

DATE	TMC SPECIFICATION NO. S-596		A
SHEET OF 22			
LB:WG AC 16 COMPILED	CHECKED	TITLE: GPT-10K to GPT-40K MODIFICATION KIT	
APPROVED	(TMC KIT NO. KIT-106)		

OBSOLETE

SUPERSEDED AND DIRECTLY
REPLACED BY S-1107

I. EQUIPMENT AFFECTED

AN/FRT-39B transmitting set, radio, serial No's. 197 and up.

II. PURPOSE

Modification Kit to convert existing GPT-10K's to accept a 40 kilowatt (PEP) linear radio frequency amplifier.

Kit will include all the necessary parts & instructions.

Kit 106 covers GPT-10K (AN/FRT-39B & later), serial numbers from 197 & up.

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III. MATERIALS SUPPLIED IN KIT

ITEM NO.	DESCRIPTION	REFERENCES	
		PACKED IN CRATE NO.	USED ON SECTION
1a.	One each, TMC No. A2064 Load and Switch Assembly One each Bag, (contains hardware to mount A2064)	19	AX-250
1b.	Four each, TMC No. NTH2520BN14 Nut, Hex.	19	AX-250
1c.	Four each, TMC No. LWS25MRN Lockwasher, Split	19	AX-250
2a.	One each, TMC No. MS-2338 Plate Bowl, Hole Cover. One each Bag, (contains hardware to mount MS-2338)	1	AX-250
2b.	Twelve each, TMC No. SCBS0832BN8 Screw, Machine.	1	AX-250
2c.	Twelve each, TMC No. LWE08MRN Lockwasher, External.	1	AX-250
2d.	Twelve each, TMC No. NTH0832BN10 Nut, Machine	1	AX-250
3a.	One each, TMC No. MS-2315 Bracket Emergency Output.	1	AX-250
3b.	One each, TMC No. JJ-137 RF Connector, Female. One each Bag, (contains hardware to mount MS-2315 and JJ-137).	1	AX-250
3c.	Six each, TMC No. SCBS1032BN8 Screw, Machine.	1	AX-250
3d.	Eight each, TMC No. LWE10MRN Lockwasher, External.	1	AX-250
3e.	Eight each, TMC No. NTH1032BN12 Nut, Machine.	1	AX-250
3f.	Two each, TMC No. SCFS1032BN8 Screw, Machine, Flathead.	1	AX-250

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ITEM NO.	DESCRIPTION	REFERENCES	
		PACKED IN CRATE NO.	USED ON SECTION
4a.	Two each, TMC No. SW-230 Switch, Interlock One each Bag, (contains hardware to mount SW-230).	14	AX-250
4b.	Four each, TMC No. SC-131-0632BN5 Screw, Undercut Flathead.	14	AX-250
5a.	One each, TMC No. AC-108 Counter, Mode One each Bag, (contains hardware to mount AC-108).	16	AX-250
5b.	One each, TMC No. GR-116 Gear, Bevel.	16	AX-250
5c.	Two each, TMC No. AN565D8H3 Setscrew.	16	AX-250
6a.	One each, TMC No. A-2065 Switch, Detent Assembly. One each Bag, (contains hardware to mount A-2065).	20	AX-250
6b.	Two each, TMC No. SCBS1032BN8 Screw, Machine.	20	AX-250
6c.	Two each, TMC No. LWE10MRN Lockwasher, External.	20	AX-250
6d.	Two each, TMC No. NTH1032BN12 Nut, Machine.	20	AX-250
7a.	One each, TMC No. PM-657 Shaft, Horizontal Drive.	1	AX-250
7b.	One each, TMC No. PM-639 Shaft, Vertical Drive One each Bag, (contains hardware and parts to make A-2064 operational).	1	AX-250
7c.	One each, TMC No. PM-658 Coupling, Shaft.	1	AX-250
7d.	Two each, TMC No. SLHC1032SN4 Screw, Allen.	1	AX-250

