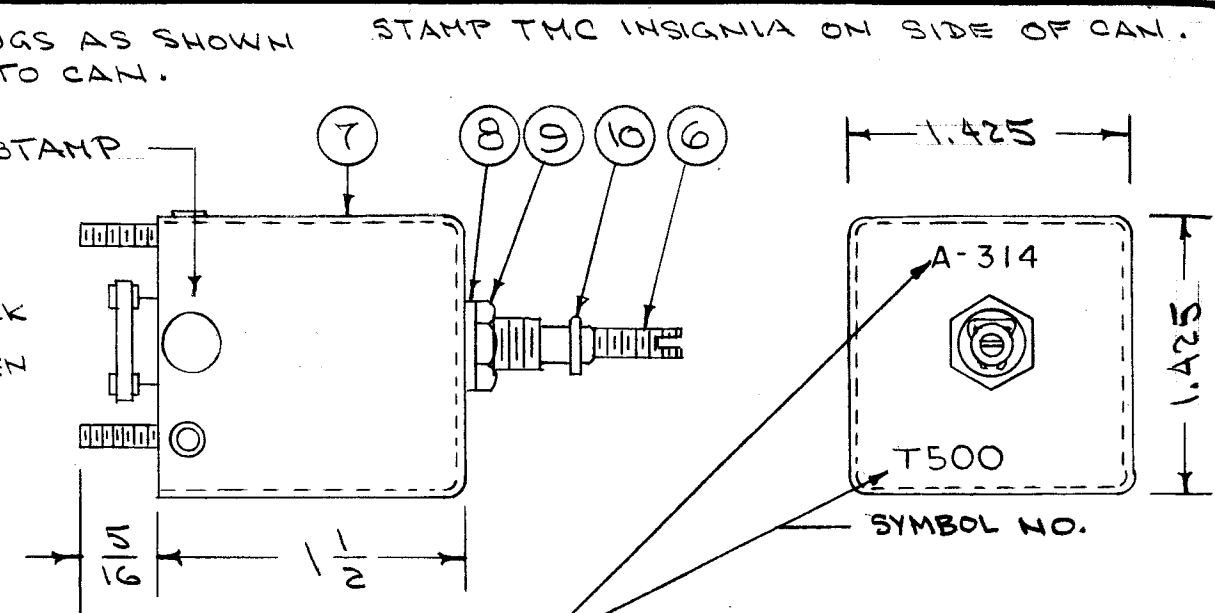
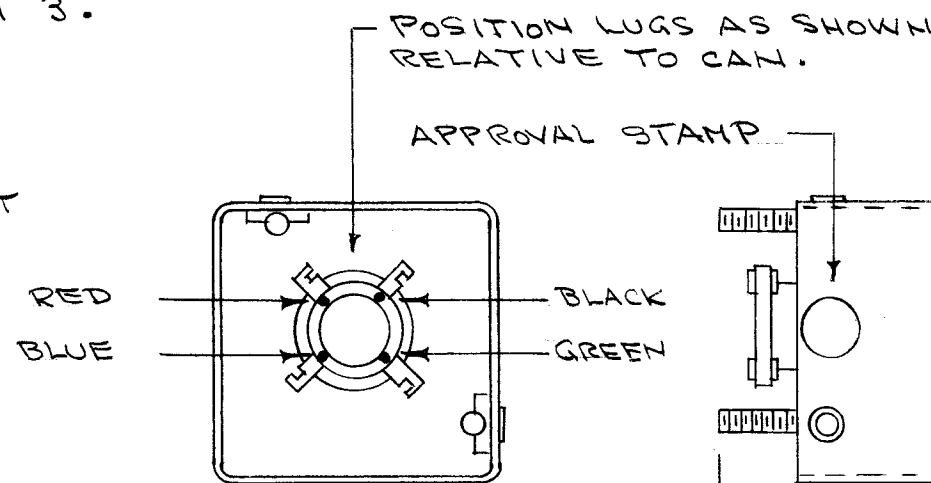
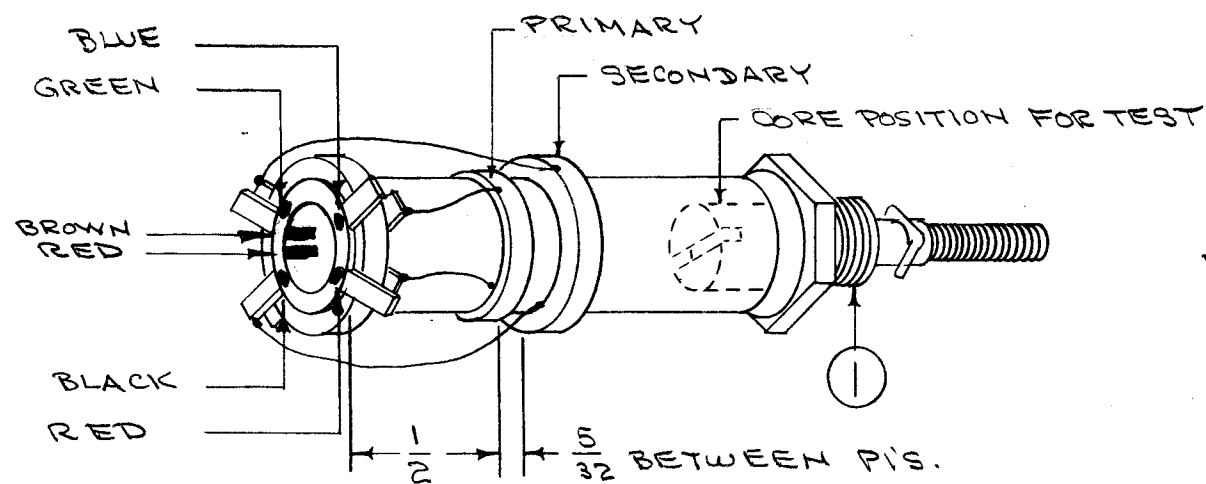


