


REQ. PER UNIT	USED ON			A-1700	B
	MODEL	SECTION	DATE		
1	GPT-10K	AX-128	9-23-59		

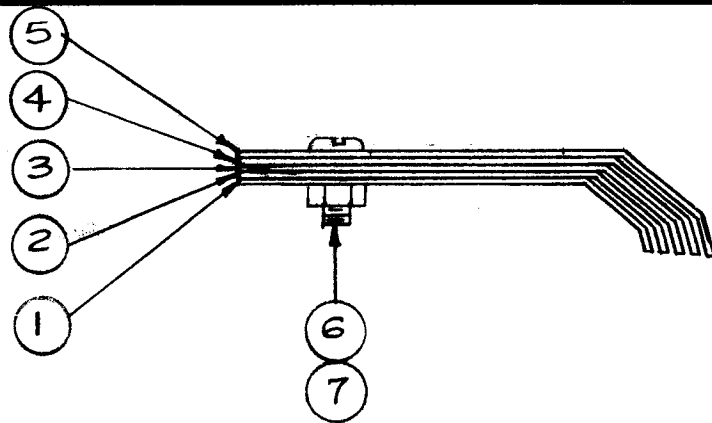
9 →  This Nut is Necessary for Spare Parts Use Only.

A1700 THIS DWG. CONSISTS OF TWO SETS OF ITEMS SHOWN.  
 A1700-2 THIS NUMBER CONSIST OF ONE SET OF ITEMS SHOWN.

PER SET {

1	9	SMI27D1032	Nut, Locking
1	8	NTH1032BN10	Nut, Hex.
1	7	SCBP1032BN4	Screw, Machine
1	6	MS 1602-1	Spring, Switch Contact
1	5	MS 1601-10	Contact, Switch
1	4	MS 1601-9	
1	3	MS 1601-8	
1	2	MS 1601-7	
1	1	MS 1601-6	Contact, Switch

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL		
B		ADD A1701-2	2-3-70	19728	KD	<i>FB</i>					THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK AX-128 ASS'Y. (CONTACT ASS'Y., LONG)			
A		-1 ADDED TO IT 6 IT 7 WAS SCBS----	10.24.66	17073	WVW	<i>WVW</i>								
TOLERANCES		SCALE:												
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES												
				TYPE & TEMPER		HEATTREAT. SPEC.		DRAWN		CHECKED		FINAL APPROVAL		
				FINISH & SPEC. NO.		ELEC. DES. APP		MECH. DES. APP		A-1700		B		



REQ. PER UNIT	USED ON			A-1701	E
	MODEL	SECTION	DATE		
1	GPT-10K	AX-129	9-23-59		

A1701 THIS DWG. CONSISTS OF TWO SETS OF ITEMS SHOWN  
 A1701-2 THIS NUMBER CONSIST OF ONE SET OF ITEMS SHOWN

ONE PER SET

	10		DELETED	
	9		DELETED	
	8		DELETED	
1	7	NTH1032BN10	Nut, Hex.	
1	6	SCBP1032BN4	Screw, Machine	
1	5	MS 1601-5	Contact, Switch	
1	4	MS 1601-4		
1	3	MS 1601-3		
1	2	MS 1601-2		
1	1	MS 1601-1	Contact, Switch	

E		ADD A1701-2	2-3-70	19728	KD	<i>HL</i>	<i>FBA</i>
D		IT 6 WAS SCBS-----	10-24-66	17073	<i>lftw</i>	<i>CS</i>	<i>CS</i>
C	1	IT.8 SM127D1032 DELE.	9-3-64	12230	<i>KB</i>	<i>@</i>	<i>CS</i>
B	2	ITEM(10) WAS MS-2154	5-3-63	8934	<i>E</i>	<i>JW</i>	<i>W</i>
	1	ITEM(8) WAS MS-2294					
A	2	ITEM 10 ADDED	9-19-69	2994	<i>CS</i>		<i>HL</i>
	1	ITEM 9 ADDED					
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES		SCALE:		NPL			
DEC. DIM. ±		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.					
FRAC. DIM. ±		REMOVE ALL BURRS AND SHARP EDGES					
ANGULAR DIM. ±							

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK AX-129 ASS'Y. (CONTACT ASS'Y., SHORT)				
STOCK SIZE				
MATERIAL				
TYPE & TEMPER		HEATTREAT.SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP	MECH. DES. APP	
			6 <sup>9</sup> / <sub>16</sub> 11/59	<i>file</i>
			<i>CS</i>	<i>AMB</i>
			A-1701	E

WINDING MACHINE DATA

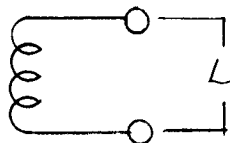
DRIVER GEAR - 69  
 CAM GEAR - 105  
 CAM - .250

WINDING PROCEDURE

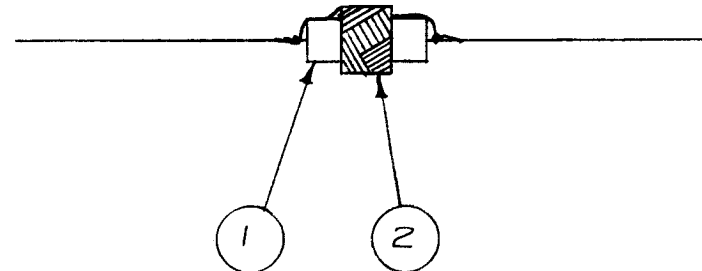
1. WIND 132 TURNS OF ITEM 2.
2. STAKE LEADS OF WINDING TO RESISTOR BODY WITH ITEM 3.
3. BAKE DRY AT 100°C.
4. SOLDER COIL LEADS TO RESISTOR LEADS AS SHOWN.
5. COAT WINDING WITH ITEM 4.
6. BAKE DRY AT 100°C.
7. TEST AS BELOW. (USE BOONTON Q-METER 160A OR EQUIV.)

TEST DATA

L = 100 MICRO-HENRIES NOM.  
 (90-110)  
 Q = 20 NOM. (15-25)  
 F = 2.5 M.C.



REQ. PER. UNIT	USED ON			A-1716	B
	MODEL	ASS'Y. NO.	DATE		
1	RTF-2	INTER/CON	6-1-59		



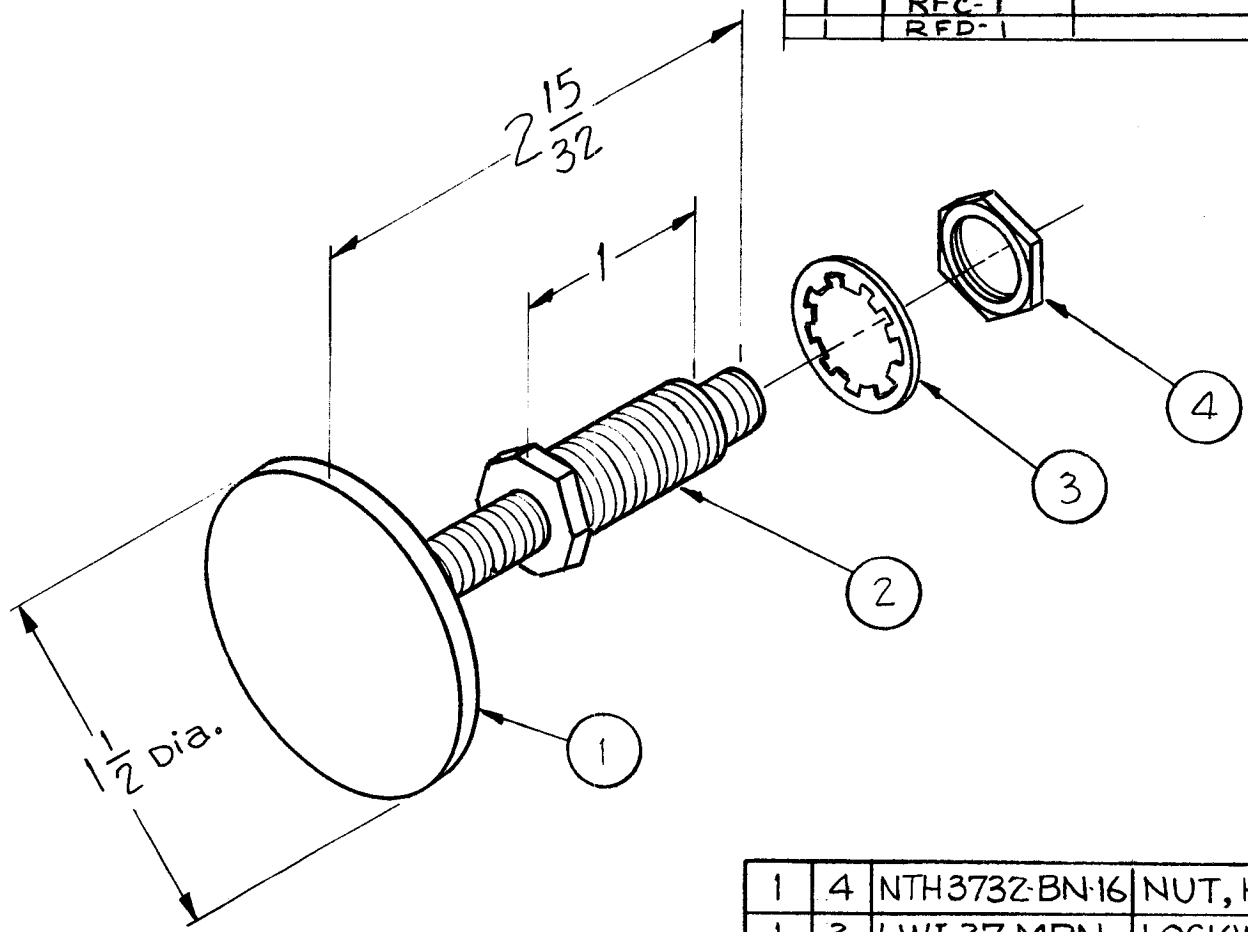
X	5	BS-100	Solder, Soft
X	4	GL-102	Q-Max
X	3	GL-103	Cement
X	2	WI-104-5415CQS	Wire, Litz
1	1	RC32GF104J	Resistor, Fixed

