

ASSY. NO.	ITEM NO. 4 (WIRE)	TOTAL NO. OF TURNS	BRING OUT TAP AT (NO. OF TURNS)	INDUCTANCE (MH)		TEST FREQ. (MC/S)	TEST FREQ. MUST BE MORE THAN	COLOR CODE	WIRE SIZE (MCS)	COIL FORM	CORE	CORE COLOR	TMC NO.
				MIN. MUST BE LESS THAN	MAX. MUST BE MORE THAN								
A-1614-1	WI-104-541DSQS	40	20	28	39	2.5	50	Black	2-4	CF107-2N			CL-149
A-1614-2	WI-107-15	22	11	5.0	7.2	7.9	80	Brown	4-8	CF107-2N			CL-150
A-1614-3	WI-107-5	11	6	1.4	1.8	7.9	80	Red	8-16	CF107-2N			CL-151
A-1614-4	WI-107-5	10	5	0.9	1.3	7.9	80	Green	8-16	CF107-2N			CL-175-1
A-1614-5	WI-104-541-DSQS	33	17	16	25	2.5	60	Yellow	2-4	CF107-2N			CL-181-1
A-1614-6	WI-107-5	10	5	1.4	1.75	7.9	85	BLUE	6.3-12.3 MC	CF107-4N	CT109-5	NO COLOR	CL-175-2
A-1614-7	WI-104-541-DSQS	33	17	16	36	2.5	55	ORANGE	1.75-3.4 MC	CF107-4N	CT118-1	SILVER BLK	CL-181-2

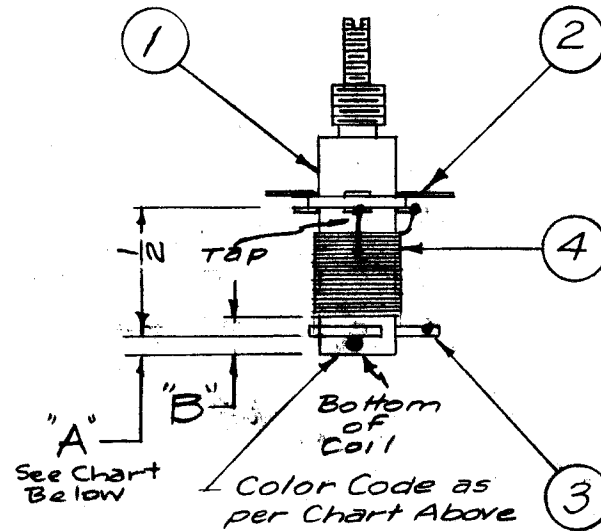
WINDING MACHINE DATA

A-1614-1,5,7 will use a .125 Cam, 49 Cam Gear, and 95 Driver.

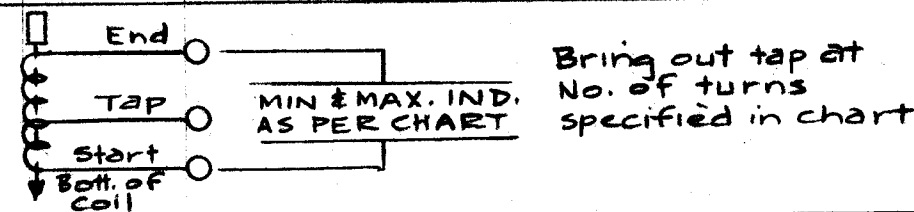
A-1614-2,3,4,6 will be close wound, single layer.

PROCEDURE

1. Secure terminals (items 2 & 3) to coil form with Insulex (item 6).
 2. Wind required number of turns of item 4 (wire) on coil form and bring out tap when required as per chart above.
 3. Stake wire ends to coil form with Q-Max (item 5).
 4. Solder coil leads to terminals.
 5. Bake for 1/2 hour at 210° F.
 6. Paint coil with Insulex (item 6)
 7. Test unit as per chart and schematic with core. Minimum & Maximum Inductance accomplished by adjusting tuning slug.
- (USE BOONTON Q-METER MODEL 160 A OR EQUIV.)



