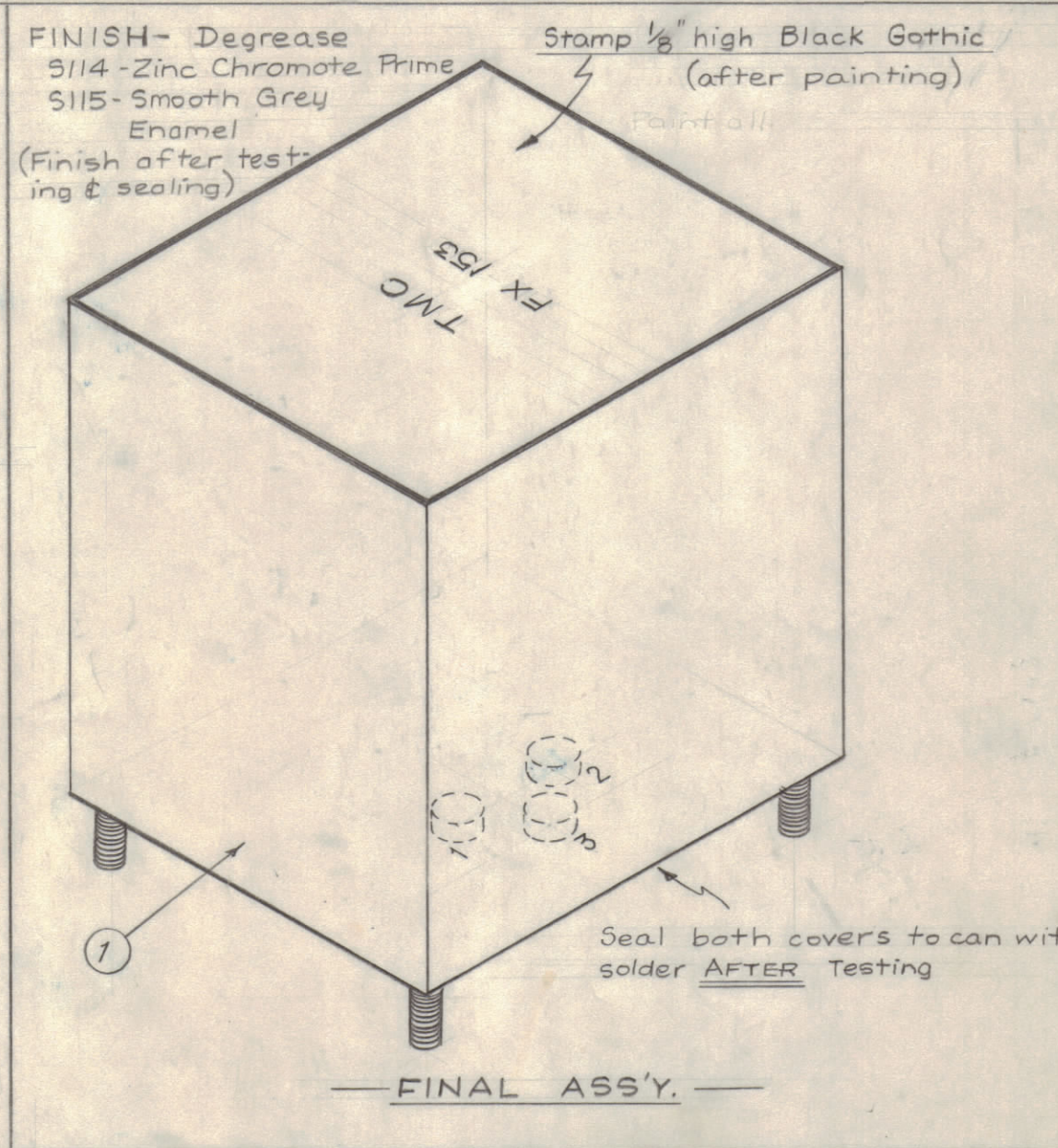
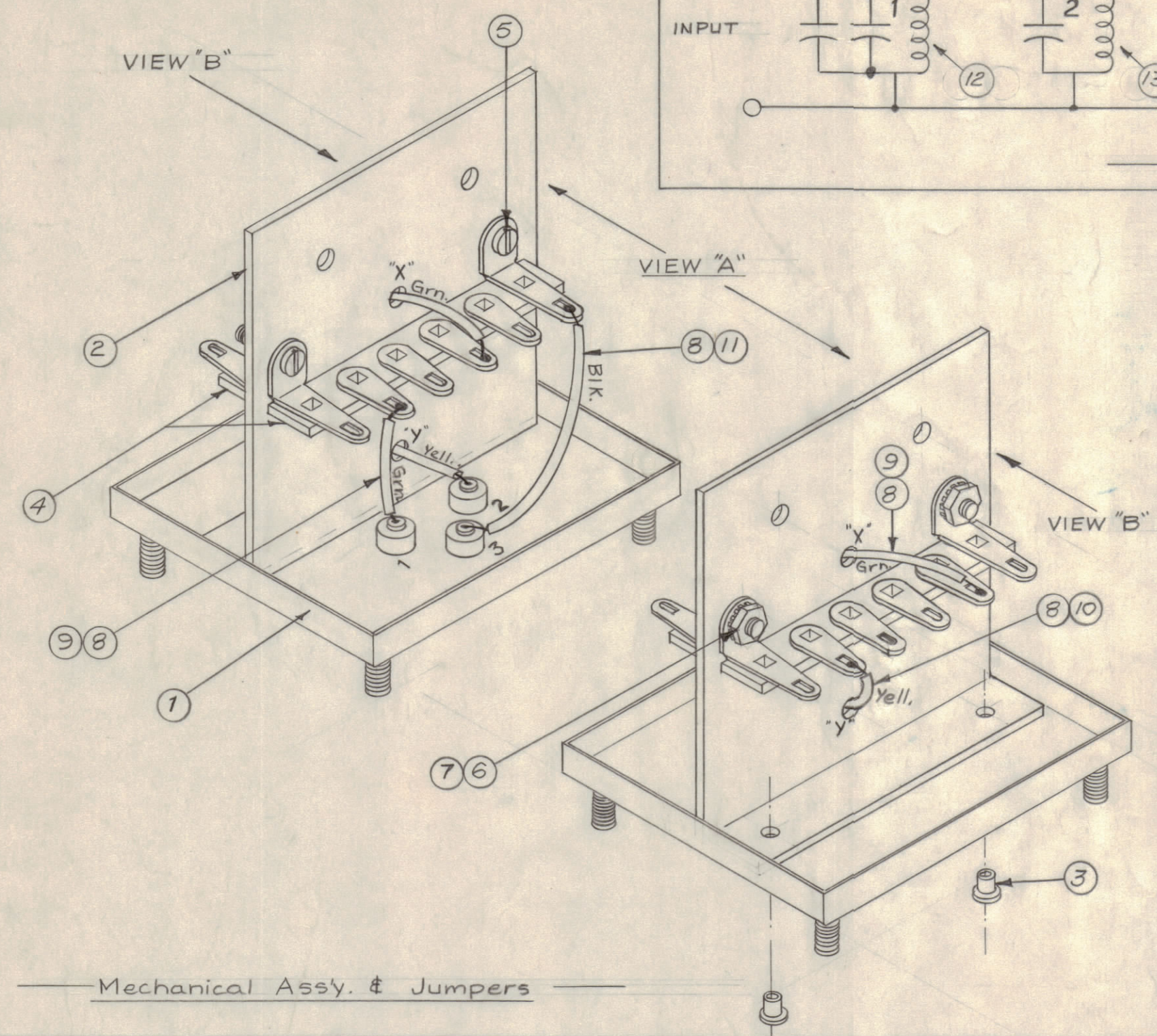
