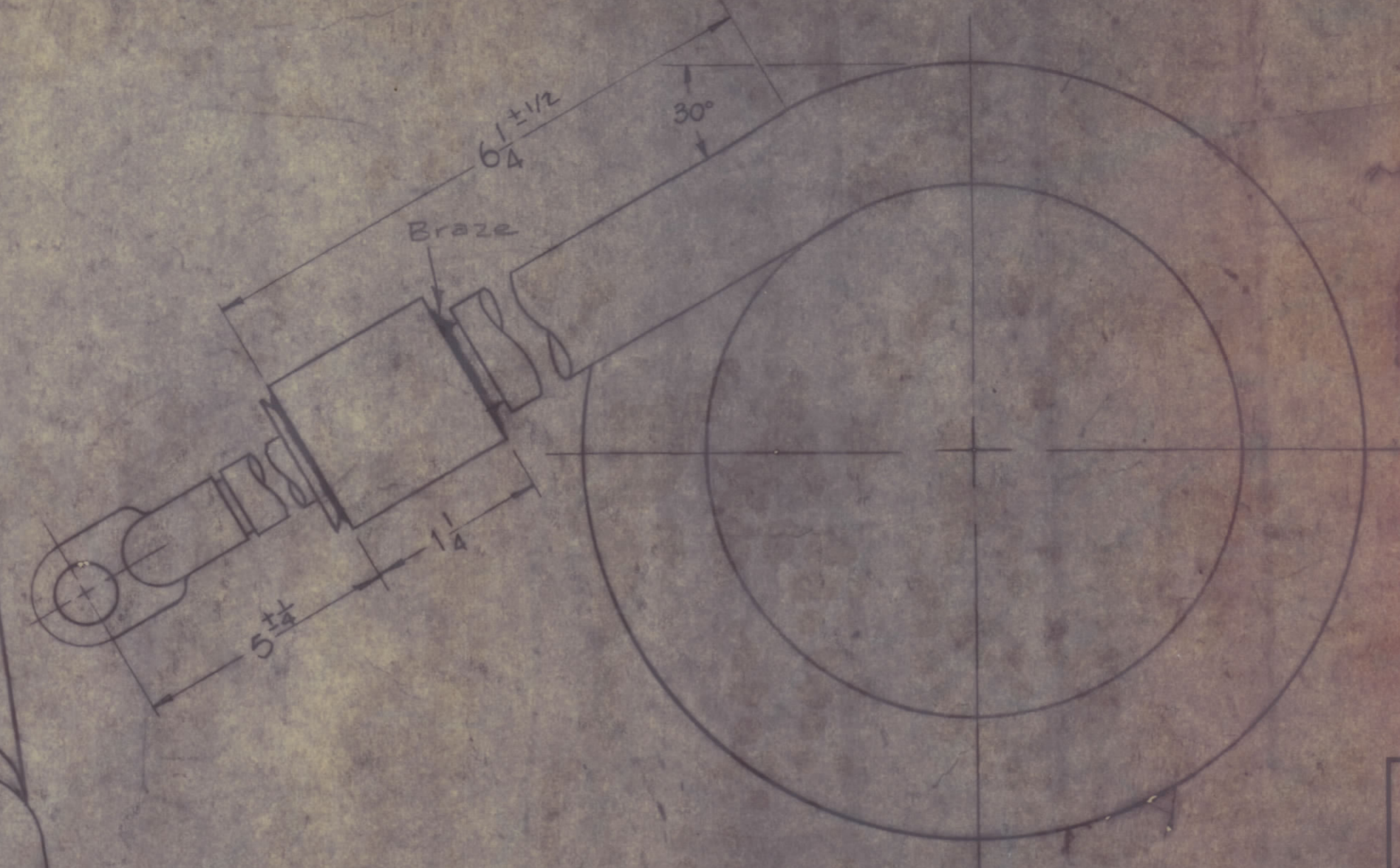
