

01-105516

FORM E-277 10-46 SCHILLER-MILWAUKEE 1

EXPANDER COIL:

TIGHTLY

TEN STRANDS OF IT.# 1 ARE TWISTED TO FORM TWO 8 FOOT LONG CABLES. (USE A TWIST DRILL) COMPLETELY SLEEVE WITH IT.# 2 AND BEND INTO APPROX. SHAPE. THOROUGHLY COAT WITH RED GLYPTAL, USING A BRUSH, AND ALLOW TO DRY WHILE SUSPENDED FOR SEVERAL HOURS. APPLY SECOND COAT AND ALLOW TO DRY 8 HOURS. (IN APPROX. SHAPE)

GENEROUSLY COAT ONE SIDE OF IT.# 7 AND MAGNET POLE AT PROPER RADIUS WITH IT.# 6 DUCO CEMENT. PLACE IT.# 7 ON POLES AND IMMEDIATELY FASTEN IT.# 1 ON TOP WITH WIRE STAPLES, IT.# 5.

GLUE ON IT.# 8 WHERE LEADS COME OUT, FASTEN WITH MORE STAPLES, AND GENTLY HAMMER COIL FLAT.

COAT ENTIRE COIL WITH DUCO CEMENT AS PER DETAIL KEEPING AIR DUCTS AS CLEAN AS POSSIBLE.

AFTER 24 HRS. REMOVE STAPLES. CUT AWAY LOOSE PIECES OF DUCO AND GENTLY HAMMER COIL FLAT AGAIN. TOUCH UP WITH DUCO ALL POORLY GLUED SPOTS.

CUT THE LEADS TO PROPER LENGTH. STRIP IT.# 2 BACK 2 INCHES AND BURN OFF ENAMEL. WHEN RED HOT DIP INTO ALCOHOL TILL COOLED AND BRIGHT. TIN ENDS AND SLIP IT.# 3, AND FASTEN TO TERMINAL BLOCK. OVER LEADS

CONTRACTOR COIL:

CUT TWO 8 FOOT LENGTHS OF IT.# 4 AND COMPLETELY SLEEVE WITH IT.# 2. BEND INTO APPROX. SHAPE AND FASTEN TO MAGNET POLE USING WIRE STAPLES, IT.# 5. GLUE IT.# 9 WHERE IT.# 4 CROSSES LEADS, IT.# 1. COMPLETELY CEMENT IT.# 4 TO POLE WITH DUCO, IT.# 6. APPLY SECOND COAT IN 2 HRS. AND ALLOW TO DRY OVERNITE. REMOVE STAPLES AND GENTLY HAMMER COIL FLAT. CUT AWAY LOOSE PIECES OF DUCO AND TOUCH UP THE BAD SPOTS. SLIP IT.# 3 OVER LEADS AND FASTEN LEAD WIRES TO TERMINAL BLOCKS.

Drawing Corrected to
FEB 21 1949
DESTROY ALL
PREVIOUS PRINTS

1 | 12-10-46 | 3 | 10-2-47
my R B DTS R B
GENERAL
CHANGES
EFF
3-0142-11630

EXPANDER
AND
CONTRACTOR COILS

ALLIS-CHALMERS MFG. CO.
MILWAUKEE, WIS., U.S.A.
EA DEPT.
DRAWN JHG. DATE 12-10-46
TRACED _____ DATE _____
CHECKED DTS DATE _____
O. K. _____ DATE _____
SIMILAR TO _____
SCALE _____ -12"

2-0142-7618

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