

A-2128 F

COIL FORM ASSY

1. Split the terminal rings.
2. Cement rings to coil form with item 6 in position shown. **Note** that rings are on top of and follow a groove. (Lugs and area between lugs must be free of U-85)
3. Bake for 1 hour at 300° F. Cool at room temperature.

WINDING DATA

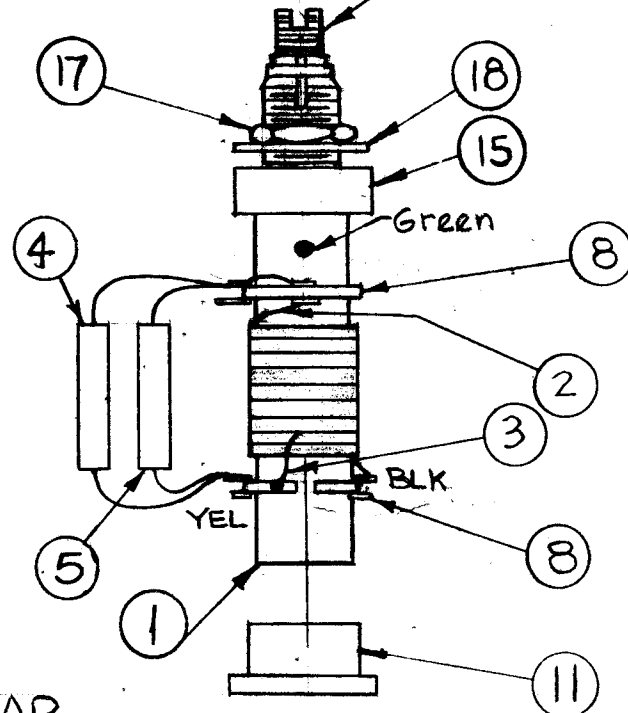
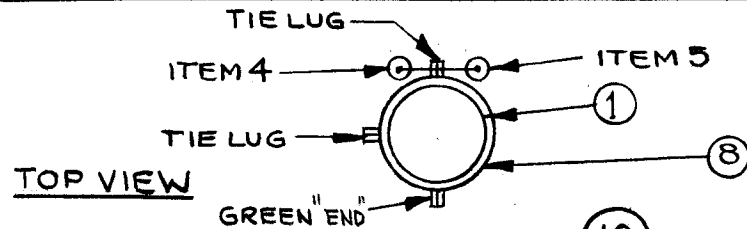
NOTE: All wire used must be free of kinks.

1. Wrap item 2 around black lug. Wind tightly in grooves 9 3/4 turns. End with wrap around on green lug and dress lead to next lug as shown. (Allow 2" lead each end for test purposes.)
2. Wrap item 3 around yellow lug. Solder tap to coil at 2 3/4 turns from start.
3. Coat winding & rings with item 6. (Lugs & wire on lugs must be free of U-85).
4. Bake for 1 hour at 300°F. Cool at room temp.
5. Solder connect leads as shown.
6. Solder connect capacitors in place as shown. Keep leads short but do not allow capacitors to touch a lug. Tie capacitors to coil with item 13. Seal knots with item 14.
7. Assemble item 10 & 15 TO COIL. CEMENT ITEM 15 WITH ITEM 12
8. Tack item 11 to form with item 14.

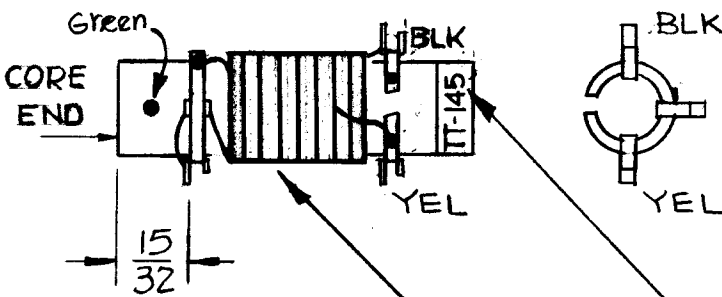
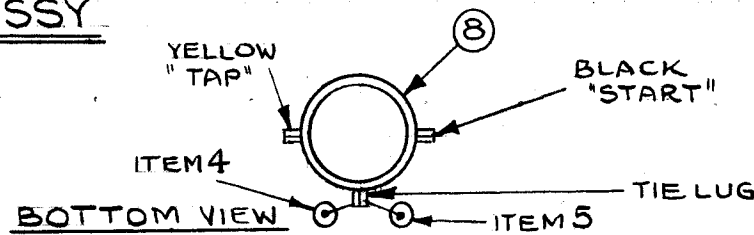
TEST DATA w/o core

