



WINDING SPECIFICATIONS

1. Wind coil to 400 mhy.
2. Bake for one half hour at 215° F.
3. Submerge hot coil in item 5, for not more than 5 seconds.
4. Test the coil for:
 - A. Inductance & Q on impedance bridge.
 - B. Self resonant frequency in accordance with S-206. Do not add capacitance across coil but tune audio Osc. to obtain peak. This should occur between 18 Kc & 19 Kc. If above 19 Kc., dip in wax for longer period of time.

Ref: TMC Spec. S-337 (Winding)

REQ. PER UNIT	MODEL	USED ON ASSY. NO.	DATE
1	FX-152		4-18-58

A-1530

ELECTRICAL SPECIFICATIONS

400 mh + 5%
 Q greater than 40
 R dc - 85 to 95 Ohms

NOTE: THIS DRAWING (A-1530) TO BE USED ONLY WHEN CL-117 IS NOT PURCHASED OUTSIDE.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 6	BS-100	SOLDER, SOFT	
X 5	GL-110	WAX, IMPREGNATING	
X 4	PX-104-1-.034	INSULATION, SLEEVING	
X 3	LWC28(7)UO	CABLE, INSULATED	
185ft 2	WI-123-34	WIRE, MAGNET	
1 1	CI-103-7	CORE, MOLYBDENUM, PERMALLOY POWDER	
STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
MATERIAL		COIL, 400 mh	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
		16 4/18/58	
FINISH & SPEC. NO.		FINAL APPROVAL	
		A-1530	

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES						
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. ±						