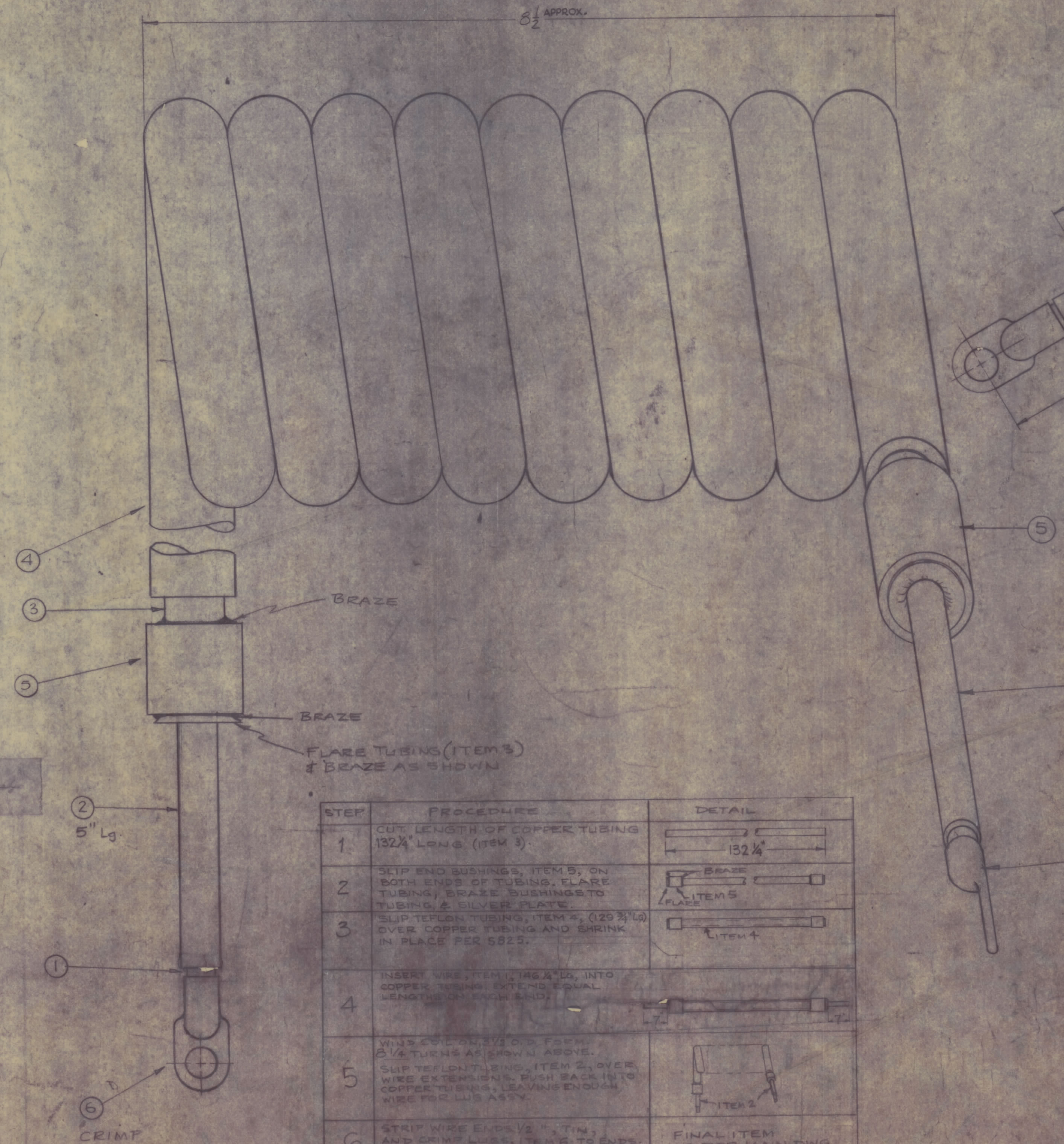
