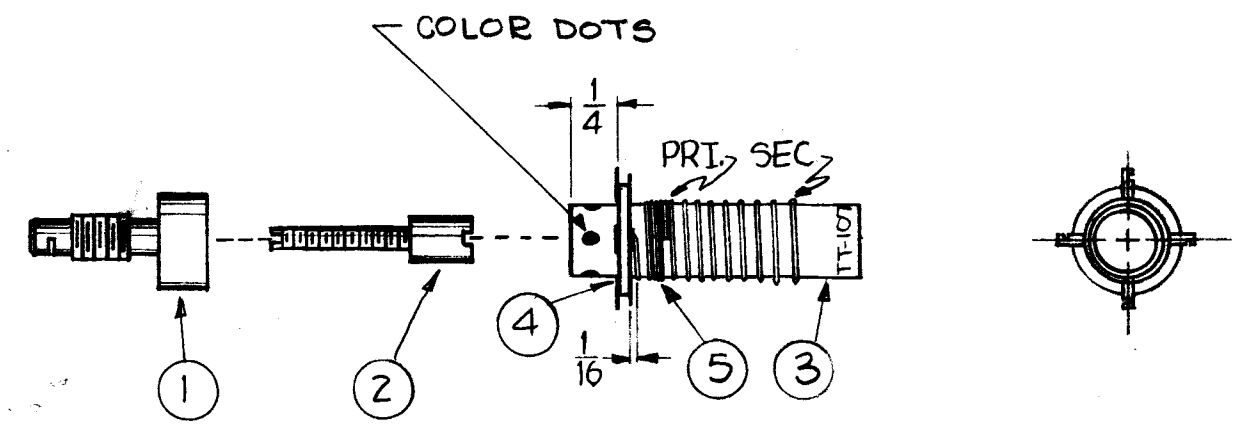
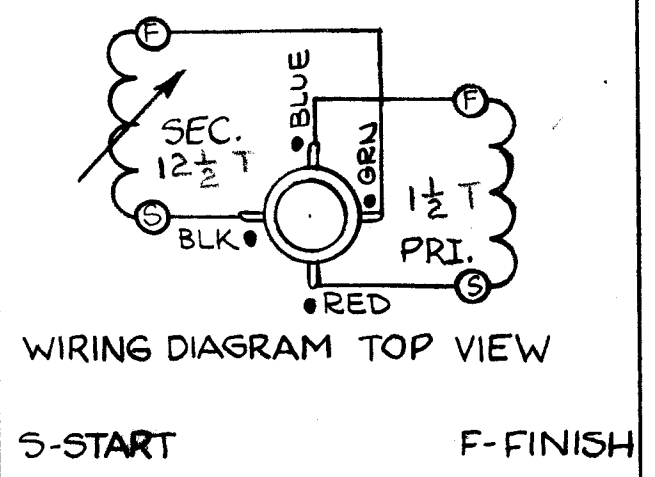
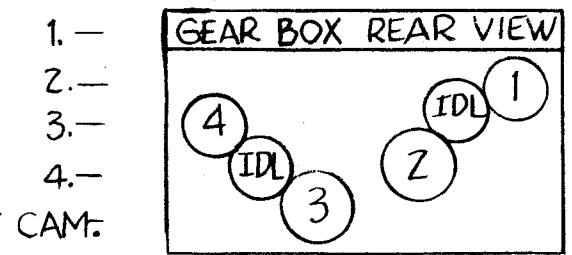


A-1888 D

COIL FORM ASS'Y

1. CEMENT TERMINAL RING TO COIL FORM AS SHOWN.

WINDING MACHINE DATA



WINDING DATA.

1. SECONDARY:  
STARTING 1/16 FROM ITEM 4, SPACE WIND (SPACED #18 BARE WIRE) 12-1/2 TURNS OF ITEM 5, SPOT WITH ITEM 6.
2. PRIMARY:  
INTERWIND 1-1/2 TURNS OF ITEM 5, BETWEEN SECONDARY, SPOT w/ITEM 6.
3. CONNECT LEADS AS PER WIRING DIAGRAM.
4. CHECK AS PER TEST DATA.
5. ASSEMBLE ITEMS 1 & 2 AS SHOWN.
6. BAKE COIL ASSEMBLY FOR 15 MIN AT 200°F.
7. DIP COIL ASSY INTO ITEM 7 UNTILL ALL BUBBLES DISAPPEAR. NOTE - REMOVE EXCESS WAX FROM TERMINAL RING.

TEST DATA w/o CORE

WINDING	L <sub>wh</sub>	Q	F	R <sub>x</sub> * APPROX
PRI.	.1 ± 5%	>55	25	0
SEC.	.75 ± 5%	7160	25	0

\* SIMPSON # 260

9. STAMP TMC PARTNUMBER TT-107 IN ANY CONVENIENT SPOT.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 7	GL-110	IMPREGNATING WAX	
X 6	GL-111	CEMENT "INSA-LUTE"	
X 5	WI-107-5	MAGNET WIRE - DOUBLE SILK COVER	
1 4	TE-170-4	TERMINAL COLLAR	
1 3	CF-117-1.5	COIL FORM, 1-1/2	
1 2	CI-109-15	CORE TUNING	
1 1	SM-110	COIL MOUNTING BUSHING	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
D		PRI WAS 15 ± 5% 750, 25, 0 SEC WAS 8 ± 5% 755, 25, 0	6-8-64	11502	A.M.	@	<i>[Signature]</i>
C	1	COLOR CODE ADDED TO WIRING DIAGRAM	7-17-63	9618		<i>[Signature]</i>	<i>[Signature]</i>
B	1	WIND DATA *8 Q PRI. WAS 100, SEC WAS 155.	6-26-62	6839	RT.	<i>[Signature]</i>	<i>[Signature]</i>
A	1	1 Req. Added To Items 1, 2, 3, 4	2-1-62	6282		<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. ±			

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	GPR-92		T108	10-16-62
1	GPR-90-RXD			5-12-60

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.

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