B
A-314

CEMENT TERMINAL RING TO COIL FORM WITH ITEM 3.
COLOR CODE END OF COIL FORM AS BELOW.



STAMP ASS'Y NO. & SYMBOL NO. ON CAN AFTER CAN IS ASSEMBLED (REF: LD-124)

WINDING MACHINE DATA

DRIVER GEAR - 81
CAM GEAR - 86
CAM - .093

WINDING DATA (UNIVERSAL WINDING)

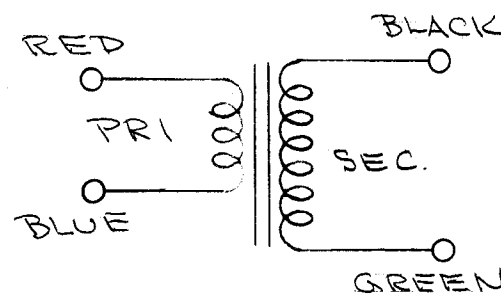
- 1- PRIMARY- STARTING AT RED LUG WIND ON $1\frac{1}{4}$ TURNS OF ITEM 2 ENDING AT BLUE LUG.
- 2- SECONDARY- STARTING AT BLACK LUG WIND ON $4\frac{3}{4}$ TURNS OF ITEM 2 ENDING AT GREEN LUG.
- 3- STAKE COIL ENDS WITH ITEM 3.
- 4- BAKE FOR $\frac{1}{2}$ HOUR AT 215° F.
- 5- SATURATE COILS WITH ITEM 4 (Q.MAX).
- 6- BAKE FOR $\frac{1}{2}$ HOUR AT 215° F.
- 7- REPEAT STEPS 5 AND 6.
- 8- STRIP, TIN & SOLDER CONNECT LEADS TO LUGS AS ABOVE.

TEST DATA (SEE ABOVE FOR CORE POSITION)

TEST LEADS TO BE $\frac{1}{4}$ " APPROX. NO CAN NEEDED FOR TEST.

	PRIMARY	SECONDARY
	BLUE/RED	GREEN/BLACK
L μ H	2.8 (2.65-2.95)	35 (33.5-36.5)
Q	55 OR GREATER	40 OR GREATER
f	7.9 M.C.	2.5 M.C.

USE BOONTON Q METER 160A OR EQUIV.



FREQ. RANGE 1.95 TO 4.1 M.C.

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	11	BS-100	SOLDER, SOFT	
	10	SP-102	SPRING LOCK P/O CF-114	
	9	NT-102	NUT, HEX P/O CF-114	
	8	LWI 25 LRC	WASHER, LOCK P/O CF-114	
	7	A-113	CAN ASSEMBLY	
	6	CI-69-19	CORE	
	5	TE-146-A	COLLAR & LUGS	
X	4	GL-102	Q MAX A-27	
X	3	GL-103	CEMENT, DUCCO	
X	2	WI-107-15	WIRE, #34 DSC	
	1	CF-114-3	COIL FORM	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B		TMC INSIGNIA DEL WINDING SEC WAS 41 1/4; T500 ADDED	10.18.66	17062	WFO	PLX	AJT
A	1	COMPLETE REVISION SUPERCEDES A-310	8/28/66	1	WFO	PLX	AJT

TOLERANCES: DEC. DIM. \pm , FRAC. DIM. \pm , ANGULAR DIM. \pm

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.	ASS'Y. NO.	DATE
1	FFRD-5	104	A-328	8-28-56

USED ON

TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
		PLX	AJT	A-314 B

FINISH & SPEC. NO. ELEC. DES. APP. MECH. DES. APP.