

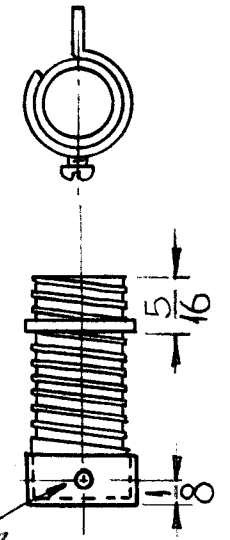
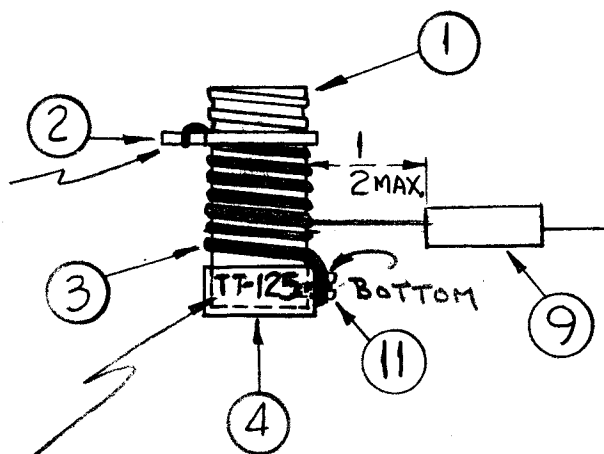
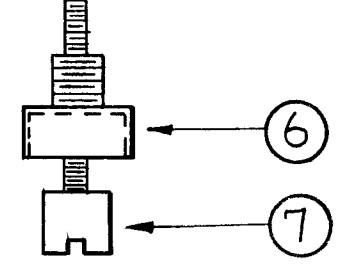
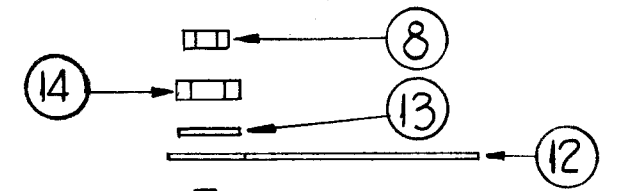
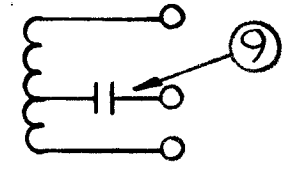
A-2039 A

**TEST DATA**

L-.40(.39-.41)Microhenries in Air  
 Q-170 or Greater  
 FREQ. (TEST)-25 Mcs  
 OPER. FREQ. 16-32 Mcs.

PROCEDURE

1. Secure Terminal Ring (Item 2) And Bushing (Item 4) To Coil Form (Item 1) With Item 10 (GL-104-2) As Shown. Bushing Hole Must Be Kept 180° From Terminal Ring Extension. Do Not Allow Insulex To Form On Terminal Tip or Top End Of Coil Form.
2. Bake For 2 Hours At 250° F.
3. Using Existing Bushing Pilot Hole, Drill Thru One Side Of Coil Form With #48 (.076) Drill.
4. Wind 6-1/2 Turns of Wire on Coil Form as shown. Crimp and Solder Wire to Terminal ring as shown. Wind in CLOCKWISE DIRECTION.
5. Attach Wire, (Item 3) To Bushing Using Screw, (Item 11). Solder Joint With Item 5.
6. Solder Tap To Coil. 2 Turns From Bottom.
7. Coat Winding With Item 10 (GL-104-2).
8. Bake Unit For 2 Hours at 250° F.
9. Test Unit As Per Chart And Schematic Using Existing Terminal Leads. (NOTE: Use Boonton Q Meter Model 160 A or Equiv.)
10. Items 6, 7, 8, 12, 13, & 14 To Be Left As a Separate Ass'y., Inserted, But Not Secured In Coil.



This View Un-Assembled to show relationship between ring terminal extension & bushing hole.

Drill thru one side of coil form. #47 (.078) Dr.

START WINDING

STAMP TMC PART NO. HERE.

NOTICE TO PERSONS RECEIVING THIS DRAWING

THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from THE TECHNICAL MATERIEL CORPORATION to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.

Property of:

THE TECHNICAL MATERIEL CORPORATION  
 MAMARONECK, NEW YORK

1	14	NTH2528BC14	NUT, HEX	
1	13	LWI25MRN	LOCKWASHER, INTERNAL TOOTH	
1	12	TE-111-1	LUG, SOLDER	
1	11	SFBO256SN3	SCREW, THREAD CUTTING	
X	10	GL-104-2	INSULEX, U-85	
1	9	CM15B111J	CAPACITOR, MICA	
1	8	NTH0632BC8	NUT, HEX	
1	7	CI-109-7	CORE, TUNING	Red
1	6	SM-142	BUSHING, COIL FORM	
X	5	BS-100	SOLDER, SOFT	
1	4	SM-143-3	BUSHING, COIL FORM	
X	3	WL-100-4	WIRE, BUSS	
1	2	TR-153-3	TERMINAL, RING TYPE	
1	1	CF-124-1.125	COIL FORM	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK, NEW YORK			
STOCK SIZE			
TT-125 TRANSFORMER ASS'Y			
MATERIAL			
15.75 - 33.75 MC			
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
			CHECKER
			FINAL APPROVAL
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

A	ON BUILD-UP ITEM (11) WAS SP# 0348 SC 3 ON PROCEDURE ITEM 3 # 48 WAS # 47 & DIM (.076) WAS (.078)	7-13-61	5231	G.D.L.	JCB	J
	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°	SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES	1	CHG-1	T1105	12-15-60