3		IT 1 TOL. WAS "K"	12-3-66	17298	RME	JCF	0003
A	1	CLERICAL CHANGE	3-22-65	-	DL	JCF	
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE: FULL				
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
STOCK SIZE			CL-172 ASS'Y.	
MATERIAL			(COIL, RF, FIXED, 100μhy) L403	
TYPE & TEMPER		HEATTREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP	MECH. DES. APP	
			16 <sup>6</sup> /1/59	ALB
			A-1716	B

REQ. PER. UNIT	USED ON		
	M DEL	ASSY. NO.	DATE
1	RFB-1		5-27-59
	RFC-1		11-22-60
	RFD-1		12-21-60

A-1717 | A

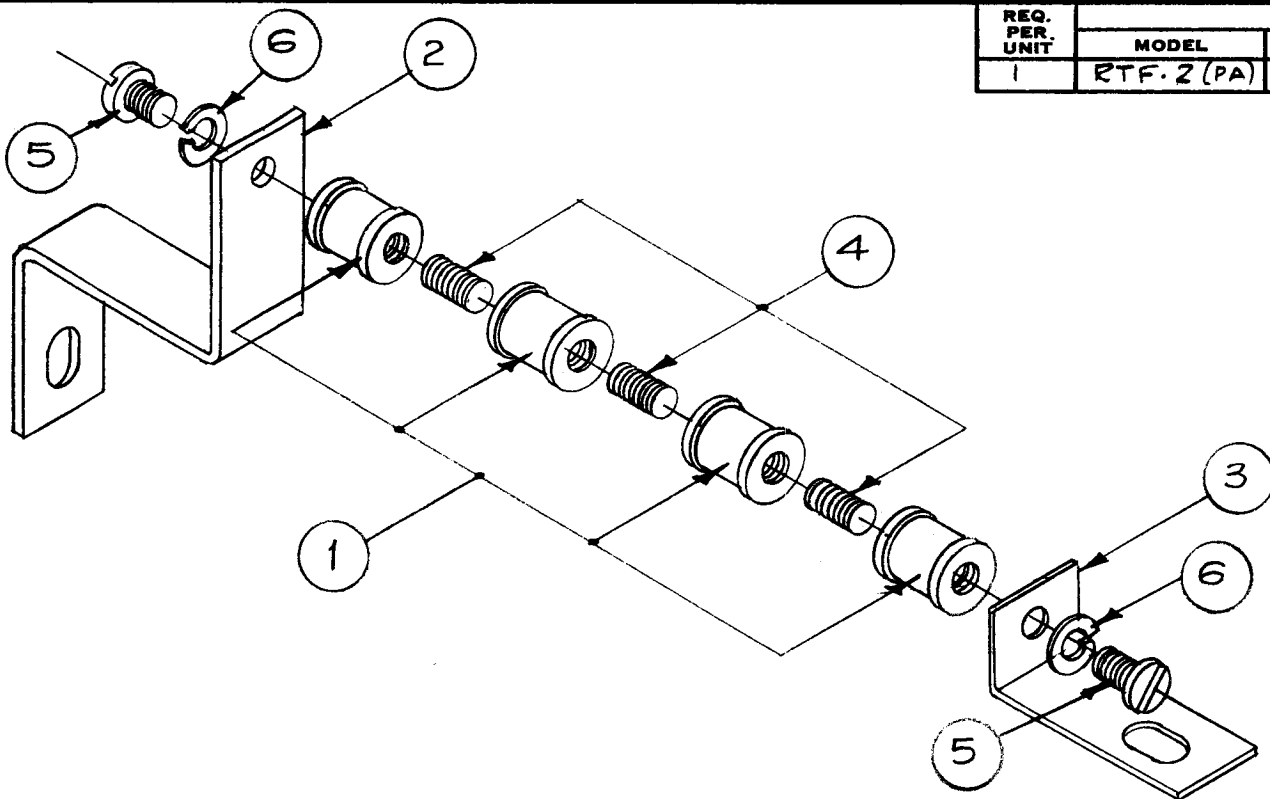


1	4	NTH3732-BN-16	NUT, HEXAGON (Double Chamfer)
1	3	LWI 37 MRN	LOCKWASHER, INTERNAL TOOTH
1	2	BB-114	BUSHING, NEUTRALIZING
1	1	A-1338	NEUTRALIZER, PLATE ASS'Y

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	1	NTH2520 BN14 (Items Deleted)	12-21-60	3780	RU	<i>JCB</i>	<i>QRB</i>
TOLERANCES			SCALE:				
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
AX-132 ASSEMBLY (NEUTRALIZING PLATE ASS'Y)				
MATERIAL		J.C. BIELE <i>JCB</i>		
TYPE & TEMPER		HEATTREAT. SPEC.		DRAWN <i>JCB</i>
FINISH & SPEC. NO.		ELEC. DES. APP.		MECH. DES. APP. <i>JCB</i>
				FINAL APPROVAL <i>JCB</i> A-1717   A

REQ. PER. UNIT	USED ON			A-1721	A
	MODEL	ASS'Y. NO.	DATE		
1	RTF. 2 (PA)		5-28-59		



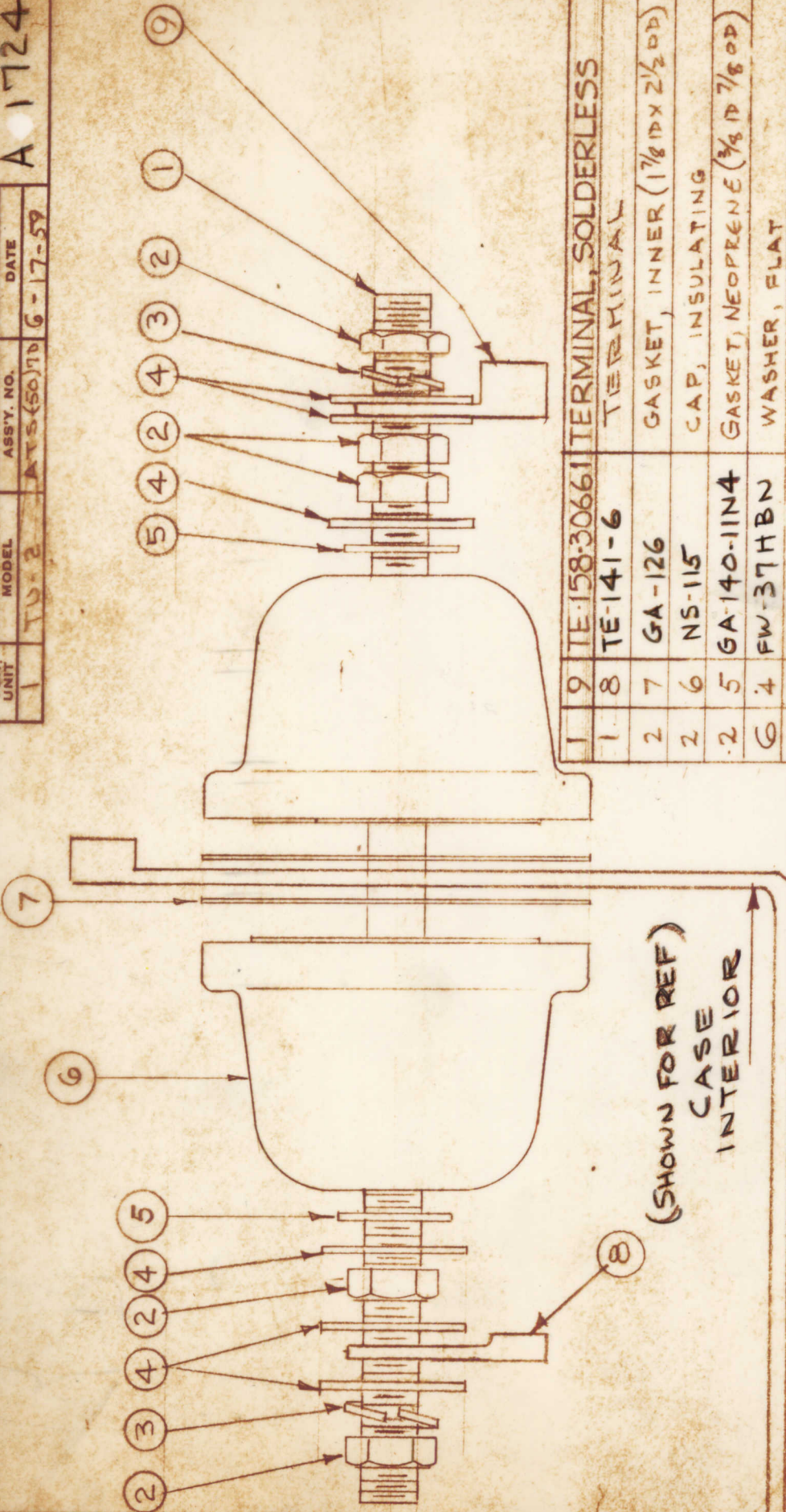
7	DELETED		
2	6	LWS02MRN	Lockwasher, Split
2	5	SCBS0256BN3	Screw, Machine
3	4	SM0256BN0.25	Rod, Threaded
1	3	MS-1471	Bracket, Bottom
1	2	MS-1399	Bracket, Top
4	1	CC-109-2	CAPACITOR, FIXED, 3 MMFD.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	1	IT.(7) WAS B5100 SOLDERING DETAIL DELETED	5-3-65	14011		<i>[Signature]</i>	<i>[Signature]</i>
TOLERANCES			SCALE:				
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL			AM-105 ASS'Y. (CAPACITOR ASS'Y., FIXED, C106)	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
		<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
FINISH & SPEC. NO.			ELEC. DES. APP	MECH. DES. APP
			A-1721	A



