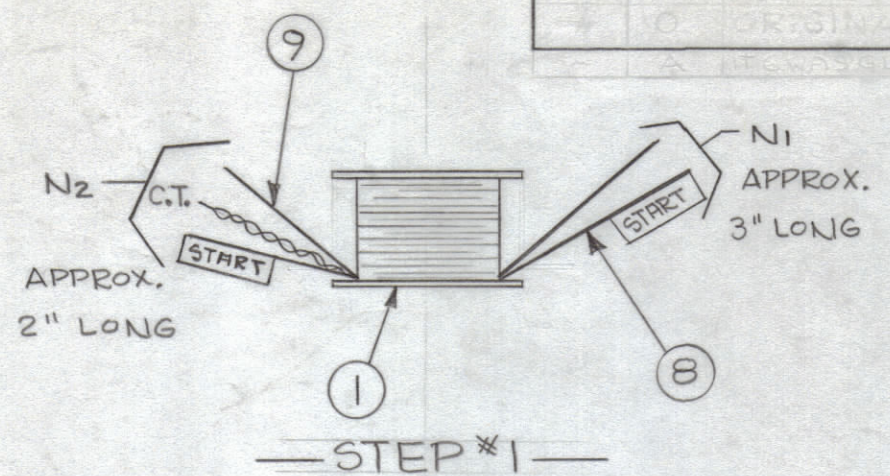
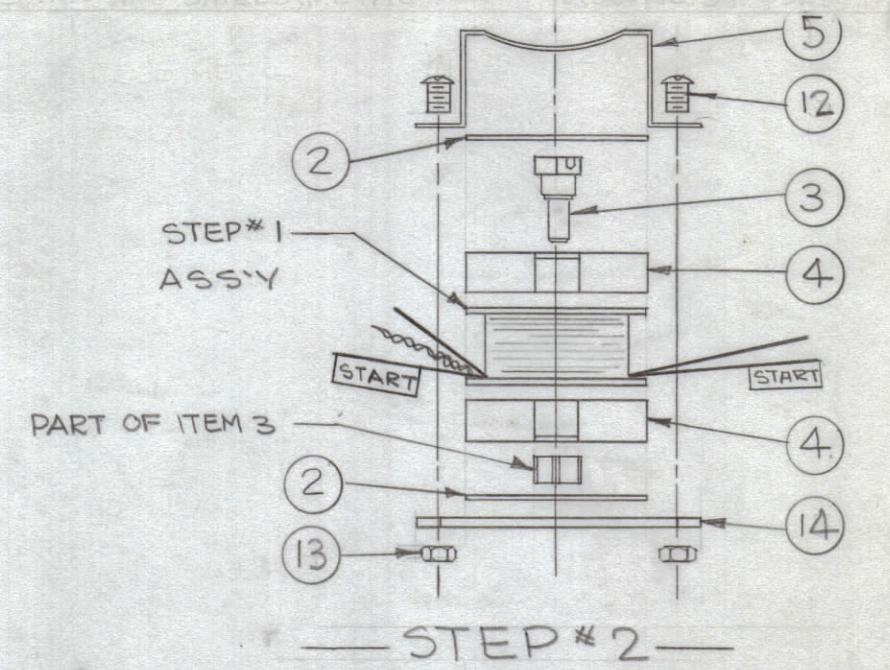


TMC PART NO	MFG PART NO	NO. OF TURNS		INDUCTANCE ±2% MH	CENTER FREQ (K.C.)	OPERATION FREQ RANGE (K.C.)
		N ₁	C.T. N ₂			
A-3272-11	-11	73	42	3.2	11	10-12
A-3272-13	-13	69	40	2.85	13	12-14
A-3272-16	-16	61	24	2.25	16	14-18
A-3272-21	-21	56	22	1.73	21	18-24
A-3272-27	-27	48	16	1.33	27	24-30
A-3272-60	-60	29	10	0.5	60	55-65

REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
	B	ON CHART: (-21) N ₁ COL. WAS 54; INDUCTANCE COL. WAS 1.68.	12-15-64	13130	92	@

