

**COIL FORM ASSY.**  
 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	48
RACK DRIVER	80
CAM	.125
CAM GEAR	49
DRIVER GEAR	95

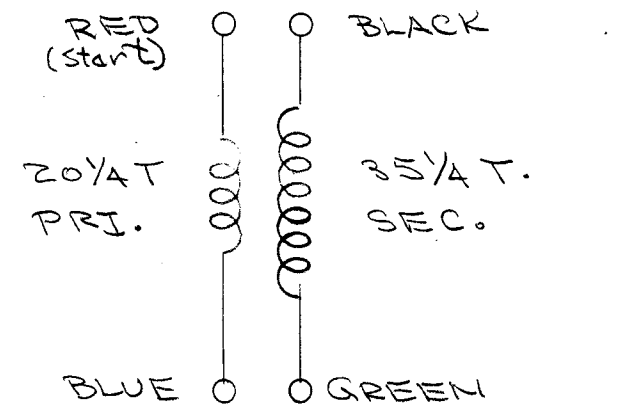
**WINDING DATA.**

- 1- SECONDARY - STARTING AT BLACK LUG, CLOSE WIND 35 1/4 TURNS OF ITEM 2, END AT GREEN LUG.
- 2- PRIMARY - STARTING AT RED LUG, UNIVERSAL WIND 20 1/4 TURNS OF ITEM 6, END AT BLUE LUG.
- 3- STAKE LEADS TO COIL FORM WITH ITEM 3. STRIP, TIN & SOLDER CONNECT LEADS AS SHOWN.
- 4- BAKE FOR 1/2 HOUR AT 215° F.
- 5- SATURATE COILS WITH ITEM 4. BAKE FOR 1/2 HOUR AT 215° F.
- 6- REPEAT STEP 5.
- 7- SOLDER TEST LEADS (APPROX. 1/4" #22 BUSS BAR) TO LUGS. TEST AS BELOW. REMOVE TEST LEADS.

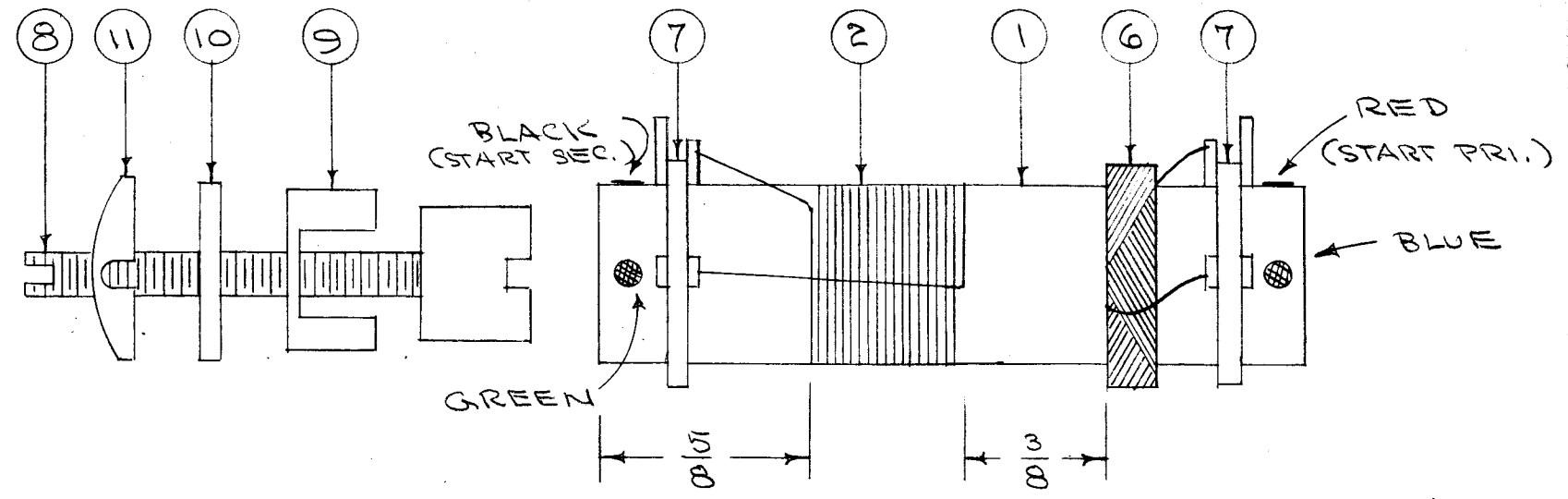
**TEST DATA. w/o CORE**

WINDING	* L uh	* Q	F
PRI.	9.0 (8.5-9.5)	55 OR GREATER	7.9 MC
SEC.	9.7 (9.2-10.2)	85 " "	2.5 MC

\* USE BOONTON Q METER 160 A OR EQUIVALENT.



FREQ. RANGE 3.2 - 5.6 MC



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

FOR IDENTIFICATION STAMP NUMBER L9 ON COIL FORM IN ANY CONVENIENT SPOT.

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	12	GL-111	CEMENT "INSA-LUTE"	
1	11	FS-112	FASTENER	
1	10	WA-125	WASHER, FIBER	
1	9	NT-113	NUT, SPEED	
1	8	CI-109-10	CORE	
2	7	TE-146-2A	TERMINAL RING	
X	6	WI-107-17	WIRE, MAGNET #30DSC	
X	5	BS-100	SOLDER, SOFT	
X	4	GL-102	Q-MAX	
X	3	GL-103	CEMENT, DUCO	
X	2	WI-107-11	WIRE, MAGNET #30DSC	
1	1	CF-112	COIL FORM	

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK, NEW YORK				
STOCK SIZE				
R.F. TRANS. ASSY. L9				
MATERIAL				
BAND 3 GPR-90				
DRAWN: P.L.K. CHECKED: J.A.D. FINAL APPROVAL: A.J.J.				
TYPE & TEMPER HEAT TREAT. SPEC. FINISH & SPEC. NO. ELEC. DES. APP. MECH. DES. APP.				

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
F	3	REVISION LETTERS CORRECTED ("E" WAS "C")	11/15/56	6	16	P.L.K.	A.J.J.
	2	Q OF 85 WAS 100					
	1	Q OF 55 WAS 65					
E	1	1/8 WAS 3/16	11/21/56	5	J.A.D.	C.S.D.	J.A.D.
D	1	REDRAWN COMPLETE REVISION	7/31/56	4	C.S.D.	P.L.K.	A.J.J.

TOLERANCES	SCALE:
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±	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	GPR-90	297		7-30-56

USED ON