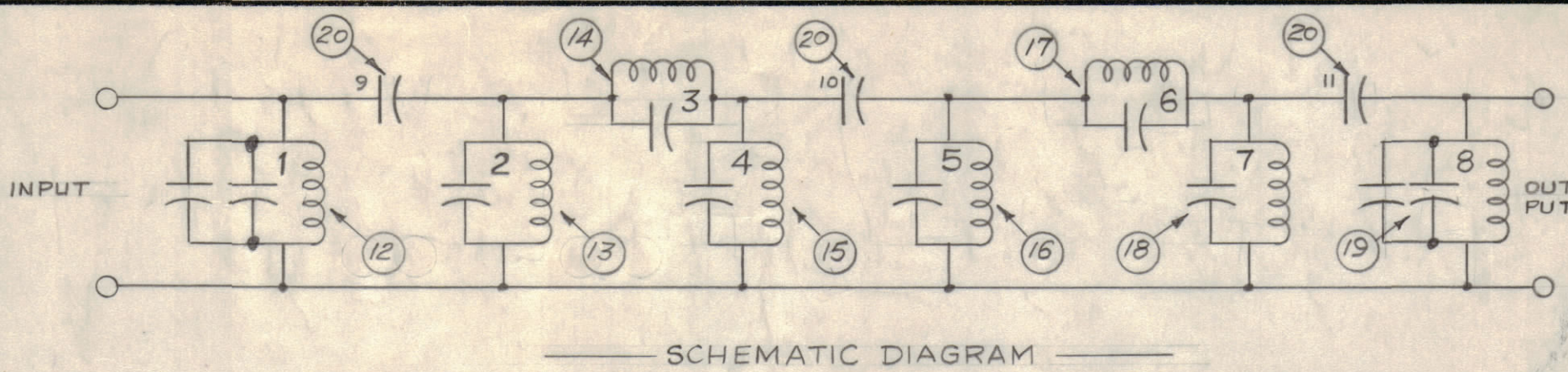


IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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

ASSEMBLY INSTRUCTIONS



- A. MECHANICAL ASSEMBLY.**
1. Assemble bracket to base with eyelets.
  2. Assemble terminal strips to bracket as shown.
  3. Connect jumpers from terminal strip to can terminals.
- B. ELECTRICAL ASSEMBLY.**
1. Clear work area.
  2. Place on table one of each numbered element (tuned pairs and single capacitors.)
  3. Separate tuned pairs.
  4. Assemble capacitors to terminal strip using insulated sleeving where needed.
  5. Assemble toroids to bracket. After coil leads have been aligned, tighten the supporting screw. Spot solder the nut to the screw.
  6. Connect the coil leads to the proper terminals and solder all connections.
  7. Assemble into can, but do not seal.
  8. Test in accordance with test specification S304 and TMC dwg. FX 153.
  9. If unit passes test, seal can, paint all except terminal end and stamp top as shown.
  10. If rejected, unit must be checked for proper resonance of elements.

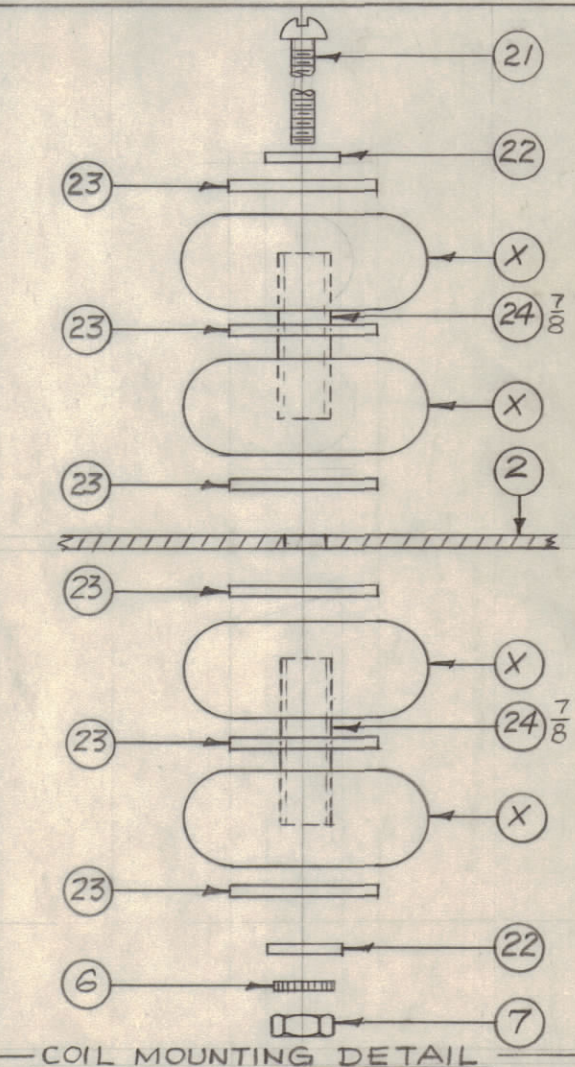
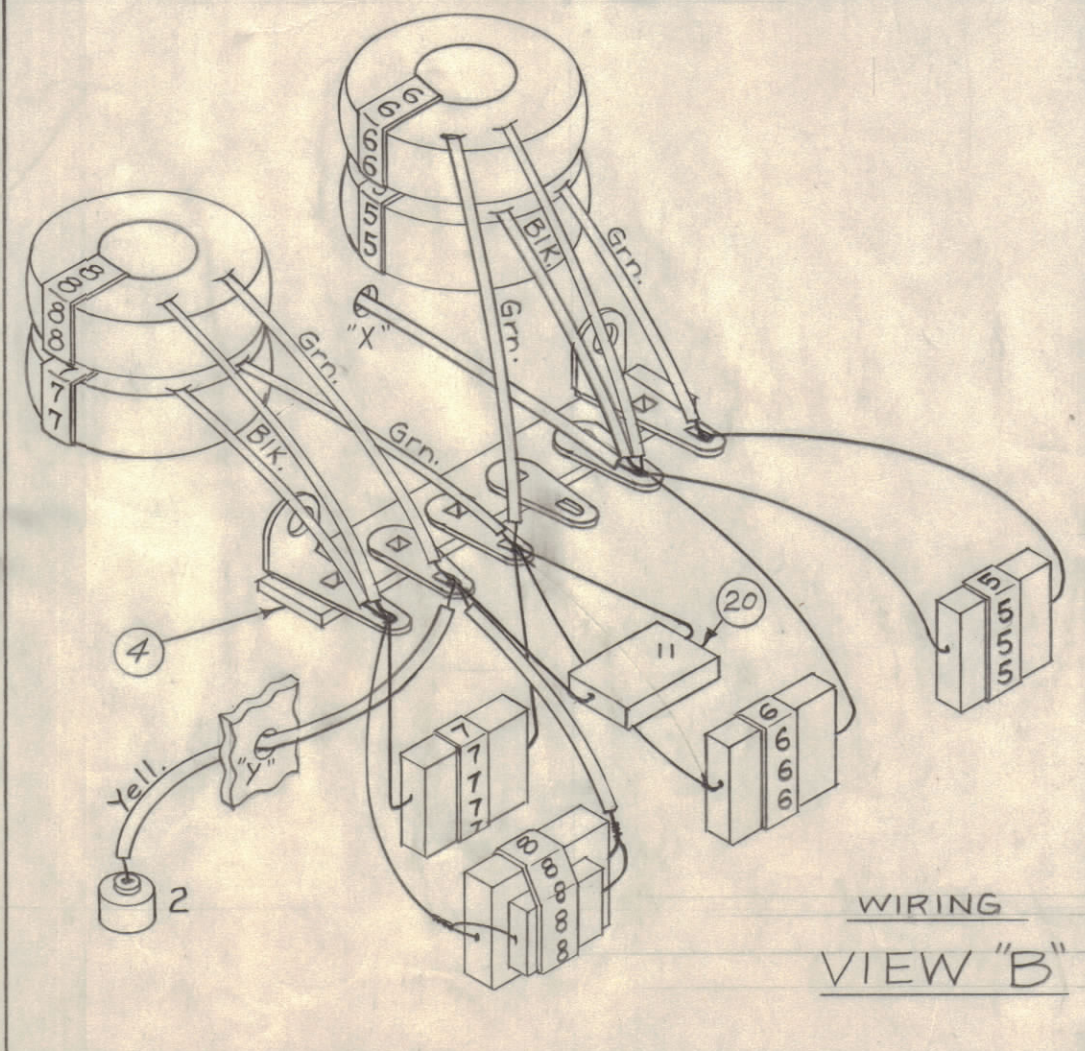
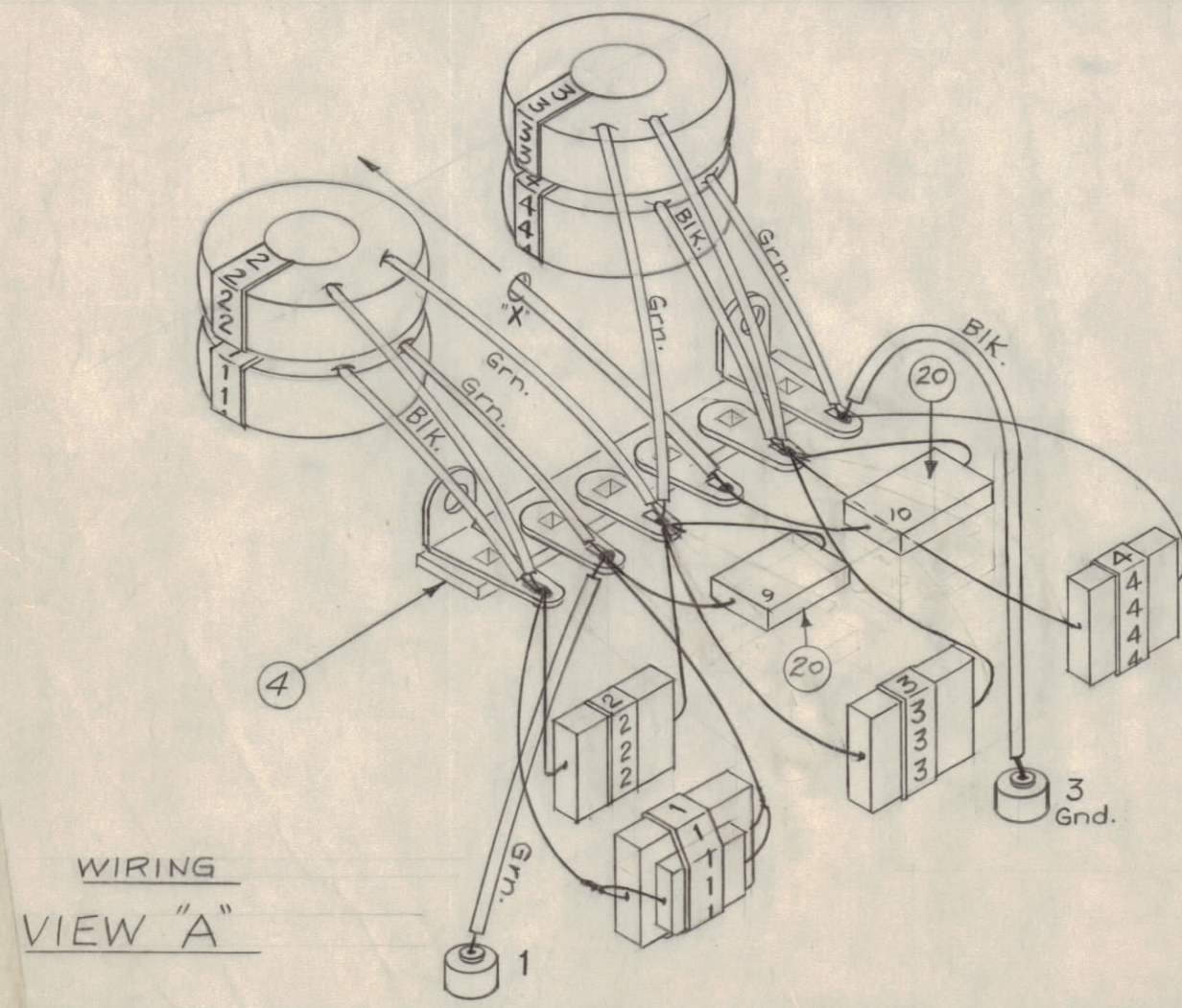
RESTRICTED

