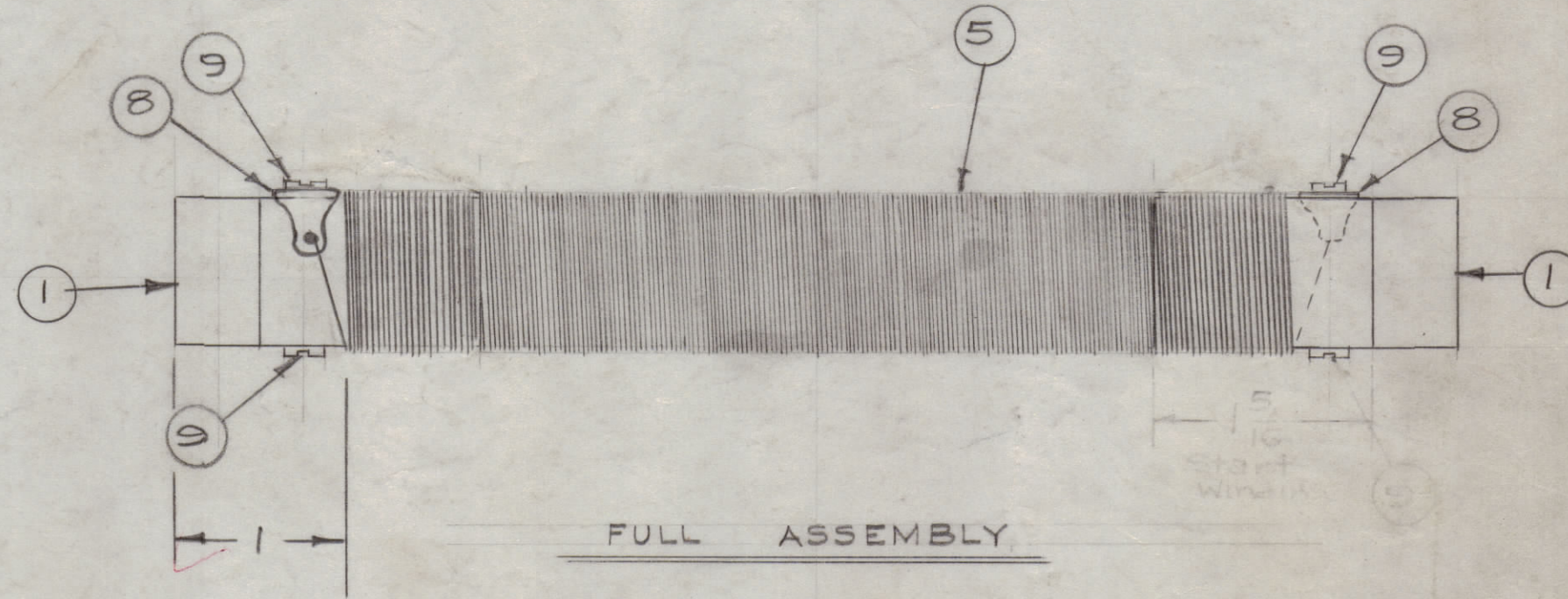
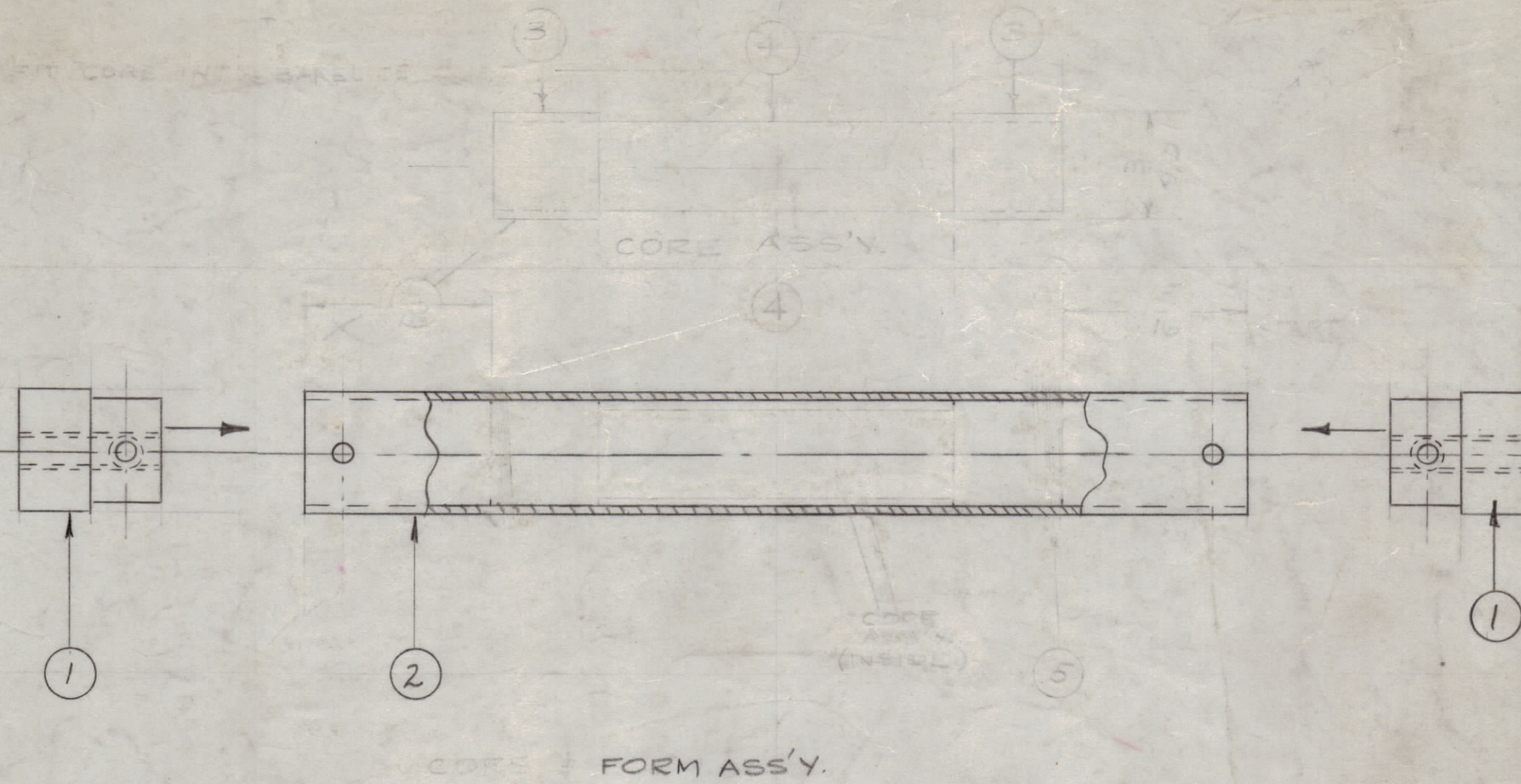


IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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

RECEIVING THIS DRAWING  
 THE TECHNICAL MATERIEL CORPORATION claims  
 the material disclosed hereon.  
 drawings issued in confidence for engineering  
 purposes only and may not be reproduced or used  
 to manufacture any part shown hereon without per-  
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 TION to the user. This drawing is loaned for mutual  
 assistance and is subject to recall at any time.

Property of:  
 THE TECHNICAL MATERIEL CORPORATION  
 MAMARONECK, NEW YORK



PROCEDURE

- 1 - BUILD UP TERRITS CORE (ITEM 4) WITH...
- 2 -...
- 3 - LEAVE...
- 4 -...
- 5 -...

PROCEDURE

- 1 - ASSEMBLE "END INSERTS" (ITEM 1) INTO COIL FORM AS SHOWN. ASSEMBLE SCREWS AND LUGS AS SHOWN.
- 2 - WIND APPROX. 118 TURNS OF WIRE (ITEM 5) ON COIL FORM, START WINDING 1" FROM END. STAKE WIRE ENDS TO FORM.
- 3 - SOLDER WIRE ENDS TO LUGS. (ITEM 8)
- 4 - COAT WINDING WITH INSULEX (ITEM 7)
- 5 - BAKE FOR 1 HOUR AT 200° F
- 6 - RECOAT WINDING WITH INSULEX (ITEM 7)
- 7 - BAKE FOR 1 HR. AT 200° F
- 8 - ALLOW UNIT TO COOL.
- 9 - TEST UNIT.

NOTE: IT IS NECESSARY TO TEST ONLY ONE COIL PER BATCH OF 10. ALL OTHERS WILL BE CHECKED MECHANICALLY ONLY.

TEST DATA

L = 45 Microhenries ±10%  
 Q = 130 or Greater  
 f = 2.5 MC

**SUPERSEDED**

DIRECTLY REPLACED BY CL154

A-1644 F

F	SUPERSEDED	6-9-71	20369	RZ			
E	IT. 3 FT. NO. WAS SCBS0632BC4	9/23/60	16905	JL			
D	TEST DATA L WAS ±5%	7-15-60	16570	JL			
C	REVISED NOTE 2; ADDED ±5% TOL. TO L ON TEST DATA	11/25/60	16401	JL			
B	5 L was .3mh, f was 790KC, Q was 35						
	4 chgd. 15/16" to 1" (winding)	11/25/59	1594	16			
	3 chgd # of turns from 79 to 118						
	2 dele. Core Detail & Proc. Steps pertaining to items 3 & 4						
A	1 dele. items 3 & 4						
A	1 Item 2 was CF-127	2-25-59	1	JCB			

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES		SCALE:					
ALL OTHERS	DEC. DIM. ±	DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.					
	FRAC. DIM. ±						
	ANGULAR DIM. ±						

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	10	GL-102	CEMENT, Q-MAX	
4	9	SCBP0632EN4	SCREW MACHINE	
2	8	TE-104-2	LUG, SOLDER	
X	7	GL-104-2	INSULEX, U85	
X	6	BS-100	SOLDER, SOFT	
X	5	WI-125-2	WIRE, CEROL # (17)	
	4		DELETED (WAS CI-112-Q-4L)	
	3		DELETED (WAS TA-101-4)	
1	2	CF-127-6.625	COIL FORM	
2	1	PM-557	INSERT, COIL FORM	

THE TECHNICAL MATERIEL CORP.	
MAMARONECK, NEW YORK	
STOCK SIZE	
CL-154 ASS'Y.	
MATERIAL	WEIGHT PER PC.
	1 (PLATE DECOUPLING COIL)
TYPE & TEMPER	
HEAT TREAT. SPEC.	
FINISH & SPEC. NO.	

REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
1	GPT-10K	CL-154		2-2-59
USED ON				