

A-1255 B

WINDING MACHINE DATA

DRIVER GEAR - 87
 CAM GEAR - 90
 CAM - .156

ASSEMBLY:

AFFIX ITEM 2 ON END OF COIL FORM WITH
 ITEM 6. AIR DRY.

WINDING PROCEDURE

1. START WINDING 1/4" FROM LUG END OF COIL FORM, AND CLOSE TO BLACK LUG. (USE WINDING FINGER WITH WIRE GUIDE ON RIGHT. START WINDING WITH FINGER IN EXTREME RIGHT HAND POSITION OF TRAVEL).
2. TAP AS SHOWN IN SCHEMATIC, AT 60 3/4 T. & 125 1/4 T., END COIL AT 200 1/2 T.
3. STAKE ENDS & TAPS TO COIL FORM WITH ITEM 6.
4. SOLDER CONNECT ENDS & TAPS AS SHOWN.
5. BAKE FOR 1/2 HR. AT 315° F. SATURATE COIL WITH ITEM 5 AND AIR DRY FOR 10 MIN. BAKE FOR 2 HOURS AT 215° F.

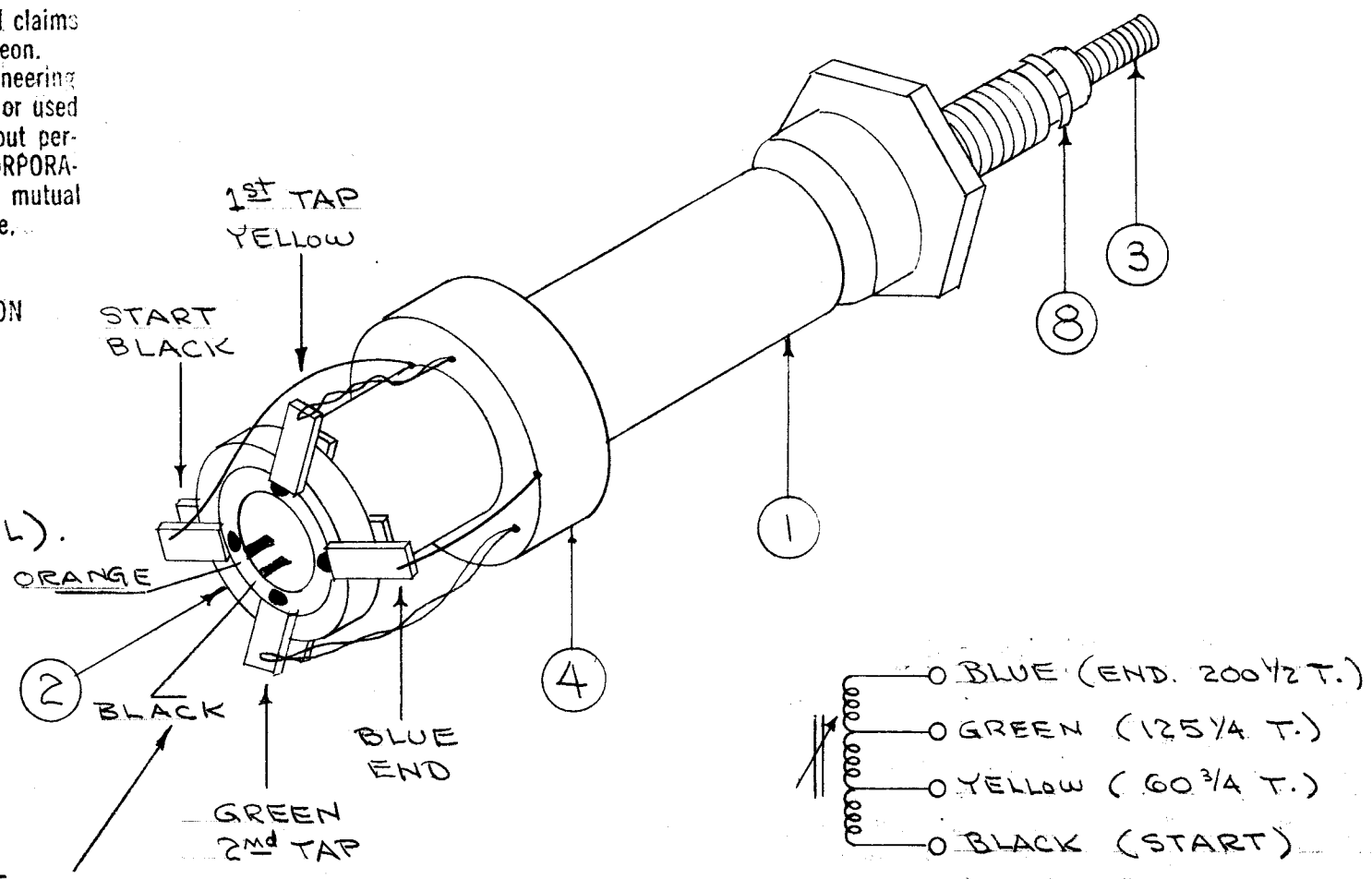
TEST PROCEDURE W/O CORE

USE BOONTON Q METER 160-A OR EQUIVALENT.

NOTICE TO PERSONS RECEIVING THIS DRAWING: COLOR CODE COIL FORM AS BELOW

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 THE TECHNICAL MATERIEL CORPORATION
 MAMARONECK, NEW YORK



NOTE
 COLOR CODE AS SHOWN
 INSIDE OF COIL FORM
 (REF: CH-102)

	BLUE - BLACK	BLUE / YELL	BLACK / GRN
L	770µh (730-810µh)	420µh (378-462)	285µh (255-315)
Q	> 25	> 20	> 15
F	790 KC	790 KC	790 KC

MISC. TEST INFO.
 OUT OF CAN, WITH CORE
 L MAX. 1.54 mh
 L MIN. .78 mh
 IN CAN, WITH CORE
 L MAX. 1.3 mh
 L MIN. .7 mh

1	8	SP-102	LOCKING SPRING
X	7	BS-100	SOLDER, SOFT
X	6	GL-103	CEMENT, DUPONT
X	5	GL-104-2	INSULEX, U-85
X	4	WI-120-15	WIRE, #34 D.S.C.
1	3	CI103D7B5	CORE
1	2	TE-146-4	COLLAR & LUGS
1	1	CF-114-3	COIL FORM

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
COIL, OSCILLATOR			
L-100			
MATERIAL			
		3/20/56	PLK 49-56
		A. J. J.	
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
		PLK 4-9-56	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
		A-1255 B	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	1	Test Data Chgd	6/4/56	2		J.P.L.	A.J.J.
A	1	COLOR CODE ADDED	5/31/56	1		J.P.L.	A.J.J.

TOLERANCES		SCALE:
DEC. DIM. ±	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES	1
FRAC. DIM. ±		
ANGULAR DIM. ±		

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	FFRD-1	E-458-P	A-1263	3-20-56
USED ON				