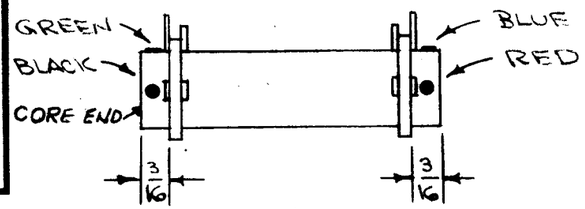
A-2470 C



COIL FORM ASSY.

1- CEMENT TERMINAL RINGS TO COIL FORM WITH ITEM 4 IN POSITION SHOWN ABOVE.
2- COLOR CODE COIL FORMS AS ABOVE.

WINDING MACHINE DATA

SECONDARY		PRIMARY	
RACK GEAR	100	DRIVER GEAR	95
RACK DRIVER	40	CAM GEAR	49
CAM	.125	CAM	.125
CAM GEAR	49		
DRIVER GEAR	95		

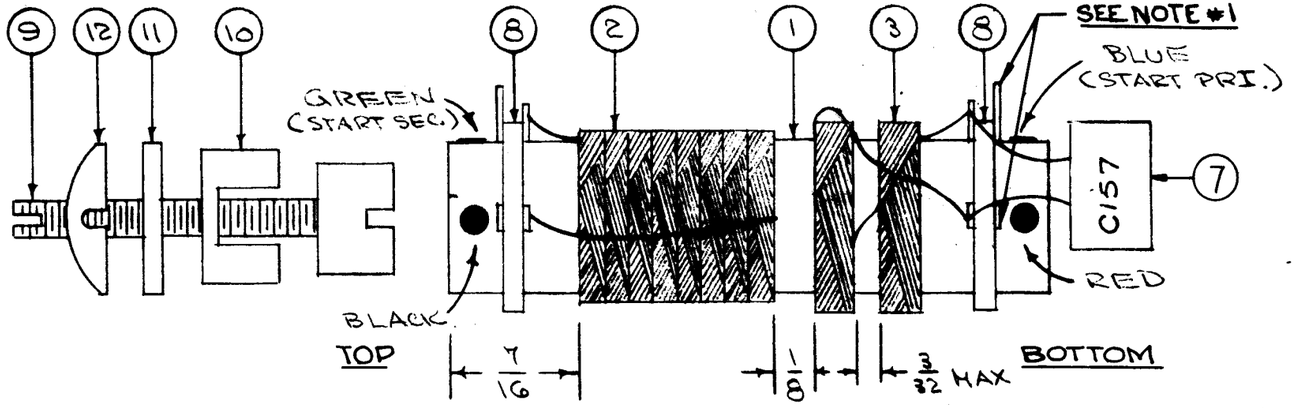
WINDING DATA

1- SECONDARY (WIND ON BEFORE PRIMARY). STARTING AT GREEN LUG, APPROX 160¼ TURNS OF ITEM 2. (PROGRESSIVE UNIVERSAL WINDING). END ON BLACK LUG.
2- PRIMARY - STARTING AT BLUE LUG, 2 PI OF APPROX. 75 TURNS EACH OF ITEM 3. END AT RED LUG.
3- STAKE LEADS TO COIL FORM WITH ITEM 4. BAKE FOR ½ HOUR AT 215° F.
4- STRIP, TIN & SOLDER CONNECT LEADS AS SHOWN.
5- SATURATE COILS WITH ITEM 5. BAKE FOR ½ HOUR AT 215° F.
6- REPEAT STEP 5.
7- SOLDER TEST LEADS TO LUGS (APPROX. 1¼" * 22 BUSS) TEST AS PER CHART BELOW. REMOVE TEST LEADS.
8 - SOLDER CAPACITOR IN PLACE AS SHOWN.

TEST DATA w/o CORE

WINDING	* L μh	* Q	F	** RΩ APPROX.
SEC	195 (185-205)	60 OR GREATER	790 KC	11.2
PRI	280 (266-294)	50 " "	790KC	10.0

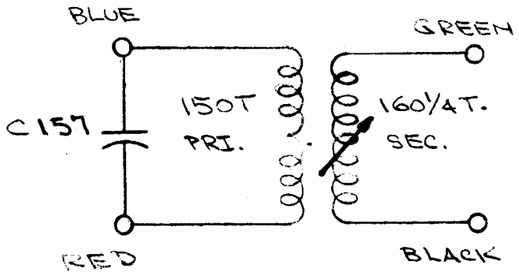
* USE BOONTON Q METER 160 A OR EQUIV.
** " SIMPSON OHMETER 260 " "



NOTE: COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS -10-11-12 ARE CEMENTED TO COIL FORM WITH ITEM 13.

FOR IDENTIFICATION., STAMP THE NUMBER TT-183 ON THE TOP OF COIL FORM.

NOTE: #1 COMPONENTS MAY BE ASSEMBLED TO EITHER END OF LUG (TE-146-2A)."



	REQ.	ITEM	PART NO.	STRUMER DESCRIPTION	SYMBOL
X	13	GL-111		CEMENT, "INSA-LUTE"	
1	12	FS-112		FASTENER	
1	11	WA-125-2		WASHER, FIBER	
1	10	NT-112		NUT, SPEED	
1	9	CI-109-11		CORE	
2	8	TE-146-2A		TERMINAL RING	
1	7	CM20D162F		CAPACITOR, FIXED	C157
X	6	BS-100		SOLDER, SOFT	
X	5	GL-102		Q MAX	
X	4	GL-103		CEMENT, DUCO	
PRI. X	3	WI-107-17		WIRE, MAGNET #36 DSC.	
SEC. X	2	WI-104-3A1-SC-QS		WIRE, LITZ 3/41 SC-QS	
1	1	CF-112		COIL FORM	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
C	2	ITEM 2 WAS WI-104-3A1-SSE	3-17-64	11048	A.M.	@	MMR
B	1	NOTES, WINDING DATA & PICTORIAL CLARIFIED. NOTE #1 ADDED	7-18-63	9515	AK.		
A	1	SYM. C157 WAS C136	1-19-63	8031			

TOLERANCES
DEC. DIM. ±
FRAC. DIM. ±
ANGULAR DIM. ±

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	PROJECT NO.	SYMBOL NO.	DATE
1	GPR-92		T113	6-4-62

USED ON

STOCK SIZE
MATERIAL
TYPE & TEMPER | HEAT TREAT. SPEC.
FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK. NEW YORK

TT-183 ASSY

TRANSFORMER, RF, TUNED (1ST MIXER)

DRAWN	CHECKED	FINAL APPROVAL
W.S.		BP

ELEC. DES. APP.	MECH. DES. APP.	
	MP	A-2470 C

FORM - 109 - A