L- 0.76 uh (0.68-0.84) L2-0.50uh (0.45-0.55)
 Q- 225 or greater
 F- 25 MC

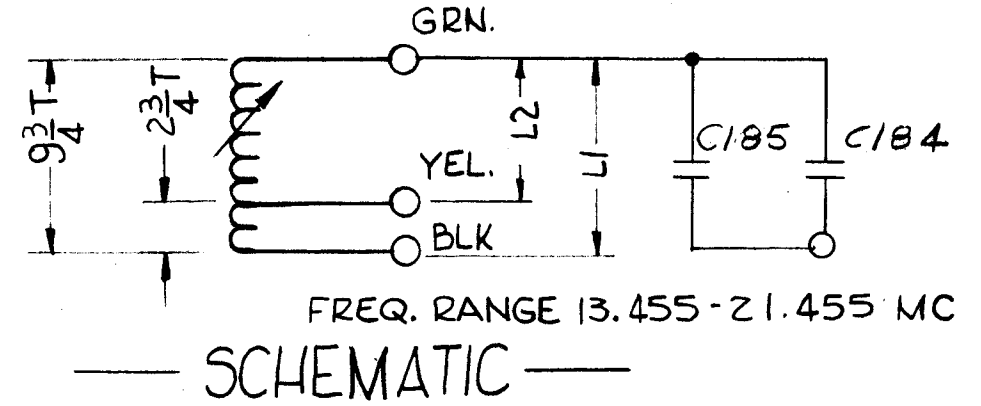
USE BOONTON Q METER 160A OR EQUIV.



COLLAR ASSY



NOTE:
 FOR IDENTIFICATION, STAMP THE NUMBER TT-145 ON ITEM 19 & ATTACH TO COIL AS SHOWN.



X	19	TA-101-1	TAPE, FIBERGLASS, ADHESIVE	
1	18	LWI25MRN	LOCKWASHER, INTERNAL TOOTH	
1	17	NT-102	NUT, HEX	
	16			
1	15	SM-157	BUSHING COIL MTG	
X	14	GL-103	CEMENT, DUCO	
X	13	CD-101-1MW	CORD, LACING	BLACK
X	12	GL-111	CEMENT, INSA-LUTE	
1	11	FS-114-2	FASTENER, WELD NUT	
1	10	CI-109-8	CORE	
	9	DELETED		
2	8	TE-146-3	TERMINAL, RING	
X	7	BS-100	SOLDER, SOFT	
X	6	GL-104-2	INSULEX, U85	
1	5	CC46SH331J	CAPACITOR, FIXED	C185
L	4	CC32SH101J	" "	C184
X	3	WL-100-7	WIRE, BUSS-BAR #22	
X	2	WL-100-6	" " " #20	
1	1	PX-323	COIL FORM	

REQ.	ITEM	PART NO.	STRUMER DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
TT-145 ASS'Y				
COIL, RF, TUNED, BAND 5				
MATERIAL			RUIZZO HQ JMA BP	
TYPE & TEMPER		HEAT TREAT. SPEC.		FINAL APPROVAL
FINISH & SPEC. NO.		ELEC. DES. APP.		MECH. DES. APP.

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
F	TOP & BOTTOM VIEWS ADD. TO COLLAR ASSY. IT. 9 TE-146-2A DELE, IT. 8 WAS REQ.	8.6.64	11801	NB	R.P.	
E	ITEM #10 WAS CI-109-19	10-4-63	10152	HP	JMP	
D	PICTORIAL CLARIFIED (COLOR)	9-27-63	10084	HP	JMP	
C	PICTORIAL CLARIFIED	4-30-63	8789	PC	JMP	
B	ADDED: ITEM (19), 15/32 DIM (RIGHT SIDE)	3-5-63	8402	PC	JMP	
A	ITEM 13 WRS CD-101-3-MW					
	SYMBOLS, C185 WAS C163 C184 WAS C164	1-22-63	8031			

UNLESS OTHERWISE SPECIFIED:		SCALE:	
DIMENSIONS ARE IN INCHES		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES	
TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°			

1	GPR-92	HF OSC	T123	10-16-62
REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.	DATE
USED ON				