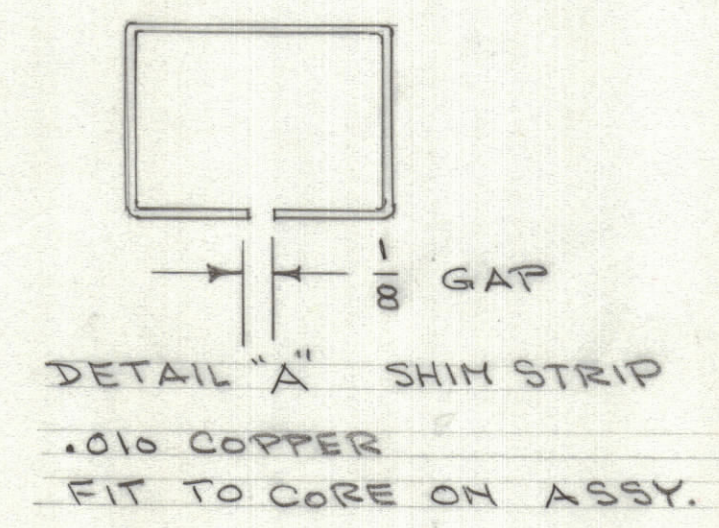
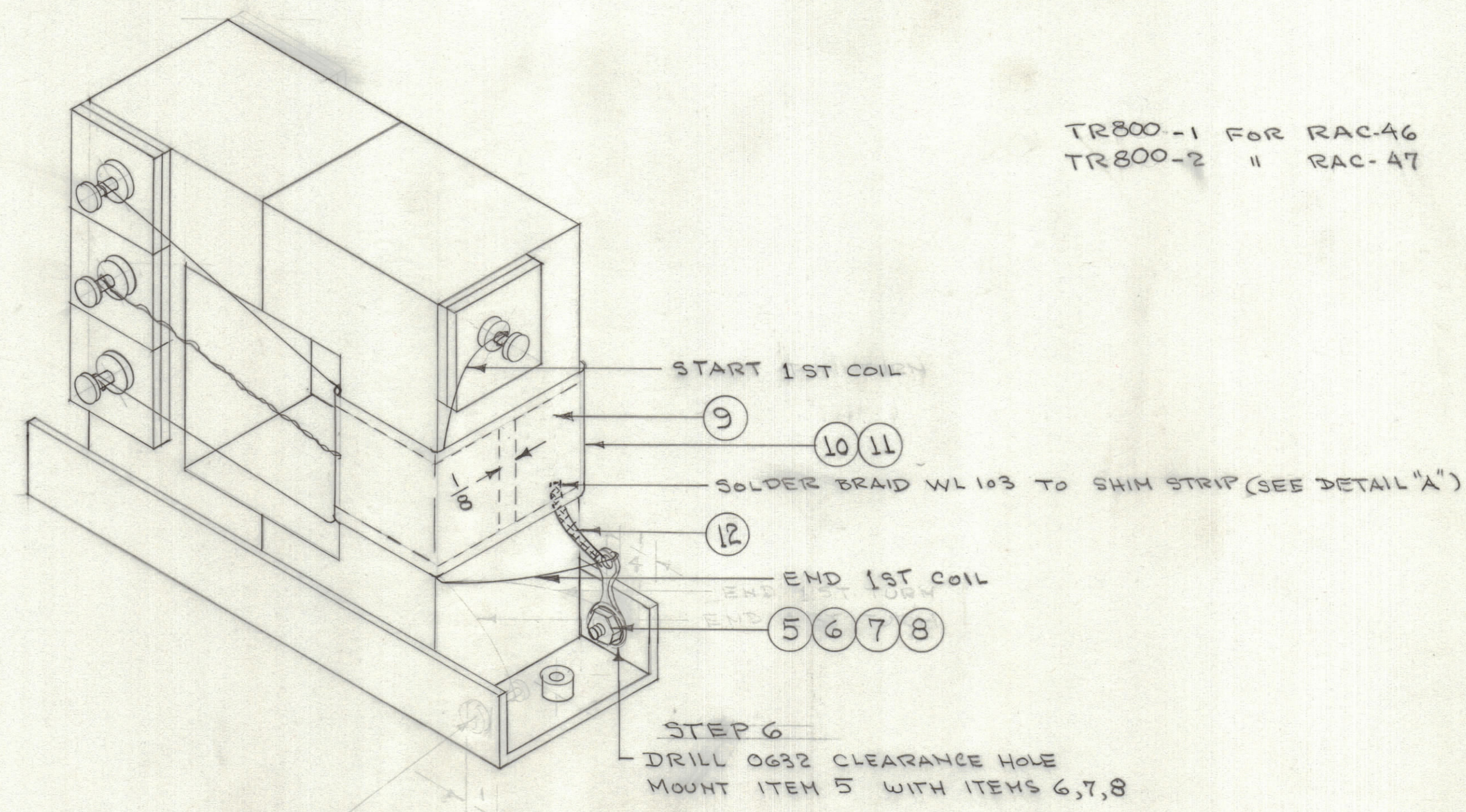