ASSY. NO.	DIM. "A"	DIM. "B"
A-1614-1	1/4	3/8
A-1614-2	3/32	7/32
A-1614-3	3/32	7/32
A-1614-4 & 6	3/32	7/32
A-1614-5 & 7	1/4	7/16



MODEL NO.	USES	QUAN.	SYMBOL NO.
RFA-1	CL-149	2	T201, T204
	CL-150	2	T202, T205
	CL-151	2	T203, T206
RFB-1	CL-150	1	L202
	CL-175	1	L209
RFD-1 RFD-1A	CL-150	1	L202
	CL-175	1	L209
RFC-1	CL-181	1	L201
	CL-175	1	L209
	CL-150	1	L202
RFD-2	CL-175-2	1	L209
	CL-181-2	1	L201
	CL-150	1	L202

1	8	SEE CHART	CORE, TUNING
X	7	BS-100	Solder, Soft
X	6	GL-104-2	Insulex, U-85
X	5	GL-102	Cement, Q-Max.
X	4	See Chart	Wire
1	3	TE-153-2	Terminal, Ring Type
1	2	TE-170-3	Terminal, Collar Type
1	1	SEE CHART	Coil Form

W		-1 ADD CL175 & CL181	12.6.66	17380	WLD	WLD	WLD
V	1	MACHINE DATA-6E-7 ADDED REF-2, CL-175 VAL-150 ADDED	11/22/65	15136	R	R	R
U	2	ON -5, INDUC. MIN. WAS 15.5 ON -5, INDUC. MAX. WAS 25.1	7.16.64	11880	WLB	WLB	WLB
T	1	ITEM 2 RELOCATED	6-23-64	11626	A.M.	A.M.	A.M.
S	2	A-1614-6, 7 & IT. B ADDED COIL FORM, CORE & COLOR COLUM. ADD. ITI WAS CE-107-2N	6.12.64	11553	WLB	WLB	WLB

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	CHART	REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
							RFD-1A		FAL-11KA			8-7-59
							RFB-1		GPT-10K			12-22-58
							RFA-1		FAL-350			5-21-58

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
RF COIL ASSY, TUNED			
(CL-149, CL-150, CL-151, CL-175)			
FINISH & SPEC. NO.			
ELEC. DES. APP. MECH. DES. APP.			

DEC. DIM. ±
FRAC. DIM. ±
ANGULAR DIM. ±

SCALE: ———

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

W	TMC ASS'Y. DWG. NO.	ITEM NO. 4 (WIRE)	TOTAL NO. OF TURNS	BRING OUT TAP AT (NO. OF TURNS)	INDUCTANCE (μhy)		TEST FREQ. (MCS)	Q @ TEST FREQ. MUST BE MORE THAN	COLOR CODE	OPER. FREQ. (MCS)	ITEM 1 COIL FORM	ITEM 8 CORE	CORE COLOR	TMC PART NO.
					MIN. MUST BE LESS THAN	MAX. MUST BE MORE THAN								
	A-1614-1	WI-104-541DSQS	40	20	28	39	2.5	50	Black	2-4	CF107-2N			CL-149
	A-1614-2	WI-107-15	22	11	5.0	7.2	7.9	80	Brown	4-8	CF107-2N			CL-150
	A-1614-3	WI-107-5	11	6	1.4	1.8	7.9	80	Red	8-16	CF107-2N			CL-151
	A-1614-4	WI-107-5	10	5	0.9	1.3	7.9	80	Green	8-16	CF107-2N			CL-175-1
	A-1614-5	WI-104-541-DSQS	33	17	16	25	2.5	60	Yellow	2-4	CF107-2N			CL-181-1
	A-1614-6	WI-107-5	10	5	1.4	1.75	7.9	85	BLUE	6.3-12.3 MC	CF107-4N	CI109-5	NO COLOR	CL-175-2
	A-1614-7	WI-104-541-DSQS	33	17	16	36	2.5	55	ORANGE	1.75-3.4 MC	CF107-4N	CI118-1	SILVER BLK	CL-181-2

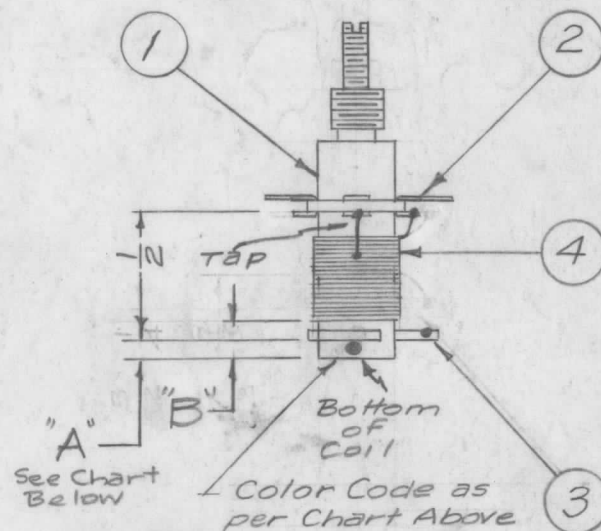
WINDING MACHINE DATA

A-1614-1,5,7, will use a .125 Cam, 49 Cam Gear, and 95 Driver.