USED ON  
 REQ. PER. UNIT: 1  
 MODEL: TV-2  
 ASSY. NO.: AT5(50)7D  
 DATE: 6-17-59  
 A 1724 C



NOTE: SUPERSEDED, DIRECTLY  
 REPLACED BY AX196 REV A

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
1	9	TE-158-30661 TERMINAL, SOLDERLESS	WIP-4
1	8	TE-141-6 TERMINAL	WIP-4 SIZE 10
2	7	GA-126 GASKET, INNER (1 7/8 ID X 2 1/2 OD)	1/32 THK
2	6	NS-115 CAP, INSULATING	
2	5	GA-140-11N4 GASKET, NEOPRENE (3/8 ID 7/8 OD)	1/16 THK
6	4	FW-37HBN WASHER, FLAT	
2	3	LWS-37MRN LOCKWASHER, SPRING TYPE	
5	2	NTH3716BN20 NUT, HEX	
1	1	PM-57D ROD, FEED THRU	

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
C	REPLACED BY AX196 A	4-10-67	18030	L.A.K.	Jude	JB
B	ITEM 5 WAS ITEM 6 WA: 102-8 TE: 141-6	10/2/59	1374	16	AMP	AMP
A	Item 9 added	8-27-59		J.C.B.	Jude	AMP

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

THE TECHNICAL MATERIEL CORP.  
 MAMARONECK, NEW YORK  
 AX-196 ASS'Y.  
 (ANTENNA FEEDTHRU)

APPROVED: *Alb*  
 DATE: 6-17-59  
 DRAWN: *Alb*  
 CHECKED: *Alb*  
 FINAL APPROVAL: *Alb*

FINISH & SPEC. NO.:  
 ELEC. DES. APP. MECH. DES. APP.

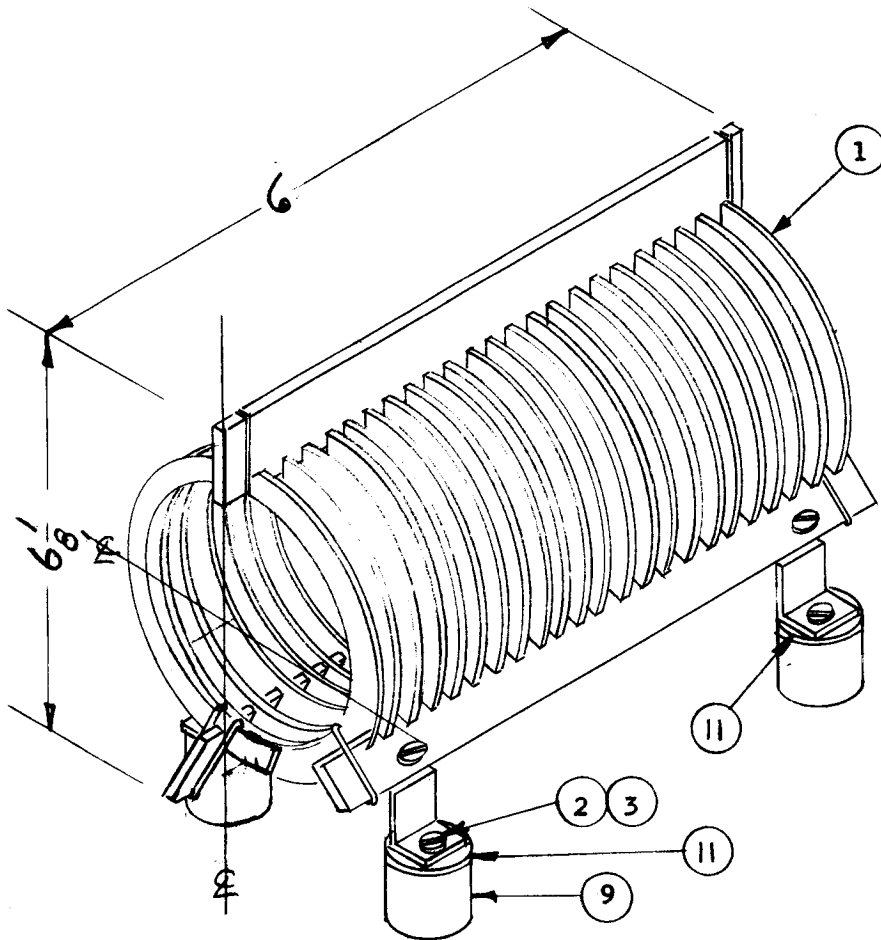
A 1724 C



REQ. PER UNIT	USED ON:			A-1731	H
	MODEL	ASSY. NO.	DATE		
1	TU-2 (L202)	ATS-2			

ELECTRICAL SPECS

Inductance - 20  $\mu$ h  
 Current - 5 amps.

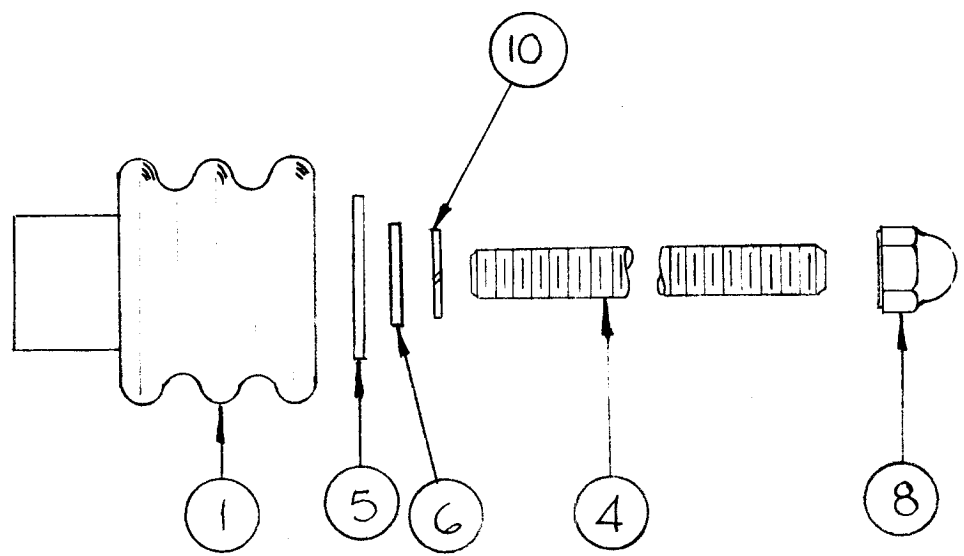
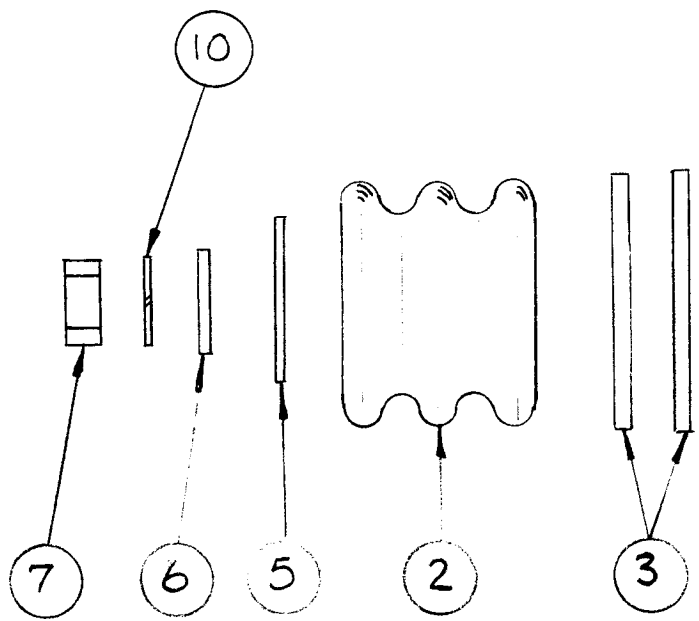


4	11	WA-109-46	WASHER, FIBER	
X	10	BS-100-1	Solder, Soft	
4	9	NS3W0206	Insulator, Pillar, Round	
	8			
	7			
	6			
	5			
	4			
4	3	LWEO8MRN	Lockwasher, Ext.	
4	2	SCBP0832BN5	Screw, Machine	
1	1	CL-118-20	Coil, Fixed, 20 $\mu$ h	

