

A-2131	COIL DATA		
	SPECIFICATIONS	PRIMARY	SECONDARY
	RACK GEAR		
	RACK DRIVER		
	CAM		
	CAM GEAR		
	CAM DRIVER		
	CAM IDLER		
	RACK IDLER	Helical, Close Wound	Helical, Close Wound
	L uh (+ 5%)	- 9.5	9.5
Q @ 7.95 MC/S	100	100	
R	1	1	

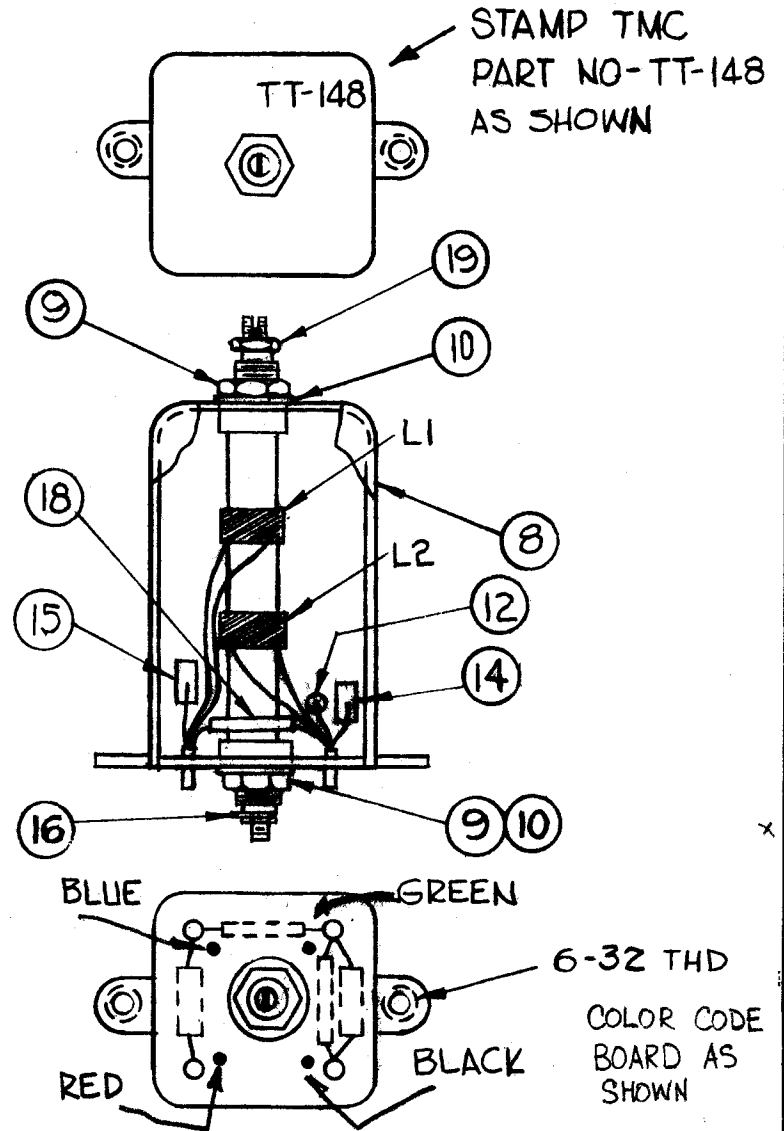
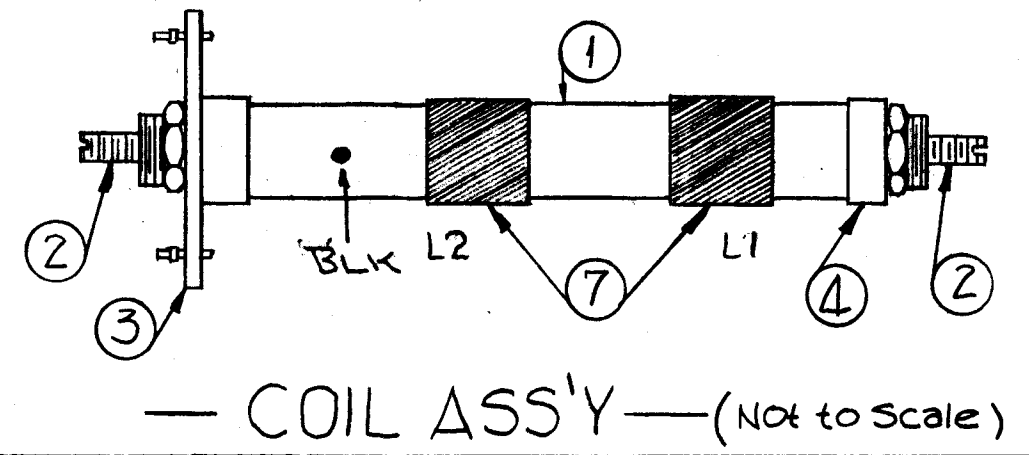
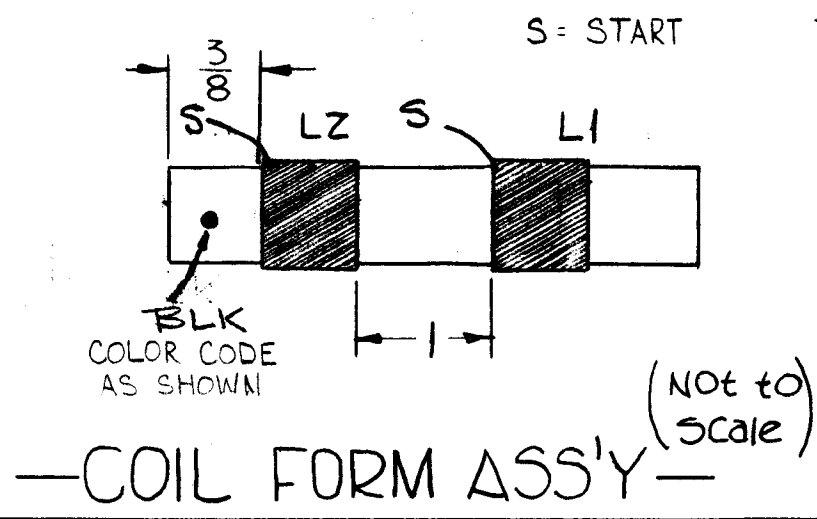
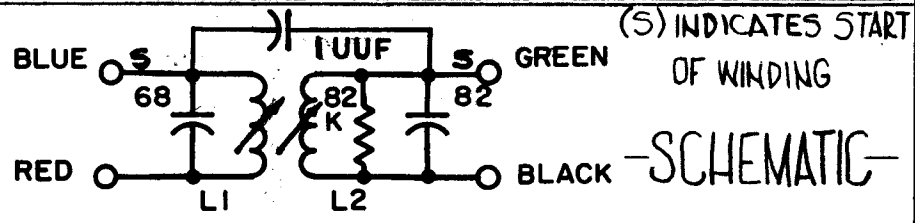
WINDING INSTRUCTIONS		
TURNS	34	34
WIRE	#34 DSC	#34DSC

