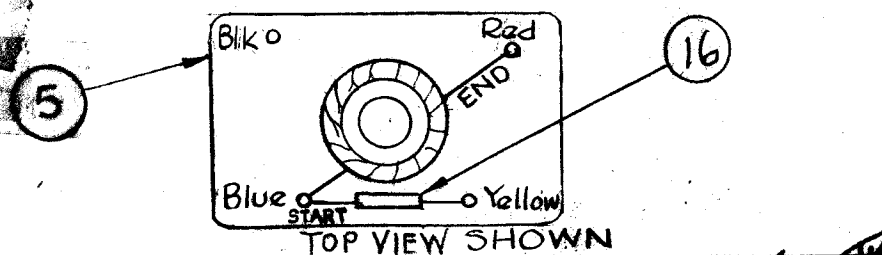
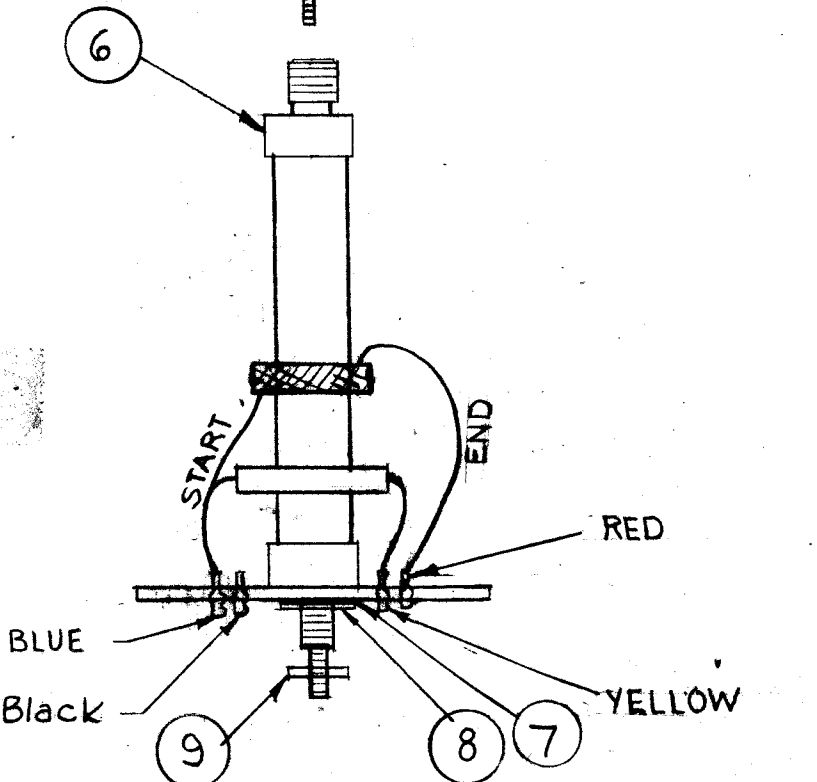
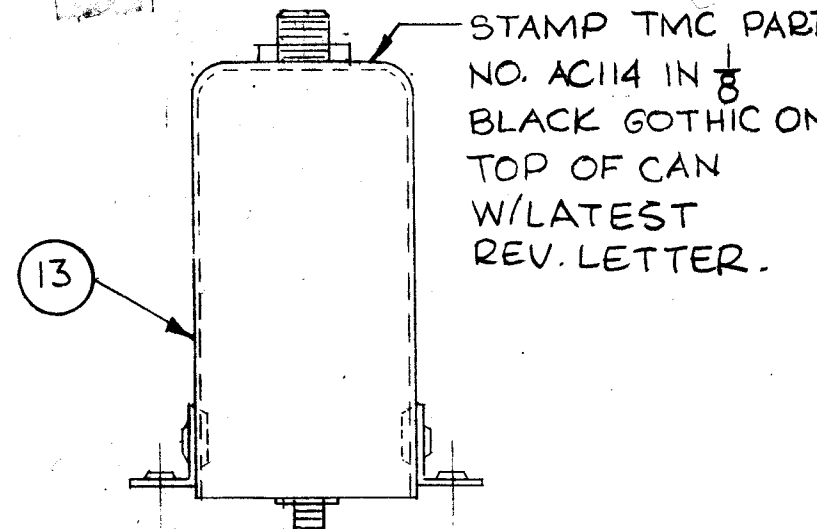


