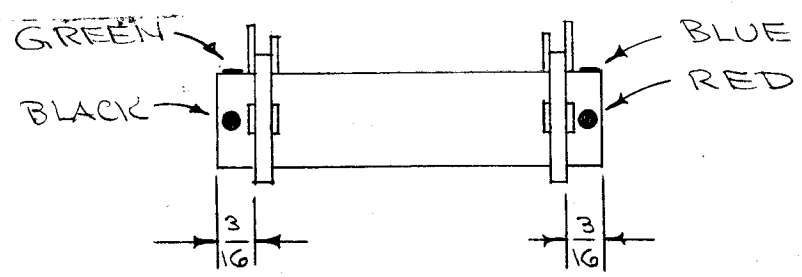


A-892-F



COIL FORM ASSY.

- 1- CEMENT TERMINAL RINGS TO COIL FORM WITH ITEM 4 IN POSITION SHOWN ABOVE.
- 2- COLOR CODE COIL FORM AS ABOVE.

COIL MACHINE DATA

SECONDARY		PRIMARY	
RACK GEAR	100	DRIVER GEAR	95
RACK DRIVER	40	CAM GEAR	49
CAM	.125	CAM	.125
CAM GEAR	49		
DRIVER GEAR	95		

WINDING DATA

- 1- SECONDARY (WIND ON BEFORE PRIMARY). STARTING AT GREEN LUG WIND ON 160 1/4 TURNS OF ITEM 2. (PROGRESSIVE UNIVERSAL WINDING). END AT BLACK LUG.
- 2- PRIMARY- STARTING AT RED LUG WIND ON 29 3/4 TURNS OF ITEM 3 (UNIVERSAL WINDING). END AT BLUE LUG.
- 3- STAKE LEADS TO COIL FORM WITH ITEM 4. STRIP, TIN & SOLDER LEADS TO LUGS.
- 4- BAKE FOR 1/2 HOUR AT 215° F.
- 5- SATURATE COILS WITH ITEM 5. BAKE FOR 1/2 HOUR AT 215° F.
- 6- REPEAT STEP 5.
- 7- SOLDER CONNECT TEST LEADS TO LUGS (APPROX 1/4" #22 BUSS BAR.). TEST AS BELOW. REMOVE TEST LEADS.

TEST DATA W/O CORE

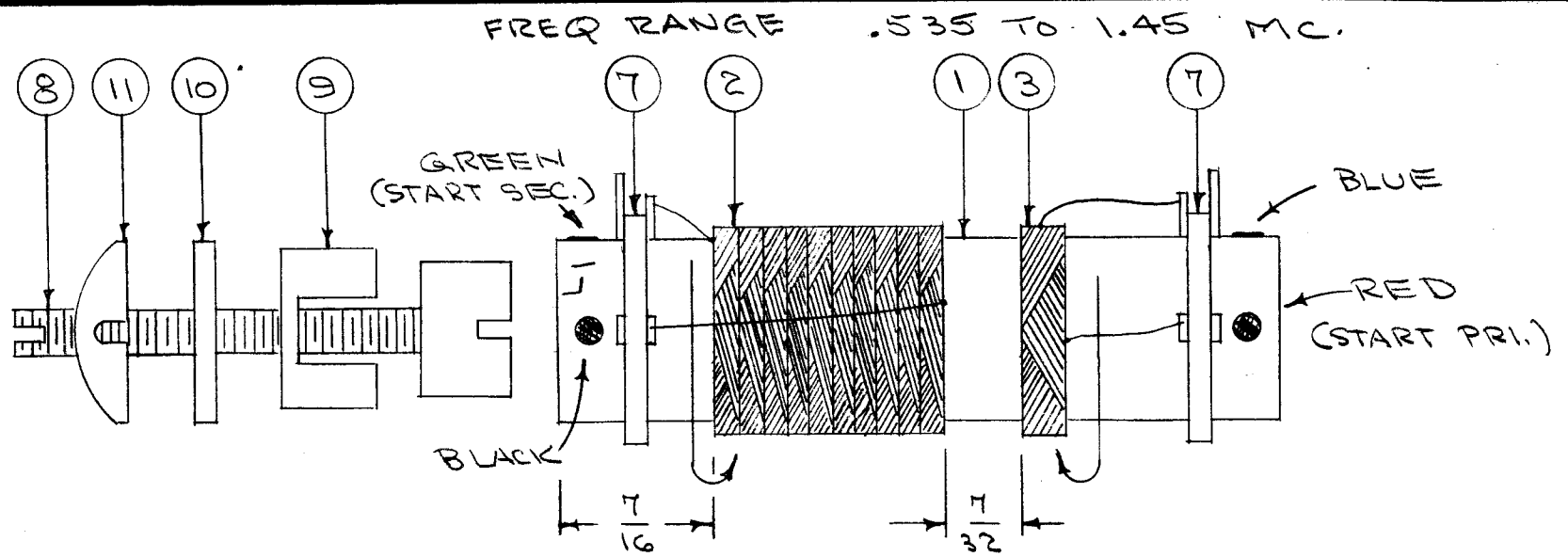
WINDING	* L _{uh}	* Q	f	RR APPROX.
SEC.	195 (185 - 205)	60 OR GREATER	790 KC	10.0
PRI.	17.5 (16.7 - 18.3)	45 " "	2.5 MC	2.0