REQ.	ITEM	PART NO.	DESCRIPTION	SYMB L
<b>THE TECHNICAL MATERIEL CORP.</b>				
MAMARONECK, NEW YORK				
<b>AC-109-46 ASSY.</b>				
MATERIAL				
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
			<i>Peter Allis</i>	
FINISH & SPEC. NO.		ELEC. DES. APP	MECH. DES. APP	

H	ITEM 8, PERTAINING NOTES & DIM. DELE.	9.30.66	16953	WTD	<i>CP</i>	<i>LB</i>	
G	ADDED IT. 11	6/3/66	16320	C.H.	<i>CP</i>	<i>LB</i>	
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE:				
DEC. DIM. $\pm$			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. $\pm$							
ANGULAR DIM. $\pm$							

REQ. PER. UNIT	USED ON			A-1734	D
	MODEL	ASS'Y. NO.	DATE		
1	GPT-10K	AX138			



2	10	LWS25MRN	LOCKWASHER, SPLIT
X	9	LUI05	SILICONE COMPOUND
1	8	NTC2520BNR	NUT, CAP
1	7	NTH2520BN12	NUT, HEX.
2	6	FW25H BN	WASHER, FLAT
2	5	WA-109-55	WASHER, FIBER
1	4	SM2520BN3.625	ROD, THREADED, 3 <sup>5</sup> / <sub>8</sub> Lg.
2	3	GA-140-12-S6	GASKET, SILICONE
1	2	NS-128-1	BUSHING, INSULATED, FEMALE
1	1	NS-127-1	BUSHING, INSULATED, MALE

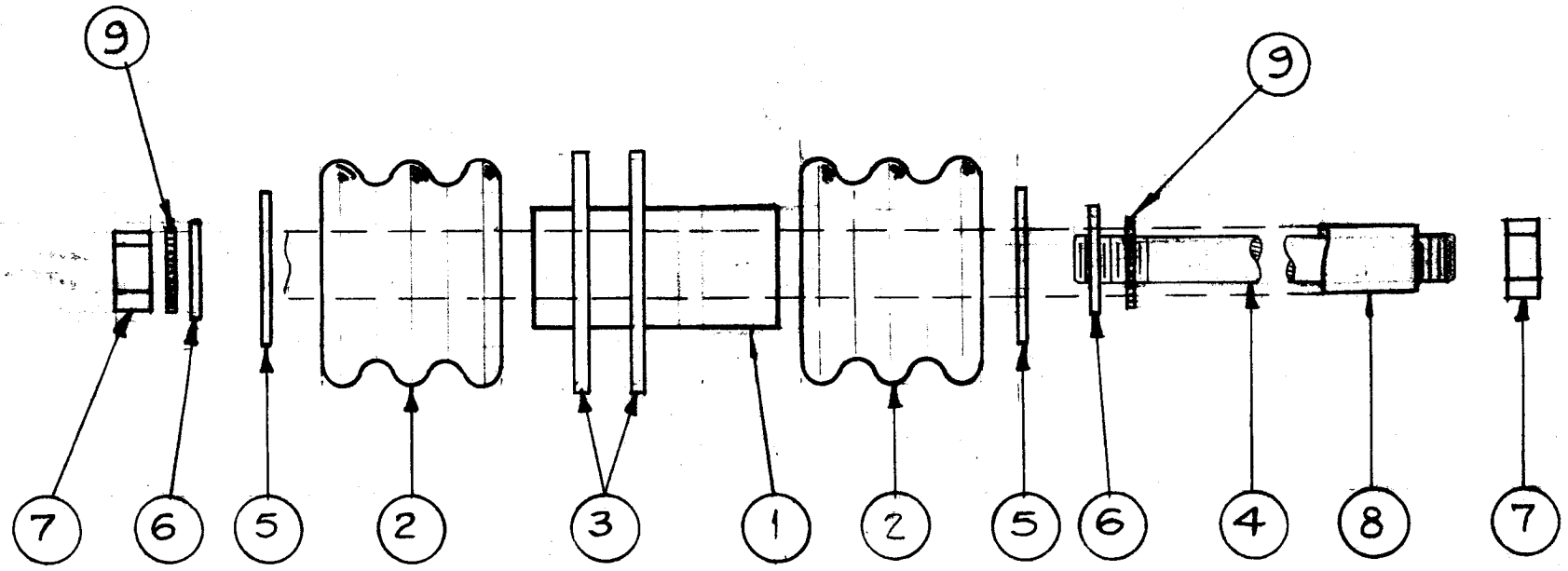
D		ITEM 10 ADDED: ITEM 4 WAS SM2520BN3.5	6-23-66	16373	N.C.	<i>Q/S</i>	<i>Q/S</i>
C		ITEM 9 & NOTE DELETED	4-19-66	16099	G.D.L.	<i>Q/S</i>	<i>Q/S</i>
B	1	ITEM '6' WAS FW25MBN	8-22-60	2852	Ru	<i>JCB</i>	<i>JCB</i>
A	2	Item 9 added	11-3-59	1504	DM	<i>JCB</i>	<i>JCB</i>
A	1	Item 3 was GA-117					

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.				
FRAC. DIM. ±			REMOVE ALL BURRS AND SHARP EDGES				
ANGULAR DIM. ±							

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
AX-150 ASS'Y. (FEEDTHRU, SHORTING RELAY)				
MATERIAL				
STOCK SIZE				
TYPE & TEMPER				
HEAT TREAT. SPEC.				
FINISH & SPEC. NO.				
		D. MANCUSO 8-31-59		
		JCB		
		AMB		
		F.G.		
		A-1734		D



REQ. PER. UNIT	USED ON			A-1736	E
	MODEL	ASS'Y. NO.	DATE		
	AX-152				



2	9	LW510MRN	LOCKWASHER, EXT.	
2 1/4"	8	PX-370-4-7	TUBING, TEFLON 3' LONG	
2	7	NTH1032BN12	NUT, HEX.	
2	6	FW10H8N	WASHER, FLAT	
2	5	WA-109-56	WASHER, FIBER	
1	4	SM-156FT-BN	STUD, THREADED	
2	3	GA-117	GASKET	
2	2	NS-128-1	BUSHING, INSULATED, FEMALE	
1	1	PX-562-2	BUSHING, TEFLON	
REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP.	
			MAMARONECK, NEW YORK	
			AX-152 ASS'Y.	
			(FEEDTHRU, INSULATED)	
			MATERIAL	
			16 7/28/59	<i>[Signature]</i>
			TYPE & TEMPER	HEAT TREAT. SPEC.
			DRAWN	CHECKED
			6.6.	<i>[Signature]</i>
			FINISH & SPEC. NO.	ELEC. DES. APP. MECH. DES. APP.
				A-1736 E

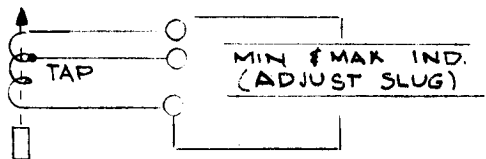
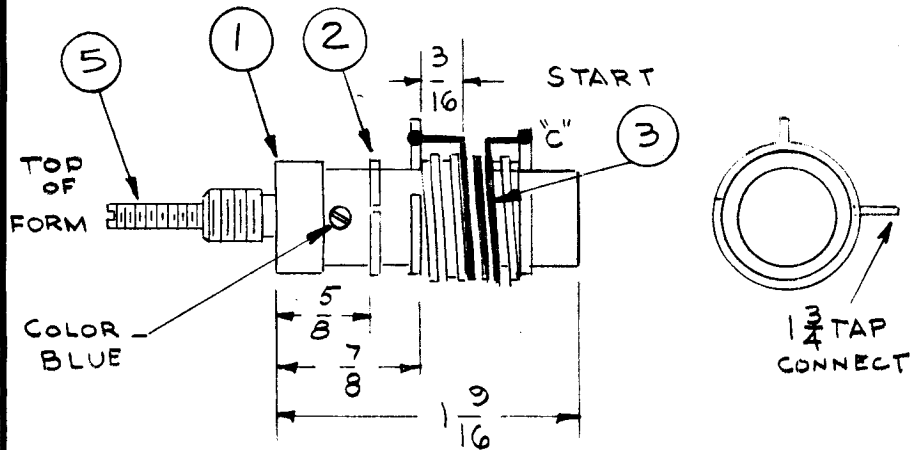
E	IT 9 WAS LW510MRN	N.I.66	17121	WHD	<i>[Signature]</i>	<i>[Signature]</i>	
D	IT 6 WAS FW10H8N	9-27-66	16904	WHD	<i>[Signature]</i>	<i>[Signature]</i>	
C	ITEM 4 WAS SM1032BN3.5	9-21-62	7238	S.S.	<i>[Signature]</i>	<i>[Signature]</i>	
B	4 Item 5 Was WA-109-53	6-20-61	5087	M.H.F.	<i>[Signature]</i>	46	
	3 Item 6 Was FW25MBN						
	2 Item 8 Was PX-370-5-8 (3' Long)						
A	1 Item 9 Added	8/10/60	<i>[Signature]</i>	Cy	<i>[Signature]</i>	<i>[Signature]</i>	
	4 Item 7 Was NTH2520BN12						
	3 Item 1 Was NS127-1						
	2 ITEM 4 WAS SM7520BN12						
	1 ITEM 8 ADDED						
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES		SCALE:					
DEC. DIM. ±		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.					
FRAC. DIM. ±		REMOVE ALL BURRS AND SHARP EDGES					
ANGULAR DIM. ±							

Minimum Inductance must be less than . uhy.  
 Maximum Inductance must be more than . uhy.  
 Q at 25 Mc must be more than 120  
 Test Frequency 25 Mc.  
 Operating Fr quency - 22-32 Mc.