A 1860

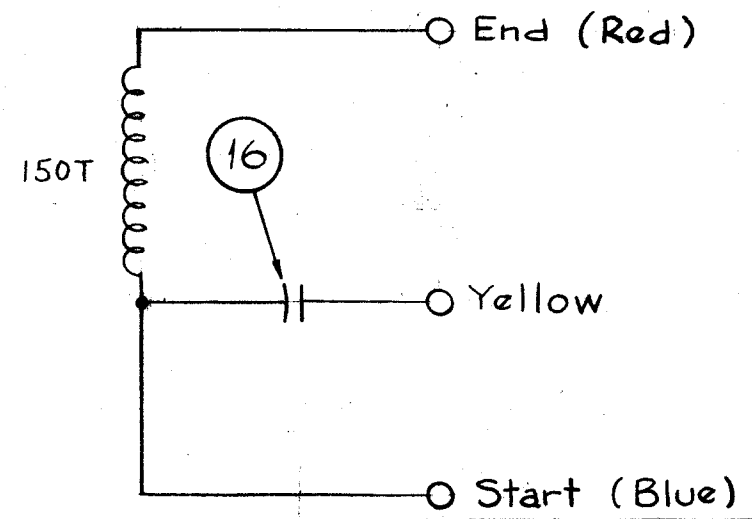
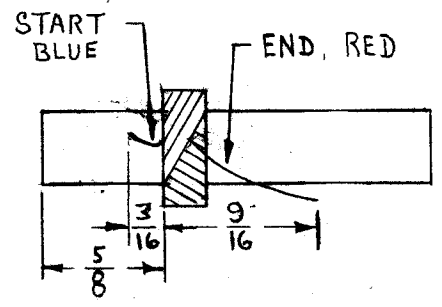


**WINDING MACHINE DATA**

CAN GEAR 104  
 DRIVER GEAR 68  
 CAM .187

**WINDING DATA**

1. START WINDING 5/8" FROM END OF FORM
2. END WINDING AT 150 TURNS
3. KEEP ALL LEADS APPROX. 2" LONG
4. STAKE LEADS TO COIL FORM WITH ITEM (GL-103).
5. BAKE FOR 1/2 HOUR AT 285° F
6. IMMEDIATELY APPLY COATING OF ITEM (GL-104-2)
7. BAKE HARD FOR 1/2 HOUR AT 285° F
8. TEST AS DESCRIBED.
9. ASSEMBLE AS SHOWN.



**TEST DATA (W/OUT CORE)**

L = 280 MICROHENRIES ± 10%  
 Q = 80 OR GREATER  
 FREQ = 790 KC  
 USE BOONTON RADIO CORP. Q METER MODEL 160 A OR EQUIV.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
20	DELETED		
19	DELETED		
18	DELETED		
17	DELETED		
16	CM15E361G03	CAPACITOR, FIXED MICA	
X 15	BS 100	SOLDER, SOFT	
14	DELETED		
13	A 1513	CAN ASS'Y,	
12	CI 109-7	CORE, TUNING	
11	DELETED		
10	DELETED		
9	NTH0632 BN8	NUT, HEX	
8	NT102	NUT, HEX	
7	LWI 25 MRN	LOCKWASHER	
6	SM 145	BUSHING, COIL MOUNTING	
5	PX 547	TERMINAL BOARD	
X 4	GL 104-2	RESIN, SYNTHETIC	
X 3	GL 103	CEMENT	
X 2	WI 104-541SCQS	WIRE, LITZ	
1	CF 117-2.0	COIL FORM	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFT	CHECKER	ENG. APP.
D	1	COMPLETELY REVISED PER EMN # 13440	2-15-65	13440	DR.										
C	1	± 10% Tol. Added to L	3/16/61	4442	DYM			G		IT 8 WAS NTH2528BN14	1-23-67	17680	RME		
B	2	Red Ter. was Blk. Blk. was Red. ITEM 11 Relocated. ITEM 17 deleted. (CM35B10SK)	10-15-60	3229	J.C.B.			F		IT 16 WAS CM20B361J	12-20-66	17534	WHD		
A	3	ITEM 9 WAS NTH0632BN8. ITEM 8 WAS NTH2528BN14. ITEM 7 WAS LWI25MRN.	5/25/60					E		STAMPING CHG FR. SIDE TO TOP	3-11-66	15911	WHD		

**TOLERANCES**  
 DEC. DIM. ±  
 FRAC. DIM. ±  
 ANGULAR DIM. ±

**SCALE:**  
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS CAUSE FOR REJECTION.  
 ALL BURRS AND SHARP EDGES

1	CHL-1			4-8-60
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE

**THE TECHNICAL MATERIEL CORP.**  
 MAMARONECK, NEW YORK

AC-114 ASS'Y  
 COIL TUNED (500 KC AMP)

TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
FINISH & SPEC. NO.	ELEC. DES. APP.	MECH. DES. APP.	A1860	