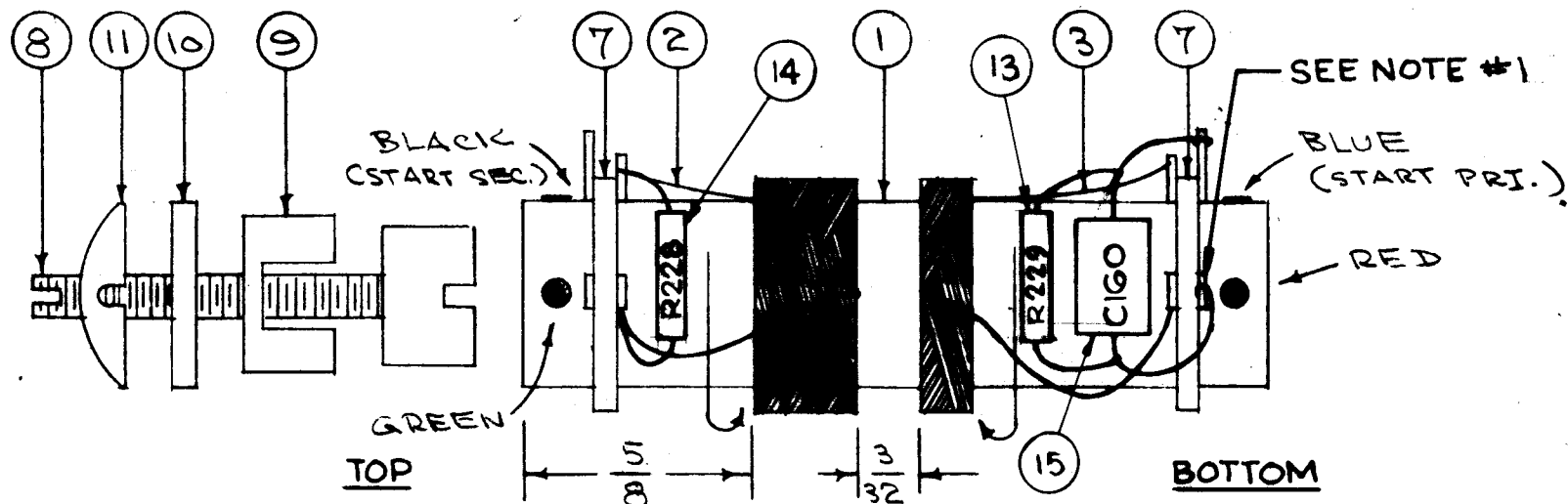
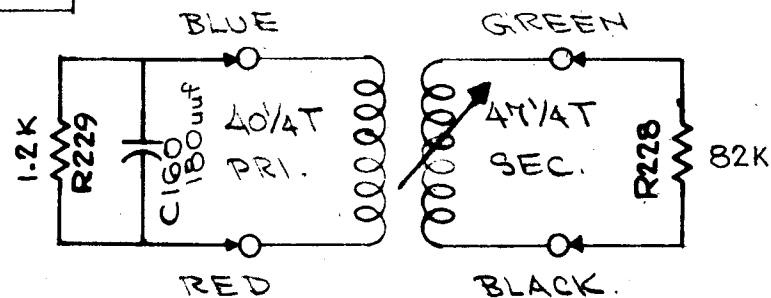
- 1- SECONDARY (WIND ON BEFORE PRIMARY). STARTING AT BLACK LUG WIND ON APPROX. 47 1/4 TURNS OF ITEM 2 (PROGRESSIVE UNIVERSAL WINDING). END ON GREEN LUG.
- 2- PRIMARY - STARTING AT BLUE LUG APPROX. 40 1/4 TURNS OF ITEM 3 (UNIVERSAL WINDING). END ON RED LUG.
- 3- STAKE LEADS TO COIL FORM WITH ITEM 4. STRIP, TIN AND SOLDER LEADS TO LUGS AS SHOWN.
- 4- BAKE FOR 1/2 HOUR AT 215° F.
- 5- SATURATE COILS WITH ITEM 5. BAKE FOR 1/2 HOUR AT 215° F.
- 6- REPEAT STEP 5.
- 7- SOLDER TEST LEADS (APPROX. 1/4" #22 BUSS BAR) TO LUGS. TEST AS BELOW. REMOVE TEST LEADS. ADD ITEMS 13, 14, 15.

TEST DATA w/o CORE

WINDING	* L uh	* Q	F	** R Ω APPROX.
SEC.	27.5 (26.1-28.9)	90 OR GREATER	2.5 MC	1.9
PRI.	32.5 (30.9-34.1)	40 " "	2.5 MC	2.6

* USE BOONTON Q METER 160A OR EQUIV.

** " SIMPSON OHMMETER 260 " "



NOTE: COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 8-9-10-11 ARE CEMENTED TO COIL FORM WITH ITEM 12.

FOR IDENTIFICATION, STAMP THE NUMBER TT-180 ON THE TOP COIL FORM.

NOTE #1 COMPONENTS MAY BE ASSEMBLED TO EITHER END OF LUG (TE-146-2A).

1	15	CM15C1BIJ	CAPACITOR, FIXED, MICA 180uuf	C160
1	14	RC20GF823K	RESISTOR, FIXED 82K	R228
1	13	RC20GF122K	RESISTOR, FIXED 1.2K	R229
X	12	GL-111	CEMENT, "	
1	11	FS-112	FASTENER	
1	10	WA-125-2	WASHER, FIBER	
1	9	NT-112	NUT, SPEED	
1	8	CI-109-9	CORE	
2	7	TE-146-2A	TERMINAL RING	
X	6	BS-100	SOLDER, SOFT	
X	5	GL-102	Q MAX	
X	4	GL-103	CEMENT, DUCCO	
X	3	WI-101-17	WIRE, MAGNET #36 DBC	
X	2	WI-104-541-SN28	" , LITZ 5/41 SN-QS	
1	1	CF-112	COIL FORM	

REQ. ITEM	PART NO.	GELLMAN DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
TT-180 ASSY			
MATERIAL			
TRANSFORMER, RF, TUNED (2 ND R.F.)			
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN, CHECKED, FINAL APPROVAL
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

D	4	CHG. ITEM #5	3-16-64	11048	AM	Q	
C	1	R228 WAS R223 R229 WAS R224	1/19/63	10459	AP	Q	
B	1	NOTES, WINDING DATA, PICTORIAL CLARIFIED, NOTE #1 ADDED	7-17-63	9515	AK	NP	
A	1	ITEMS (13, 14, 15) ADDED	6-5-63	9173	P	NP	
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

TOLERANCES		SCALE:	
DEC. DIM. ±		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES	
FRAC. DIM. ±			
ANGULAR DIM. ±			

1	GPR-92	TT10	10-25-62
REQ. PER UNIT	MODEL	PROJECT NO.	SYMBOL NO.
			DATE
USED ON			