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		PACKED IN CRATE NO.	USED ON SECTION
7e.	One each, TMC No. GR-145 Gear, Bevel 3/8 I.D.	1	AX-250
7f.	One each, TMC No. GR-155 Gear, Bevel 1/2 I.D.	1	AX-250
7g.	Four each, TMC No. AN565D8H4 Screw, Allen.	1	AX-250
7h.	One each, TMC No. KY-102-2-0.75SS Key, 1/8 by 1/8.	1	AX-250
7i.	Five each, TMC No. BB-106-3 Washer, Bearing	1	AX-250
8a.	One each, TMC No. CA-532 Cable, Interconnect. One each Bag, (contains hardware and parts to mount CA-532.)	1	AX-250
8b.	Three each, TMC No. CU-102-3 Clamp, Plastic	1	AX-250
8c.	Three each, TMC No. SCFS0632BN8 Screw, Flathead Machine	1	AX-250
8d.	Three each, TMC No. LWE06MRN Lockwasher, External.	1	AX-250
8e.	Three each, TMC No. NTH0632BN8 Nut, Machine.	1	AX-250
8f.	Seven (feet), TMC No. CD-101-1-MW Cord, Lacing.	1	AX-250
9a.	One each, TMC No. MS-2535 Strap, 40K R.F. Input.	1	AX-250
9b.	One each, TMC No. NTH2520BN14 Used to mount MS-2535 to unit.	1	AX-250
9c.	One each, TMC No. LWS25MRN Used to mount MS-2535 to unit.	1	AX-250

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		PACKED IN CRATE NO.	USED ON SECTION
10a.	One each, TMC No. MS-1996 Base.	3	AX-252
10b.	One each, TMC No. MS-1999 Shield, Base. Mounted to base for shipping purposes.	3	AX-252
10c.	Four each, TMC No. SCFS0832BN6 Screw, Machine, Flathead	3	AX-252
10d.	One each, TMC No. MS-2326 Cover AC access, mounted to MS-1996.	3	AX-252
10e.	Two each, TMC No. MS-1850-S Door access, Steel.	3	AX-252
10f.	Fourteen each, TMC No. SCHH2520SS12 Nut, Hex., (to mount MS-1850-S).	3	AX-252
11a.	One each, TMC No. AP-106 Final P.A. Frame Assembly, shields MS-1993, MS-2186 inc. One each Bag, (contains hardware to mount frame to frame)	14	KIT-106
11b.	Twenty each, TMC No. SCHH3118SN16 Screw, Machine.	2	AX-252
11c.	Twenty each, TMC No. LWS31MSN Lockwasher, Split	2	AX-252
11d.	Ten each, TMC No. NTH3118SN20 Nut, Machine.	2	AX-252
11e.	Twenty each, TMC No. FW31HBN Washer, Flat.	2	AX-252
12a.	One each, TMC No. AP-103 Power, Supply Final Assembly.	16	KIT-106
13a.	Three each, TMC No. TF-211 Transformer, HV. Hardware to mount transformer is mounted in existing holes in AP-103.	5,6,7	AP-103
13b.	Twelve each, TMC No. FW37HSN Washer, Flat, 3/8		AP-103
13c.	Twelve each, TMC No. LWS37MSN Lockwasher, Split, 3/8		AP-103
13d.	Twelve each, TMC No. SCHH3716SN32 Hexagon 3/8-16-2".		AP-103

