

# COMMUNICATIONS DIVISION

PULSE INVERTER

015-0495-00

MANUFACTURING PROCEDURE



# C N A DIVISION

Redmond, Oregon

## PROCEDURE / PROCESS DOCUMENT

This procedure is for internal use only

Written by Carroll Piper 7-22-87  
Date

Reviewed by \_\_\_\_\_  
Date

### APPROVALS:

Product Line Manager \_\_\_\_\_  
Date

Manufacturing Engineering \_\_\_\_\_  
Date

Materials Manager \_\_\_\_\_  
Date

\_\_\_\_\_  
Date

\_\_\_\_\_  
Date

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to this procedure, or to order  
additional copies contact  
CNA Document Control.

PULSE INVERTER

015-0495-00



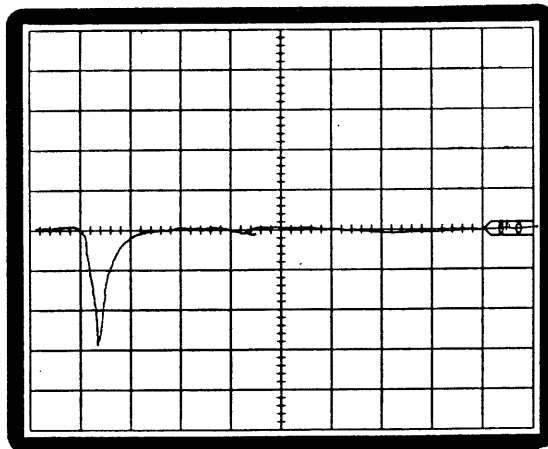
DOCUMENT NUMBER 02

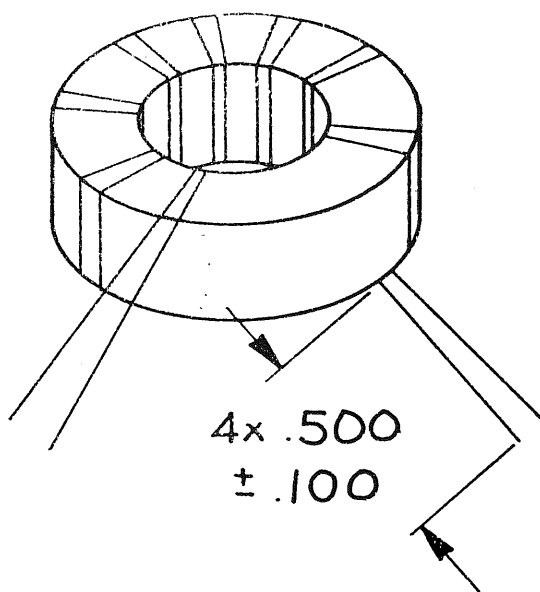
REVISION DATE 06/28/88

## PULSE INVERTER

015-0495-00

1. Twist 1 red and green lead of the transformer together.
2. Solder 1 terminal pin (214-0579-02 to the twisted pair.
3. Solder 1 red wire to center of BNC Female.
4. Put rubber washer over the threaded part of the BNC Female.
5. Put into housing, spade lug will fit opposite the set screw and lodge between flatside and case ground.
6. Tighten set screw.
7. Insert #18 tinned Buss wire into Male BNC connector, solder in and trim to about 1 inch.
8. Assemble Male BNC.
9. Insert Male BNC into housing and screw in set screw.
10. Solder green lead to #18 tinned Buss wire.
11. Hook inverter directly to 1503, then install approximately 3 feet of cable. Install 50 ohm terminator (011-0049-01) to cable then hook to scope. Scope settings are 2V per div at 20us. Should see a negative going spike.
12. Fill with enough RTV to partially cover the transformer and install cover and part number.





