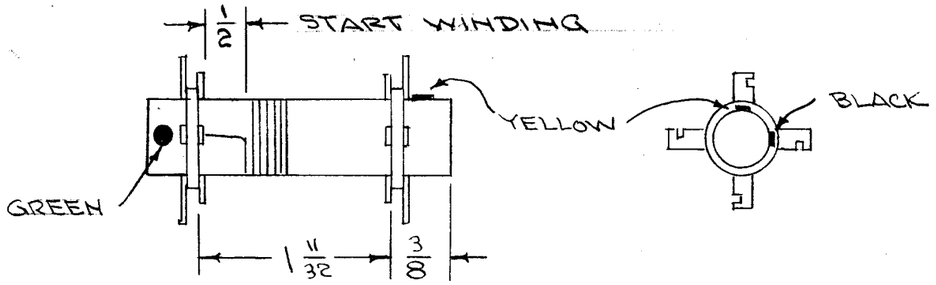
A-899 L



COIL FORM ASSEMBLY

1- CEMENT TERMINAL RINGS TO COIL FORM WITH ITEM 3 IN POSITION SHOWN ABOVE.
2- COLOR CODE COIL FORM AS ABOVE

WINDING MACHINE DATA

RACK GEAR	48
RACK DRIVER GEAR	80

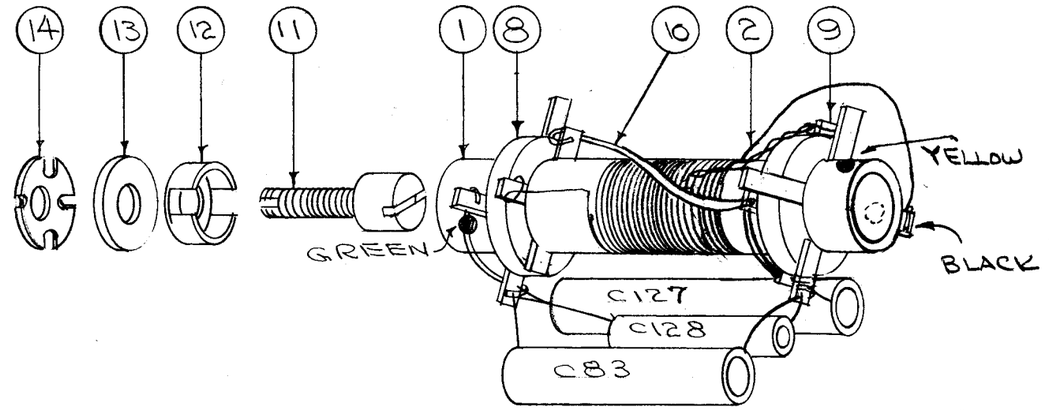
WINDING DATA

1- STARTING AT GREEN LUG WIND ON 22 3/4 TURNS OF ITEM 2.
2- BRING OUT 1" LONG TWISTED TAP AS SHOWN.
3- CONTINUE WINDING FOR 7 3/4 TURNS MAKING A TOTAL OF 30 1/2 TURNS.
4- STAKE ENDS TO COIL FORM WITH ITEM 3.
5- STRIP, TIN & SOLDER LEADS TO LUGS AS SHOWN.
6. BAKE FOR 1/2 HOUR AT 215°F. AS SHOWN.
7- SATURATE COIL WITH ITEM 5. BAKE FOR 30 MIN. AT 215°F.
8- SOLDER 1" OF BUSS BAR TO EACH LUG FOR TEST.
9- MAKE TESTS (SEE CHART). REMOVE TEST LEADS.
10- SOLDER CAPACITORS IN PLACE AS SHOWN.
11. TIE CAPACITORS TO COIL W/ ITEM 16, SEAL KNOTS W/ ITEM 3.

TEST DATA W/O CORE

WINDING	L μh *	Q *	F
L1	8.2 (7.8-8.6)	100 OR GREATER	7.9 MC
L2	5.5 (5.25-5.75)	85 " "	"

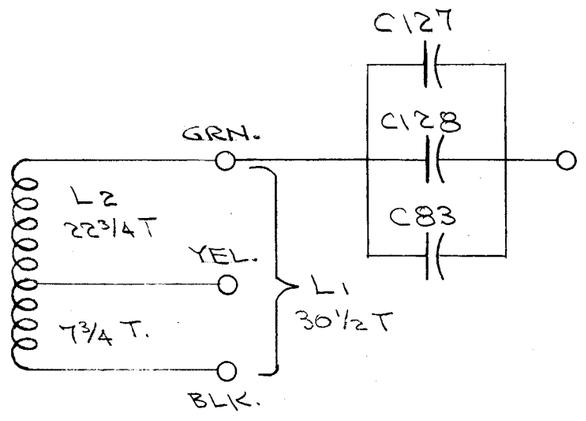
* USE BOONTON Q METER 160 A OR EQUIVALENT.



NOTE: KEEP CAPACITOR LEADS SHORT BUT DO NOT ALLOW ANY CAPACITOR TO TOUCH A LUG.

COIL MUST BE INSTALLED IN CHASSIS BEFORE ITEMS 11-12-13-14 ARE CEMENTED TO COIL FORM WITH ITEM 15.

FOR IDENTIFICATION STAMP THE NUMBER L15 ON COIL FORM IN ANY CONVENIENT SPOT.



FREQ. RANGE- 3.655 TO 6.055 MC.

X	16	CD-101-1MW	COED, LACING	
X	15	GL-111	CEMENT, "INSA-LUTE"	
1	14	FS-112	FASTENER	
1	13	WA-125-2	WASHER, FIBER	
1	12	NT-112	NUT, SPEED	
1	11	CI-109-10	CORE	
X	10	WL-100-5	WIRE, BUSS BAR #18	
1	9	TE-146-4	RING, TERMINAL	
1	8	TE-146-3	" " "	
1	7	CC35UJ181J	CAPACITOR, FIXED	C128
2	6	CC45UJ751J	" " "	C127 C83
X	5	GL-102	Q MAX	
X	4	BS-100	SOLDER, SOFT	
X	3	GL-103	CEMENT, DUPONT	
X	2	WI-107-11	WIRE, MAGNET	
1	1	CF-112	COIL FORM	
REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
L		IT. 16 WAS CD101-3MW	10/19/66	17040	RME		
K	2	ITEM 16 ADDED	5-26-60	2380	CY	QCB	
	1	STEP 11 ADDED					
J	3	CHANGE TITLE	5/19/60	2271	CY	QCB	
	2	NT-112 WAS NT-113					
	1	WA-125-2 WAS WA125					
H	1	Q of 85 WAS 115	11/15/56	8	[illegible]	P.L.K.	A.J.J.
G	1	COLOR CODE CLARIFIED	10/16/56	7	[illegible]	P.L.K.	A.J.J.
F	1	REDRAWN COMPLETE REVISION	7/25/56	6	[illegible]	P.L.K.	A.J.J.

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.	SYMBOL NO.	DATE
1	GPR-90-2XD			5-23-60
1	GPR-90	297	L15	7-26-55

USED ON

STOCK SIZE

MATERIAL

TYPE & TEMPER | HEAT TREAT. SPEC.

FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK. NEW YORK

COIL, RF, TUNED, OSCILLATOR, BAND 3

DRAWN	CHECKED	FINAL APPROVAL
CDD 7/26/56	[illegible]	A.J.J.
ELEC. DES. APP.	MECH. DES. APP.	A-899 L
P.L.K.		