REQ. PER UNIT	USED ON			A - 1740	A
	MODEL	ASSY. NO.	DATE		
	CL-182		8-7-59		

PROCEDURE

- Slip two terminal rings (item 2) on form (item 1) as shown. (Marked "A" and "B").
- Force fit outer form (item 3) onto inner form (item 1) and cement with Insulex (item 6).
- Slip terminal ring marked "C" on inner form.
- Cement all rings to inner form.
- Wind 3 turns of wire (item 4) on outer form. Bring out tap at  $1\frac{7}{8}$  turns from top. Slip sleeving (item 7) over tap. Solder all wire ends to proper terminals.
- Paint Winding with Insulex.
- Bake for 1/2 hour at 250° F.
- Insert Core (item 5).
- Test as shown below. Use Boonton Q - Meter Model 160A or Equivalent.



X	8	BS-100	Solder, Soft	
1/2"	7	PX-100-1-.053	Insulation, Sleeving (Size 16)	Blk
X	6	GL-104-2	Insulex, U85	
1	5	CI-109-19	Core, Tuning, Red	
X	4	WL-100-5	Wire, Buss (Size 18)	
1	3	CF-125-3PO.50	Coil, Form, Grooved	
3	2	TE-153-3	Terminal, Ring Type	
1	1	CF-119-1.562	Coil Form, w/bushing	

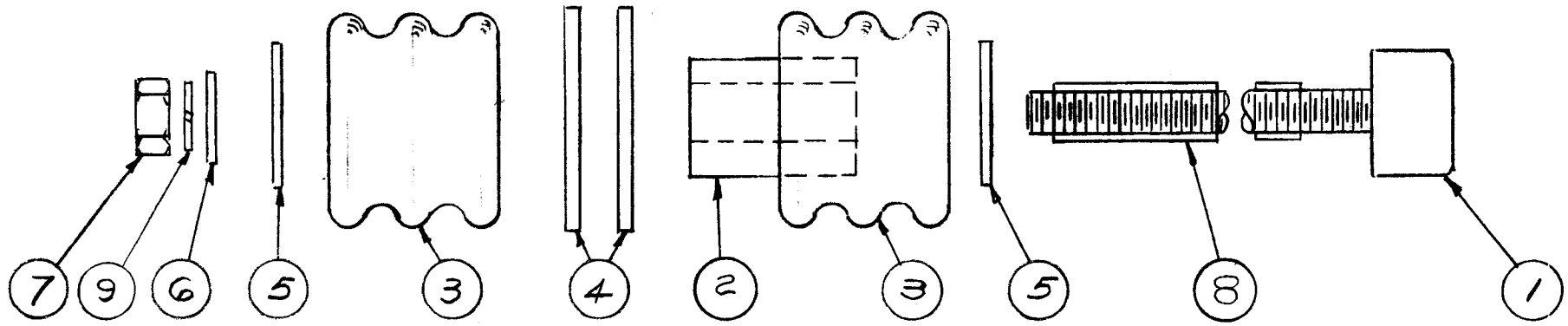
A	1	1 7/8 TAP WAS 2"	2-18-60	1854	W.F.			
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	
TOLERANCES			SCALE:					
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES					

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
STOCK SIZE				
CL-182 ASSEMBLY (COIL, RF, TUNED, 22-32 MC)				
MATERIAL				
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	
			8-7-59	AMB
				A-1740 A

REQ. PER UNIT	USED ON		
	MODEL	SECTION	DATE
1	GPT-10K	AX-103	9-23-59

A-1744

C



1	9	LWEIOMRN	LOCKWASHER, SPLIT
3	8	PX-370-4-7	SLEEVING TEFLON, 208 ID
1	7	NTH1032BN12	NUT, HEX
1	6	FW104BN	FLAT WASHER
2	5	WA-109-55	WASHER, FIBER
2	4	GA-140-12S6	GASKET, NEOPRENE
2	3	NS-128-1	BUSHING, INSULATED, FEMALE
1	2	PX-562-2	BUSHING, INSULATED, MALE
1	1	PM-525	CONTACT, BUTTON

C	1	Item 9 Added, Item 6 Was FW104BN	-15-62	6204	RF	RF	
B	6	ITEM 2 WAS NS-127-1	8-15-60	2785	RUL	RF	RF
	5	ITEM 3, 2 REQ WAS 1 RBQ					
	4	ITEM 4 WAS GA140-12S6					
	3	ITEM 6 WAS FW25MRN					
	2	ITEM 7 WAS NTH2520BN12					
A	1	ITEM 4 WAS GA-117	1-20-60	1789	RF	RF	RF
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE:				
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL			AX-172 ASS'Y FEED-THRU INSULATED CONTACT H.V.E.	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	A-1744

REQ. PER UNIT	USED ON		
	MODEL	ASS'Y. NO.	DATE
1	GPT-10K		12-15-59
1	GPT-40K	AX209	10-12-60

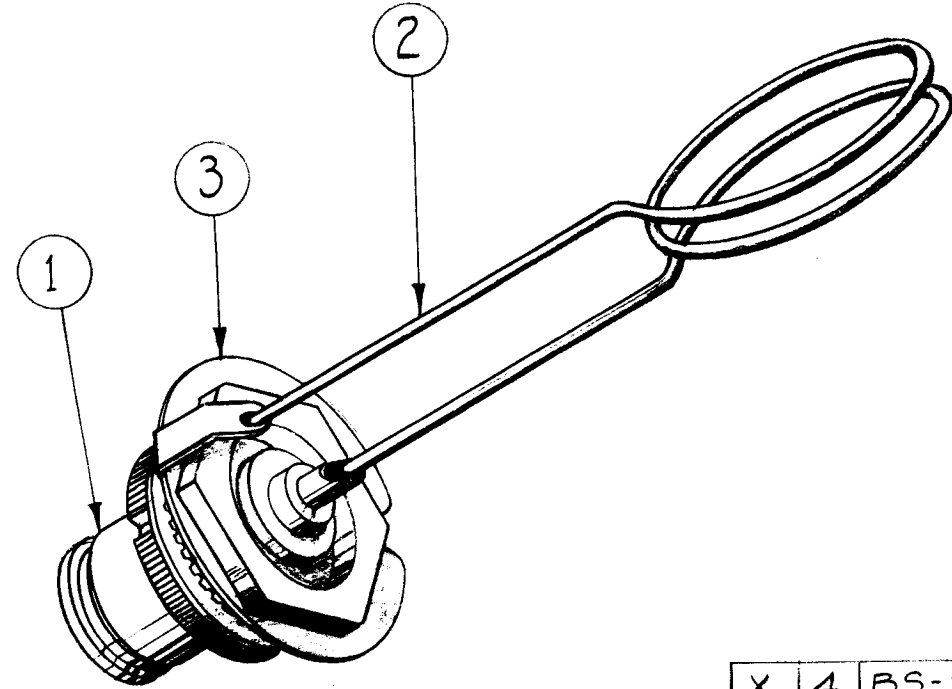
A-1746

NOTICE TO PERSONS RECEIVING THIS DRAWING

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Property of:

THE TECHNICAL MATERIEL CORPORATION  
MAMARONECK, NEW YORK



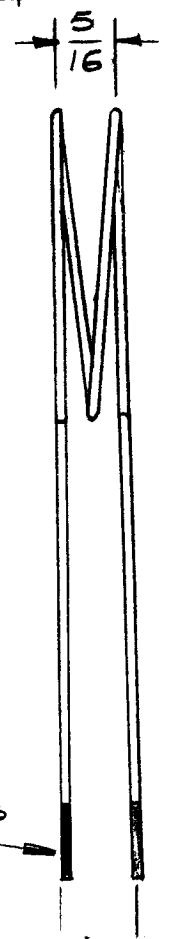
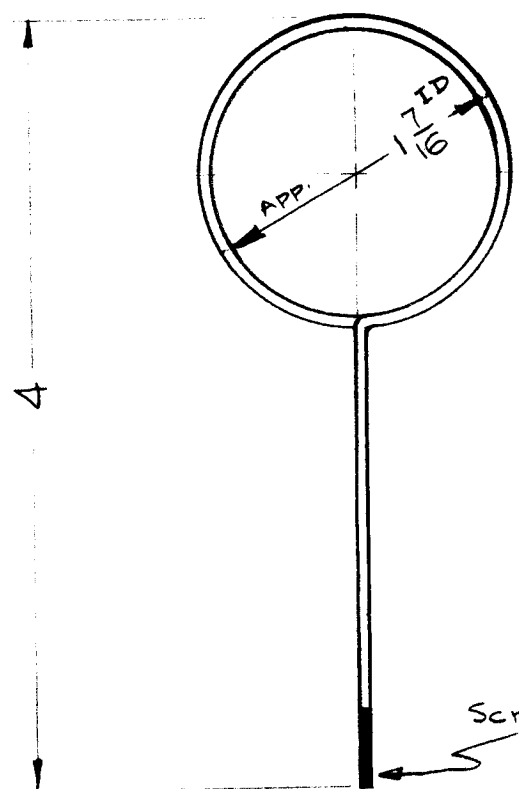
X	4	BS-100	Solder, Soft
1	3	TE-177	Lug, Horseshoe
1	2	CL-183	Coil, RF Probe
1	1	JJ-164	Connector