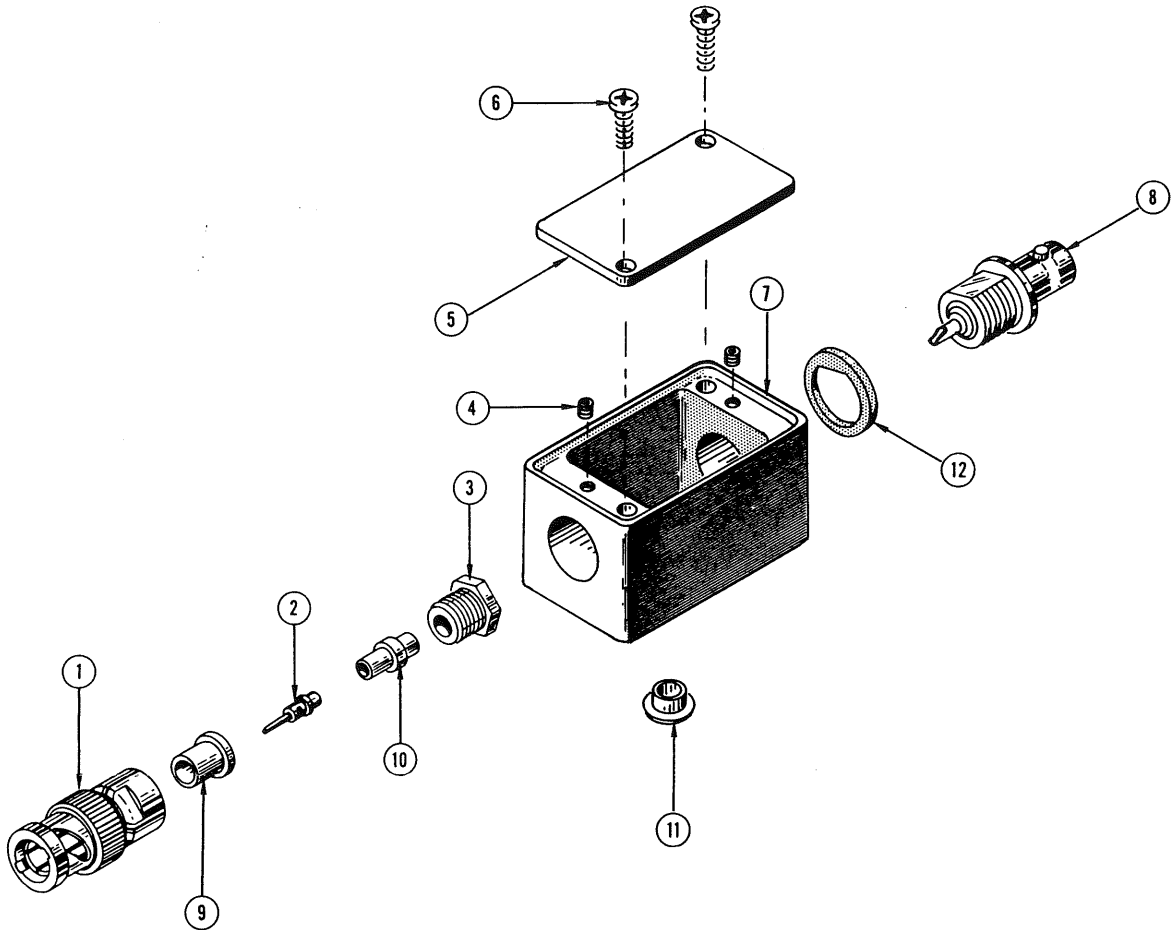
PROCEDURE :

1. WIND 8 BIFILAR TURNS ON ABOUT  $\frac{3}{4}$  OF CORE.
2. CUT LEADS PER DWG.
3. TIN  $.300 \pm \begin{smallmatrix} .050 \\ .100 \end{smallmatrix}$  (4x)

DATA :

CODE :  
 CORE NO. : 276-0640-00  
 WIRE SIZE : 26 AWG (RED & GREEN)  
 WIRE P/N :  
 NO. OF TURNS : 8 BIFILAR

# COUPLER, BNC, TEST SET (unwired) (Part No. 011-0081-00)



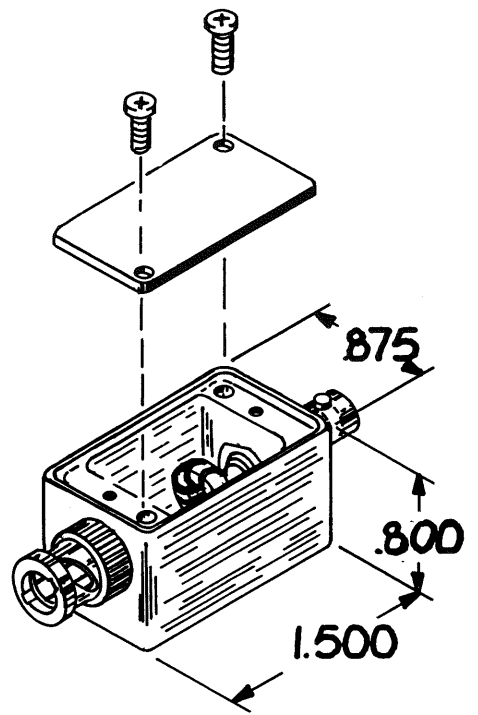
REF. NO.	PART NO.	SERIAL/MODEL NO.		QTY.	DESCRIPTION
		EFF.	DISC.		
1	134-0044-00			1	PLUG, probe, BNC
2	214-0109-00			1	PIN, probe contact, male
3	132-0081-00			1	NUT, BNC
4	213-0075-00			2	SCREW, set, 4-40 x 3/32 inch, HHS
5	200-0681-00			1	COVER, box
				-	mounting hardware: (not included w/cover)
6	213-0088-00			2	SCREW, thread forming, #4 x 1/4 inch, PHS
7	202-0095-00			1	BOX
8	131-0126-00			1	CONNECTOR, coaxial, , single contact
9	358-0072-00			1	BUSHING, insulator, ,
				-	0.323 inch long
10	166-0217-00			1	TUBE, spacer, insulator,
				-	plastic, 5/8 inch long
11	214-0271-00			1	BUTTON, plastic
12	210-0962-00			1	WASHER, plastic, 0.505 ID x
				-	0.688 OD

**DATA SHEET NO.**  
JUNE 1966  
  
062-0678-00  
(REVISED)

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