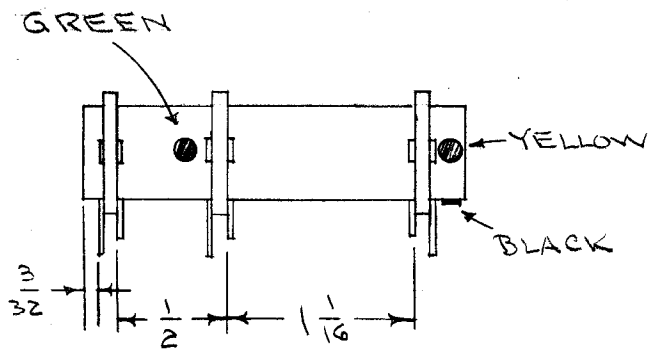


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COIL FORM ASSEMBLY

- 1- CEMENT TERMINAL RINGS TO COIL FORM WITH ITEM 3 IN POSITION SHOWN ABOVE.
- 2- COLOR CODE COIL FORM AS ABOVE.

WINDING MACHINE DATA

RACK GEAR 42
RACK DRIVER GEAR 50

WINDING DATA

- 1- STARTING AT GREEN LUG WIND ON 38 TURNS OF ITEM 2.
- 2- BRING OUT 1" LONG TWISTED TAP AS SHOWN.
- 3- CONTINUE WINDING FOR 14 1/4 TURNS MAKING A TOTAL OF 52 1/4 TURNS.
- 4- STAKE ENDS TO COIL FORM WITH ITEM 3.
- 5- STRIP & TIN ENDS AND TAP. SOLDER CONNECT TO LUGS AS SHOWN.
- 6- BAKE FOR 1/2 HOUR AT 215° F.
- 7- SATURATE COIL WITH ITEM 5. BAKE FOR 30 MIN AT 215° F.
- 8- SOLDER 1" OF #22 BUSS BAR TO EACH LUG FOR TEST.
- 9- MAKE TEST (SEE CHART). REMOVE TEST LEADS.
- 10- SOLDER CAPACITOR IN PLACE AS SHOWN.
- 11- TIE CAPACITOR TO COIL WITH ITEM 13 SEAL KNOTS WITH ITEM 3.

TEST DATA w/o CORE

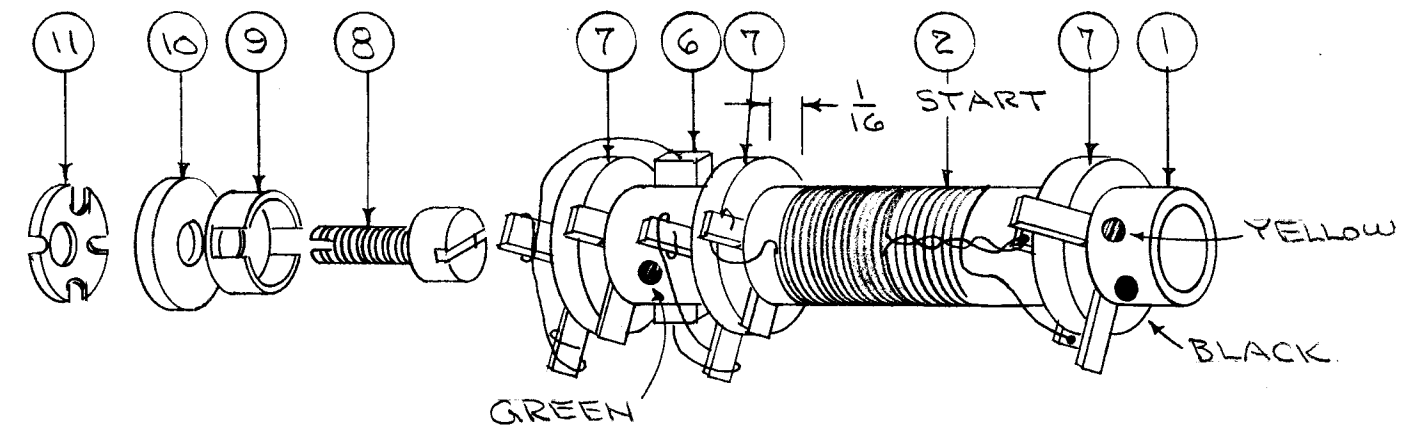
WINDING	L μH *	Q *	F
L ₁	20.5 (19.5-21.5)	100 OR GREATER	2.5 MC
L ₂	13.5 (12.9-14.1)	90 " "	"

