

A-706 C

ASSEMBLY

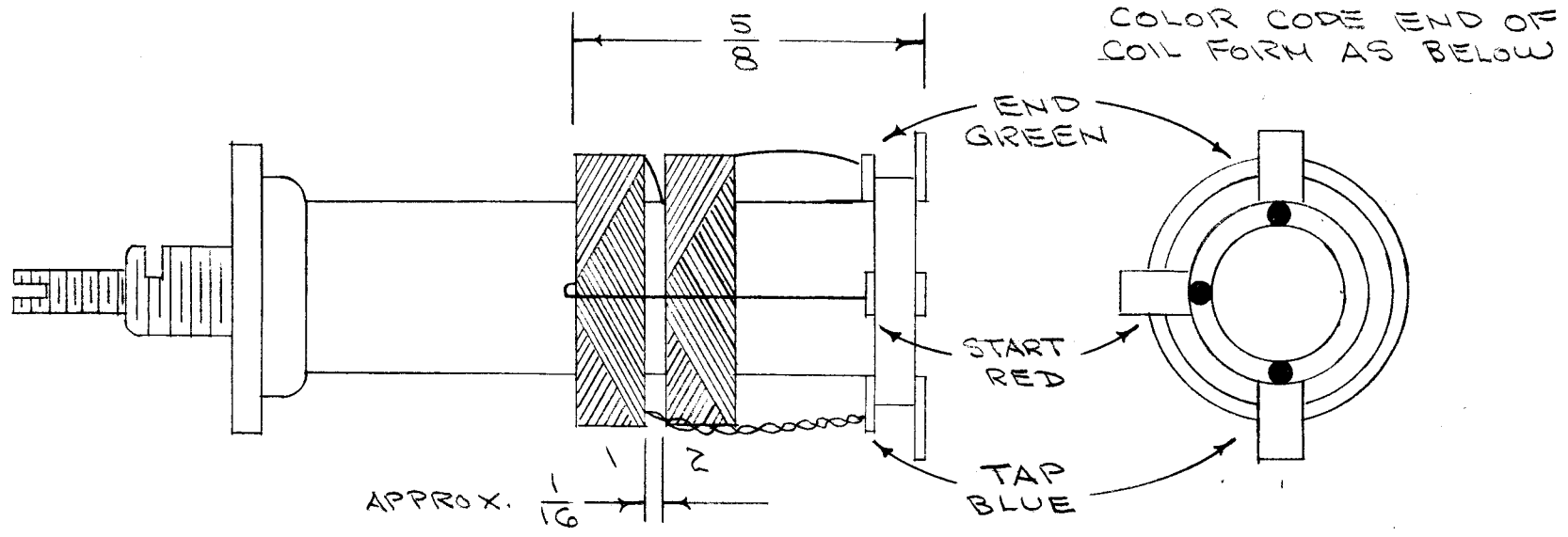
AFFIX COLLAR TO COIL FORM WITH ITEM 6 (CEMENT).
AIR DRY.

WINDING MACHINE DATA.

DRIVER GEAR - 90
CAM GEAR - 87
CAM - .136

WINDING PROCEDURE

- 1- START 1st PI 5/8" FROM LUG END OF COIL FORM AND IN LINE WITH RED LUG. USE WINDING FINGER WITH GUIDE ON LEFT. START WINDING WITH FINGER IN EXTREME LEFT HAND POSITION OF TRAVEL.
- 2- TAP 1st PI AT 125 1/4 TURNS ADJACENT TO BLUE LUG.
- 3- END 1st PI AT 245 TURNS.
- 4- START 2nd PI 1/16" FROM 1st PI.
- 5- END 2nd PI AT 490 3/4 TURNS ADJACENT TO GREEN LUG.
- 6- STAKE TAP & ENDS TO COIL FORM WITH ITEM 6. AIR DRY.
- 7- BAKE FOR 1/2 HOUR AT 215° F. SATURATE COIL WITH ITEM 5 AND AIR DRY FOR 10 MIN. BAKE FOR 2 HOURS AT 215° F.



TAP 1st PI 125 1/4 TURNS FROM START
 END 1st PI 245 " " "
 END 2nd PI 490 3/4 " " "

TEST PROCEDURE W/O CORE
 USE BOONTON Q METER 160A OR EQUIVALENT.

| | RED / GREEN | GREEN / BLUE |
|---|---------------------|----------------------|
| L | 2.85 mh (2.7 - 3.0) | 1.8 mh (1.62 - 1.98) |
| Q | > 50 | > 45 |
| F | 250 KC | 250 KC |

MISC. TEST DATA W/CORE OUT OF CAN

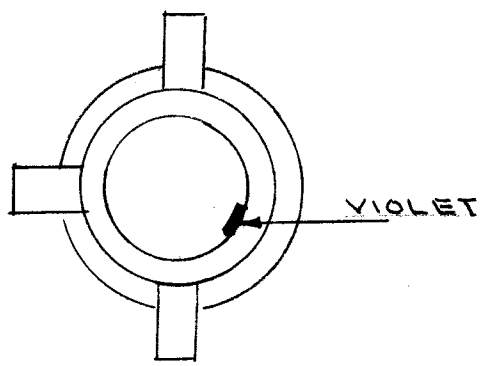
MIN L - 3.1 mh Q - 55
 MAX L - 7.8 mh Q - 60

IN CAN

MIN L - 2.7 mh Q - 55
 MAX L - 6.0 mh Q - 60

NOTE

COLOR CODE AS SHOWN INSIDE OF COIL FORM (REF: CH-102)



| REQ. ITEM | PART NO. | DESCRIPTION | SYMBOL |
|-----------|------------|----------------|--------|
| 1 8 | SP-102 | LOCKING SPRING | |
| X 7 | BS-100 | SOLDER, SOFT | |
| X 6 | GL-103 | CEMENT, DUPONT | |
| X 5 | GL-104-2 | INSULEX, U-85 | |
| X 4 | WI-120-15 | WIRE, #34 DSC | |
| 1 3 | CI103 D7B5 | CORE | |
| 1 2 | TE-146-3 | COLLAR & LUGS | |
| 1 1 | CF-114-3 | COIL FORM | |

| THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK | | | |
|--|-------------------|-----------------|-----------------|
| MIXER & R.F. COIL SUB ASSY. | | | |
| T 201 & T 202 FFRD-2 | | | |
| TYPE & TEMPER | HEAT TREAT. SPEC. | DRAWN | CHECKED |
| | | PLK 4/11/56 | WOC |
| FINISH & SPEC. NO. | | ELEC. DES. APP. | MECH. DES. APP. |
| | | | A. J. J. |
| | | | A-706 C |

| ISSUE | ITEM | CHANGED FROM | DATE | CH. NO. | DRAFTS | CHECKER | ENG. APP. |
|-------|------|--|---------|---------|----------|---------|-----------|
| C | 1 | Test Data chgd. | 6/14/56 | 3 | JAK P.K. | A.J.J. | |
| B | 2 | Color CODE ADDED | 5/31/56 | 2 | JAK P.K. | A.J.J. | |
| A | 1 | TITLE CHANGED SCHEMATIC DIAGRAM CORRECTED | 5/21/56 | 1 | JAK P.K. | A.J.J. | |

| 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. | ASS'Y. NO. | DATE |
|---------------|--------|-------------|------------|---------|
| 2 | FFRD-2 | 458 | A-707 | 4-12-56 |
| USED ON | | | | |