A. COIL FORM ASSEMBLY

1. Cement terminal rings to coil form with item .13
2. Color code coil forms as shown.

WINDING DATA

1. Wind secondary first, 34 turns, item 7, starting 3/8 in from end. Stake ends with item 13,
2. Wind primary, 1 inch from end of secondary 34 turns of item 7. Stake ends with item 13.
3. Strip & tin leads. Solder them to proper color-coded lugs on collar.
4. Saturate coils with item 11. Bake for 1/2 hour at 215° F. Repair.
5. Solder test leads to lugs (item 17) test as per chart above Q, Dope all leads.
6. Assemble per Elec Schematic & Drawing as shown.



-FINAL ASSEMBLY-

REQ.	ITEM	PART NO.	STRUMER DESCRIPTION	SYMBOL
	1	19	NTH0632BN8	NUT, HEXAGON
	1	18	CC21SLO10K	CAPACITOR, CERAMIC
X	17	BS-100	SOLDER SOFT	
	1	16	SP-102	SPRING, LOCKING
	1	15	CM15C680K	CAPACITOR FIXED MICA
	1	14	CM15C820J	CAPACITOR, FIXED COMPOSITION
X	13	GL-103	DUCO	
	1	12	RC20GF823J	RESISTOR, FIXED, COMPOSITION
X	11	GL-102	Q-DOPE	
	2	10	LW125MRN	LOCKWASHER INTERNAL TOOTH
	2	9	NT-102	NUTS, HEX
	1	8	A-3084	CAN ASSEMBLY
X	7	WI-107-15	WIRE, #34DSC	
X				
	2	4	SM-110	BUSHING, COIL MTG
	1	3	A-977	BASE
	2	2	CI-109-5	CORE, TUNING
	1	1	CF-117-2.563	FORM COIL

B	ITEM 1 WAS CF117-2.625	6/9/64	11499	A.M.	@	
A	ITEM 18 WAS CC21SLO10	3-20-63	8581	TC		
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: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

1	GPR-92	I.F.	TT25	10-16-62
REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.	DATE
USED ON				

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
TT-148 ASS'Y			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKER
FINISH & SPEC. NO.	ELEC. DES. APP.	MECH. DES. APP.	FINAL APPROVAL
			A-2131 B