

WINDING MACHINE DATA

CAM GEAR 105
 DRIVER " 60
 CAM 1/4

WINDING DATA

1 WINDING
 100 TURNS OF ITEM 16 (LITZ WIRE)

2 WINDING
 32 TURNS, CLOSE WOUND, SINGLE LAYER OF ITEM 17 (#30 DSC, MAGNET)

3 WINDING
 5 TURNS OF ITEM 18 (#32 DSC MAGNET) ON TOP OF & IN CENTER OF COIL #1. SINGLE LAYER & CLOSE WOUND.

4 WINDING
 2 TURNS OF ITEM 18 (#32 DSC MAGNET) SINGLE LAYER & CLOSE WOUND AT BASE OF AND ADJACENT TO COIL #2.

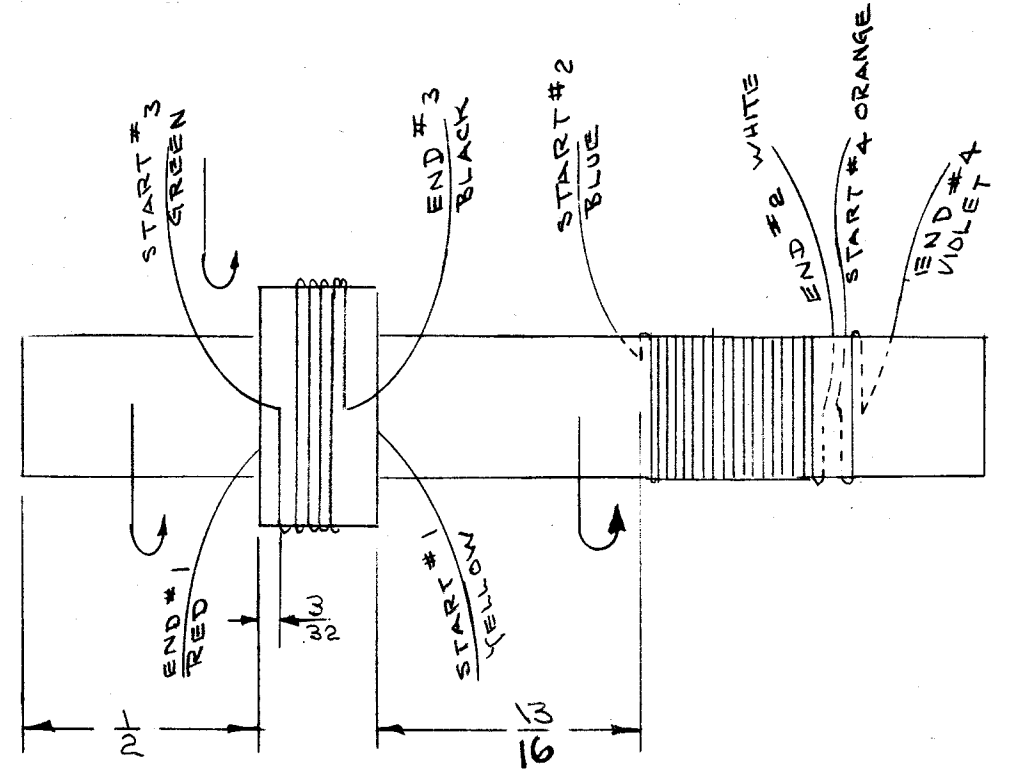
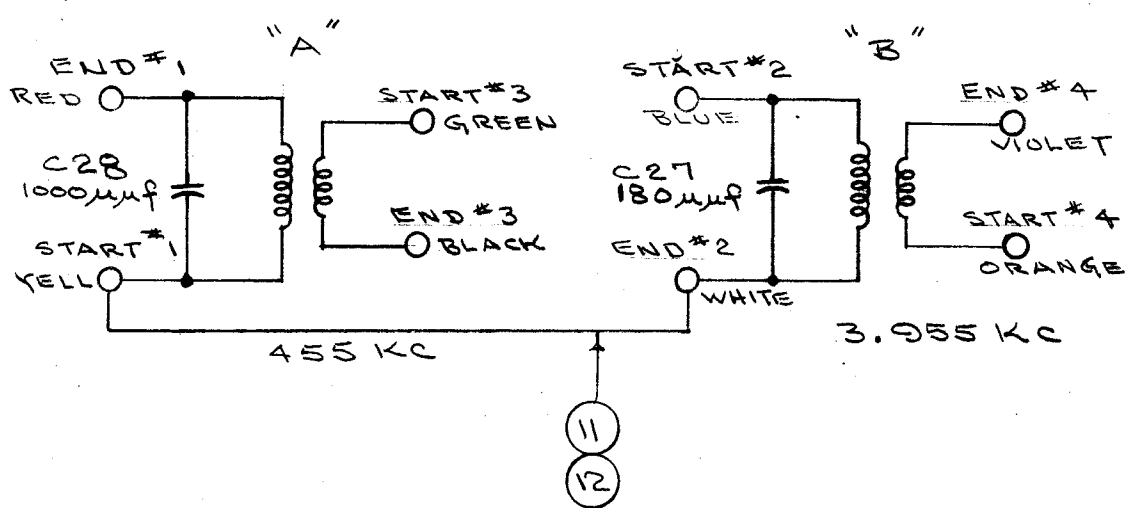
FABRICATION

