

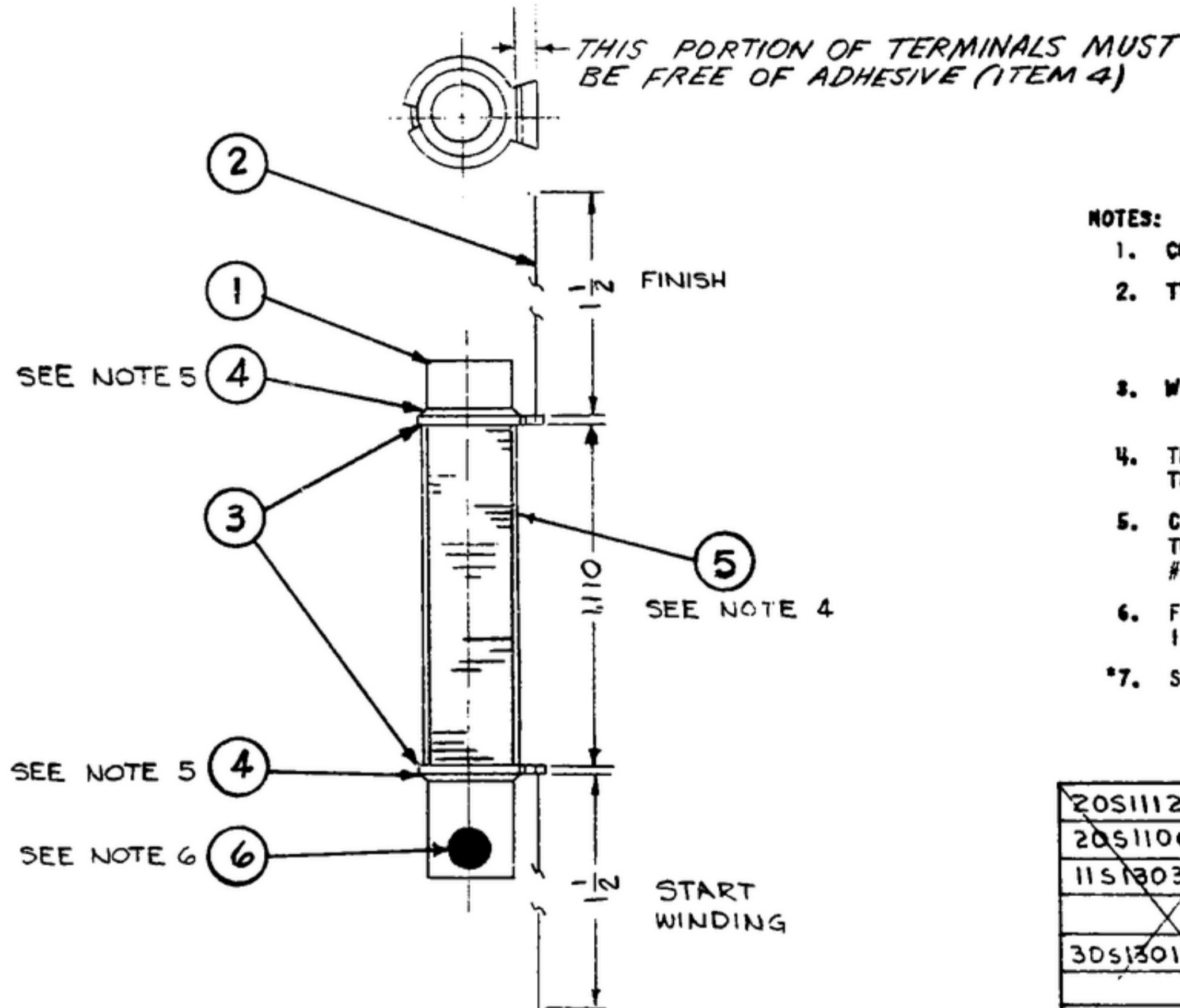
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NOTE:

*FOR INFORMATION ONLY. CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS

SWE APPROVAL		REVISIONS			
SYM	DATE	DESCRIPTION	DATE	APPROVAL	
A1	16 DEC 59	REVISED & REDRAWN		Q2AZB-PC-59-41 -51 REVO PHE	



NOTES:

- COIL TO BE WOUND TO MEET ELECTRICAL REQUIREMENTS SPECIFIED ON SM-D-249095.
- TYPICAL WINDING DATAS:
NO. OF TURNS: 44
TYPE OF WIND: SINGLE LAYER VARIABLE PITCH.
- WIRE: SINGLE STRAND OF NO. 32 AWG WIRE WITH HEAVY POLYURETHANE FILM INSULATION; DRAWN & ANNEALED. COPPER. AS SUPPLIED BY BELDEN MFG. CO., CHICAGO, ILL. OR EQUAL.
- THE COIL WINDING SHALL BE SUFFICIENTLY COATED TO FIRMLY ANCHOR ALL WIRES. COATING MATERIAL (ITEM 5) TRANSPARENT "Q" MAX. #A27 TO BE SUPPLIED BY COMMUNICATIONS PRODUCTS CO. INC., MARLBORO, N.J. OR EQUAL.
- CEMENT TERMINAL (ITEM 3) TO COIL FORM (ITEM 1) BY APPLYING THE BONDING AGENT #R313 (ITEM 4) ONLY ON THE OUTER SIDE OF TERMINALS ADJACENT TO THE EXTREMITIES OF THE COIL FORM AS SHOWN. BONDING AGENT #R313 AS SUPPLIED BY CARL H. BIGGS CO., LOS ANGELES, CALIF. OR EQUAL.
- FOR IDENTIFICATION USE COLOR CODING LACQUERS (ITEM 6) AS SUPPLIED BY CAPITAL CHEMICAL CO., CHICAGO, ILL. OR EQUAL. APPLY YELLOW COLOR DOT (1/8 DIA.) ONTO COIL FORM LOCATED AS SHOWN.
- S.W.E. WINDING PROCEDURE FOR 4-8 MC. R.F. COIL SPECIFIED ON 12P205236.

*SWE PART NO.	ITEM	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC	NOTES
20S111266-5	6	AS REQ'D		LACQUER, COLOR CODING YELLOW		TT-L-31	6
20S110664-5	5	AS REQ'D		LACQUER			4
11S130318-7	4	AS REQ'D		ADHESIVE			5
	3	2	SM-B-85398	TERMINAL			5
30S130131-32	2	1	SM-B-283290-1	WIRE, MAGNET (45 IN TYP)		MIL-W-583	3
	1	1	SM-B-249171-1	FORM, COIL			

LIST OF MATERIAL

UNLESS OTHERWISE SPECIFIED				COLLINS RADIO CO.		DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY
DIMENSIONS ARE IN INCHES				CEDAR RAPIDS, IOWA		
TOLERANCES ON FRACTIONS DECIMALS ANGLES				14214-PH-51-93		
± 1/64 ± .005 ±				SIGNAL CORPS		
DRAWN BY L BRIGGS				REVIEWED PME		SM-B-283290
CHECKED BY BG				APPROVED HLY PME		
CHIEF DRAFTS				DATE 14 MAR-58		
ENG APPROVAL				SCALE 2/1		
NEXT ASSY	USED ON	NEXT ASSY	USED ON			
*SWE APPLICATION		APPLICATION				