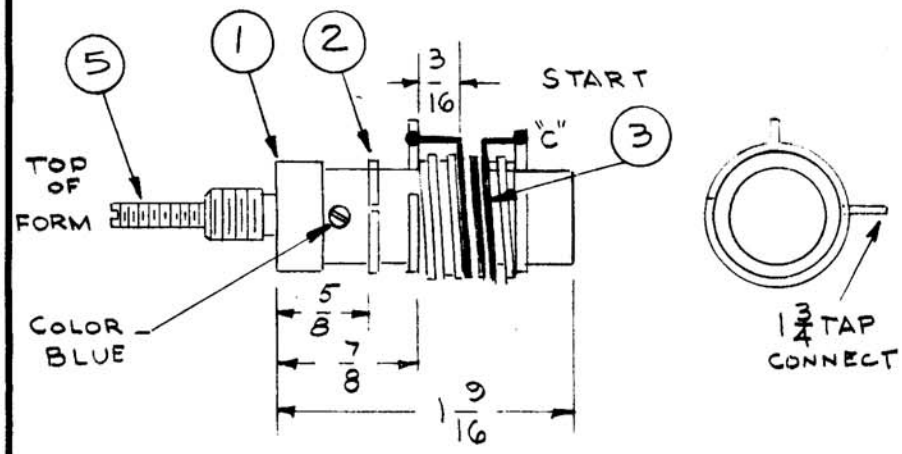
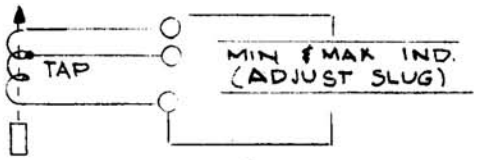
Minimum Inductance must be less than . uhy.
Maximum Inductance must be more than . uhy.
Q at 25 Mc must be more than 120
Test Frequency 25 Mc.
Operating Fr quency - 22-32 Mc.

REQ. PER UNIT	USED ON				
	MODEL	ASS'Y. NO.	DATE	A - 1740	A
	CL-182		8-7-59		



PROCEDURE

1. Slip two terminal rings (item 2) on form (item 1) as shown. (Marked "A" and "B").
2. Force fit outer form (item 3) onto inner form (item 1) and cement with Insulex (item 6).
3. Slip terminal ring marked "C" on inner form.
4. Cement all rings to inner form.
5. Wind 3 turns of wire (item 4) on outer form. Bring out tap at 1 7/8 turns from top. Slip sleeving (item 7) over tap. Solder all wire ends to proper terminals.
6. Paint Winding with Insulex.
7. Bake for 1/2 hour at 250° F.
8. Insert Core (item 5).
9. Test as shown below. Use Boonton Q - Meter Model 160A or Equivalent.



REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	8	BS-100	Solder, Soft	
1/2"	7	PX-100-1-.053	Insulation, Sleeving (Size 16)	Blk
X	6	GL-104-2	Insulex, U85	
1	5	CI-109-19	Core, Tuning, Red	
X	4	WL-100-5	Wire, Buss (Size 18)	
1	3	CF-125-3P0.50	Coil, Form, Grooved	
3	2	TE-153-3	Terminal, Ring Type	
1	1	CF-119-1.562	Coil Form, w/bushing	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	1	1 7/8 TAP WAS 2"	2-18-60	1854	W.F		

TOLERANCES

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

STOCK SIZE

MATERIAL

TYPE & TEMPER | HEAT TREAT. SPEC.

FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

CL-182 ASSEMBLY
(COIL, RF, TUNED, 22-32 MC)

DRAWN	CHECKED	FINAL APPROVAL
8-7-59		A-1740 A

ELEC. DES. APP. | MECH. DES. APP.

FORM 106-A