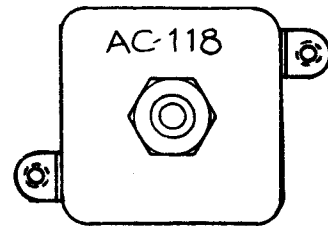


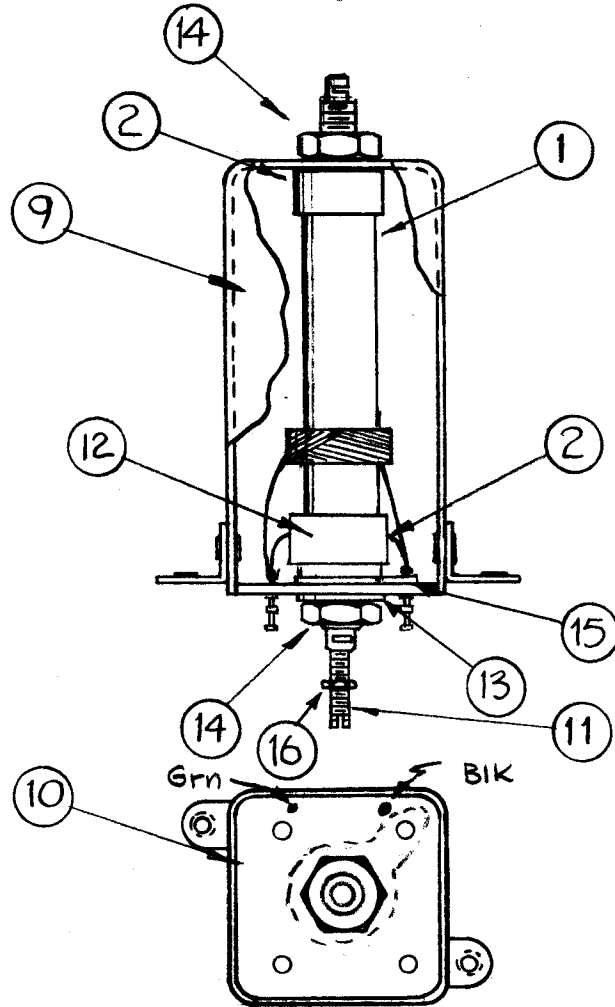
A1868 D

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 Bias shown.

WINDING MACHINE DATA (FOR PI WINDING)

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

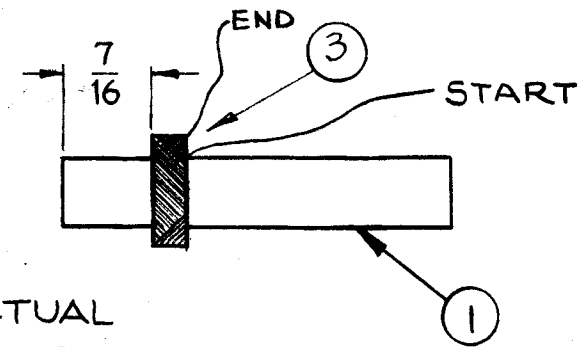
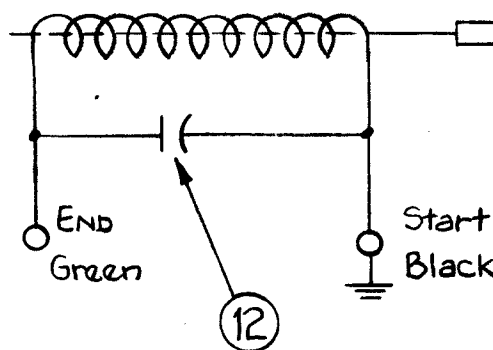
WINDING DATA

- Start winding 7/16 from end of form.
- End winding at 95 turns.
- Keep all leads approximately 3" long.
- Stake leads to coil form W/GL-103. (ITEM 7)
- Fasten ends of WI-104-541-DSQS (Item 3) to ring terminals.
- Bake unit for 1/2 hour at 215° F.
- Coat windings WITH GL-104-2 (ITEM 8)
- Bake hard for 1/2 hour at 215° F.
- Test as shown below.
- Assemble as shown.

TEST DATA (W/OUT CORE)

L = 96 uh ± 15 uh
Q = 75 or greater
FREQ. = 790 kcs.

Color Codes for Terminal Bd. Shown Below.



ACTUAL SIZE

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	LWI 25MRN	LOCK WASHER, INTERNAL	
1	12	CM20F751G03	CAPACITOR, FIXED	
1	11	CI 109-7	CORE, TUNING	
1	10	PX 547	TERMINAL BOARD	
1	9	A-1864	ASSEMBLY, CAN	
X	8	GL-104-2	INSULEX, U85	
X	7	GL-103	CEMENT, 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	COIL FORM, 3/8 OD	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
AC-118, ASSEMBLY			
MATERIAL			
COIL, RF TUNED			
TYPE & TEMPER		HEAT TREAT. SPEC.	FINAL APPROVAL
DRAWN		CHECKED	
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
D		B/U UPDATED (13, 14)	1-23-67	17680	RME	JCB	
C	2	PICT. UPDATED, IT. 5 WL-100-8 DELE	9-18-64	12394	HB	@	
B	1	On test data L was ± 3uh	6-9-61	5046	WAF	JCB	
A	2	1/8 DIM. ADDED	9-23-60	3069	CY	JCB	
A	1	1-3/16 DIM. ADDED					

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	T307	AX-224	4-14-60
REQ. PER UNIT	MODEL	SYMBOL	ASS'Y. NO.	DATE
USED ON				