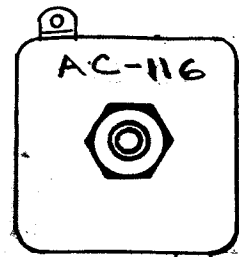
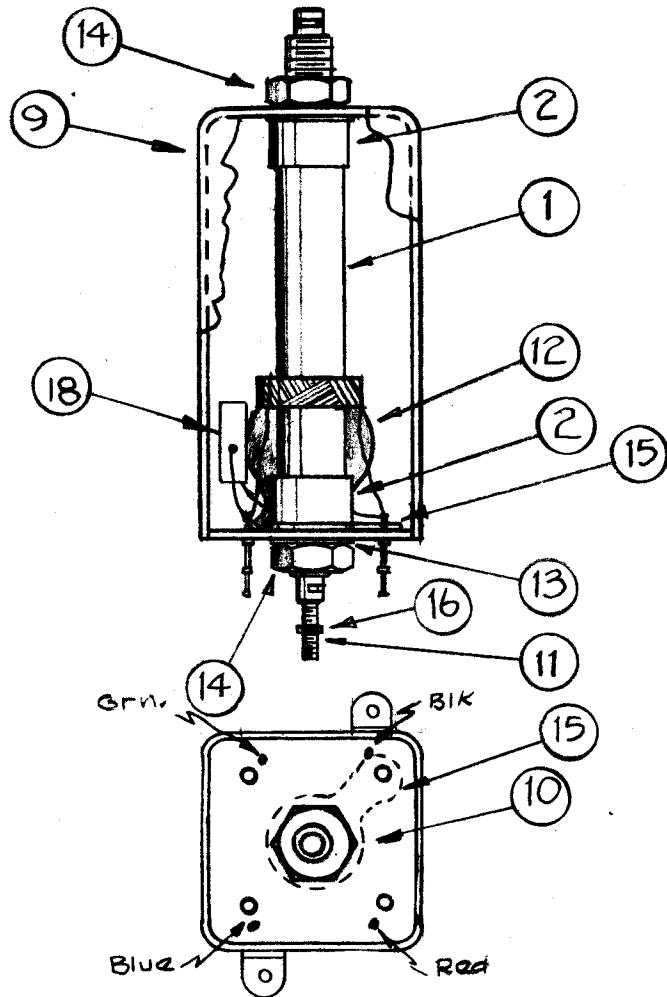


A 1866 E

Stamp Can as shown - 1/8 high Black Gothic  
 Note - Stamp TMC insignia & Approval  
 on side of can.



Cement coil form to bushings with  
 item 8 (GL-104-2).



Color Code Terminal Bd. as shown.

**WINDING MACHINE DATA (FOR PI WINDING)**

Can Gear = 104  
 Driver Gear = 68  
 Cam = .187

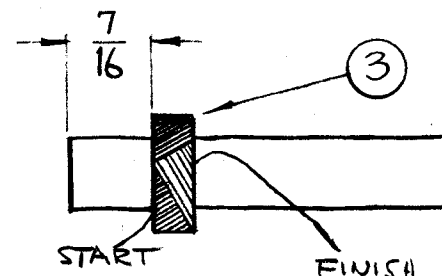
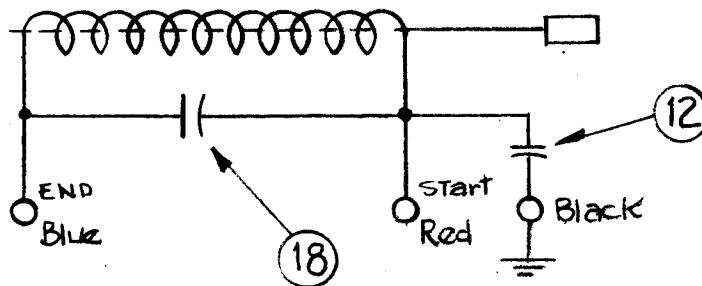
**WINDING DATA**

1. Start winding 7/16 from end of form.
2. End winding at approximately 140 turns.
3. Keep all leads approximately 3" long.
4. Stake leads to coil form W/GL-103. (ITEM 7)
5. Fasten ends of WI-104-541 DSQ 5 (Item 3) to ring terminals.
6. Bake unit for 1/2 hour at 215° F.
7. Coat windings W/GL-104-2 (ITEM-8)
8. Bake hard for 1/2 hour at 215° F.
9. Test as shown below.
10. Assemble as shown.

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

L = 230 uh ± 5 uh  
 Q = 85 or greater  
 FREQ. = 790 kcs.

Color Codes for Terminal Bd Shown Below



ACTUAL  
 SIZE

1	18	CM15F391G03	CAPACITOR, FIXED, MICA
X	17	BS 100	SOLDER, SOFT
1	16	NTH0632BN8	NUT, HEXAGON
1	15	TE 104-5	TERMINAL, LUG
2	14	NT 102	NUT, HEXAGON
3	13	LW125MRN	WASHER, LOCK, INTERNAL
1	12	CC 100-24	CAPACITOR, FIXED, CERAMIC
1	11	CI 109-7	CORE, TUNING
1	10	PX-547	TERMINAL BOARD
1	9	A-1864	CAN ASSEMBLY
X	8	GL-104-2	INSULEX, U85
X	7	GL-103	ADHESIVE, DUCO
	6	DELETED	
	5	DELETED	
	4	DELETED	
X	3	WI 104-541 DSQS	WIRE, LITZ, 5/41
2	2	SM-145	BUSHING, COIL MOUNTING
1	1	CF-117-2.0	FORM, COIL, 3/8 OD

E		IT 14 WAS NTH2528BN14 IT 18 WAS CM20C391K	1-23-67	17680	RME	JCS	
D	2	PICT. UPDATED, IT 5 WI-100-8 DELE IT 4 TE-153-2, IT 6 PX-104-5-DELE	9-18-64	12394	AB		
C	1	DWG UPDATED	1/11/63	10428			
B	1	ON BOTTOM VIEW OF ASSY MTG BRK POSITION CORRECTED	4-26-61	4758	WAF	JCS	
A	2	1/8 DIM. ADDED	9-23-60	3069	CU		
A	1	1-3/16 DIM. ADDED	23				
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

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

1	CMO	T 306	AX-224	4-14-60
REQ. PER UNIT	MODEL	SYMBOL	ASSY. NO.	DATE
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
AC-116 ASSEMBLY			
COIL, RF, TUNED			
TYPE & TEMPER		HEAT TREAT. SPEC.	FINISH & SPEC. NO.
DRAWN		CHECKED	FINAL APPROVAL
A.R.F.			A 1866 E
ELEC. DES. APP.		MECH. DES. APP.	