



REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
	X1	REDDRAWN WITH CHANG.	10/3/69			
	Ø	ORIG RELEASE FOR PROD	4/3/70		CV	

PART NO.	ITEM 1	NO. OF TURNS SECONDARY	NO. OF TURNS PRIMARY	SYM. NO.
TT303-1	CF141-2	18	2	T3
TT303-2	CF141-1	10	2	T4

PROCEDURE

- ASSEMBLE COIL FORM ITEM 1 ON A .250 MANDREL CAPABLE OF HOLDING FORM SECURE AND UNDAMAGED AGAINST WINDING TENSION OF 2.5 TO 3.0 INCH-POUNDS AS MEASURED ACROSS MANDREL WITH INCH-POUNDS SCALE
- WIND SECONDARY USING ITEM 3 IN START THREAD OF ITEM 1. SECURE START OF WINDING USING ITEM 2 SO THAT START THREAD IS VISIBLE. SET TENSION AT 2.5 TO 3.0 INCH-POUNDS AND HAND WIND REQUIRED TURNS ENDING IN LINE WITH START THREAD. TAPE END OF WINDING WITH ITEM 2 BEYOND LAST TURN. USING ITEM 4 WIND TIGHTLY IN SAME DIRECTION THE CORRECT NUMBER OF PRIMARY TURNS EVENLY SPACED AND SECURE WITH ITEM 2. SO THAT ALL TURNS ARE VISIBLE. BAKE AT 215°F FOR 1/2 HOUR TO REMOVE MOISTURE.
- COAT EXPOSED COIL TURNS WITH ITEM 5. DO NOT COAT HOLDING TAPE OR MACHINED ENDS OF ITEM 1. BAKE AT 215°F FOR 1 HOUR.
- CAREFULLY REMOVE HOLDING TAPE AT BOTH ENDS. APPLY NEW ITEM 2 DIRECTLY OVER COIL TURNS AND FLUSH WITH ENDS OF WINDING. SEAL WITH ITEM 5. TRIM ALL LEADS TO 2". STRIP AND TIN TO WITHIN 3/8" OF COIL FORM. TWIST AND SOLDER PRIMARY AND SECONDARY LEADS TOGETHER AT FINISH THREAD. MARK WITH TMC P/N.

X	6	BS 100	SOLDER, TIN ALLOY	
X	5	GL 104-2	INSULEX, U 85	
X	4	WI 141-26-9	WIRE, ELEC. MAG. INS.	
X	3	WI 141-22-9	WIRE, ELEC. MAG. INS.	
X	2	TA 101-1	TAPE, FIBERGLASS	
1	1	SEE CHART	COIL FORM, THREADED	
REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.

POSE

LIST OF MATERIAL

1	HFR-4	AX5005
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		FINAL APPROVAL	DATE
DECIMALS	FRACTIONS	ELECT. DES.	DATE
.X ± .05	1/64	CHECKED	DATE
.XX ± .01	TOLS. ANGLES	DRAWN	DATE
.XXX ± .005	0° -30'		DATE
MATERIAL			
FINISH			

THE TECHNICAL MATERIEL CORP.
 MAMARONECK, NEW YORK

TRANSFORMER, ANTENNA

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	TT 303	Ø

SCALE SHEET OF