1. STAKE LEADS TO COIL FORM W/ ITEM 15 (GL-103).
2. BAKE FOR 1/2 HR. AT 215° F
3. APPLY COATING OF ITEM 19 (Q-MAX)
4. BAKE FOR 1/2 HR. AT 215° F.

ELECTRICAL TEST DATA W/O CORE

WINDING	L	Q	F
# 1	95 μh (90-100)	> 82	790 KC
# 2	6.2 μh (5.9-6.5)	710	7.9 KC

WIRING DIAGRAM



REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	19	GL-102	Q-MAX	
X	18	WI-107-13	WIRE, MAGNET # 32 DSC	
X	17	WI-107-11	WIRE, MAGNET # 30 DSC	
X	16	WI-104-541-SNE	WIRE, LITZ (5/41)	
X	15	GL-103	CEMENT, DUCO	
X	14	BS-100	SOLDER, SOFT	
1	13	A-949	CAN, SUB-ASSY	
X	12	PX-104-1-.022	INSULATION, SLEEVING	(BLK)
X	11	WL-100-7	WIRE, BUSS BAR (22 GA)	
1	10	CM15F181G03	CAPACITOR, FIXED	C27
1	9	CM20F102G03	CAPACITOR, FIXED	C28
1	8	CI-109-15	CORE	
1	7	CI-109-16	CORE	
2	6	NTH0632BN8	NUT, HEX	
2	5	NT-102	NUT, HEX.	
2	4	LWI25LRN	WASHER, LOCK	
2	3	SM-110	BUSHING	
1	2	A-986	TERMINAL BD - SUB ASSY	
1	1	CF-117-2.5	COIL FORM	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
K		UPDATED ITS. 4, 6, 9 & 10	9.28.66	16893	4/4	P.L.K.	
J	1	ITEM #9 CM20D102G WAS CM109D1001G	11/12/58	522	J.C.B.	me	P.L.K.
J	2	ITEM #10 CM20D181G WAS CM109D1800G					
H	1	TITLE CLARIFIED	7/3/56	2	16	P.L.K.	A.J.J.
G	2	SUPERSEDES A-971 COMPLETELY REVISED	8/3/56	1	J.M.R.	COO	A.J.J.

TOLERANCES: DEC. DIM. ±, FRAC. DIM. ±, ANGULAR DIM. ±

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

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	GPR-90	297		6-21-55

USED ON

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
IF COMPOSITE TRANSFORMER ASSY				
T3, T4 MODEL GPR				
TYPE & TEMPER		HEAT TREAT. SPEC.		FINAL APPROVAL
FINISH & SPEC. NO.		ELEC. DES. APP.		MECH. DES. APP.

DRAWN: P.L.K.
 CHECKED: [Signature]
 FINAL APPROVAL: A.J.J.
 A-1038 K