

A-1259

ASSEMBLY:

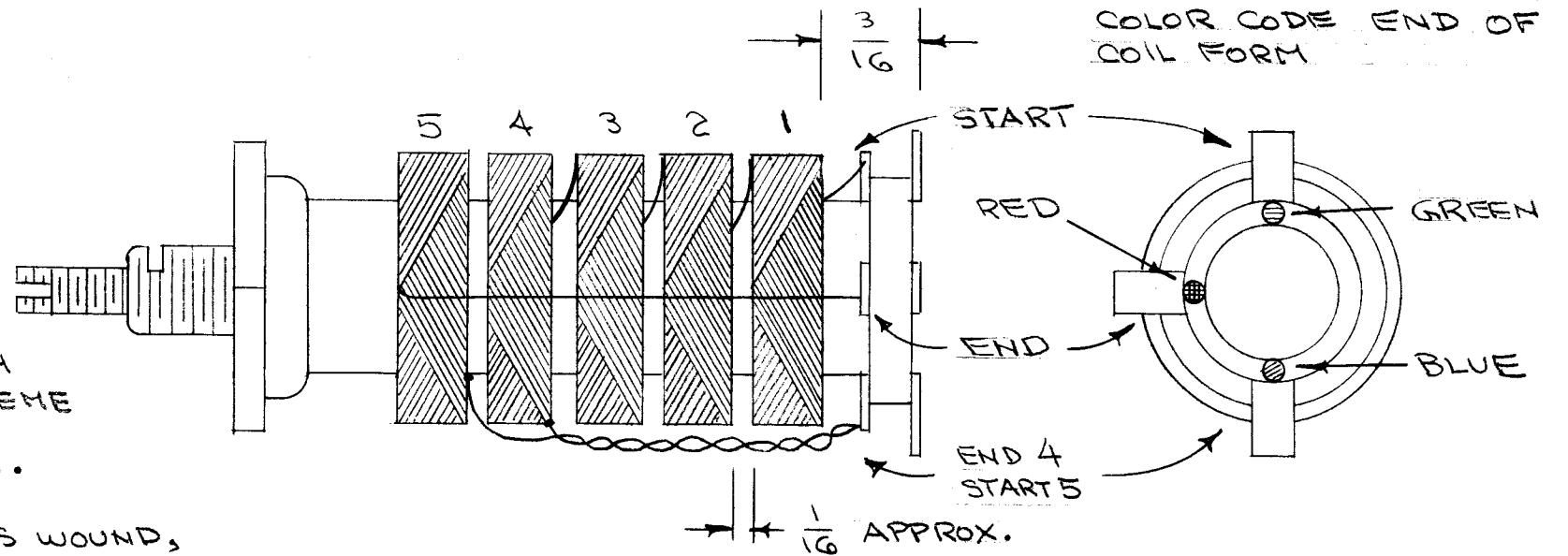
AFFIX COLLAR TO COIL FORM WITH ITEM 6. (CEMENT).  
AIR DRY.

WINDING MACHINE DATA

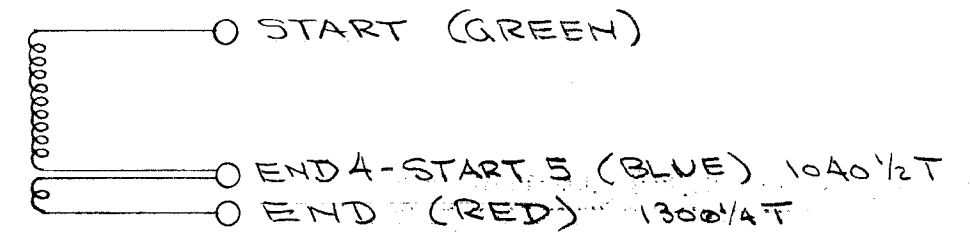
DRIVER GEAR - 87  
CAM GEAR - 90  
CAM - .156

WINDING PROCEDURE

- 1.- START 1st PI 3/16" FROM END OF COIL FORM AND ADJACENT TO GREEN LUG. (USE WINDING FINGER WITH GUIDE ON RIGHT. START WINDING WITH FINGER IN EXTREME RIGHT HAND POSITION OF TRAVEL).
- 2.- END PI WITH FINGER IN EXTREME LEFT HAND POSITION.
- 3.- SPOT END OF PI WITH ITEM 6. (CEMENT)
- 4.- ROTATE SPINDLE & COIL FORM 180° IN DIRECTION COIL IS WOUND, SO WINDING FINGER IS AGAIN IN EXTREME RIGHT HAND POSITION. PERMIT LOOSE END OF WIRE TO FALL OFF OF PI. DRESS WIRE CLOSE AGAINST BASE OF PI.
- 5.- USING RACK FEED KNOB, POSITION COIL FORM SO THAT WINDING FINGER GUIDE JUST TOUCHES LEFT SIDE OF PI. THIS GIVES SPACING BETWEEN PIS OF APPROX. 1/16".
- 6.- REPEAT ABOVE STEPS FOR PIS 2-3-4 & 5 (NOTE THAT END OF PI 4 & START OF PI 5 ARE ON BLUE LUG.)
- 7.- SECURE COIL ENDS WITH ITEM 6. AIR DRY.
- 8.- MAKE SOLDER CONNECTIONS TO PROPER LUGS.
- 9.- BAKE FOR 1/2 HOUR AT 215°F. SATURATE COIL WITH ITEM 5 AND AIR DRY FOR 10 MIN.  
BAKE FOR 2 HOURS AT 215°F.



END 1st PI	260 1/4	TURNS FROM START
" 2nd PI	519 3/4	" " "
" 3rd PI	779 1/2	" " "
" 4th PI	1040 1/2	" " "
" 5th PI	1300 1/4	" " "



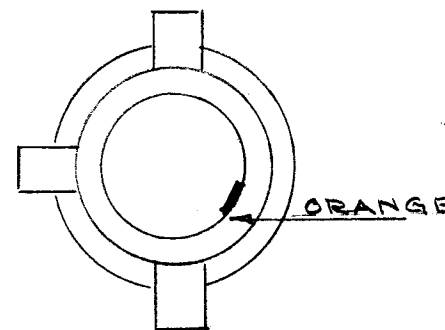
TEST DATA w/o CORE

	GRN/RED	GRN/BLUE
L	11.0 mh (10.4-11.6)	9.2 mh (8.3-10.1)
Q	>40	>40
F	79 KC	250 KC

USE BOONTON Q METER 160A OR EQUIVALENT.

MISC. TEST INFO.

IN CAN WITH CORE	L MAX.	22.0 mh
	L MIN.	16.7 mh
OUT OF CAN WITH CORE	L MAX	29.2 mh
	L MIN	21.5 mh



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

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
1	8	SP-102	SPRING LOCK
X	7	BS-100	SOLDER, SOFT
X	6	GL-103	CEMENT
X	5	GL-10A-2	INSULEX U85
X	4	WI-120-15	WIRE 34 DSC
1	3	C1103D7B3	CORE
1	2	TE-146-3	COLLAR & LUGS
1	1	CF-114-3	COIL FORM
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
MIXER & RF COIL ASSY. T-101 AND T-102			
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.
C	1	ITEM 3 WAS C1103D7B5	9/9/56	3	JAR	P.L.X.	A.J.J.
B	1	Test Data chgd	6/4/56	2	JAR	P.L.X.	A.J.J.
A	1	COLOR CODE ADDED	5/31/56	1	JAR	P.L.X.	A.J.J.

2	FFRD-1	E-458-P	A-1264	3-22-56
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
USED ON				