

WINDING MACHINE DATA

.125 CAM, 49 CAM GEAR, 95 DRIVER GEAR

PROCEDURE

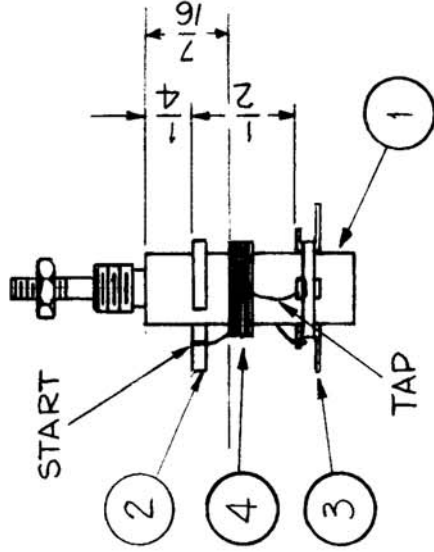
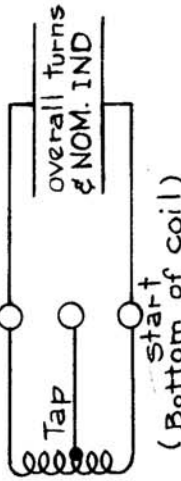
- 1- SECURE TERMINALS (ITEMS 2 & 3) TO COIL FORM (ITEM 1) WITH INSULEX (ITEM 7).
- 2- WIND 42 TURNS OF WIRE (ITEM 4) ON COIL FORM, TAP AT 16 FROM START.
- 3- STAKE COIL ENDS TO COIL FORM WITH Q MAX. (ITEM 6).
- 4- SOLDER COIL LEADS TO TERMINALS.
- 5- PAINT COIL WITH INSULEX (ITEM 7).
- 6- BAKE COIL FOR 1/2 HOUR AT 210°F.
- 7- TEST ON BOONTON Q-METER, MODEL 160A OR EQUIV.

TEST DATA

NOM. IND. \rightarrow , W/O CORE - 25.5 uhy (23.5 - 27.5)

TEST F = 2.5 mcs

Q = 60 or GREATER



REQ. PER UNIT	USED ON
2	ASBY. NO.
	DATE
	8-27-59

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X	7	GL-104-2	INSULEX, U-85
X	6	GL-102	LACQUER, Q MAX.
X	5	BS-100	SOLDER, SOFT
X	4	WT104-541-DSQS	WIRE, LITZ
1	3	TE-170-3	TERMINAL, COLLAR
1	2	TE-153-2	TERMINAL, RING TYPE
1	1	CF-107-ZN	COIL, FORM W/CORE

REG. ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE		THE TECHNICAL MATERIEL CORP.	
		MAMARONECK, NEW YORK	
		CL-184 ASSEMBLY	
		(COIL, R.F. TUNED, 2-4.3 MC)	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
		J.C. Biele	JCB
FINISH & SPEC. NO.		FINAL APPROVAL	
		A-1754 A	

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	ON TEST DATA Q WAS 60	7-7-61	5192	GDL	JCB	
1	DIMENSION 7/16 ADDED					
TOLERANCES						
SCALE: Do Not SCALE						
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES.						
DEC. DIM. \pm						
FRAC. DIM. \pm						
ANGULAR DIM. \pm						