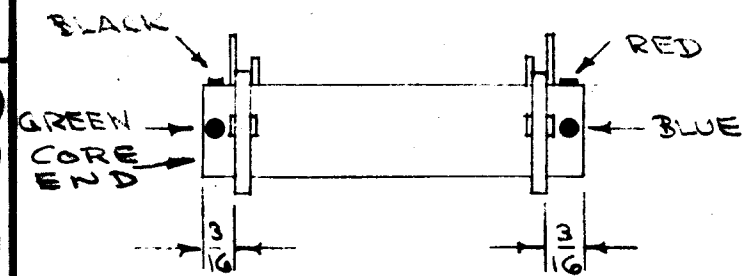


A-2466 A



COIL FORM ASSEMBLY

- 1- CEMENT TERMINAL RINGS TO COIL FORM WITH ITEM 3 IN POSITION SHOWN ABOVE.
- 2- COLOR CODE COIL FORM AS ABOVE.

WINDING MACHINE DATA

RACK GEAR	48
RACK DRIVER	80
CAM	.125
CAM GEAR	49
DRIVER GEAR	95

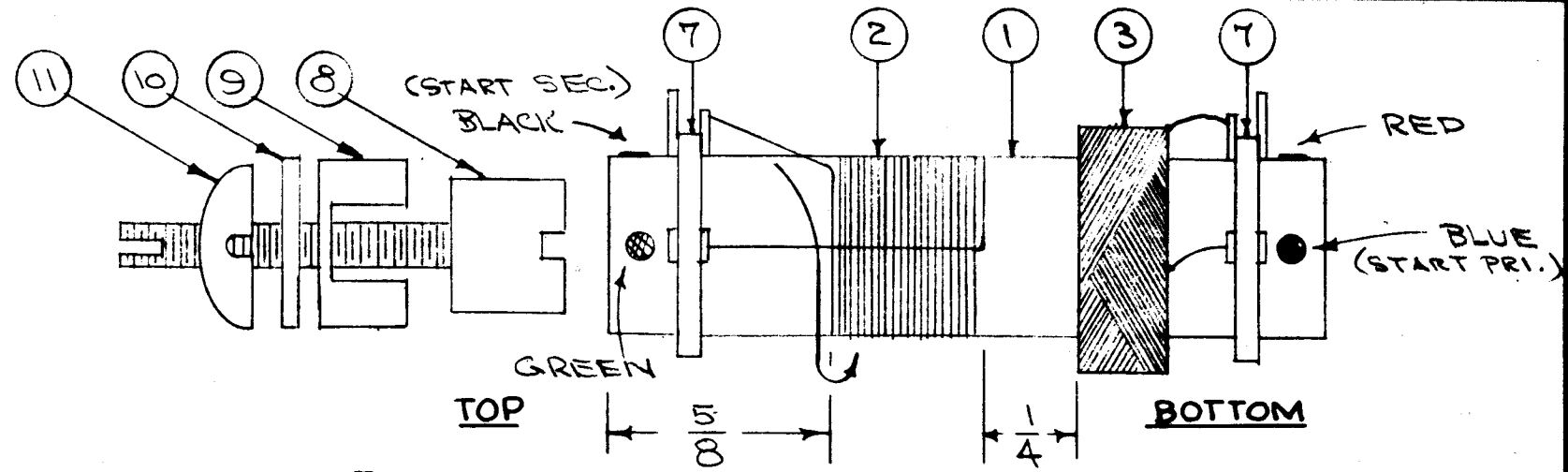
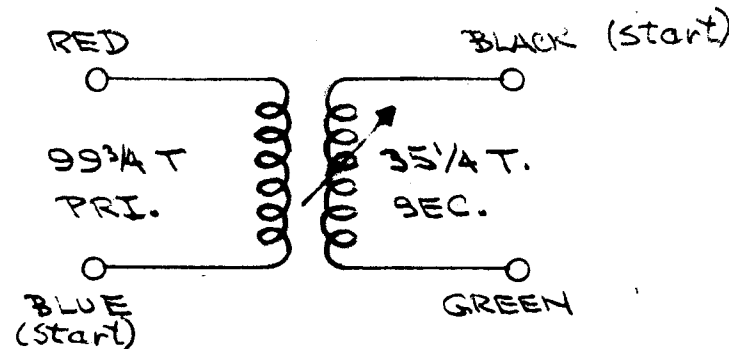
WINDING DATA

- 1- SECONDARY-(WIND ON BEFORE PRIMARY) APPROX. 35 1/4 CLOSE WOUND TURNS OF ITEM 2.
- 2- PRIMARY APPROX. 99 3/4 TURNS OF ITEM 3. UNIVERSAL WOUND.
- 3- STAKE LEADS TO COIL FORM WITH ITEM 4. STRIP, TIN & SOLDER LEADS TO LUGS AS SHOWN.
- 4- BAKE 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 #22 BUSS BAR (APPROX. 1/4") TO LUGS. TEST AS PER BELOW. REMOVE TEST LEADS.

TEST DATA. W/O CORE.

WINDING	* L _{uh}	* Q	f
PRI.	190 (180-200)	50 or GREATER	790 KC
SEC.	9.7 (9.2-10.2)	85 or "	2.5 HC

* USE BOONTON Q METER 160 A OR EQUIVALENT.



NOTE:

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

FOR IDENTIFICATION STAMP NUMBER TT-181 ON TOP OF COIL FORM.

X	12	GL-111	CEMENT, "INSA-LUTE"	
1	11	FS-112	FASTENER	
1	10	WA-125-2	WASHER, FIBER	
1	9	NT-112	NUT, SPEED	
1	8	CI-109-7	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, DUOCO	
X	3	WI-107-17	WIRE, MAGNET #36 DSC	
X	2	WI-107-11	" " #30 DSC	
1	1	CF-112	COIL FORM	
REQ. ITEM	PART NO.		DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
STOCK SIZE				
TT-181 ASSY. BAND 3				
MATERIAL				
TRANSFORMER, RF, TUNED (2 ND RF)				
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	1	CLARIFICATION MADE ON NOTES WINDING DATA & PICTORIAL	7-17-63	9515	AK	MD	WJA

DEC. DIM. ±	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES	1	GPR-92	T-111	10-16-62
FRAC. DIM. ±		REQ. PER UNIT	MODEL	PROJECT NO.	SYMBOL NO.
ANGULAR DIM. ±		USED ON			