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.				
FRAC. DIM. ±			REMOVE ALL BURRS AND SHARP EDGES				
ANGULAR DIM. ±							

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP.	
			MAMARONECK, NEW YORK	
			AJ-100 ASS'Y.	
			(RF CONNECTOR PROBE)	
			16 <sup>12/15/59</sup>	
			<i>[Signature]</i>	<i>[Signature]</i>
			DRAWN	CHECKED
			FINAL APPROVAL	
			A-1746	
			ELEC. DES. APP	MECH. DES. APP

REQ. PER UNIT	USED ON		
	MODEL	ASS'Y. NO.	DATE
1	10K-B	AX-187	12-15-59
1	10K	AJ-100	

A-1747 A



Wind Coil on 1 3/16 OD Form.  
2 Turns

Scrape and tin ends  
3/8"

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MAMARONECK, NEW YORK

X	2	BS100	SOLDER, TIN ALLOY	
X	1	WI-127-12	Wire, Magnet	
REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL			CL-183 ASS'Y. (COIL, RF PROBE)	
TYPE & TEMPER		HEATTREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	

A	ITEM 2 ADDED	9.27.61	16904	WHD			
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES		SCALE:					
DEC. DIM. ±		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.					
FRAC. DIM. ±		REMOVE ALL BURRS AND SHARP EDGES					
ANGULAR DIM. ±							



FOR SPARE PARTS USE

REQ. PER UNIT	USED ON			A-1750	A
	MODEL	ASS'Y. NO.	DATE		
	GPT-10K				

This Kit, AX-176, consists of  
 3 ea. Kit # PO-183  
 3 ea. Line Contacts  
 3 ea Load Contacts  
 3 ea Moveable Contact Ass'y's.

Note-Pack in Bag (item 2) for Shipment.

									1	2	BG101	Bag		
									3	1	PO-183	Contact Kit (Single)		
									REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL	
									THE TECHNICAL MATERIEL CORP.					
									MAMARONECK, NEW YORK					
									AX-176 ASS'Y.					
									(RL-130 CONTACT KIT (TRIPLE))					
A		BG101 ADDED TO IT 2	3-16-67	17980	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>							
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.							
TOLERANCES			SCALE:											
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES											
									TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL	
													A-1750	
									FINISH & SPEC. NO.	ELEC. DES. APP.	MECH. DES. APP.		A	

# WINDING MACHINE DATA

.125 CAM, 49 CAM GEAR, 95 DRIVER GEAR

## PROCEDURE

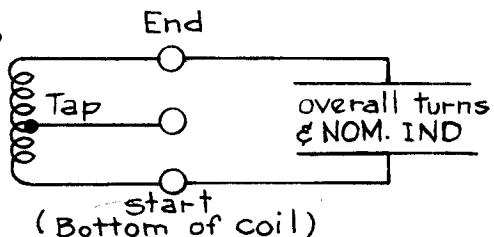
- 1-SECURE TERMINALS (ITEMS 2 & 3) TO COIL FORM (ITEM 1) WITH INSULEX (ITEM 7).
- 2-WIND 42 TURNS OF WIRE (ITEM 4) ON COIL FORM, TAP AT 16 FROM START.
- 3-STAKE COIL ENDS TO COIL FORM WITH Q MAX. (ITEM 6).
- 4-SOLDER COIL LEADS TO TERMINALS.
- 5-PAINT COIL WITH INSULEX (ITEM 7).
- 6-BAKE COIL FOR 1/2 HOUR AT 210°F.
- 7-TEST ON BOONTON Q-METER, MODEL 160A OR EQUIV.

## TEST DATA

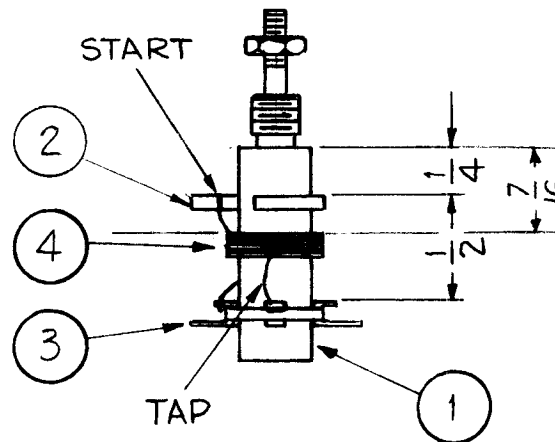
NOM. IND. --, W/O CORE - 25.5 uhy (23.5 - 27.5)

TEST F = 2.5 mcs

Q = 60 or GREATER



REQ. PER UNIT	USED ON			A-1754	A
	MODEL	ASSY. NO.	DATE		
2	TTG		8-27-59		

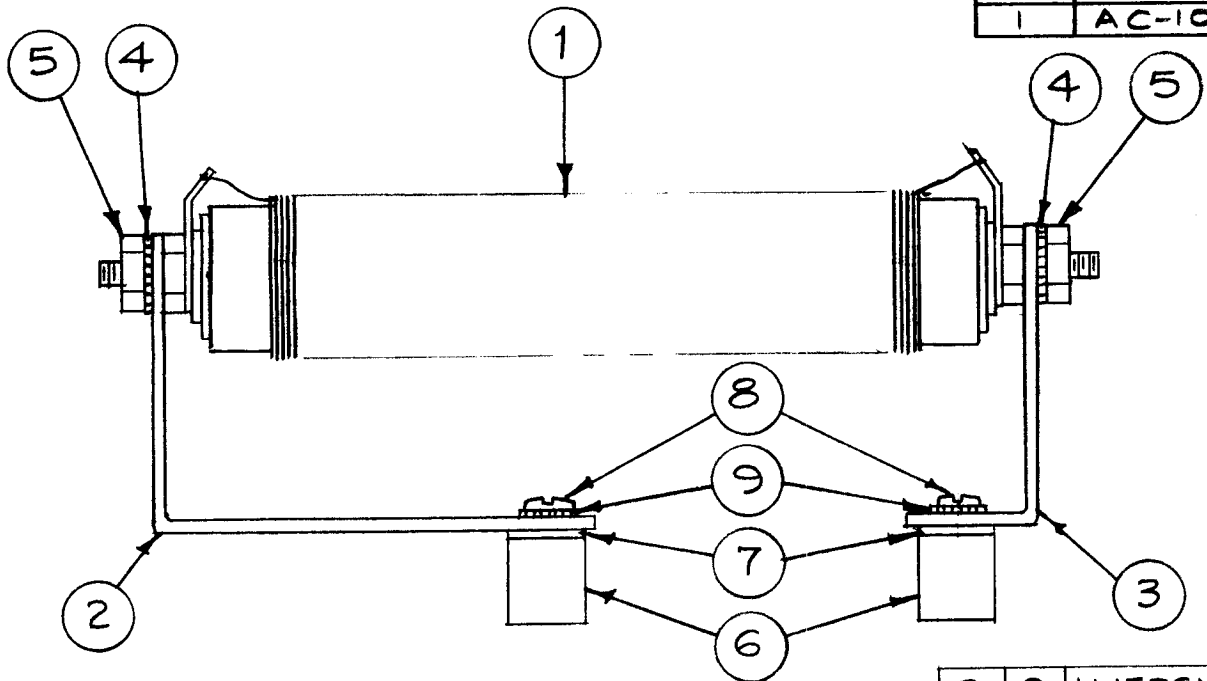


X	7	GL-104-2	INSULEX, U-85
X	6	GL-102	LACQUER, Q MAX.
X	5	BS-100	SOLDER, SOFT
X	4	WI104-541-DSQS	WIRE, LITZ
1	3	TE-170-3	TERMINAL, COLLAR
1	2	TE-153-2	TERMINAL, RING TYPE
1	1	CF-107-2N	COIL, FORM W/CORE

A	2	ON TEST DATA Q WAS 60	7-7-61	5192	GDL	JCB		
	1	DIMENSION 7/16 ADDED						
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	
TOLERANCES			SCALE: Do Not Scale					
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES.					

