



COLORS SHOWN ARE TERMINAL BOARD COLORS

GLUE BUSHINGS TO COIL FORM WITH ITEM 3.

RED (START PRI.)

BLUE

BLACK (START SEC.)

GREEN

TAP AT 30T LEADS & TAPS TO BE APPROX. 2 1/2" LONG.

A4515

REVISIONS

SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X	EXP. RELEASE	10-22-66	X	WHD		
Ø	ORIGINAL RELEASE FOR PRODUCTION	11/10/66	Ø	RME		<i>file</i>

TEST DATA (W/O CORE)

WINDING	$L_{ph}$	Q	F
PRI	415 (395-435)	90 OR GREATER	790 KHz
SEC	40 (36-44)	65 " "	2.5 MHz

WINDING DATA

PRIMARY: 1 PI - 190 TURNS OF ITEM 2 (UNIVERSAL WINDING)

SECONDARY: 1 PI - 60 TURNS OF ITEM 2 (UNIVERSAL WINDING). BRING OUT TAP AT 30 TURNS

1 STAKE LEADS & TAP TO COIL FORM WITH ITEM 3.

BAKE FOR 1/2 HOUR AT 215°F

2 SATURATE COILS WITH ITEM 4. BAKE FOR 1/2 HOUR AT 215°F

3 TEST AS PER CHART

4 ASSEMBLE AS INDICATED AT LEFT

WINDING MACHINE DATA

CAM GEAR - 104

DRIVER GEAR - 68

CAM - .187

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
2	9	NTH0632BN8	NUT, HEX	
2	8	NT102	NUT, HEX	
2	7	LWI25LRN	WASHER, LOCK	
2	6	CI109-5	CORE	
2	5	SM110	BUSHING, COIL MTG	
X	4	GL102	Q MAX	
X	3	GL103	CEMENT, DUCO	
X	2	WI104-5A1SCQS	WIRE, LITZ 5/41 SCQS	
1	1	CF117-2-5	COIL FORM	

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
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O. POSE LIST OF MATERIAL

MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK
FINISH	TITLE TRANSFORMER ASS'Y (IF)

1	GPR92B	
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	
	A	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN	DATE	FINAL APPROVAL	DATE
		WHD	10-22-66	<i>Joe M...</i>	11/8/66
		CHECKED	DATE		
		<i>JK</i>	10/29/66		
		ELECT. DES.	DATE		
		<i>WHD</i>	10-31/66		
		MECH. DES.	DATE		

NOTES

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DECIMALS	FRACTIONS
.X ± .05	± 1/64
.XX ± .01	ANGLES
.XXX ± .005	± 0° 30'

TOLERANCES

ML SPR