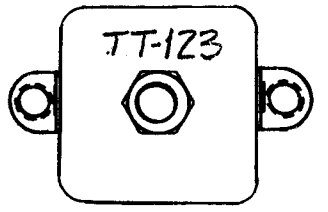
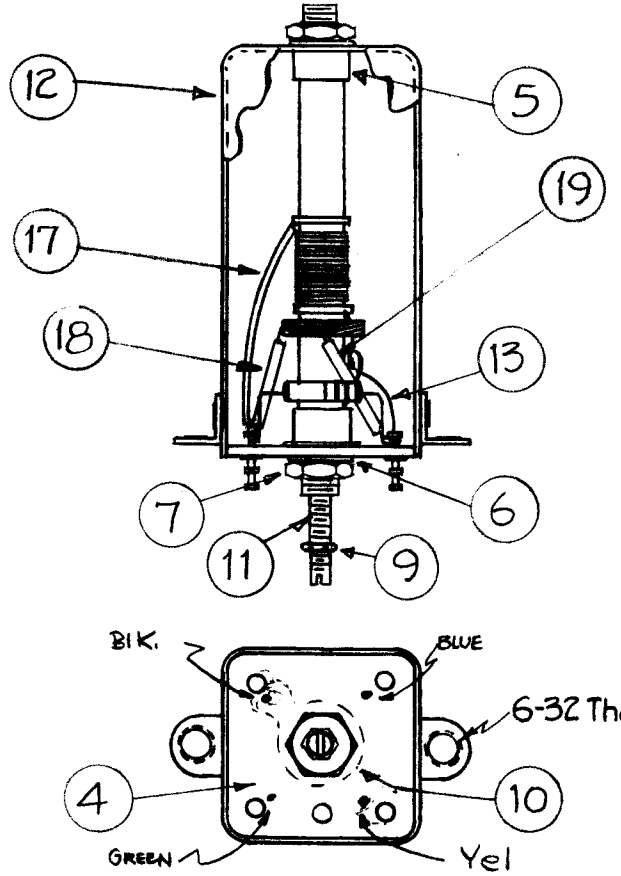


A-1977 F

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



CEMENT COIL FORMS TO BUSHINGS WITH GL-103.



COLOR CODE TERMINAL BOARD AS SHOWN ABOVE

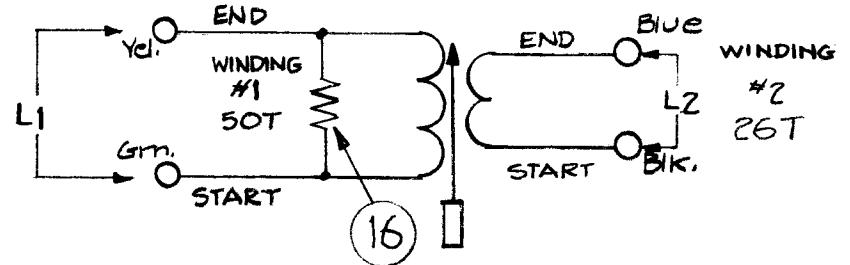
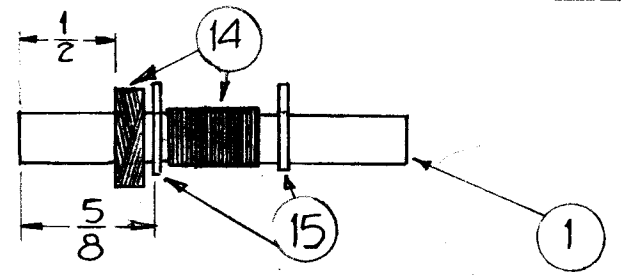
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
E	1	ADDED FIFTH TERMINAL TO BOARD PICTORIAL	5/23/61	4937	DDM	JCS	[Signature]
D	2	LONG WINDING (1 WAS 1 9/16) L2 WAS 4.5UH	4/27/61	4780	DDM	JCS	[Signature]
C	3	Item 11 WAS CI-116-6					
C	2	Item 1 WAS CF-122-2-0	12-21-60	3790	R.U.	Whe	[Signature]
C	1	Winding Data 1, 1/2 WAS 3/4					
B	1	ITEM 9 QUAN. WAS 2	11-8-60	3423	W.F.	JCS	[Signature]
A	1	TITLE OF DRAWING WAS AC-135 COIL ASSY	10/27/60		DDM	[Signature]	[Signature]

**WINDING MACHINE DATA**

Cam Gear 49  
Driver Gear 95  
Cam .125

**WINDING DATA**

1. Start winding #1, (1/2") from end of form.
2. End winding at 50 turns.
3. Keep all leads approximately 2" long.
4. Stake leads to coil form with item 2.
5. Assemble ring terminals (item 15) on form as shown and stake with item 2.
6. Start winding #2 against winding #1.
7. End winding at 26 turns.
8. Stake leads to coil form with item 2.
9. Fasten ends of item 14 to ring terminals.
10. Bake unit for 1/2 hour at 215° F.
11. Coat windings and ring terminals with item 3.
12. Bake hard for 1/2 hour at 215° F.
13. Test as shown in test data.
14. Assemble as shown.



**TEST DATA (W/OUT CORE)**

Winding #1                      Winding #2  
L = 21 uh ( ±10%)              L2 = 3.5 uh ( ±10%)  
Q = 20 or Greater              Q = 50 or Greater  
Freq = 2.5 mcs                      Freq = 7.9 mcs

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	19	PX-104-6-.022	Sleeving, Insulation	Blue
X	18	PX-104-2-.022	Sleeving, Insulation	Yellow
X	17	PX-104-4-.022	Sleeving, Insulation	Green
1	16	RC20GF104J	Resistor, Fixed	
2	15	TE-153-1	Terminal, Ring Type	
X	14	WI-106-17	Wire, Magnet #36 DSC	
X	13	WL-100-8	Wire, Buss #24	
1	12	A-1950-1	Can, Assembly	
1	11	CI-116-5	Core, Tuning	Red
1	10	TE-104-3	Lug	
1	9	NTH0348BN6	Nut, Hex	
X	8	BS-100	Solder Soft	
2	7	NTH0832BN8	Nut, Hex	
2	6	LWI08MRN	Lockwasher, Int.	
2	5	SM-140-2	Bushing, Coil Mtg.	
1	4	PX-586-1	Terminal Board	
X	3	GL-104-2	Insulex. U85	
X	2	GL-103	Cement, Duco	
1	1	CF-122-1.93	Coil Form .250 O.D.	

THE TECHNICAL MATERIEL CORP.  
MAMARONECK, NEW YORK

TT-123 TRANS. ASS'Y

MF OUTPUT

F	ITEM 16 WAS RC20GF104K	9.27.66	16902	WFO	JCS		
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO	DRAFT	CHECKER	ENG APP
1	CHG-1	MF/RF					9-21-60
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE			
USED ON							

TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
		D. J. M.	J. W. S.	A. J. J.
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	A-1977 F