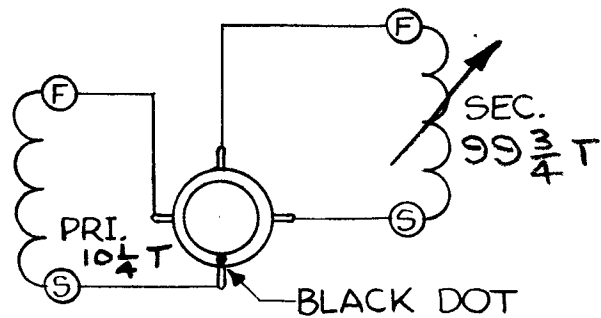
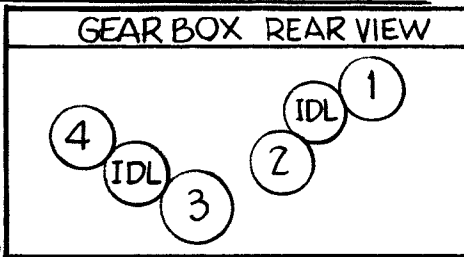


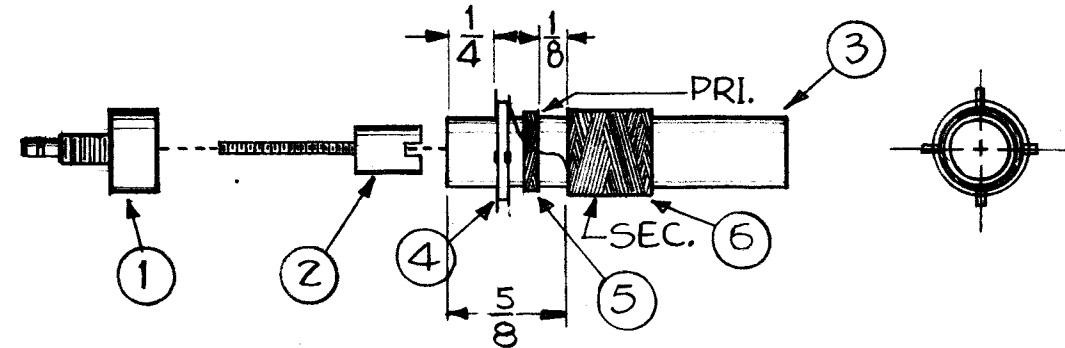
WINDING MACHINE DATA

- 1.- 67
- 2.- 63
- 3.- 100
- 4.- 37
- CAM: 175



WIRING DIAGRAM TOP VIEW

S-START F-FINISH



WINDING DATA

1. SECONDARY:

STARTING 5/8 FROM EDGE OF COIL, WIND 99-3/4 TURNS OF ITEM 6, SPOT w/ITEM 7.

- 2. WIND 10-1/4 TURNS OF ITEM 5, 1/8" FROM SECONDARY, SPOT w/ITEM 7.
- 3. ASSEMBLE TERMINAL RING 1/16" FROM STARTING EDGE OF PRIMARY, SPOT w/ITEM 7.
- 4. CONNECT LEADS AS PER WIRING DIAGRAM.
- 5. CHECK AS PER TEST DATA
- 6. ASSEMBLE ITEMS 1 & 2 AS SHOWN.
- 7. BAKE COIL FOR 15 MIN. AT 200° F.
- 8. DIP COIL ASSY INTO ITEM 8 UNTIL ALL BUBBLES DISAPPEAR.

NOTE ~ REMOVE EXCESS WAX FROM TERMINAL RING.

TEST DATA W/O CORE

WINDING	Lwh	Q	F
PRI.	1.4 TO 1.76	GREATER THAN 49	7.9 MC
SEC.	69. TO 74	GREATER THAN 85	2.5 MC

- 10. STAMP TMC PARTNUMBER TT-103 IN ANY CONVENIENT SPOT.

9			
X	8	GL-110	IMPREGNATING WAX
X	7	GL-111	CEMENT 'INSA-LUTE'
X	6	WI-104341-DSQS	WIRE, LITZ
X	5	WI-107-17	MAGNET WIRE, DOUBLE SILK COVERED
1	4	TE-170-4	TERMINAL, COLLAR
1	3	CF-117-1-25	COIL FORM, 1-1/4
1	2	CI-109-16	CORE, TUNING
1	1	SM-110	COIL MOUNTING BUSHING

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
F	1	ON PICTORIAL & WINDING DATA, DIM 5/8 WAS 9/16	7-17-63	9636			
E	1	ITEM (2) WAS CI-109-11	2-12-63	8226			
D	1	Req. Added To Items 1, 2, 3, 4	2-1-62	6282			
C	1	TEST DATA CHART REVISED Q PRIM. WAS 49 TO 51 Q SEC. WAS 85 TO 90	7-3-61	5167		RU	
B	1	Test Data Chart Revised Lwh Prim Was 1.4 Sec. 7.5 Q Prim Was 45 Sec. 85 F Prim Was 2.5 Sec. 7.90	6-23-61	5114			
A	1	on Pictorial & Winding Data 9/16 was 7/16	1-30-61	4026		RU	

TOLERANCES		SCALE:	
DEC. DIM. ±		1	GPR-92
FRAC. DIM. ±		1	GPR-92-RXD
ANGULAR DIM. ±			

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
1	GPR-92		T104	10-16-62
1	GPR-92-RXD		L29	5-10-60

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
MATERIAL			
TT-103 ASSEMBLY			
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
			CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

A-1884 F