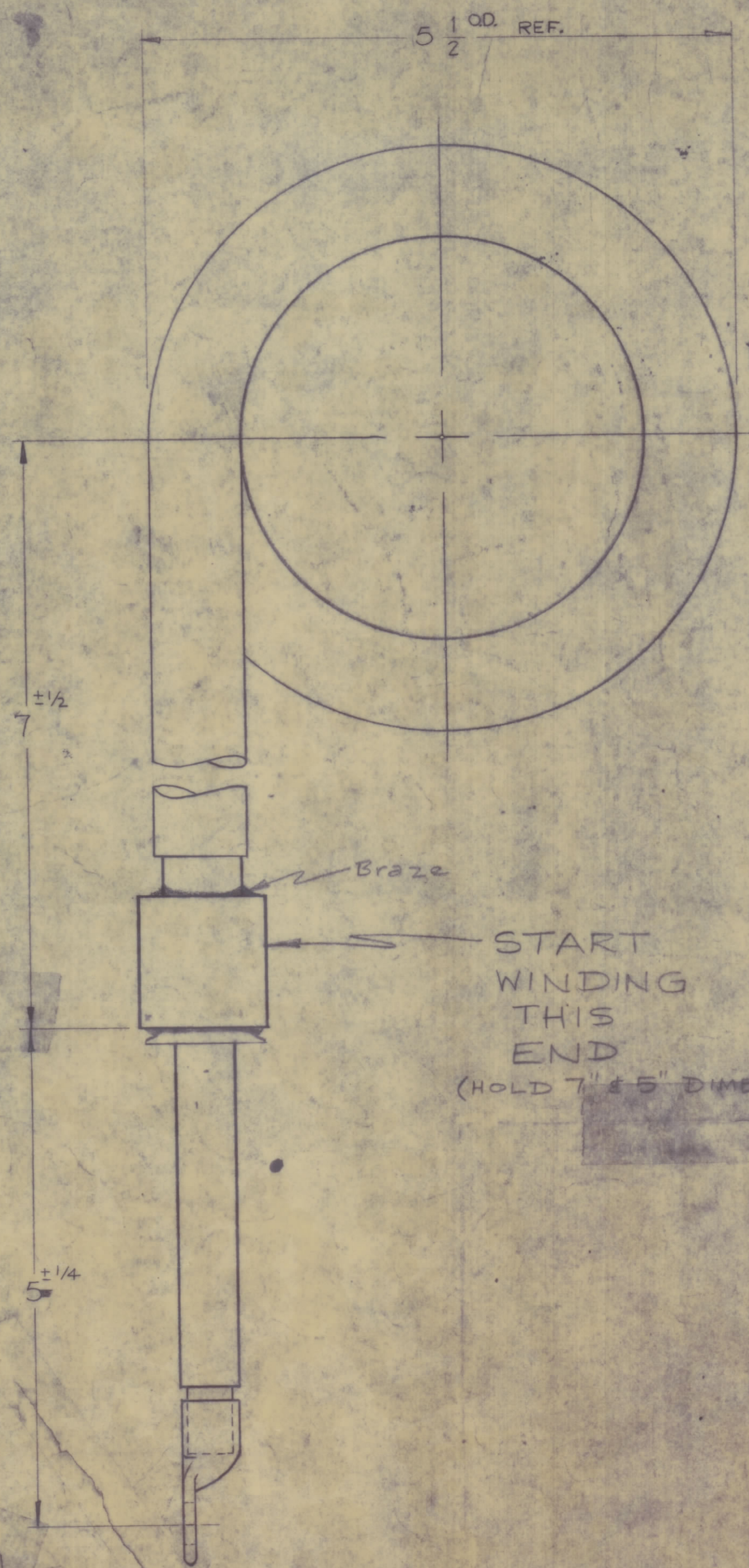


