

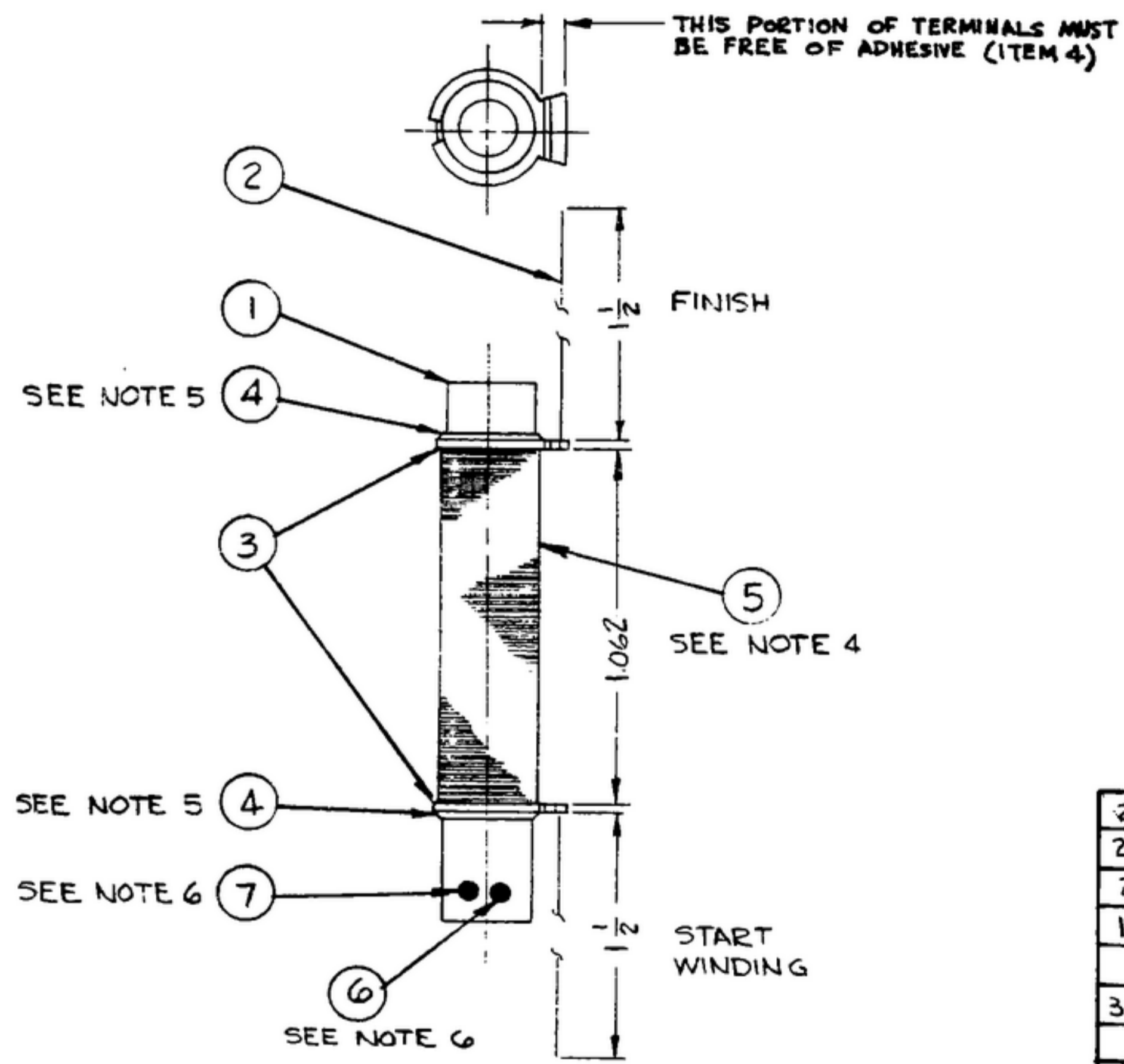
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NOTE:

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

SWE APPROVAL		REVISIONS		
SYN	DESCRIPTION	DATE	APPROVAL	
A <sub>1</sub>	A <sub>1</sub> -REVISED & REDRAWN	16 DEC 59	42428-PC-59-A -51 REV'D PHE	



NOTES:

1. COIL TO BE WOUND TO MEET ELECTRICAL REQUIREMENTS SPECIFIED ON SM-D-249090.
2. TYPICAL WINDING DATAS:  
NO. OF TURNS: 23  
TYPE OF WIND: SINGLE LAYER VARIABLE PITCH
3. WIRE: SINGLE STRAND OF NO. 28 AWG WIRE WITH SINGLE POLYURETHANE FILM INSULATION. DRAWN & ANNEALED COPPER. AS SUPPLIED BY BELDEN MFG. CO. CHICAGO, ILL. OR EQUAL.
4. 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., MARLBOROUGH, N.J. OR EQUAL.
5. 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.
6. FOR IDENTIFICATION USE COLOR CODING LACQUERS (ITEMS 6 & 7) AS SUPPLIED BY CAPITAL CHEMICAL CO., CHICAGO, ILL. OR EQUAL. APPLY BLACK & BLUE COLOR DOTS (1/8 DIA.) ONTO COIL FORM LOCATED AS SHOWN.
7. S.W.E. WINDING PROCEDURE FOR 8-16 MC ANT. COIL SPECIFIED ON 12P205231.

*SWE PART NO.	ITEM	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC	NOTES
205111266-7	7	AS REQ'D		LACQUER, COLOR CODING BLUE		TT-L-31	6
205111266-1	6	AS REQ'D		LACQUER, COLOR CODING BLACK		TT-L-31	6
205110664-5	5	AS REQ'D		LACQUER			4
115130318-7	4	AS REQ'D		ADHESIVE			5
	3	2	SM-B-85398	TERMINAL			5
305130130-28	2	1	SM-B-283285-1	WIRE, MAGNET (26 IN TYP)		MIL-W-583	3
	1	1	SM-B-249171-2	FORM, COIL			

LIST OF MATERIAL

UNLESS OTHERWISE SPECIFIED				COLLINS RADIO CO.		DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES	
DIMENSIONS ARE IN INCHES				CEDAR RAPIDS, IOWA			
TOLERANCES ON FRACTIONS DECIMALS ANGLES				14214-PH-51-93			
± 1/64 ± .005 ±				SIGNAL CORPS		FORT MONMOUTH NEW JERSEY	
DRAWN BY L BRIGGS				REVIEWED PME			
SM-D-249090 SC-DL-248775				CHECKED BY BS		SM-B-283285	
NEXT ASSY USED ON NEXT ASSY USED ON				APPROVED HLY PME			
*SWE APPLICATION- APPLICATION				CHIEF DRAFTS			
ENG APPROVAL				DATE 11 MAR 58		SCALE 2/1	