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK, NEW YORK CL-184 ASSEMBLY (COIL, R.F. TUNED, 2-4.3MC)				
STOCK SIZE				
MATERIAL				
		J.C. Biele	JCB	AMP
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
			RWB	RWB
FINISH & SPEC. NO.		ELEC. DES. APP	MECH. DES. APP	
			A-1754	A

REQ. PER. UNIT	USED ON			A-1764
	MODEL	ASS'Y. NO.	DATE	
1	AC-105			



2	9	LWE06MRN	Lockwasher, Ext.	
2	8	SCBS0632BN5	Screw, Machine	
2	7	WA-109-36	Washer, Fiber	
2	6	NS3W01-8	Insulator	
2	5	NTH1032BN12	Nut, Hex	
2	4	LWE10MRN	Lockwasher, Ext.	
1	3	MS-1861	Bracket, Top	
1	2	MS-1862	Bracket, Bottom	
1	1	CL-179	Coil, Fixed, RF, 38 mhy	NPL

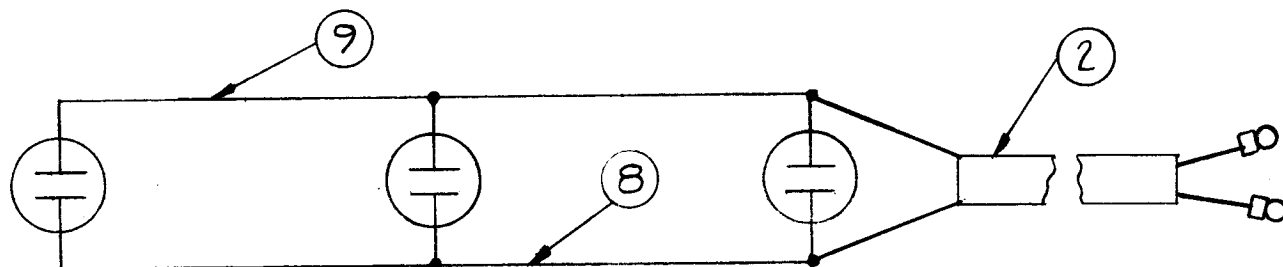
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE: Full - Do Not Scale				
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
			AC-105 Ass'y. (Coil, RF, Fixed, 38 mhy)	
			MATERIAL	
		16 1/4 / SA	FILE	AMB
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
			FILE	FILE
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	A-1764

REQ. PER. UNIT	USED ON		
	MODEL	SECTION	DATE
1	RAK-9	AX-197	9-18-59

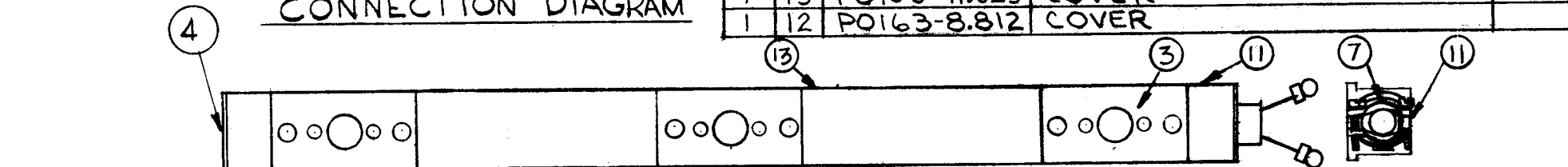
A1772

E



CONNECTION DIAGRAM

1	13	PO163-17.625	COVER
1	12	PO163-8.812	COVER



2	11	PO-163-2.937	COVER	
1	10	CU-113	CLAMP	
	9	MWC 14(19)U0	CABLE, INSULATED	BLACK
	8	MWC 14(19)U9	CABLE, INSULATED	WHITE
1	7	PO-162	END FITTING, CABLE ENTRY	
6	6	SCBP0540BN3	BINDER HEAD SCREW	
6	5	TE-112-2	LUG, TERMINAL	
1	4	PO-161	END FITTING, BLANK	
3	3	JJ-170	RECEPTACLE TWIST LOCK AC.	0612,613 614
1	2	CA-588-1	CABLE, RUBBER SHIELDED	BLACK
1	1	MS-1891	AC STRIP	

ITEM (6) REPLACES DISCARDED SCREW

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
AX-197 ASS'Y				
AC. POWER STRIP				
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.		MECH. DES. APP.

E		DRAWING UPDATED	1-9-67	17643	RME	<i>[Signature]</i>	
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.				
FRAC. DIM. ±			REMOVE ALL BURRS AND SHARP EDGES				
ANGULAR DIM. ±							

REQ. PER UNIT	USED ON			A-1774
	MODEL	ASSY. NO.	DATE	
2	RAK-9	AR-112	3-8-60	

**PROCEDURE:**

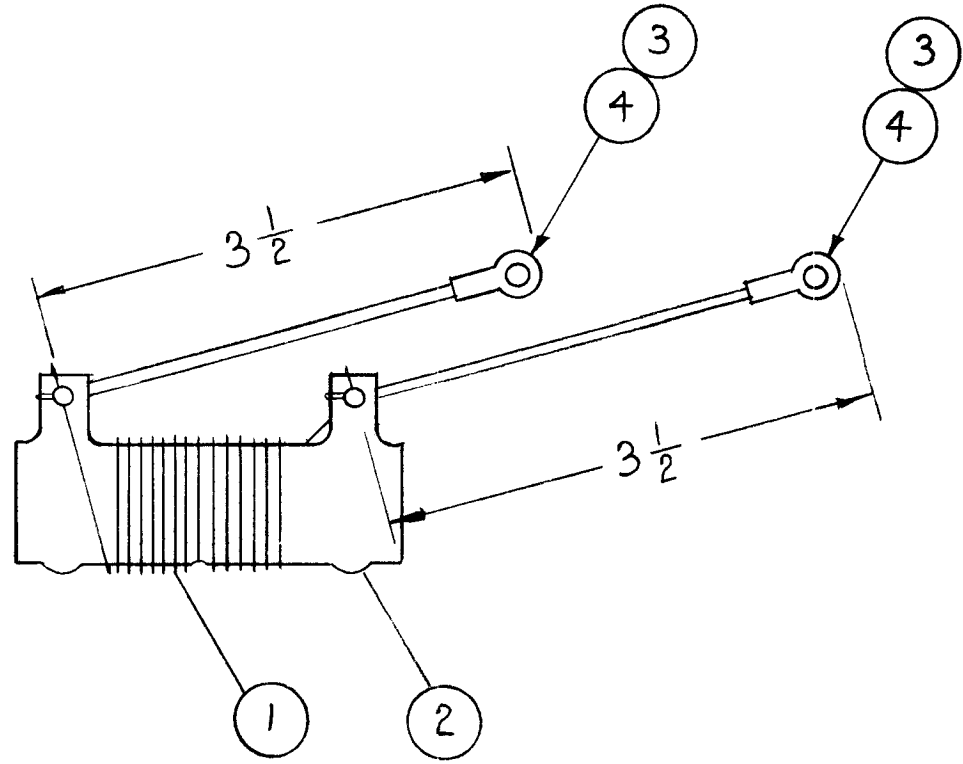
1. Wind 36 turns of wire (Item 1) on resistor (Item 2), close wound.
2. Attach solder lugs (Item 4) to, two 3-1/2" pieces of Item 3 and solder wires to resistor as shown.
3. Coat winding and entire resistor w/U-85.
4. Bake for 30 minutes at 270° F.

**Note:**

Test one unit of 100

R-min. .05 Ω

R-max. .09 Ω



X	5	BS-100	SOLDER, SOFT	
2	4	TE-155-34170	TERMINAL, SOLDERLESS	
X	3	MWC 12 (19) UO	CABLE, INSULATED	BLACK
1	2	RW-109-28	RESISTOR, WIREWOUND	
X	1	WI-108-7	WIRE, CEROC (HI TEMP)	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
								<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK, NEW YORK				
								<b>ARI12 ASSEMBLY</b> RESISTOR, SHUNT				
								MATERIAL				
								TYPE & TEMPER    HEAT TREAT. SPEC.    DRAWN    CHECKED    FINAL APPROVAL				
								FINISH & SPEC. NO.    ELEC. DES. APP.    MECH. DES. APP.				
TOLERANCES			SCALE:					A 1774				
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. ±												



**PROCEDURE:**

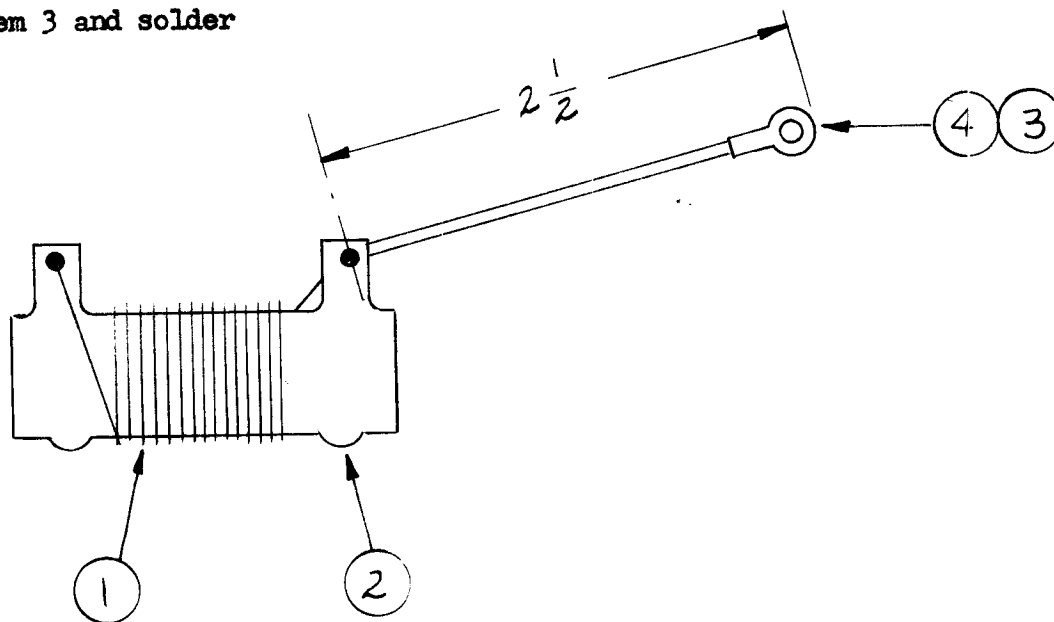
1. Wind 12 turns of wire (item 1) on resistor (item 2), close wound.
2. Attach solder lag. (item 4) to, 2-1/2 pieces of item 3 and solder wire to resistor as shown.
3. Coat winding and entire resistor w/U-85.
4. Bake for 30 minutes at 270° F.