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ITEM NO.	DESCRIPTION	REFERENCES	
		PACKED IN CRATE NO.	USED ON SECTION
14a.	One each, TMC No. PM-603 Bar, Support Transformer, PS Frame. (Washers & Hdwe. on Bar)	16	AP-103
15a.	Two each, TMC No. CP-107 Capacitor, Fixed Oil Filled, 4 mfd.	10	AP-103
16a.	One each, TMC No. TF-5016 Coil Filter Hardware to mount located on TF-5016.	11	AP-103
16b.	Four each, TMC No. FW31HBN Washer, Flat.		AP-103
16c.	Four each, TMC No. LWS31MSN Lockwasher, Split.		AP-103
16d.	Four each, TMC No. NTH3118SH Nut, Machine.		AP-103
17a.	Two each, TMC No. CB-149 Capacitor Vacuum, Variable 25-450 mmfd.	1	AX-244
17b.	Two each, TMC No. PM-588 Crated with CB-149.	1	AX-244
18a.	One each, TMC No. CB-158 Capacitor Vacuum Variable 30-750 mmfd.	1	AX-244
18b.	One each, TMC No. PM-588 Crated with CB-158	1	AX-244
18c.	One each, TMC No. CJ-102-1-21.00	1	AX-244
19a.	One each, TMC No. ML-6697	12	AX-244
20a.	One each, TMC No. AS-120 Assembly Bandswitch Packed with AS-120 is bag with mounting hardware:	15	AX-244
20b.	Six each, TMC No. SCBS1032BN24 Screw, Machine.		AX-244
20c.	Six each, TMC No. LWB10MRN Lockwasher, External.		AX-244
20d.	Six each, TMC No. NTH1032BN12 Nut, Machine.		AX-244

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		PACKED IN CRATE NO.	USED ON SECTION
21a.	One each, TMC No. MS-2018 Shield, Right Side, PS Frame, Shipped mounted to frame.	16	AP-103
22a.	Twenty each, TMC No. SCHH3118SS24 Screw, Machine.	2	AX-252
22b.	Twenty each, TMC No. FW31HBN Washer, Flat.	2	AX-252
22c.	Twenty each, TMC No. LWS31HBN Lockwasher, Split.	2	AX-252
22d.	Twenty-four each, TMC No. HB-101-6-B Plug, Button, 7/8.	2	AX-252
23a.	Two each, TMC No. MS-2037 Door Rear, Main and P.S. Frame.	4	AX-252
23b.	One each, TMC No. MS-2120-1 Door, Front Main Frame.	4	AX-252
23c.	One each, TMC No. MS-2120-2 Door, Front PA Frame.	4	AX-252
23d.	Twenty-two each, TMC No. SCBS1032BN8 Screw, Machine.	2	AX-252
24a.	One each, TMC No. TF-215 Transformer, Filament.	13	AP-106
25a.	One each, TMC No. AP-104 Bias Supply.	8	KIT-106
26a.	One each, TMC No. AT-102 Antenna Tuning Unit.	18	KIT-106
27a.	One each, TMC No. AX-212 Crowbar Drawer.	17	KIT-106
28a.	One each, TMC No. AP-105 Rectifier Drawer.	9	KIT-106
29a.	One each, TMC No. MS-1997 Cover Top. One each Bag, (contains hardware for MS-1997).	4	AX-252
29b.	Ten each, TMC No. FW25HBN Washer, Flat	2	AX-252
29c.	Ten each, TMC No. LWS25MRN	2	AX-252

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ITEM NO.	DESCRIPTION	REFERENCES	
		PACKED IN CRATE NO.	USED ON SECTION
29b.	Twelve each, TMC No. HB-101-6-B Plug, Button, 7/8.	2	AX-252
29c.	Ten each, TMC NO. SCHH2520BN10 Bolt, Hexhead.	2	AX-252
30a.	One each, TMC No. AR-116 Panel, Relay.	14	KIT-106
31a.	One each, TMC No. MS-2442 Cover, Bowl Opening.	4	AX-252
31b.	Four each, TMC No. SCBS0832BN8	2	AX-252
31c.	Four each, TMC No. LWE08MRN	2	AX-252
31d.	Four each, TMC No. NTH0832BN10	2	AX-252
32a.	Three each, TMC No. MS-2042 Bracket, Door Mtg., Right Side.	2	AX-252
32b.	Three each, TMC No. MS-2041 Bracket, Door Mtg., Left Side.	2	AX-252
32c.	Twelve each, TMC No. SCHH2520BN8 Screw, Machine.	2	AX-252
32d.	Twelve each, TMC No. FW25HBN washer, Flat.	2	AX-252
32e.	Twelve each, TMC No. LWS25MRN Lockwasher, External.	2	AX-252
33a.	Four each, TMC No. MS-2122 Latch, Plate Bottom.	2	AX-252
33b.	Four each, TMC No. MS-2123 Bracket Bottom.	2	AX-252
33c.	Four each, TMC No. MS-1660 Latch Plate, Top.	2	AX-252
33d.	Four each, TMC No. MS-1661 Bracket, Top.	2	AX-252
33e.	One each, TMC No. MS-2533 Bracket, Alternate 3" top hats One each Bag, (contains hardware to mount brackets and latches.	2	AX-252