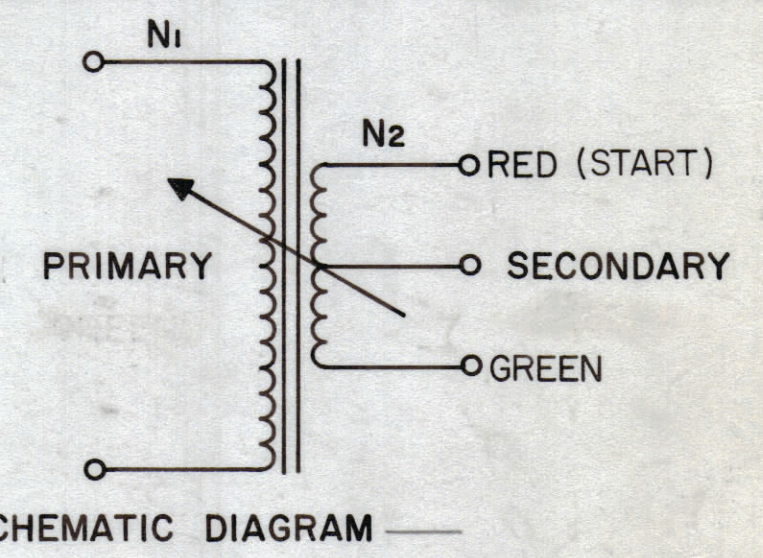
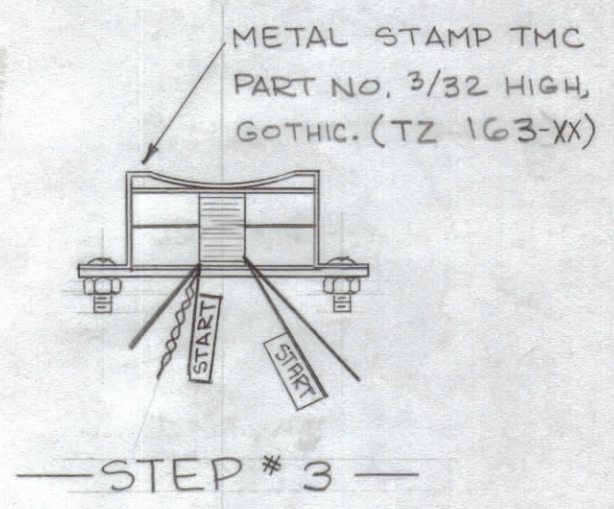


NOTE:
WINDINGS MUST TERMINATE AS SHOWN AND A "START TAG" IS ON ITEM #8 (N₁). ALSO, WINDING MUST BE PUT ON IN ONE DIRECTION.



—WINDING PROCEDURE—

- 1 - DIP ITEMS (N₁) WITH ACETONE (APPROX. 3" LONG). PLACE MASKING TAPE ON BEGINNING OF WIRE & MARK START, AS SHOWN IN STEP 1.
- 2 - WIND N₁ WINDING WITH ITEMS 8 ONTO ITEM 1 AS IN STEP #1.
- 3 - PLACE ITEM 6 ON FINISH OF WINDING, LET DRY FOR ONE MINUTE & ASSEMBLE AS SHOWN IN STEP #2. DO NOT USE ITEM 3 FOR THIS MEASUREMENT. DIP END OF LEAD WITH ACETONE.
- 4 - TIN ENDS OF LEADS. MEASURE THE INDUCTANCE AND "Q" WITH THE GENERAL RADIO BRIDGE.
- 5 - THE INDUCTANCE MUST FALL WITHIN ±2% OF THE INDUCTANCE INDICATED. ADJUSTMENT OF ±1 TURN SHOULD BE APPROX. EQUAL 20 (USE GENERAL RADIO BRIDGE).
- 6 - UNASSEMBLE STEP #2 AS SHOWN.
- 7 - WIND ITEM 9 (N₂) ON ITEM 1 AND SECURE WITH ACETONE LET DRY FOR ONE MINUTE. MARK START WITH MASKING TAPE.
- 8 - BAKE ITEM 1 AT 200° F, FOR 20 MINUTES.
- 9 - APPLY ITEM 6 TO FINISHED TRANSFORMER.
- 10 - SEPARATE RED & GREEN BIFILAR WIRE.
- 11 - TWIST TOGETHER START (GREEN LEAD) & END (RED LEAD).
- 12 - TIN ENDS OF LEADS.
- 13 - ASSEMBLE AS SHOWN IN STEP #2. PLACE TRANSFORMER ON GENERAL RADIO BRIDGE AND CHECK "Q" AND INDUCTANCE, WITHOUT TUNING SLUG (ITEM 3).
- 14 - ADD TUNING STUG (ITEM 3) TO FINISHED TRANSFORMER.
- 15 - CHECK CONTINUITY OF WINDINGS & FOR SHORTS BETWEEN WINDINGS.
- 16 - ITEMS 12, 13 & 14 MUST BE REMOVED BEFORE MOUNTED TO THE PRINTED CIRCUIT BOARD.



A-3272 B

QTY	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
1	14	MS-3488	RETAINER, COIL	
2	13	NTH0256BNG	NUT, HEX. HINE	
2	12	SCBP0256BNG	SCREW, MACHINE	
X	11	BS-100	SOLDER, SOFT	
#	10	DELETED	#	
X	9	WI-148-34-25	HUDSOL WIRE, MAGNETIC, #34	RED/GRN
X	8	WI-104-4044-SCP-QS	WIRE, LITZ	
#	7	DELETED	#	
X	6	GL130	ADHESIVE, Q-DOPE	
1	5	CU-148-1	RETAINER, CUP CORE	
2	4	CI-132	CORE, CUP	
1	3	CI-133	CORE, TUNING	
2	2	WA-140-1	WASHER, NON-METALLIC	
1	1	CF-135-4	BOBBIN, NYLON	

REQ'D. ITEM PART NUMBER DESCRIPTION SYMBOL

M. GELLMAN LIST OF MATERIAL

MATERIAL #

FINISH #

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

TITLE
TZ-163 ASSEMBLY

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN G. Jensen	DATE 8-3-63	FINAL APPROVAL RJC	DATE
SCALE NONE	CODE A	ASSY. NO. A-3212	DATE 5-8-64	
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	FRACTIONS ± 1/64 ANGLES ± 0° 30'	TOLERANCES	ELECT. DES. MECH. DES.	DATE 8-6-64

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NOTES

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STOCK NO. 440H