**NOTE:**

Test one unit of 100 mfd

R-min.

R-max.



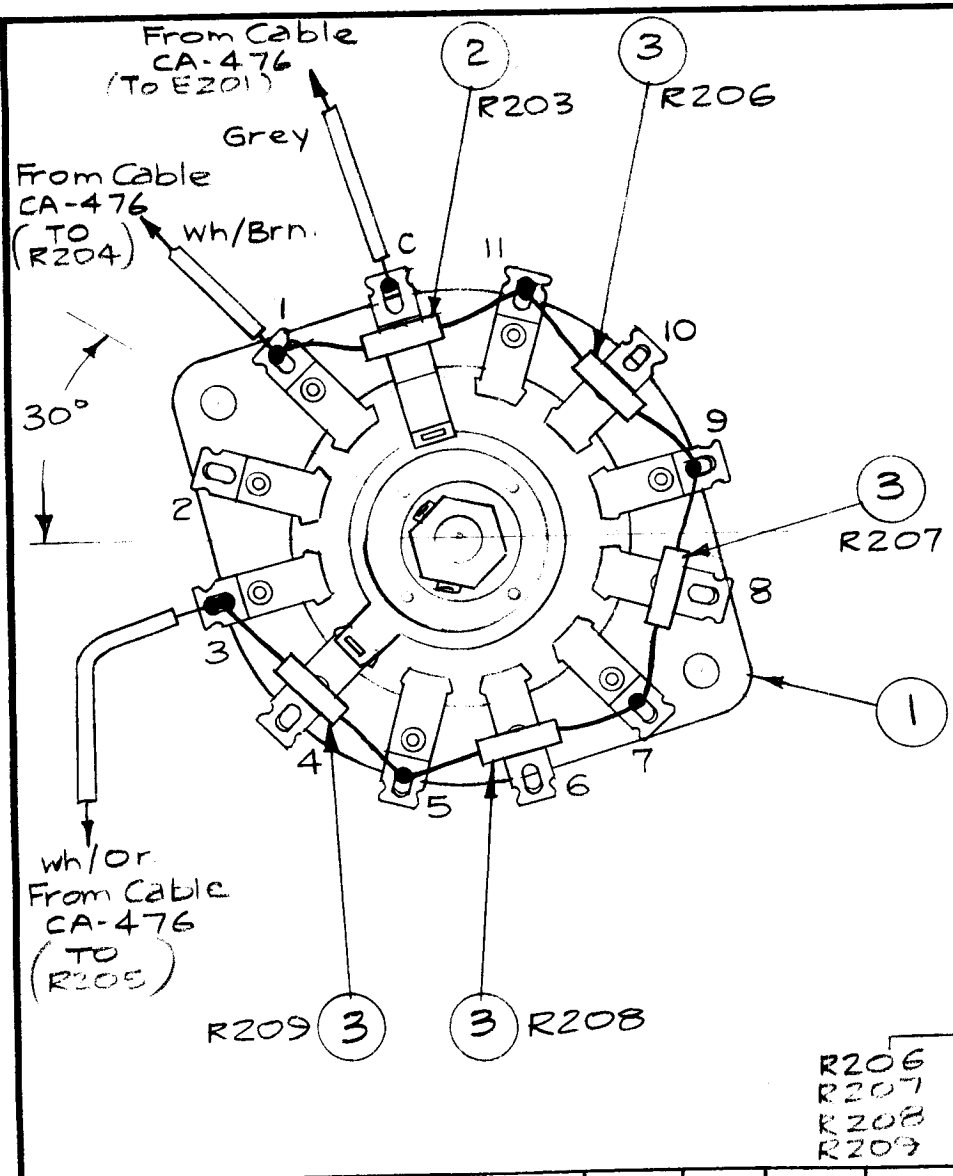
REQ. PER. UNIT	USED ON			A-1775
	MODEL	ASS'Y. NO.	DATE	
	AR-113		10-5-59	

X	5	BS-100	SOLDER, SOFT	
	1	4	TE-159-34161	TERMINAL, SOLDER
X	3	MWC 14(19)J0	CABLE, INSULATED	BLACK
	1	2	RW-109-34	RESISTOR, WIREWOUND
X	1	WI-108-2	WIRE, CEROC (HI TEMP)	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP.	
			MAMARONECK, NEW YORK	
			AR-113 ASSEMBLY	
			RESISTOR - SHUNT	
			10-5-59	
TYPE & TEMPER		HEATTREAT. SPEC.	DRAWN	CHECKED
				FINAL APPROVAL
				A-1775
FINISH & SPEC. NO.		ELC/DES. APP	MECH. DES. APP	

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



REQ. PER. UNIT	USED ON			A-1777	A
	MODEL	ASS'Y. NO.	DATE		
1	TU-2		10-1-59		

ASSY. SHOWN AT 30° ANGLE AS IT MOUNTS INTO UNIT. SOLDER ALL CONNECTIONS EXCEPT CABLE CONNECTIONS, WHICH WILL BE SOLDERED UPON ASSY. OF WAFER INTO UNIT.

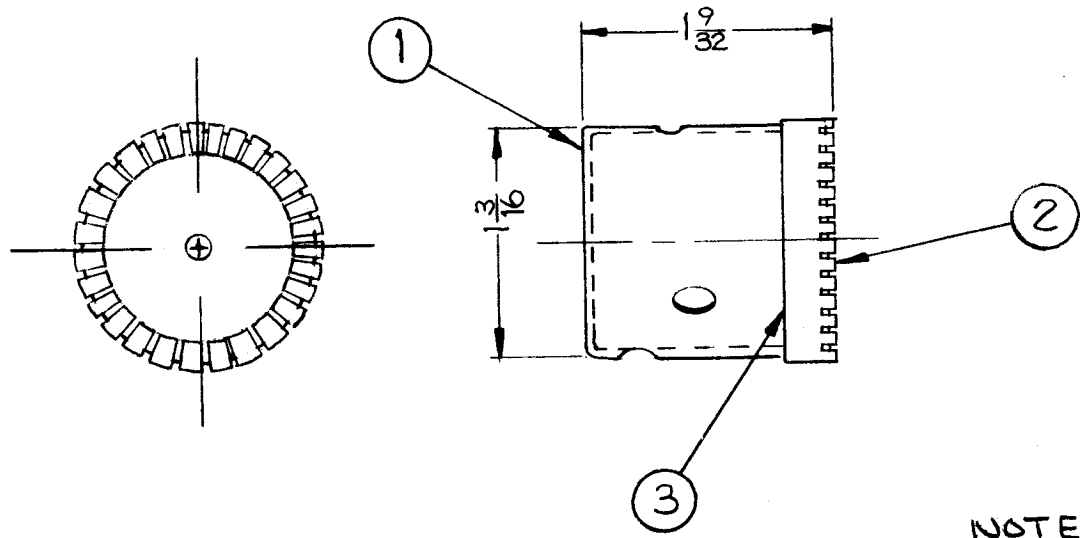
USE SLEEVING ON RESISTOR LEADS IF DANGER OF SHORTING EXISTS

X	5	BS-100	Solder, Soft	
X	4	PX-100-1-034	Insulation, Sleevling	BIK.
4	3	RC20GF332J	Resistor, Fixed, Comp.	
1	2	RC20GF302J	Resistor, Fixed, Comp.	R203
1	1	AS-114	WAFER & ROTOR	524A

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
	A	ITS. 263 LAST LETTER IN P/N CHG. FROM K TO J	8-2-72	20786	GE	EP	EP
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. ±							

REQ.	ITEM	PART NO.	DESCRIPTION		SYMBOL
			THE TECHNICAL MATERIEL CORP.		
			MAMARONECK, NEW YORK		
			WAFER & RESISTOR		
			ASS'Y.		
			16 19/59		
TYPE & TEMPER		HEATTREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
			GG		
FINISH & SPEC. NO.		ELEC. DES. APP.		MECH. DES. APP.	
					A-1777 A

REQ. PER. UNIT	USED ON			A-1795	C
	MODEL	ASS'Y. NO.	DATE		
2	CU-2	A-1503	11-2-59		



NOTE:  
 S-245 SILVER PLATE  
 S-423 CLEAR IRIDITE

X	3	BS-100	SOLDER, SOFT	
1	2	FP-174-1A	CONTACT RING	
1	1	BX-187	CAN, ROUND	
REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP.	
			MAMARONECK, NEW YORK	
			CAN, ASSEMBLY	
			MATERIAL	
			DJ. MANCUSO	
			DRAWN	CHECKED
			FINAL APPROVAL	
			SEE NOTE	
			ELEC. DES. APP.	MECH. DES. APP.
			A-1795	C

C	2	IT. 2 WAS FP-174-1	6/29/65	14364	D.V.V.	JCB	MM
B	1	FINISH S423 ADDED	2-19-63	8275	BB	FW	STB
A	1	FP-174-1 WAS FP-174	5/29/61	A958	DD	JCB	STB
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.				
FRAC. DIM. ±			REMOVE ALL BURRS AND SHARP EDGES				
ANGULAR DIM. ±							