

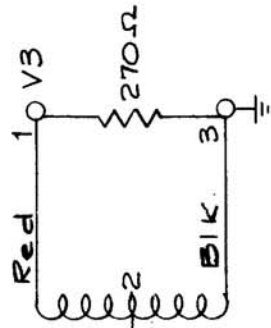
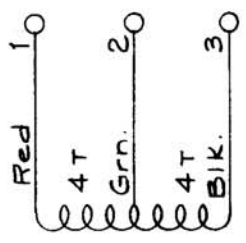
REQ. PER UNIT		USED ON	
1	MODEL	SYMBOL NO.	DATE
1	A-1396	T123	9-19-57
1	A-1516	T123	3-27-57

A 1812

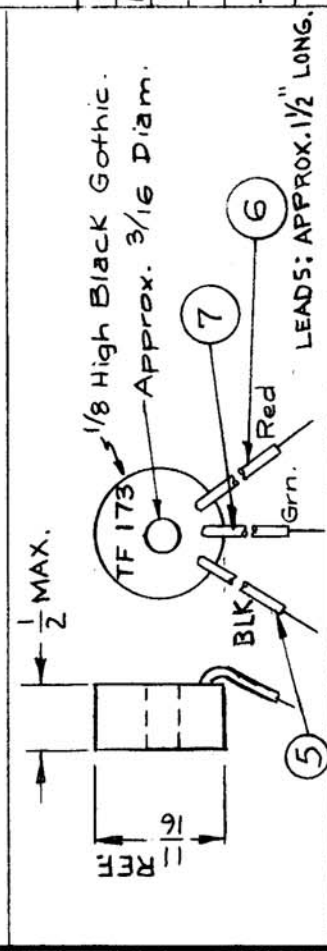
B

**PROCEDURE**

1. Wind as shown. (Four turns CW, then tap, then four turns CW) Close Wound.
2. Keep leads 1-5/8" long. Strip 5/8".
3. Bake for 1/2 hour at 210° F.
4. Paint Winding with GL 104-2 (Item 3)
5. Bake for 1 hour at 210° F.
6. Test as shown at left.
7. Place Sleeving on leads. Push Sleeving up to Core body.
8. Submerge Coil in Compound (item 4). Sleeving must protrude from Compound as shown in lower left detail.
9. Test as shown.
10. Stamp Unit as shown.



SIG. GEN. FREQ	V1	V2	V3
2 MC	1.0 V	.387 V -.473 V	.738 V -.902 V
8 MC	1.0 V	.414 V -.506 V	.792 V -.968 V
32 MC	1.0 V	.450 V -.550 V	.792 V -.968 V



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
1 1/8"	PX 104-4-.022	Insulation, Sleeving	# 24 Grn.
1 1/8"	PX 104-3-.022	Insulation, Sleeving	# 24 Red
1 1/8"	PX 104-1-.022	Insulation, Sleeving	# 24 Blk
X 4	GL 106	Compound, Plastic	
X 3	GL 104-2	Insulox, UBS	
X 2	WI 107-11	Wire, Magnet	# 30 DS
1	CI 115	Core, Toroidal	

THE TECHNICAL MATERIEL CORP.  
MAMARONECK, NEW YORK

TF-173 ASSEMBLY

RE-DRAWN: *[Signature]* 6/31/58  
CHECKED: *[Signature]*  
ELEC. DES. APP. MECH. DES. APP. *[Signature]*

FINAL APPROVAL: *[Signature]*

A 1812 B

SCALE: \_\_\_\_\_

TOLERANCES: \_\_\_\_\_

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

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B 2	PICT: SIDE VIEW & LEAD NOTE ADDED; FREQ. CHART: V2 & V3 COLS. REVISED; REDRAWN, SLEEVING (ITEMS 5, 6, 7) ADDED.	2-8-65	13453	24	<i>[Signature]</i>	<i>[Signature]</i>
A 1		3/31/58	1	16	<i>[Signature]</i>	<i>[Signature]</i>