* USE BOONTON Q METER 160 A OR EQUIVALENT.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
K		IT 6 WAS CM20D1091F03YY	2-20-67	17834			
J	1	ADD "03YY TO IT. 6	9/28/66	16893			
H	3	WA-125-2 WAS WA-125	5/19/60	227			
H	2	NT-112 WAS NT-113					
H	1	CHANGE TITLE					
G	1	Item 13 e note added.	2/3/59	737	J.C.B.		
F	2	Q OF 90 WAS 100	11/5/56	6	LS	P.L.K.	A.J.J.
F	1	Q OF 100 WAS 110					
E	1	REDRAWN COMPLETE REVISION	1/21/56	5	COO	P.L.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. ±	

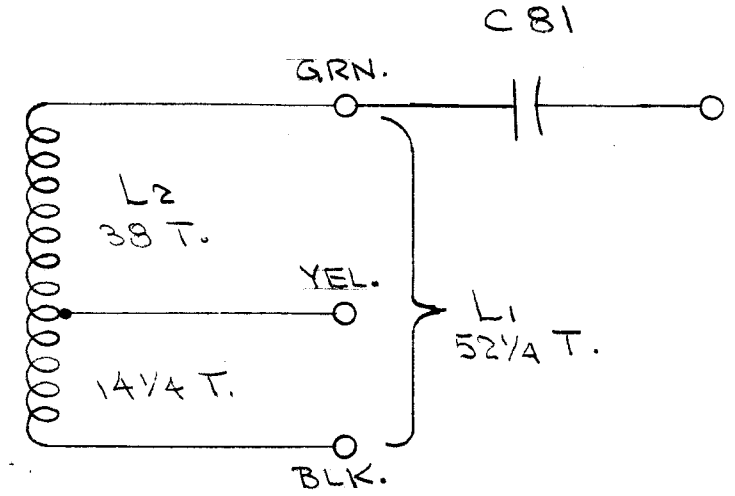
REQ. PER UNIT	MODEL	PROJECT NO.	SYMBOL NO.	DATE
1	GPR-90-RXD			5-23-60
1	GPR-90	297	L14	7-25-56



NOTE: KEEP CAPACITOR LEADS SHORT BUT DO NOT ALLOW CAP. TO TOUCH A LUG.

COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 8-9-10-11 ARE CEMENTED TO COIL FORM WITH ITEM 12.

FOR IDENTIFICATION STAMP THE NUMBER L14 ON THE COIL FORM IN ANY CONVENIENT SPOT.



FREQ. RANGE 1.885 TO 3.755 MC.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 13	CD-101-3MW	CORD, LACING	
X 12	GL-111	CEMENT, "INSA-LUTE"	
1 11	FS-112	FASTENER	
1 10	WA-125-2	WASHER	
1 9	NT-112	NUT, SPEED	
1 8	CI-109-7	CORE	
3 7	TE-146-2A	RING, TERMINAL	
1 6	CM200D1091F	CAPACITOR	C81
X 5	GL-102	Q MAX	
X 4	BS-100	SOLDER, SOFT	
X 3	GL-103	CEMENT, DUCO	
X 2	WI-104-3A1SNE	WIRE, LITZ	
1 1	CF-112	COIL FORM	

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
COIL, RF, TUNED OSCILLATOR, BAND 2			
STOCK SIZE		MATERIAL	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

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