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 MAMARONECK, NEW YORK



SPECS
 OUTER COIL INDUCT. - 6 Microhenries
 INNER COIL INDUCT. - 7 Microhenries
 Q - 220 (OUTER)
 185 (INNER)
 TEST FREQ. - 7.9 MC

OBsolete
 USE CL220

NOTE:
 WIND COIL ON 5/2 DIA. FORM,
 (AS PER STEP 5)

STEP	PROCEDURE	DETAIL
1	CUT LENGTH OF COPPER TUBING 132 1/4" LONG (ITEM 3)	
2	SLIP END BUSHINGS, ITEM 5, ON BOTH ENDS OF TUBING. FLARE TUBING, BRAZE BUSHINGS TO TUBING & SILVER PLATE	
3	SLIP TEFLON TUBING, ITEM 4, (129 3/4" LG) OVER COPPER TUBING AND SHRINK IN PLACE PER 5825.	
4	INSERT WIRE, ITEM 2, 160 1/2" LG, INTO COPPER TUBING EXTENDING EQUAL LENGTH ON EACH END.	
5	WIND COIL ON 5/2 DIA. FORM, 8 1/2 TURNS AS SHOWN ABOVE. SLIP TEFLON TUBING, ITEM 4, OVER WIRE EXTENSIONS. PUSH BACK IN TO CONTACT WITH WIRE, LEAVING ENOUGH WIRE FOR LUG ASSY.	
6	STRIP WIRE ENDS 1/2" (TIN) AND CRIMP LUGS, ITEM 6, TO ENDS.	

ISSUE NO.	DESCRIPTION	DATE	CH. NO.	QTY.	CHECKER	ENG. APP.
H	OBsolete NOTE ADDED	10-30-67	18575	148	FB	10
G	ADD TOL. TO 5, 6 1/4 & 7" DIMS.	3-1-67	17872	RME		
F	ITEM 4 PART NO. ADDED & SHRINK WAS EXPANDED. PER 5825 ADDED TO STEP 3	6-29-64	1657	A.M.		
E	8 1/2 APPROX. WAS 11" APPROX.	8/16/68	10528			
D	ITEMS (1) QTY WAS 100 (2) QTY WAS 130 (3) QTY WAS 100 (4) QTY WAS 100 (5) QTY WAS 100 (6) QTY WAS 100 (7) QTY WAS 100 (8) QTY WAS 100 (9) QTY WAS 100 (10) QTY WAS 100 (11) QTY WAS 100 (12) QTY WAS 100 (13) QTY WAS 100 (14) QTY WAS 100 (15) QTY WAS 100 (16) QTY WAS 100 (17) QTY WAS 100 (18) QTY WAS 100 (19) QTY WAS 100 (20) QTY WAS 100	4-30-63	8906			
C	BZ ADDED ITEM (6), ITEM (2) QTY WAS 2	4-18-63	8777			
B	AZ ITEM 1 WAS WZ-137-1	8-23-61	7116			
A	3788					

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
1	8	TE 178-3	LUG, TERMINAL	
X	7	BS 101	SOLDER, SILVER	
1	6	TE 178-1	LUG, TERMINAL	
2	5	PM 625	BUSHING, END	
123	4	PX845 220	SLEEVING, TEFLON, SHRINK	
374	3	TU 100-12N	TUBING, COPPER, 3/4 OD	
10	2	PX 370-62-7	SLEEVING, TEFLON, 5/8 ID	
161	1	WI 137-2	CABLE, STRANDED SIZE 0	

THE TECHNICAL MATERIEL CORP.		MAMARONECK, NEW YORK	
STOCK NO.	CL-220 ASSY (COIL, PA	DATE	3-16-60
MATERIAL	FILAMENT)	BY	
TYPE & QUANTITY		REV.	
HEAT TREAT SPEC.		DATE	