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DESCRIPTION

REFERENCES

PACKED IN
CRATE NO. USED ON
SECTION

33f.

Sixteen each, TMC No. SCFS1032BNS
Screw, Machine.

2

AX-252

33g.

Sixteen each, TMC No. NTH1032BN12
Nut, Machine.

2

AX-252

33h.

Thirty-two each, TMC No. SCRS1032BN10
Screw, Machine.

2

AX-252

33i.

Sixteen each, TMC No. LW10MRN
Lockwasher, External.

2

AX-252

33j.

Sixteen each, TMC No. FW10HBN
Washer, Flat.

2

AX-252

33k.

Sixteen each, TMC No. FW25HBN
Washer, Flat.

2

AX-252

34a.

One each, TMC No. MS-2052
Trim, Rear, Left Side PA Frame.

4

AX-252

34b.

One each, TMC No. MS-2051
Trim, Right Side, Rear, PA Frame.

4

AX-252

34c.

One each, TMC No. MS-2025
Trim, Front Right Side PS Frame.

4

AX-252

34d.

One each, TMC No. MS-2027
Trim, PS and PA Front

4

AX-252

34e.

One each, TMC No. MS-2026
Trim Front, P.A., Main Frame.

4

AX-252

34f.

One each, TMC No. MS-2029
Trim Front, Bottom

4

AX-252

34g.

One each, TMC No. MS-2028
Trim Front, Top.

4

AX-252

34h.

Two each, TMC No. MS-2053
Trim, Top and Bottom, Rear.

4

AX-252

34i.

Thirty-two each, TMC No. NT-108-5
Speed Nut.

4

34j.

Eighteen each, TMC No. SCSS032BNS
Screw, Machine.

2

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ITEM NO.

DESCRIPTION

REFERENCES

PACKED IN USED ON
CRATE NO. SECTION

35a. One each, TMC No. CO-106-1000-30C
Capacitor, Fixed, Vacuum.

1 AX-244

36a. One each, TMC No. NP-360-4
Nameplate, Modification.

1 KIT-106

36b. Eight each TMC No. SFB0256SN3

1 KIT-106

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IV. TOOLS REQUIRED

A. To be provided by installing activity.

1. Pliers, 6 inch longnose.
2. Pliers, 6 inch diagonal cutter
3. Screwdriver, 5 inch.
4. Allen Wrench, 6-32.
5. Allen Wrench, 8-32.
6. Allen Wrench, 10-32.
7. Wrench open end, 3/8 - 7/16.
8. Wrench, crescent, 10 inch.
9. Wrench, socket, 7/16.
10. Wrenches, socket, 5/8.
11. Soldering Iron, 75 watt.

V. PROCEDURES

Kit is assembled in five procedures.

1. Procedure #1.
Preliminary dis-assembly of GPT-10K in field.
2. Procedure #2.
Final Electro-Mechanical dis-assembly.
3. Procedure #3.
Preparation of field GPT-10K to accept modification .
4. Procedure #4.
Preliminary re-assembly.
5. Procedure #5.
Final re-assembly.

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PROCEDURE NUMBER ONE

Case marked number two contains drawings, instruction & manual.

