

NOTE 1:  
USE ITEM 14 ON SECONDARY  
LEADS BEFORE THEY ARE  
TWISTED TOGETHER.

WINDING DATA

PRIMARY

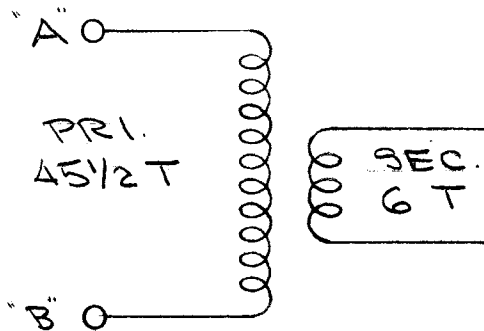
- 1- 45 1/2 CLOSE WOUND TURNS OF ITEM 2, FROM POINT "A" TO POINT "B" (SINGLE LAYER).
- 2- STAKE LEADS TO COIL FORM WITH ITEM 3.
- 3- STRIP, TIN & SOLDER CONNECT LEADS TO LUGS "A" & "B"
- 4- BAKE FOR 30 MIN. AT 250° F.
- 5- SATURATE COIL WITH ITEM 4.
- 6- BAKE FOR 1 HOUR AT 250° F.

SECONDARY

- 1- PUT ON 1 LAYER OF ITEM 5 (TAPE) OVER PRIMARY IN POSITION SHOWN IN SKETCH.
- 2- 6 TURNS OF ITEM 2, CLOSE WOUND & CENTERED ON TAPE AND IN SAME DIRECTION AS PRIMARY.
- 3- COAT COIL WITH ITEM 6. AIR DRY.

TEST DATA.

	PRIMARY	SECONDARY
L <sub>mh</sub>	59.0 (53-65)	3.0 (2.7-3.3)
Q	150 OR GREATER	40 OR GREATER
f	2.5 MC	7.9 MC



USE BOONTON Q METER 160A OR EQUIV

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
G		NOTE # ITEM 14 ADD.	8.28.67	18482	H.G.	<i>[Signature]</i>	
F		B/M UPDATED	10.18.66	17064	AW	<i>[Signature]</i>	
F	2	COMPLETE REVISION	12.16.66	5	EDS	<i>[Signature]</i>	ATTJ.
F	1	REDRAWN					

TOLERANCES		SCALE:
DEC. DIM. ±		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES
FRAC. DIM. ±		
ANGULAR DIM. ±		

REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
1	XFK		A-753	11-23-56
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 14	PX830-24-1	INS SLVG - SHRINK	
X 13	BS-100	SOLDER, SOFT	
2	TE-104-2	LUG, LOCKING	
2	SC-106-1	SPADE BOLT	
8	WA-109-34	WASHER, FIBER	
2	LW106MRN	WASHER, LOCK	
4	NTH0632BNS	NUT, HEX	
4	SCBP0632BNG	SCREW, MACHINE	
X 6	GL-115	LACQUER, AIR DRYING	
X 5	TA-101-2	TAPE	
X 4	GL-10A-2	INSULEX, U-85	
X 3	GL-103	CEMENT, DUCO	
X 2	WI-107-7	WIRE # 26 DSC	
1	CF-108	COIL FORM	
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
TRANSFORMER, MAIN SECTION OF TG XFK			
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
		<i>[Signature]</i>	<i>[Signature]</i>
		A-344 G	