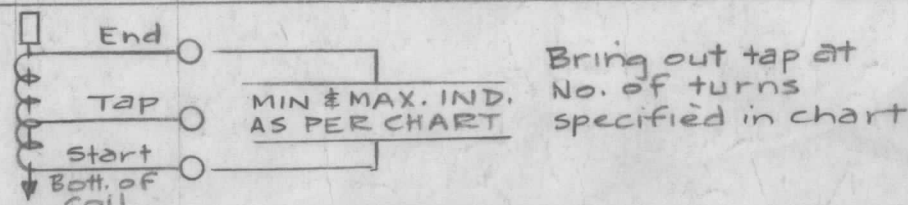
A-1614-2,3,4,6, will be close wound, single layer.

PROCEDURE

1. Secure terminals (items 2 & 3) to coil form with Insulex (item 6).
 2. Wind required number of turns of item 4 (wire) on coil form and bring out tap when required as per chart above.
 3. Stake wire ends to coil form with Q-Max (item 5).
 4. Solder coil leads to terminals.
 5. Bake for 1/2 hour at 210° F.
 6. Paint coil with Insulex. (item 6)
 7. Test unit as per chart and schematic, with core. Minimum & Maximum Inductance accomplished by adjusting tuning slug.
- (USE BOONTON Q-METER, MODEL 160 A OR EQUIV.)



ASS'Y. NO.	DIM. "A"	DIM. "B"
A-1614-1	1/4	3/8
A-1614-2	3/32	7/32
A-1614-3	3/32	7/32
A-1614-4 & 6	3/32	7/32
A-1614-5 & 7	1/4	7/16



MODEL NO.	USES	QUAN.	SYMBOL NO.
RFA-1	CL-149	2	T201, T204
	CL-150	2	T202, T205
	CL-151	2	T203, T206
RFB-1	CL-150	1	L202
	CL-175	1	L209
RFD-1 RFD-1A	CL-150	1	L202
	CL-175	1	L209
RFC-1	CL-181	1	L201
	CL-175	1	L209
	CL-150	1	L202
RFD-2	CL-175-2	1	L209
	CL-181-2	1	L201
	CL-150	1	L202

1	8	SEE CHART	CORE, TUNING
X	7	BS-100	Solder, Soft
X	6	GL-104-2	Insulex, U-85
X	5	GL-102	Cement, Q-Max.
X	4	See Chart	Wire
1	3	TE-153-2	Terminal, Ring Type
1	2	TE-170-3	Terminal, Collar Type
1	1	SEE CHART	Coil Form

W	1	ADD CL175 & CL181	12.6.66	17380	WAD	OK	OK
V	1	MACHINE DATA-6 & 7 ADDED RED-2, CL175, CL150 ADDED	11/22/65	15136	R.Y.K.	OK	MM
U	2	ON -5, INDUC. MIN. WAS 15.5 ON -5, INDUC. MAX. WAS 25.1	7.16.64	11880	WB	OK	OK
T	1	ITEM 2 RELOCATED	6-23-64	11626	A.M.	OK	OK
S	2	A-1614-6, 7 & IT. 8 ADDED COILFORM, CORE & COLOR COLUM. ADD. ITI WAS CE-107-2N	6.12.64	11553	WB	@	W

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
		TOLERANCES	SCALE: 1/16"				
		DEC. DIM. ±	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
		FRAC. DIM. ±					
		ANGULAR DIM. ±					

CHART	REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
CHART		RFD-1A	FAL-11KKA		8-7-59
CHART		RFB-1	GPT-10K		12-22-58
CHART		RFA-1	PAL-350		5-21-58

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE		RF COIL ASS'Y, TUNED	
MATERIAL		(CL-149, CL-150, CL-151, CL-175, 181)	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP. MECH. DES. APP.	

A-1614 W