* USE BOONTON Q METER 160A OR EQUIVALENT
 ** USE SIMPSON OHMMETER 260 OR EQUIVALENT

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
F	2	Q OF 45 WAS 50	11/5/56	6	16	P.L.K.	AJT
E	1	REBORN COMPLETE REVISION	8/1/56	5	16	P.L.K.	AJ

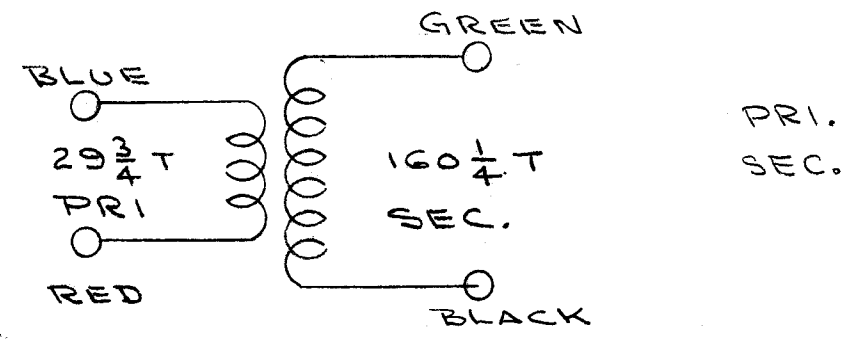
TOLERANCES		SCALE:
DEC. DIM. ±		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES
FRAC. DIM. ±		
ANGULAR DIM. ±		

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	GPR-90	297		8-1-56



NOTE - COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 8-9-10-11 ARE CEMENTED TO COIL FORM WITH ITEM 12.

FOR IDENTIFICATION, STAMP THE NUMBER L1 ON THE COIL FORM IN ANY CONVENIENT SPOT.



FREQ. RANGE - .535 - 1.45 MC

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 12	GL-111	CEMENT, "INSA-LUTE"	
1 11	FS-112	FASTENER	
1 10	WA-125	WASHER, FIBER	
1 9	NT-113	NUT, SPEED	
1 8	CI-109-11	CORE	
2 7	TE-146-2A	TERMINAL RING	
X 6	BS-100	SOLDER, SOFT	
X 5	GL-102	Q MAX	
X 4	GL-103	CEMENT, DUCO	
X 3	WI-107-17	WIRE, MAGNET #36 DSC	
X 2	WI-104-341-SSE	WIRE, LITZ 3/41 SSE	
1 1	CF-112	COIL FORM	

THE TECHNICAL MATERIEL CORP.			
MAMARONECK, NEW YORK			
STOCK SIZE		ANT. TRANS. ASSY L1	
MATERIAL		BAND 1 GPR-90	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
		P.L.K.	A.J.J.
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.