

WINDING MACHINE DATA

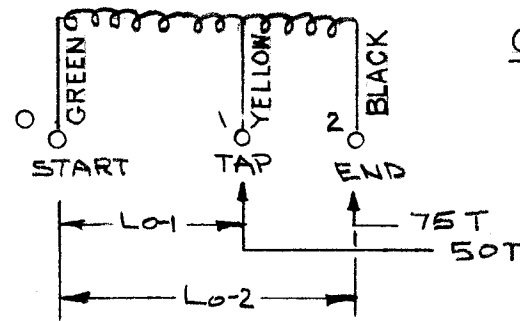
DRIVER GEAR 80
 CAM GEAR 86
 CAM .125

WINDING PROCEDURE

- 1- WIND ON 50 TURNS OF ITEM 2
- 2- BRING OUT TAP
- 3- CONTINUE WINDING. END COIL AT 75 TURNS.
- 4- STAKE LEADS & TAP TO COIL FORM WITH ITEM 3 (CEMENT)
- 5- BAKE COIL FOR 1/2 HOUR AT 215° F
- 6- SATURATE COIL, AND COAT TERMINAL RINGS, EXCEPT ENDS, WITH ITEM 4, INSULEX.
- 7- BAKE COIL FOR 1/2 HOUR AT 125° C.

ELECTRICAL DATA (TEST TRANSFORMER W/O CORE)

TEST LEADS TO BE 1/2"

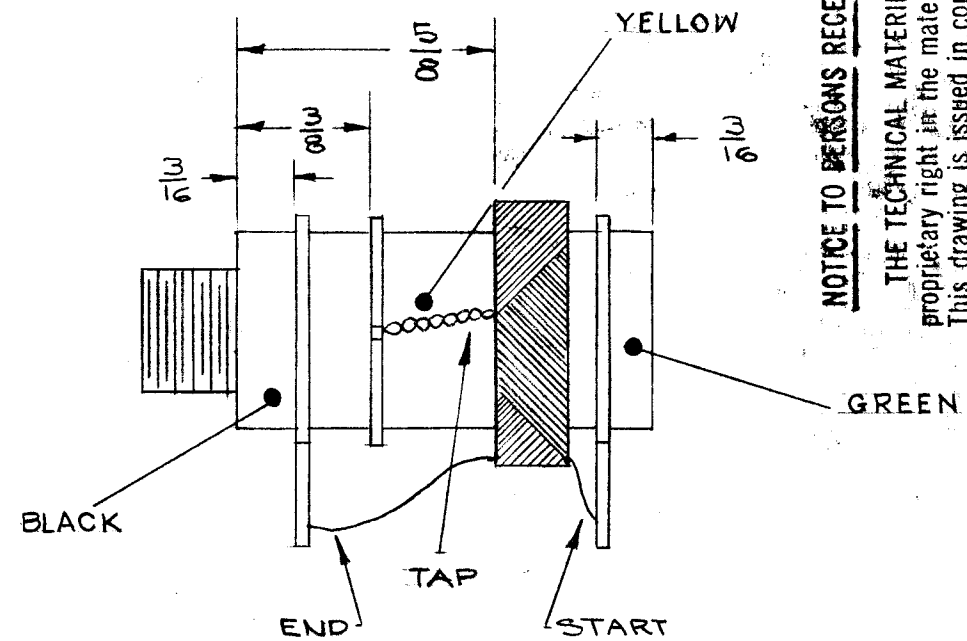
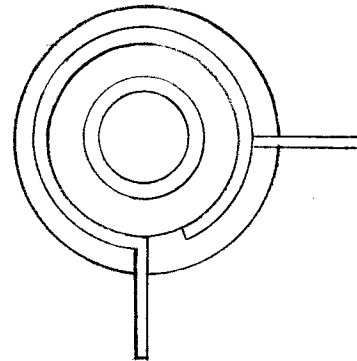


COLOR CODE AS SHOWN

- * L0-2 78.4h (72-84)
- * L0-1 29.4h (27-31)
- * Q 60 OR GREATER
- * 2.5 MC
- Δ R0-2 1.8 - 2.2 OHMS.

- * BOONTON Q METER TYPE 160 A OR EQUIV.
- Δ SIMPSON OHMMETER MODEL 260 OR EQUIV.

LEADS & TAP TO BE APPROX. 2"

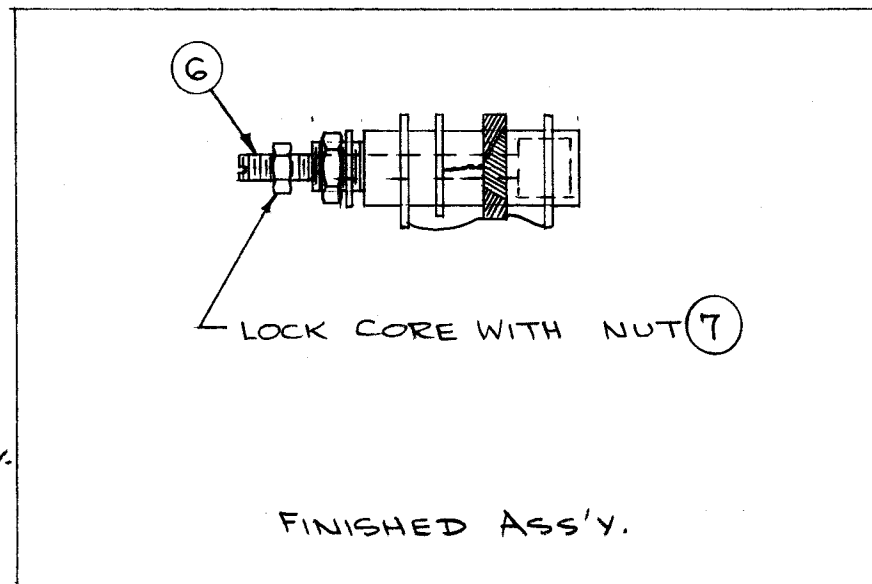


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THE TECHNICAL MATERIEL CORPORATION
 MAMARONECK, NEW YORK



1	7	NTH0632BCB	NUT, HEX.	
1	6	CI-109-16	CORE, TUNING	
3	5	TE-153-2	TERMINAL RINGS	
X	4	GL-104-2	INSULEX, U-85	
X	3	GL-103	CEMENT	
X	2	WI-104-1243-SC-QS	WIRE, LITZ	
1	1	CF-107-4	COIL FORM	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
438 & 472 KC OSC. SUB- ASSEMBLY (TI.)			
STOCK SIZE		MATERIAL	
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
SC. 5-7-57		46	A.J.J.
P.L.K.		A-1413 B	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	1	*Q WAS 80 OR GREATER	6-22-64	11612	A.M.	<i>[Signature]</i>	<i>[Signature]</i>
A		GREEN, YELLOW, BLACK COLORS ADDED.	10-14-58	475	J.C.B.	<i>[Signature]</i>	<i>[Signature]</i>
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. ±							
ANGULAR DIM. ±							

1	GSB-1	MARK II	5-7-57
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.
USED ON			