

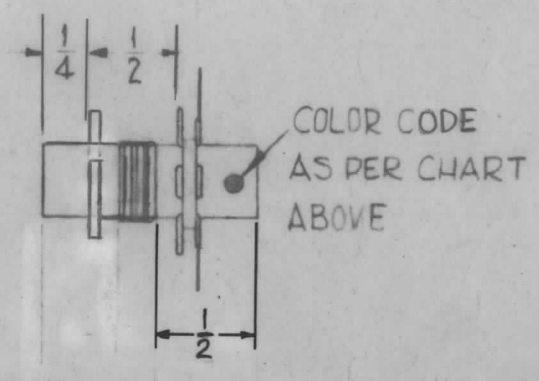
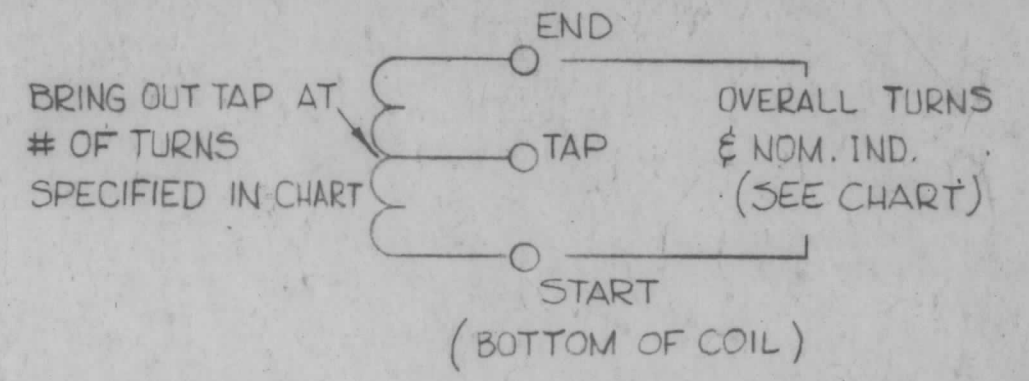
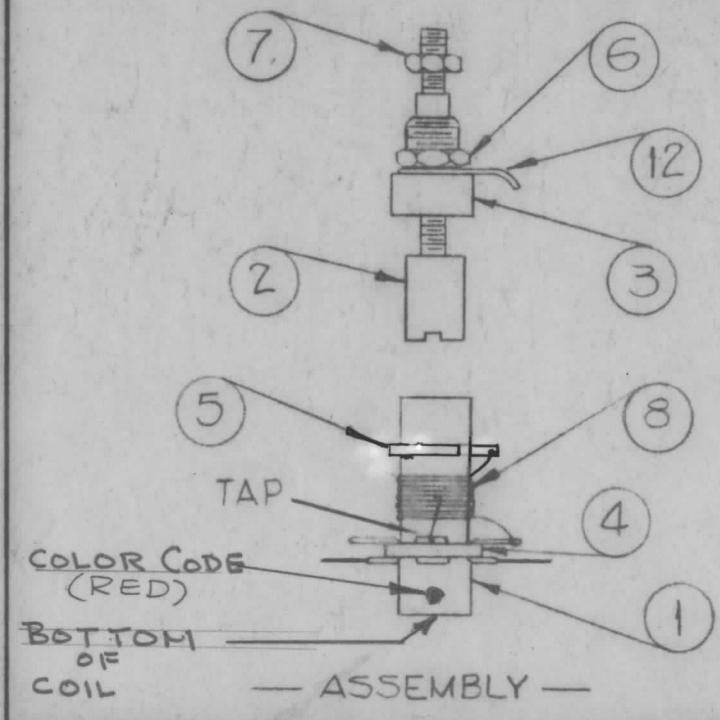
D	TMC MFG. NO.	NO. OF COIL TURNS OVERALL	BRING OUT TAP AT— (NO. OF TURNS)	NOM. IND. O/A W/O CORE (Uhy)	TEST FREQ (MCS)	Q AT TEST FREQ MUST BE GREATER THAN	QUAN PER UNIT	BAND FREQ (MCS)	BAND	COLOR CODE	SCHEM SYM.	TMC PART NO.
	A-3031	20	14	3.7(3.4-4.3)	7.9	70	3	4-8	3	RED	T-4,8,12	TT-137

A-3031

WINDING MACHINE DATA  
CLOSE WOUND, SINGLE LAYER

PROCEDURE

1. SECURE ITEMS 4 & 5 TO COIL FORM (ITEM 1) WITH INSULEX (ITEM 10).
2. WIND REQ. NUMBER OF TURNS OF ITEM 8 ON COIL FORM AND BRING OUT TAP WHEN REQ. AS PER CHART.
3. STAKE COIL ENDS TO COIL FORM WITH Q-MAX (ITEM 9).
4. SOLDER COIL LEADS AS SHOWN
5. BAKE COIL FOR 1/2 HOUR AT 210° F.
6. PAINT COIL WITH INSULEX (ITEM 10).
7. DO NOT ALLOW INSULEX TO FORM ON TOP END OF COIL FORM WHERE BUSHING WILL BE ASSEMBLED
8. TEST UNIT AS PER CHART AND SCHEMATIC, WITHOUT CORE. (USE BOONTON Q-METER MODLE 160A OR EQUIV.)
9. ASSEMBLE AND SECURE ITEMS 2, 3 & 12 WITHIN COIL FORM. WIRE ITEM 12 (SOLDER LUG) TO ITEM 5 (TERMINAL RING) WITH BUSS-BAR AND SOLDER.



X	13	WL-100-7	WIRE, BUSS
1	12	TE-104-5	LUG, SOLDER
X	11	BS-100	SOLDER, SOFT
X	10	GL-104-2	INSULEX, U-85
X	9	GL-102	LACQUER, Q-MAX.
X	8	WI-107-15	WIRE #34 DSC
1	7	NTH0632BN8	NUT, HEX
1	6	NTH2528BN4	NUT, HEX
1	5	TE-153-2	TERMINAL, RING TYPE.
1	4	TE-170-3	TERMINAL, COLLER
1	3	SM-110	BUSHING, COIL MTG.
1	2	CI-109-7	CORE, TUNING
1	1	CF-133-1.125	COIL FORM

D	ON COLOR CODE ASSY, IT(5) RELOCATED (ERROR)	5-3-65	13972			
C	IT. 4 & IT. 5 ON PICT. RELOCATED TO IT. 8 DESC. #34 DSC ADDED	1.5-65	13177			
B	7/16 DIM. DELETED 1/2 DIM. ADDED	1-16-62	6200			
A	ON SCHEM. SYM. T-4,8,12 ADDED "Q" WAS 90 ITEM 10 WAS CF-123	8/31/61	5520			

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

3	GPE-1			6-20-61
REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.	DATE
	USED ON			

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
TT-137 ASSY			
MATERIAL			
		R 6220	
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN
			CHECKER
			FINAL APPROVAL
			A-3031
			D