

COIL FORM ASSY.

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

WINDING MACHINE DATA

RACK GEAR 25
RACK DRIVER GEAR 100

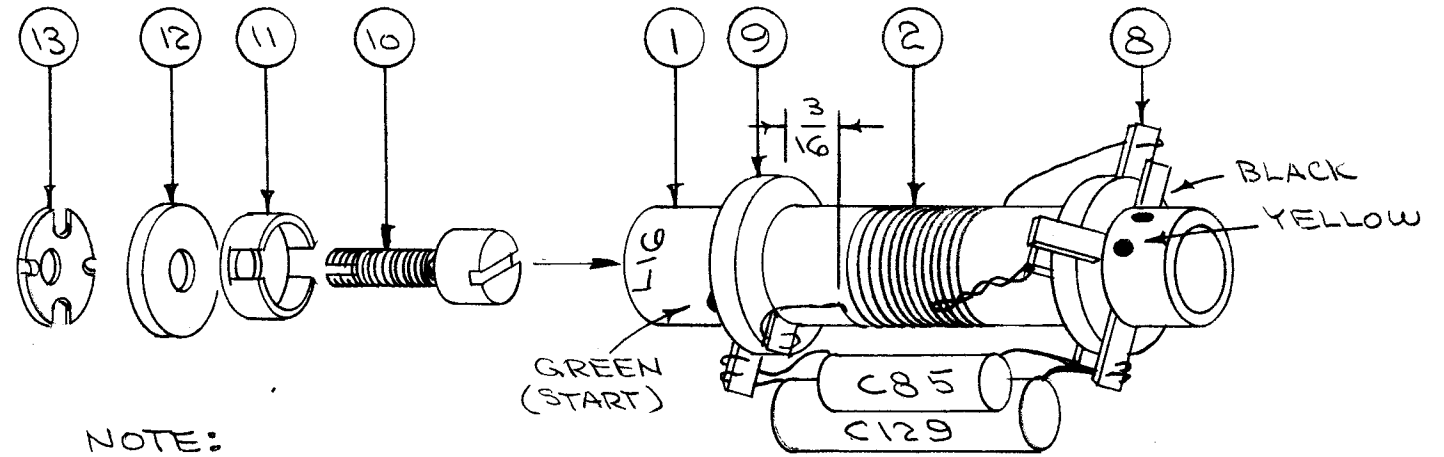
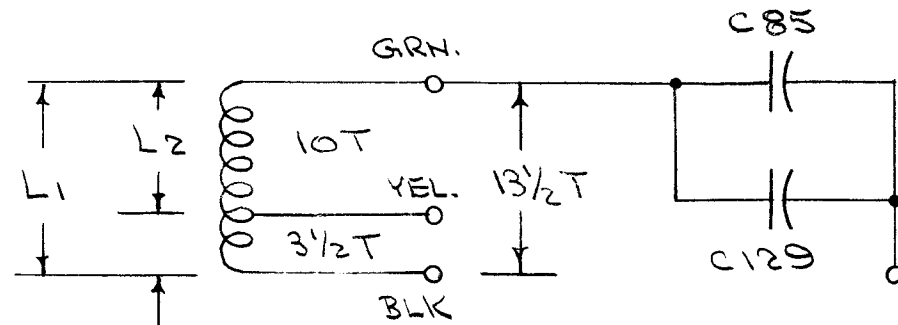
WINDING DATA

- 1- STARTING AT GREEN WIND ON 10 TURNS OF ITEM 2. BRING OUT TWISTED TAP 1" LONG TO YELLOW LUG.
- 2- CONTINUE WINDING FOR 3 1/2 TURNS ENDING AT BLACK LUG FOR A TOTAL OF 13 1/2 TURNS.
- 3- STAKE LEADS TO COIL FORM WITH ITEM 3. STRIP, TIN & SOLDER LEADS AND TAP TO LUGS AS SHOWN.
- 4- BAKE FOR 1/2 HOUR AT 215° F.
- 5- SATURATE COIL WITH ITEM 5. BAKE FOR 1/2 HOUR AT 215° F.
- 6- SOLDER CONNECT TEST LEADS TO LUGS. (APPROX. 1/4" #22 BUSS BAR). TEST AS BELOW. REMOVE TEST LEADS
- 7- SOLDER CONNECT CAPACITORS IN PLACE AS SHOWN. TIE CAPACITORS TO COIL WITH ITEM 15 Seal knots with item 3.

TEST DATA w/o CORE

WINDING	L μ h	Q	F
L1	1.66 (1.58-1.74)	30 OR GREATER	7.9 MC
L2	1.12 (1.07-1.17)	75 " "	7.9 MC

USE BOONTON Q METER 160A OR EQUIVALENT



NOTE:

- 1- KEEP CAP. LEADS SHORT BUT DO NOT ALLOW CAP. TO TOUCH A LUG.
- 2- COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 10-11-12-13 ARE CEMENTED TO COIL FORM WITH ITEM 14.
- 3- FOR IDENTIFICATION, STAMP THE NUMBER L16 ON COIL FORM IN ANY CONVENIENT SPOT.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 15	CD-101-1 MW	CORD, LACING	
X 14	GL-111	CEMENT, "INSA-LUTE"	
1 13	FS-112	FASTENER	
1 12	WA-125-2	WASHER, FIBER	
1 11	NT-112	NUT, SPEED	
1 10	CI-169-7	CORE	
1 9	TE-146-1	TERMINAL RING	
1 8	TE-146-3	" "	
1 7	CC35CG 910 J	CAPACITOR, FIXED	C85
1 6	CC45SH 221 J	" "	C129
X 5	GL-102	Q MAX	
X 4	BS-100	SOLDER, SOFT	
X 3	GL-103	CEMENT, DUCO	
X 2	WI-107-11	WIRE, MAGNET #30 DSC	
1 1	CF-112	COIL FORM	

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
COIL, RF, TUNED, OSCILLATOR BAND 4			
REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			
MATERIAL			
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
K	15	WAS CD101-3MW	10-19-66	17040	RME	[Signature]	[Signature]

REQ. PER UNIT	MODEL	PROJECT NO.	SYMBOL NO.	DATE
1	GPR-90-RXD	297	L16	5-23-60
1	GPR-90	297	L16	8-2-56

DEC. DIM. \pm
FRAC. DIM. \pm
ANGULAR DIM. \pm

SCALE: 1" = 1"

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