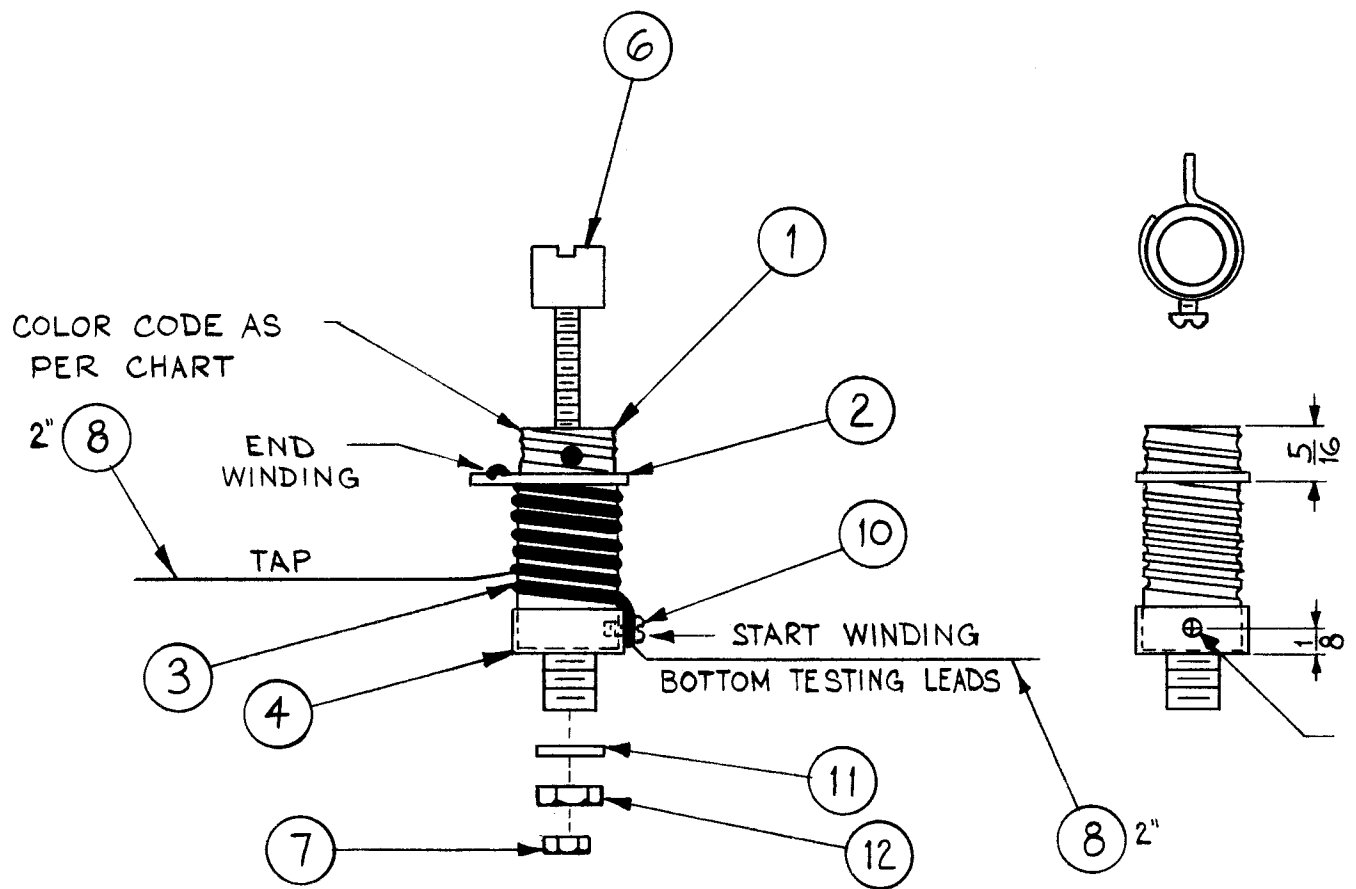


A-2110

TMC MFG. ASSY. NO.	TMC PART NO	SYMBOL	NO. OF TURNS	TAP INFORMATION	NOMINAL INDUCTANCE AT 25 Mcs. - W/O CORE (uhy)	Q AT .25 Mcs. MUST BE GREATER THAN	REG. PER UNIT	COLOR CODE COIL FORM
A-2110	TT-140	T-14	6½	1½ Turns From Bottom	.39-.41	170	1	Orange

- PROCEDURE**
- Secure Terminal Ring (Item 2) And Bushing (Item 4) To Coil Form (Item 1) With Item 9 (GL-104-2) As Shown. Bushing hole Must Be Kept 180°. From Terminal Ring Extension. Do Not Allow Insulex To Form On Terminal Tip or Top End Of Coil Form.
 - Bake For 2 Hours At 250° F.
 - Using Existing Bushing Pilot Hole, Drill Thru One Side Of Coil Form With #48 (.076) Drill.
 - Wind 6-1/2 Turns of Wire on Coil Form As Shown. Crimp and Solder Wire To Terminal Ring As Shown. Wind In **CLOCKWISE** DIRECTION.
 - Attach Wire, (Item 3) And Lead, (Item 8) To Bushing Using Screw, (Item 10). Solder Joint With Item 5.
 - Solder Tap To Coil As Per Chart And Pictorial.
 - Coat Winding With Item 9 (GL-104-2).
 - Bake Unit For 2 Hours At 250° F.
 - Test Unit As Per Chart And Schematic Using Existing Terminal Leads. (NOTE: Use Boonton Q Meter Model 160 A or Equiv.)
 - Remove bottom lead after Testing, Because it is no longer Required.
 - Assemble Items 6, 7, 11, and 12.



THIS VIEW UN-ASSEMBLED TO SHOW RELATIONSHIP BETWEEN RING TERMINAL EXTENSION & BUSHING HOLE.

DRILL THRU ONE SIDE OF COIL FORM # 48 (.076) DR.

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
1	12	NTH2528BN14	NUT, HEX	
1	11	LWI25M	LOCKWASHER, INTERNAL TOOTH	
1	10	SFD0256SN3	SCREW, THREAD CUTTING	
X	9	GL-104-2	INSULEX, U-85	
6"	8	WL-100-7	WIRE, BUSS	
1	7	NTH0632BN8	NUT, HEX	
1	6	CI-109-10	CORE TUNING	
X	5	BS-100	SOLDER, SOFT	
1	4	SM-143-4	BUSHING, COIL FORM	
X	3	WL-100-4	WIRE, BUSS	
1	2	TE-153-3	TERMINAL, RING TYPE	
1	1	CF-124-1.125	COIL FORM	

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°

SCALE: DO NOT SCALE
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
 REMOVE ALL BURRS AND SHARP EDGES

REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.	DATE
1	GPE-1	R.F. SECTION		7-20-61

USED ON

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK TT-140 ASS'Y. (.TRANSFORMER R.F. TUNED).				
MATERIAL				
STOCK SIZE				
FINISH & SPEC. NO.				
TYPE & TEMPER		HEAT TREAT. SPEC.		DRAWN
				CHECKER
				FINAL APPROVAL
				A-2110