

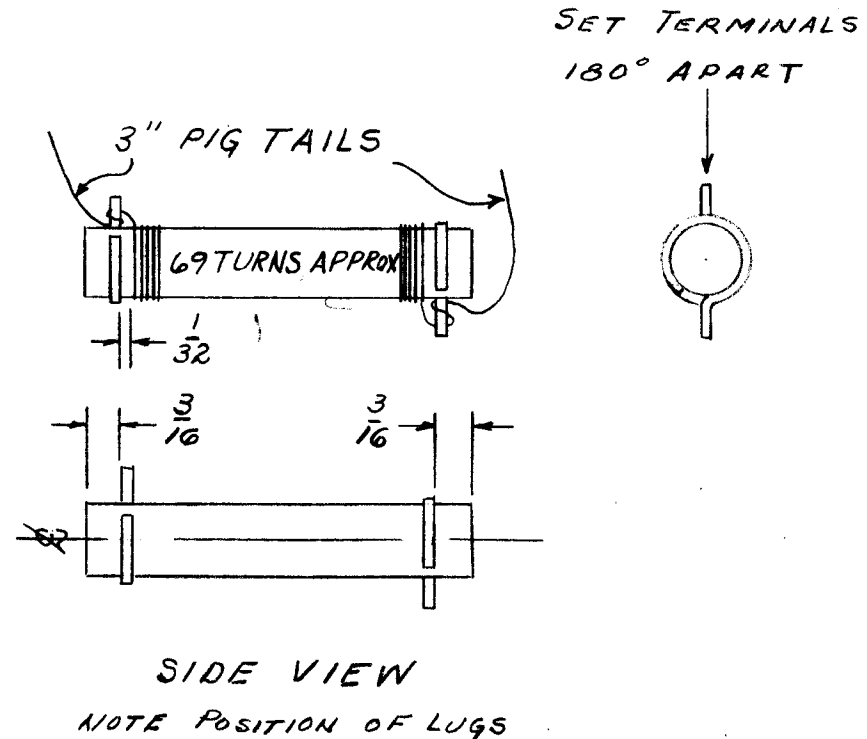
A-1544

WINDING

69 Close Wound Turns of WI-107-7 Spaced On Core As Shown. Allow 3" Stripped Pigtail Each End For Connection To Lugs. Pigtail Also To Be Used During Dipping In Insulex, For Hanging Coil In Oven And For Attachment To Q Meter.

FABRICATION

1. Expand Lugs Slightly For Firm Mechanical Fit to Core.
2. Secure Lugs Firmly To Core With Item 4 (Insulex-U85) As Shown.
3. Bake For 2 Hours At 250° F.
4. Wind Coil As Above.
5. Solder Leads To Terminals.
6. Dip Unit In Item 4 (Insulex-U85).
7. Bake For 2 Hours At 250° F.
8. Scrape Terminals & Pigtail Free Of Insulex.
9. Test As Shown.
10. Cut Pigtails OFF at Terminals.



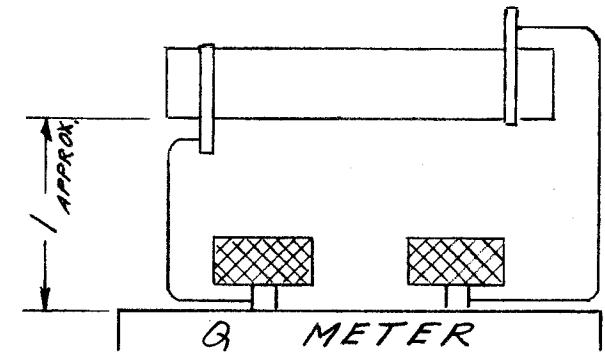
TEST DATA

Meter-Boonton "Q" Meter, Type 160A Or Equivalent.

SPECIFICATIONS

L - 185 uhy ± 15 uhy
Q - 50 Or Greater
F - 790 KC

SET UP



NOTICE TO PERSONS RECEIVING THIS DRAWING

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MAMARONECK, NEW YORK

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 5	BS-100	SOLDER, SOFT	
X 4	GL-104-2	INSULEX, U-85	
2 3	TE-153-1	TERMINALS	
X 2	WI-107-7	WIRE	
1 1	CI-112-Q-PROF	CORE	
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
CL-254 ASS'Y			
MATERIAL			
ATS-CU			
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	1	IT. 1 WAS CI-112-Q-2 R OF	3-26-65	13781	2 F.	JOB	JOB
A	2	SPEC (L) WAS 185UH ± 15UH	7-24-62	6948	G.S.	JOB	JOB
	1	APPROX ADDED TO 69 TURNS					

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
2	ATS-70CU-2			4-23-59
2	ATS-70CU			5/21/58

TOLERANCES: DEC. DIM. ±, FRAC. DIM. ±, ANGULAR DIM. ±

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

A-1544 B