REFERENCES

AX-227
 IN-1060 assembly instructions
 Drawing Model GPT-10K (unconverted)

IN-1098 assembly instructions
 Drawing Model GPT-10K (converted)

1. Remove AC power from unit.
2. Remove relay panel, front window, driver draw and HVR draw from main frame and place aside for later use.
3. Referring to AX-214 10K should be placed to allow clearance to accept the 40K amplifier section.
4. Referring to AX-227 on serial number from 197 and up, remove the following:
 - A. MS-2118, Frame, P.S.
 - B. MS-1647, door, P.S. frame.
 - C. MS-2116, P.S. Frame.
 - D. MS-1830, shield outer, right side main frame - save.
 - E. MS-1592, shield, inner, right side main frame - save.
 - F. Remove connecting leads for BI-106 (HV on) from terminal strip, E3003 mounted on the top of auxiliary frame behind meter panel. Now TS-138 can be removed with next step and save for later use.
 - G. MS-1699, panel, top, remove & save.
 - H. MS-1648, door, rear, auxiliary frame, do not disturb.
 - I. MS-1594, shield rear main frame, remove & save.
 - J. MS-1605, bracket, connector, unbal. output - discard.
 - K. MS-1633, trim, front, right side main frame - discard.
 (replaced by MS-2026).

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PROCEDURE NUMBER TWO

1. Referring to figure 2 remove MS-1544, main control panel R.F. shield and place aside for later use.
2. Referring to figure 2 remove connections from C927 PA tune capacitor, remove capacitor for later use.
3. Referring to figure 2 remove connections from C916, output balance capacitor, remove capacitor for later use.
4. Referring to figure 2 remove connections from C928, PA load capacitor, remove capacitor for later use.
5. Referring to figure 2 remove connections from C1019 and C1020.
6. Referring to figure 2, for dis-assembly of antenna tuner, ~~MS-1538~~ 1538, bracket, support, right angle drive and leave in place for later use.
7. Referring to figure 2 remove MS-1537, bracket support, right angle drive and discard.
8. Referring to figure 2 remove PM-547, vertical drive shaft antenna tuner.
9. Remove output load knob on main control panel and save. Now referring to figure 2 remove PM-549 and discard.
10. Remove output load counter, discard counter but retain mounting hardware.
11. Remove all external connections from antenna tuner.
12. Located on top of GPT-10K main frame is four 1/4-20 bolts that hold antenna tuner in place, antenna tuner must be held in place while removing the 1/4-20 bolts, then the antenna tuner assembly can be removed to be replaced later by a switch and load assembly, A-2064.
13. Remove both bowl assemblies to be replaced later by blank cover, MS-2338.

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PROCEDURE NUMBER THREE

REFERENCE (ID-244 Sheet 2 of 2)

1. Bracket and Interlocks.

NOTE: Disregard the following steps if items concerned already conform.

REFERENCE (ID-244 Sheet 2)

- A. On MS-1548 Drill F and G holes to accept emergency output bracket.
- B. On MS-1547 Drill H and J holes.
- C. On Detail K and L Drill holes to accept the front and rear Interlocks Switches.

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PROCEDURE NUMBER FOUR

REFERENCES ID-248 - Cable Installation
AX-250 - Modification Assembly

NOTE: Crate marked number two contains all the parts to modify GPT-10K.

