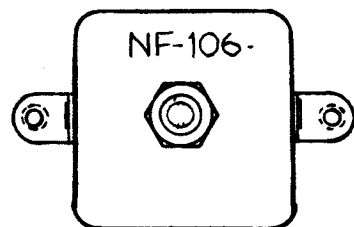
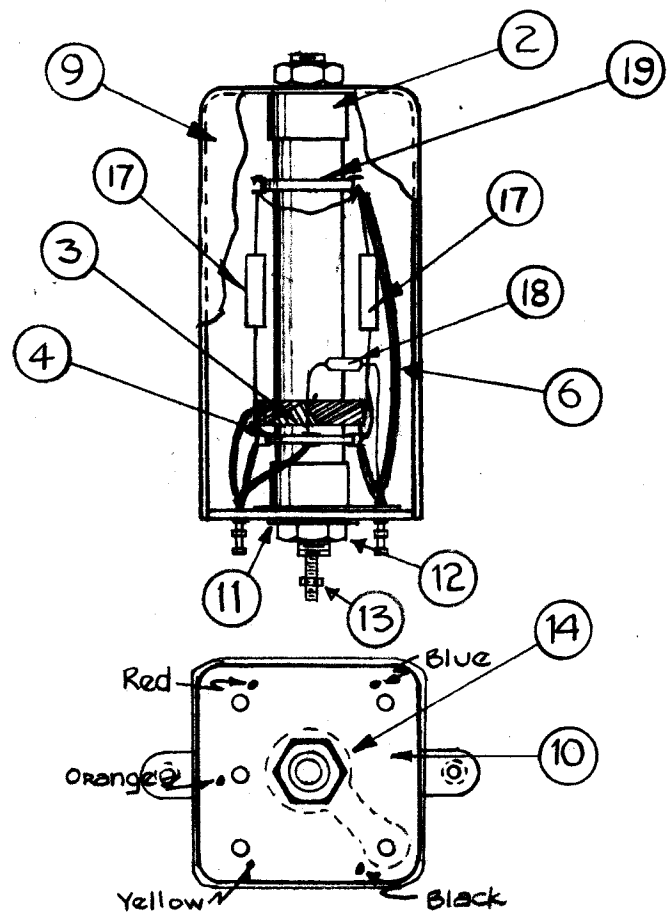


A-1895

STAMP CAN AS SHOWN 1/8 HIGH BLACK GOTHIC. NOTE - STAMP TMC INSIGNIA & APPROVAL ON SIDE OF CAN.



CEMENT COIL FORM BUSHING WITH ITEM 7.

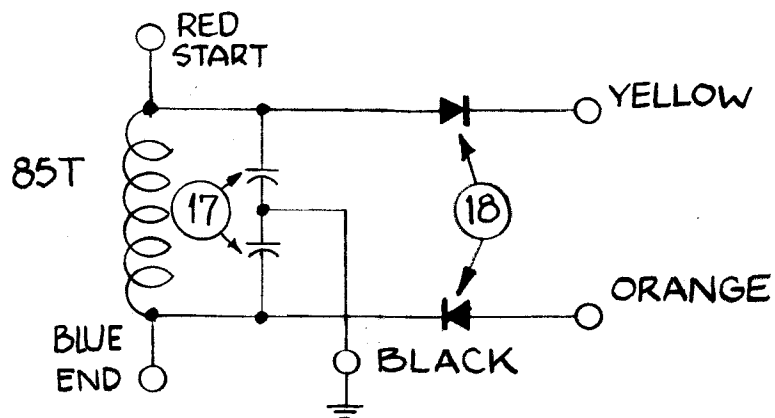
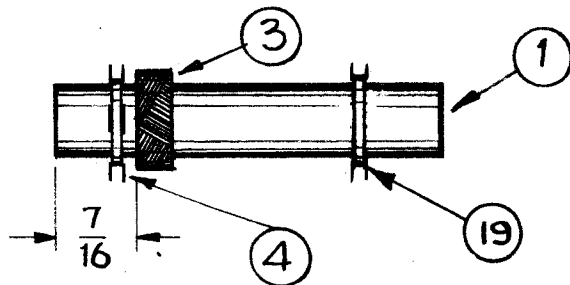


WINDING MACHINE DATA

CAM GEAR-----104
 DRIVER GEAR----68
 CAM-----187

WINDING DATA

1. START WINDING 7/16 FROM END OF FORM.
2. END WINDING AT 85 TURNS.
3. KEEP ALL LEADS APPROXIMATELY 3" LONG.
4. STAKE LEADS TO COIL FORM W/GL-103.
5. ASSEMBLE RING TERMINALS (ITEM 4) ON FORM AS SHOWN AND STAKE W/GL-104-2 (ITEM 8). POSITION RINGS AS SHOWN.
6. FASTEN ENDS OF WI-104-541 (ITEM 3) TO RING TERMINALS.
7. BAKE UNIT FOR 1/2 HOUR AT 215°F.
8. COAT WINDINGS AND RING TERMINALS W/GL-104-2.
9. BAKE HARD FOR 1/2 HOUR AT 215°F.
10. TEST AS SHOWN BELOW.
11. ASSEMBLE AS SHOWN.



COLOR CODE FOR TERMINAL BOARD SHOWN

TEST DATA (W/OUT CORE)

± 10
 L = 85 MICROHENRIES
 Q = 50 or Greater
 FREQ = 2.5 MCS

USE BOONTON RADIO CORP. Q METER MODEL 160A OR EQUIVALENT.

1	19	TE-170-2	TERMINAL, MOUNTING
2	18	IN67	DIODE
2	17	CM15F471J03	CAPACITOR, FIXED
X	16	BS-100	SOLDER, SOFT
1	15	CI-109-7	CORE, TUNING
1	14	TE-104-5	TERMINAL, LOCKING
1	13	NTH0632BN8	NUT, HEX
2	12	NT102	NUT, HEX
2	11	LWI25MRN	LOCKWASHER
1	10	PX-403	TERMINAL BOARD 5 LUG
1	9	A-1513	CAN ASSEMBLY
X	8	GL-104-2	INSULEX U85
X	7	GL-103	CEMENT, DUCO
X	6	PX-104-6-022	INSULATION SLEEVING
X	5	WL-100-8	WIRE, BUSS-BAR #24
1	4	TE-170-4	TERMINAL, MINIATURE
X	3	WI-104-541-DSQ3	WIRE, MAGNET, 5/41 LITZ
2	2	SM-145	BUSHING COIL MOUNTING
1	1	CF-117-2.0	COIL FORM 3/8 O.D.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
NF-106 ASS'Y COUPLING NETWORK			
MATERIAL			
STOCK SIZE			
FINISH & SPEC. NO.			
TYPE & TEMPER		HEAT TREAT. SPEC.	FINAL APPROVAL
DRAWN		CHECKED	
ELEC. DES. APP.		MECH. DES. APP.	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
G		B/U UPDATED (47)	2.1.67	17767	440		
F	1	IT. 12 WAS NTH2528BN14	9/12/66	16837	RME		
TOLERANCES			SCALE:				
DEC. DIM. \pm			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.				
FRAC. DIM. \pm			REMOVE ALL BURRS AND SHARP EDGES				
ANGULAR DIM. \pm							

1	CSS-1	PROJECT NO.	ASS'Y. NO.	DATE
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
USED ON				