

**COIL FORM ASSY.**

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

**WINDING MACHINE DATA**

SECONDARY		PRIMARY	
RACK OR PINION GEAR - 40		DRIVER GEAR - 95	
RACK GEAR - 100		CAM GEAR - 49	
		CAM - .125	

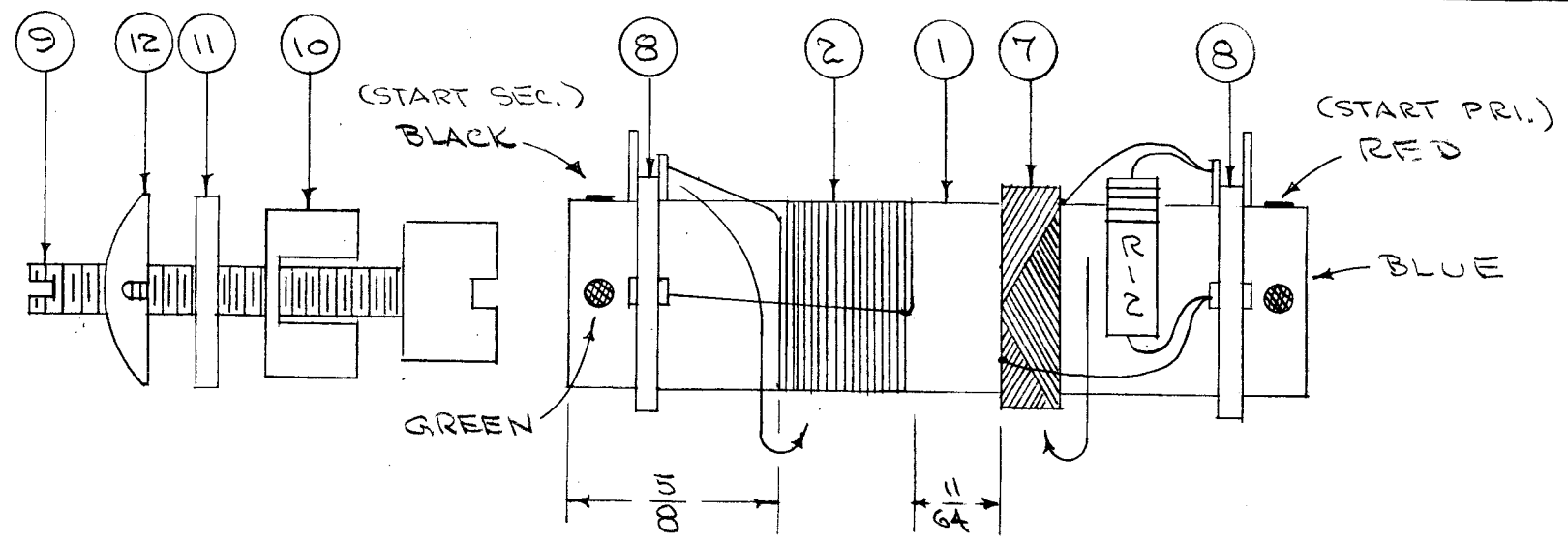
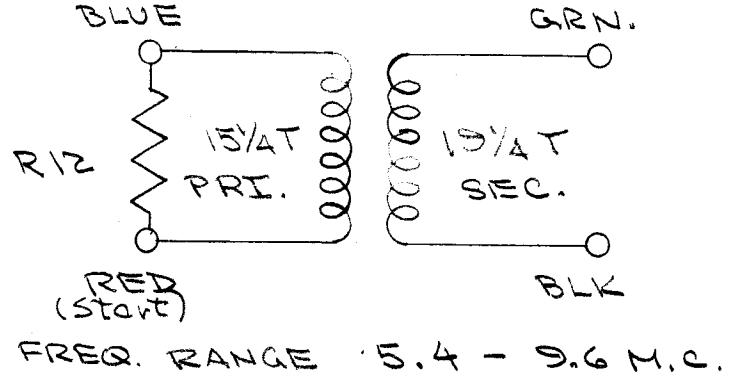
**WINDING DATA**

- 1- SECONDARY - (WIND ON BEFORE PRIMARY). STARTING AT BLACK LUG SPACE WIND 19 1/4 TURNS OF 2, ENDING ON GREEN LUG.
- 2- PRIMARY - START AT RED LUG 15 1/4 TURNS OF ITEM 7, UNIVERSAL WOUND. END ON BLUE LUG.
- 3- STAKE LEADS TO COIL FORM WITH ITEM 3.
- 4- STRIP, TIN & SOLDER CONNECT LEADS AS SHOWN.
- 5- BAKE FOR 1/2 HOUR AT 215°F.
- 6- SATURATE COILS WITH ITEM 4, BAKE FOR 1/2 HOUR AT 215°F.
- 7- REPEAT STEP 6.
- 8- SOLDER CONNECT TEST LEADS (APPROX. 1/4" #22 GA. BUSS.) TEST AS BELOW. REMOVE TEST LEADS.
- 9- SOLDER CONNECT RESISTOR IN PLACE.

**TEST DATA w/o CORE**

WINDING	* L μH	* Q	F
PRI.	5.0 (4.7-5.2)	62 OR GREATER	7.9 MC
SEC.	3.4 (3.2-3.6)	120 " "	7.9 MC

\* USE BOOMTON Q METER 160 A OR EQUIVALENT.



NOTE: COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 9-10-11-12 ARE CEMENTED TO COIL FORM WITH ITEM 13.

FOR IDENTIFICATION STAMP NUMBER L10 ON COIL FORM IN ANY CONVENIENT SPOT.

X	13	GL-111	CEMENT, "INSA-LUTE"		
	1	R2	FASTENER		
	1	11	WA-125-2	WASHER, FIBER	
	1	10	NT-112	NUT, SPEED	
	1	9	CI-109-7	CORE	
	2	8	TE-146-2A	RING, TERMINAL	
PRI.	X	7	WI-107-17	WIRE, MAGNET #36 DSC	
	1	6	RC20GF102 J	RESISTOR, FIXED	R12
	X	5	BS-100	SOLDER, SOFT	
	X	4	GL-102	Q MAX	
	X	3	GL-103	CEMENT DU CO	
SEC.	X	2	WI-107-11	WIRE, MAGNET #30 DSC	
	1	1	CF-112	COIL FORM	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK, NEW YORK			
STOCK SIZE			
MATERIAL			
TRANSFORMER, RF TUNED, BAND 4			
		CD 7/31/56	HAISE
		PLK	A.J.J.
			FINAL APPROVAL
			A-964 G

ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
1	REPAWN COMPLETE REVISION	7/31/56	4	PLK	PLK	AJJ
1	Q of 62 WAS 78	11/15/56	5	16	PLK	AJJ
1	Q of 120 WAS 138	11/15/56	5	16	PLK	AJJ
1	CHANG TITLE	11/15/56	5	16	PLK	AJJ
2	NT-112 WAS NT-113	11/15/56	5	16	PLK	AJJ
3	WA-125-2 WAS WA-125	11/15/56	5	16	PLK	AJJ
3	ITEM 6 WAS RC20GF102K	9-27-66	6890	G.D.L.	PLK	AJJ

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

1	GPR-90-RXD			5-23-60
1	GPR-90	297	L10	7-31-56
REQ. PER UNIT	MODEL	PROJECT NO.	SYMBOL NO.	DATE
USED ON				