1. Remove MS-2338 (cover, bowl hole) from crate and mount using hardware in appropriately marked bag.
2. Mount A-2064, load and switch assembly in same four holes vacated by antenna tuner. Mounting hardware in appropriately marked bag.
3. Mount JJ-137, RF connector to bracket MS-2315 and then mount bracket to MS-1548 using hardware in appropriately marked bag.
4. Mount the two interlock switches SW-230 located with hardware in appropriately marked bag.
5. Crate #16 contains AC-108 and GR-116. Mount GR-116 on to AC-108, mode counter. Mount counter in place vacated by output load counter. Use same hardware in the removal of old counter to mount AC-108, Ref. AX-250.
6. Referring to ID-248, mount CA-532, lacing to existing cable with CD-101-3 furnished by kit. Clamp down cable extending to rear interlock using the three (3) CU-102-3 (cable clamps).
7. Mount A-2065, detent switch assembly using hardware in appropriately marked bag in case #20. Mount output loading knob on PM-691 extending thru front panel. Set AC-108 to tune position, and WS-109 to tune position and mesh the two GR-116. Referring to WS-109 wiring detail wire CA-532 to WS-109 using rosin core solder.
8. Mount PM-658 to PM-691, PM-658 is located in appropriately marked bag in case #1. Connect PM-657 to PM-658, slide GR-145, (teeth facing toward the front) onto PM-657 behind GR-145 slide on five (5) BB-106-3 and leave loose. Insert PM-639 thru BB-121 mounted on MS-1538, place gear, GR-145 on PM-639 and insert key, KY-102-2-0.75SS and lock with set screws in GR-145.
9. Referring to AX-250, place wiper of mode switch to tune. The vertical drive shaft PM-639 keyway should align with the mode switch shaft keyway, insert item 7H located in case #1, KY-102-2-0.75SS and slide coupling, PM-638 down and tighten setscrews. Now tighten down MS-1538 as original, mesh gears GR-145 and GR-155 and tighten. Check work and tighten all loose hardware. By turning output loading knob from tune to oper. and then to emergency, both the small wafer WS-109 and the large mode switch must correspond to Mode counter AC-108 indication.

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PROCEDURE NUMBER FOUR CONTINUED

10. Referring to ID-248, connect the two red leads on the rear interlock to common and normally open. On the front interlock connect the red leads to the common and the normally open.
11. Referring to ID-248, connect the Blue and Black/White wire marked 220 VAC to the 0-220 VAC primary position on T800, High Voltage Transformer.
12. Remove the bottom connections on the high voltage on and off switch, replace with White/Violet wire with lug. Remove lug from wires previously taken away from switch, connect the White/Yellow to them and insulate with tape.
13. Remove PA monitor from bottom of 4CX5000 tube compartment and connect IPA monitor cable to its place. Now referring to ID-248 connect RG-174 terminated with JJ-172, RF connector to the PA monitor cable. Now the PA monitor, monitors the 40KW amplifier and the IPA monitors the 10KW amplifier, the driver is no longer monitored.

Check the whole interconnect cable with ohmmeter referring to CK.

14. Replace PA tune, C927 and connect as usual. Replace PA load C928, connect as usual, then connect lead from C911 to top with lead from bandswitch. Replace output balance, C916 and connect lead from operate position of mode switch to the top of C916.

Connect lead from emergency position of mode switch to JJ-137, emergency output connector.

Connect leads from L916 and L917 to C1019 and C1020 back of meter panel.

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PROCEDURE NUMBER FIVE

REFERENCE AX-214

1. Replace the inner and outer shield to the 10K.
2. Place item 10A, MS-1996 base next to 10K base, location is determined from items supplied list. Remove base shield item 10B, hardware is used for shipping purposes only. An AC interconnect cable is supplied with the 40K base, if the 10K base has an inlet AC hole the AC inputs can be fed from one source, if not the AC inputs have to be derived from two different sources. After proper grounding and routing of AC input, replace shield, MS-1999.
3. Mount item 11A, AP-106, final frame assembly next to GPT-10K main frame. With hardware supplied in appropriately marked bag in case #2, bolt frames together, then bolt to base.
4. Mount item 12, AP-103, power supply final assembly to AP-106, and bolt, then bolt to base using hardware supplied in appropriately marked bag.
5. Remove bar support on right side of AP-103 and hardware from base of AP-103, and install the three (3) TF-211, high voltage transformers and bolt down with hardware previously removed. Reinstall bar support. Location of TF-211 can be obtained from item supplied in list.
6. In rear of AP-103 are two shelves and mounting brackets to mount item #15, CP-107, 4 mfd oil filled fixed capacitor. The symbol numbers C8107, C8108 are stamped on frame. Packing location of CP-107's can be found on items supplied in list.
7. In the rear of AP-103 below the shelves for the capacitors, item 16A, TF-5016, filter coil is to be mounted, hardware for mounting is located on TF-5016, packing location can found on items supplied list.
8. INSTALLATION OF VACUUM CAPACITORS, Item 17, C7301, C7303; item 18, C7329; and item 35, C7328.