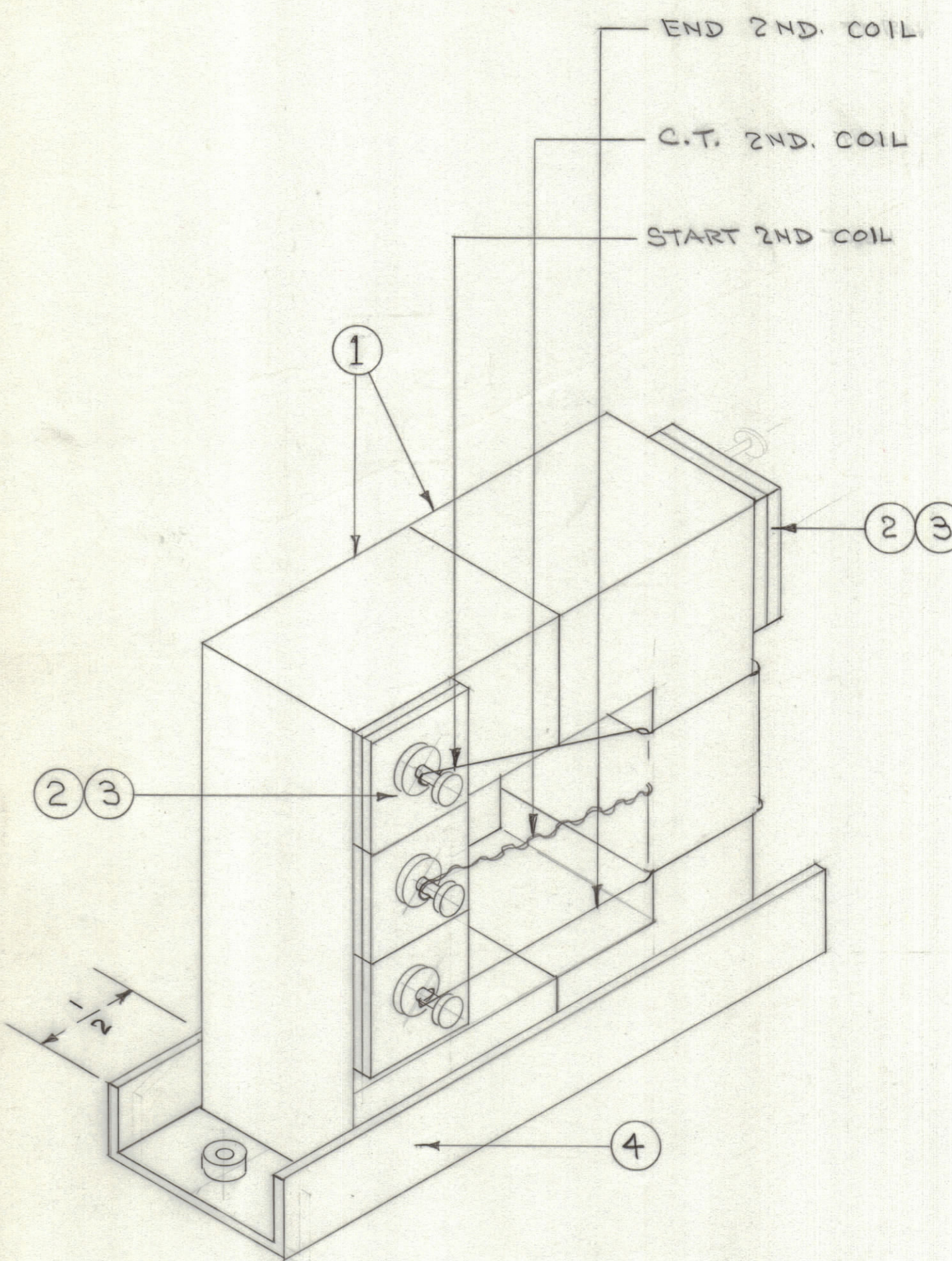


REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD
	A	.005 SHIM WAS .010	6/10/68			



STEP 6
DRILL .0632 CLEARANCE HOLE
MOUNT ITEM 5 WITH ITEMS 6,7,8

TR800-1 For RAC-46
TR800-2 " RAC-47

- ASSEMBLY STEPS
1. USING ITEM 13, JOIN ITEM 1 AS SHOWN.
 2. ALLOW ITEM 13 TO HARDEN FOR 2 HOURS.
 3. USING ITEM 13, JOIN ITEMS 2 & 3 TO ITEM 1 AS SHOWN.
 4. " " 13, " ITEM 1 TO ITEM 4 AS SHOWN.
 5. ALLOW ITEM 13 TO HARDEN FOR 2 HOURS.
 6. MODIFY ITEM 4 AS INDICATED BELOW.
 7. WRAP 2 TURNS OF ITEM 10 AROUND ITEM 1 ASSY.
 8. WRAP ON 2 TURNS OF ITEM 11. SOLDER TO TERMINALS AS SHOWN.
 9. WRAP ON 2 MORE TURNS OF ITEM 10.
 10. SOLDER ITEM 12 TO ITEM 9 AS SHOWN.
 11. WRAP COPPER SHIM OVER TAPE AS SHOWN. NOTE 1/8" GAP.
 12. SOLDER BRAID TO GROUND LUG AS SHOWN.
 13. WRAP ON 2 MORE TURNS OF ITEM 10.
 14. WRAP ON 4 TURNS OF ITEM 14 CENTER TAPPED AT 2 TURNS.
 14. " " 6 " " 14 " " 3 "
 15. SOLDER ENDS AND CENTER TAP TO TERMINALS AS SHOWN.
 16. WRAP ON 2 MORE TURNS OF ITEM 10.
 17. ALLOW ENTIRE XFMR ASSY. TO CURE FOR 24 HOURS

QTY. REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	15	BS100	SOLDER, TIN ALLOY	
X	14	WI123-22	WIRE, ELEC	
X	13	GL125	ADHESIVE, EPOXY (BLACK)	
X	12	WL103-	BRAID	
X	11	WI123-18	WIRE, ELEC	
X	10	TA110-	INS. TAPE, ELEC.	
X	9		.005THK COPPER SHIM	
1	8	NTH0632BN8	NUT, HEX	
1	7	LWI06MRN	WASHER, LOCK	
1	6	SCBF0632BN4	SCREW, MACHINE	
1	5	TE104-2	SOLDER LUG	
1	4	M55140-2	BRACKET, XFMR MTG	
4	3	PX1051-1	STRIP, TERM. MTG	
4	2	PX1051-2	" " " "	
2	1	CE101-3-QL	CORE, "U" TYPE	

1	RAC 46	
1	RAC 47	
QTY / UNIT	MODEL USED ON	ASS'Y NO.
APPLICATION		
CODE		
MATERIAL		
FINISH		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	FINAL APPROVAL	DATE
TOLERANCES ON	MECH. DES.	DATE
DECIMALS	ELECT. DES.	DATE
FRACTIONS	CHECKED	DATE
.X ± .05	DRAWN	DATE
.XX ± .01	C.D. DEAN	5-1-68
.XXX ± .005		

LIST OF MATERIAL		
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
TR8000 MFGR ASSY		
SIZE	CODE IDENT. NO.	DWG NO.
D	82679	A 8039
ISSUE		
A		
SCALE	SHEET OF	
SCALE		

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