NOT TO BE RELEASED  
W/O AUTHORIZATION  
AUTH BY: \_\_\_\_\_  
DATE: \_\_\_\_\_

X	25	BS 100	Solder, Soft
3 1/2"	24	FX 100-1-208	INSULATION, SLEEVING
12	23	WA 109-56	WASHER, FIBRE
4	22	FW08MBC	WASHER, FLAT
2	21	SCRS0632BC32	SCREW, MACHINE

A 1408 A

3	20	CM20E821G	CAPACITOR, FIXED, MICA	9,10,11
1	19	A 1407-8	COIL & CAP ASSEMBLY	8
1	18	-7		7
1	17	-6		6
1	16	-5		5
1	15	-4		4
1	14	-3		3
1	13	-2		2
1	12	-1		1
X	11	PX 104-1-.022	INSULATION, SLEEVING	BLK.
X	10	PX 104-2-.022	INSULATION, SLEEVING	YELL.
X	9	PX 104-4-.022	INSULATION, SLEEVING	GREEN
X	8	WL 100-8	WIRE, BUSS	
4	7	NTH0632BC10	NUT, HEX	
4	6	LWE06MRC	LOCKWASHER, EXT.	
2	5	SCB50632BC6	SCREW, MACHINE	
2	4	TM 117-26	TERMINAL STRIP	
2	3	EY 100-2	EYELET	
1	2	MS 1036	BRACKET, FILTER	
1	1	BX 152	CASE & COVERS	



ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES						
SCALE: FX 153 (2)						
DEC. DIM. ±			DRILL, PUNCH, COMMERCIAL STOCK			
FRAC. DIM. ±			SIZES AND MANUFACTURERS			
ANGULAR DIM. ±			TOLERANCES ARE NOT INCLUDED.			

1	FX 153			3-28-57
REQ PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
MATERIAL WEIGHT PER PC.			
TYPE & TEMPER			
HEAT TREAT. SPEC.			
FINISH & SPEC. NO.			

A 1408 A