The following is a step-by-step detail for the installation of the above mentioned capacitors. Refer, as required to Figure 4,5,6, page 4,5,11 of NAVSHIPS 93617 Instruction Manual for positioning of the capacitors and allied parts.

- A. Remove vacuum capacitors from packing Crate. Remove excess packing from capacitors.
- B. Turn capacitor adjustment shafts so that capacitors are at minimum capacity. (Plates completely open).

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C. Set front panel TUNE and LOAD counters to 000.

Refer to Figure 4,5,6, page 4,5,11 of NAVSHIPS 93167 for positioning of capacitors.

D. Insert C7301 into clamping ring. Mesh gears so that capacitor turns smoothly. Tighten clamping ring to secure bottom of capacitor.

E. Insert C7329 into clamping ring. Feed drive chain over sprocket. do not tighten clamping ring at this time.

F. Insert C7303 into clamping ring. Feed drive chain over sprocket. Check for smooth operation of C7302 and 7303. Tighten both bottom clamping rings.

NOTE: A slight up and down movement of the capacitors may be necessary to assure smooth operation.

G. Place metal plate, with attached top clamping rings, over the tops of the capacitors. (See figure). Do not secure the plate at this time.

H. Install C7328 in clamping ring which is in place on the wall of the final tube compartment. Do not tighten clamping ring at this time.

I. Secure bracket and capacitor clamping ring to capacitor as shown in figure mentioned above.

J. Using hardware furnished, fasten bracket to metal plate which is resting on tops of other capacitors.

K. Adjust height of plate so that C7328 is level and is not under strain.

L. Tighten front and rear clamping rings of C7328. Tighten top clamping rings of other capacitors.

M. Install L7312 as per supplied installation drawing.

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9. INSTALLATION OF BANDSWITCH ASSEMBLY, Item 20. Ref: ID-258

- A. Remove BANDSWITCH ASSEMBLY from case. Remove excess packing material, tape, etc. from the assembly. Loose hardware will be found in a bag attached to the assembly. The BAND MCS switch on the front panel of the transmitter and the BANDSWITCH ASSEMBLY were set at 19 - 24 mcs before disassembly. (See ID-258 for correct placement of BANDSWITCH rotor, keyway alignment and front panel setting of BAND MCS switch). In the event that the BANDSWITCH rotor and the front panel reading do not agree, it becomes necessary to make them do so. Since it is impossible to change the position of the rotor. See ID-258 for details of how to defeat the bandswitch stop mechanism so that the BAND MCS front panel setting may be varied to match the BANDSWITCH ASSEMBLY rotor setting.
- B. Remove all packing material, tape, loose hardware etc. from the P.A. compartment. of the transmitter.
- C. Place BANDSWITCH ASSEMBLY in the transmitter as per position shown in ID-258. Keyway in rotor shaft and bottom hub must line up for assembly. Bottom mounting screws for legs are part of the P.A. compartment. Align BANDSWITCH ASSEMBLY leg supports to fit screws.
- D. Connect LOAD CAPACITOR STRAP using the two 1/4-20 bolts supplied. See ID-258 for position of strap. Screws must be very tight for firm connection.
- E. Connect HF COIL to MAIN COIL using two long 1/4-20 bolts which are on one leg of the BANDSWITCH ASSEMBLY. Check other end of connecting strap (in tube compartment) for tight connection.
- F. Connect H.F. "L" section loop to C7325 at top of compartment.
- G. Tighten all screws at base of BANDSWITCH ASSEMBLY legs to secure assembly to transmitter.
- H. Using hardware supplied, fasten fiberglass AIR DUCT (furnished) to side of tube compartment and base of P.A. compartment.

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10. INSTALLATION OF THE FINAL P.A. TUBE (ML-6697), Item 19. Ref: ID-258

The following is a step-by-step procedure for the installation of the FINAL P.A. TUBE ML-6697.

Carefully unpack Case which contains ML-6697. Remove excess packing material, tape etc. from the tube. Inspect packing material for any loose items which it may contain. Set tube aside until called for in step 10H of these instructions.

