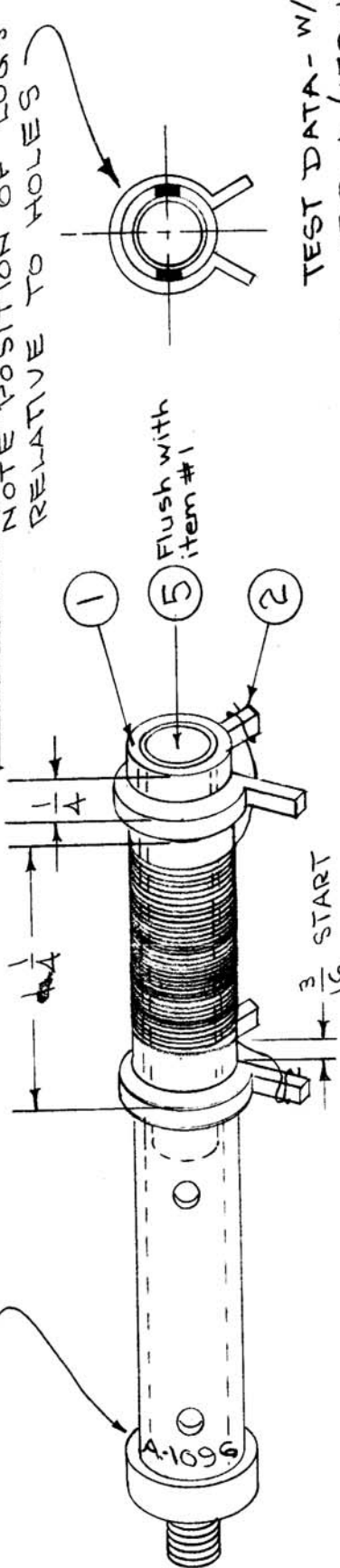


STAMP AS SHOWN 1/8" HIGH BLACK GOTHIC. A-1096



1. Position lugs on coil form as shown. Secure with Item 6 (U-85)
2. Wind on 61 close wound turns of item 3. (Allow 3" stripped leads each end for test purposes. Remove after test.)
3. Stake coil ends with item 4.
4. Solder leads to lugs as shown.
5. Coat the entire coil, coil form and inner surface of the coil form with item 6 (U-85) on core to insure a snug fit in coil form (see below)
6. Wind 2 turns of item 7 (tape) on core with item 6 (U-85) then insert core into coil form as shown. Core must fit form securely.
7. Coat item 5 (core) with item 6 (U-85) then insert core into coil form as shown. Core must fit form securely.
8. Bake for 1 hour at 270° F.
9. Test (w/core)
10. Stamp coil form as shown.

Insert this end in coil form first.

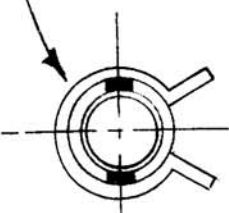


TEST DATA - W/CORE
 L - 180µh (170-190µh)
 Q - 120 OR GREATER
 F - 790 KC

Use Boonton Q-Meter
 160 A OR EQUIV.

REQ. PER UNIT	MODEL	USED ON ASSY. NO.	DATE
1	RTF		11-21-56
1	RTF-2	MULT.	11-20-58

NOTE POSITION OF LUGS RELATIVE TO HOLES



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 8	TA-100-2	TAPE, VINYL (1/2" WIDE)	
X 7	BS-100	SOLDER, SOFT	
X 6	GL-10A-2	INSULEX U-85	
1	CI-11202R0 F	CORE	
X 4	GL-103	CEMENT, DUCO	
X 3	WI-107-11	WIRE #30 D8C	
2	TE-153-3	LUG, RING TYPE	
1	CF-121	COIL FORM	

TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
		MP	MP	A. J. J.

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
E 1	TAPE ADDED. NOTES CHGD.	11/19/57	5	16	MP	A.J.J.
D 1	ITEM WAS CF-119-A.06 REDRAWN	11/21/56	4	000	MP	A.J.J.

SCALE:
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
 REMOVE ALL BURRS AND SHARP EDGES

DEC. DIM. ±	FRAC. DIM. ±	ANGULAR DIM. ±	FINISH & SPEC. NO.
			A-1096