The following steps are performed from the rear of the transmitter in the top compartment of the second frame from the left facing the rear of the transmitter.

- A. Remove and retain the two 10-32 screws which hold the TUBE BASE STRAP around the AIR DUCT TUBE BASE.
- B. Remove SPRING CLIPS at the base of the AIR DUCT TUBE BASE.
- C. Lift up and remove the AIR DUCT TUBE BASE from the transmitter.
- D. Remove and retain screws, nuts and lockwasher which hold front section of GRID SCREEN in place.
- E. Remove and retain front section of GRID SCREEN.
- F. Place AIR DUCT TUBE BASE on table which is strong enough to support at least 100 pounds.
- G. Remove six SPRING CONNECTORS and six L shaped ANODE CONNECTORS from top of the AIR DUCT TUBE BASE.
NOTE: The AIR DUCT TUBE BASE is now ready to receive the FINAL TUBE.
- H. Holding FINAL TUBE with glass section up, slip tube very carefully into AIR DUCT TUBE BASE.
- I. Replace six SPRING CONNECTORS and six ANODE CONNECTORS at top of AIR DUCT TUBE BASE.
NOTE: Due to tube manufacturers height tolerances, the ANODE CONNECTORS may have to be bent down slightly to make firm contact with FINAL TUBE.
- J. Using extreme caution replace FINAL TUBE and AIR DUCT TUBE BASE in the transmitter.
NOTE: CAPACITOR STRAP at bottom of AIR DUCT TUBE BASE must be in position shown in ID-258.

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- K. Slip CAPACITOR C7326 into CAPACITOR SOCKET as shown in ID-258.
 - L. Slip CAPACITOR STRAP over top end of CAPACITOR C7326 as shown in ID-258.
 - M. Tighten top and bottom clamps to secure CAPACITOR C7326.
 - N. Replace 10-32 screws in TUBE BASE STRAP and tighten to secure AIR DUCT TUBE BASE.
 - P. Replace SPRING CLIPS at bottom of AIR DUCT TUBE BASE.
 - R. Place FILAMENT RINGS (furnished) over top of FINAL TUBE as shown in ID-258.
 - S. Tighten allen screws in FILAMENT RINGS for snug fit.
NOTE: Due to possible damage to the FINAL TUBE, the FILAMENT RINGS must not be too tight. Consider snug fit to mean that FILAMENT RINGS cannot be slipped off by hand.
 - T. Loosen GRID RING as much as possible.
 - U. Replace front section of GRID SCREEN.
NOTE: Before fastening GRID SCREEN in place, make sure GRID CONNECTORS are under GRID RING as shown in ID-258.
 - V. Replace and tighten all GRID SCREEN hardware.
The FINAL TUBE is now ready for electrical testing.
11. Install item 24, TF-215, filament transformer in the base of AP-106, mounting hardware is located in mounting holes.
 12. Install item 25, AP-104, bias supply below main control panel in AP-106.
 13. Install item 26, AT-102, antenna tuning unit of AP-103 after installation of bowl assemblies located in crate.#1.
 14. Install item 27, AX-212, crowbar drawer below antenna tuning unit.
 15. Install item 28, AP-105, rectifier drawer below crowbar drawer.
 16. Bring plug on CA-532 10K thru 3 inch hole on 10K outer shield and connect to J7103 on 10K interconnect box located above TF-215, filament transformer.

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17. Connect item 9, MS-2535, 40K RF input strap from the operate position to the 40K input, feedthru insulator NS-112, NS-112 is dismantled for shipping and is located in Box #1.

18. After all electrical and mechanical items are replaced or installed, it would be advisable to check the operation of all control circuits before the completion of procedure, that is, the mounting of doors, trims and panels.

19. Referring to AX-214, 40K assembly point mount items 21 thru 35. Mounting hardware is located with items involved.

20. Affix Modification Nameplate, item No. 36A, conveniently near existing system nameplate on the 10K relay panel cover.

