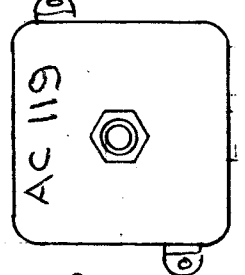


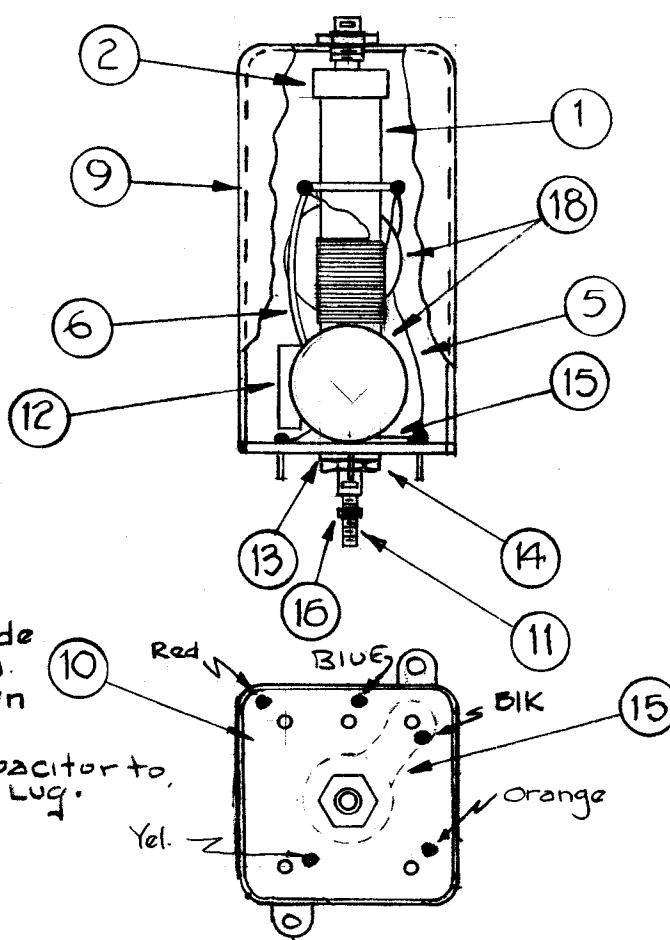
A 1869

Stamp Can as shown - 1/8 high Black Gothic

Note: Stamp TMC insignia & Approval on side of Can.



Cement Coil form to bushing with item 8 (GL-104-2).



Color Code Term. bd. as shown  
Wire Capacitor to ground Lug.

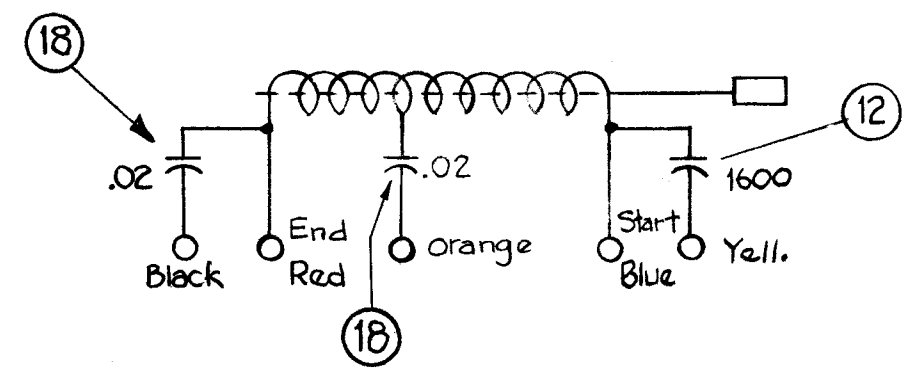
DATA

1. Start winding 7/16 from end of form.
2. Tap winding at 46 turns, then wind 8 additional turns.
3. Keep all leads approximately 3" long.
4. Stake leads to coil form W/GL-103.
5. Assemble ring terminals (Item 4) on form as shown and stake W/GL-104-2 (Item 8). Position rings as shown.
6. Fasten ends of WI-106-15 (Item 3) to ring terminals.
7. Bake unit for 1/2 hour at 215° F.
8. Coat windings and ring terminals W/GL-104-2.
9. Bake hard for 1/2 hour at 215° F.
10. Test as shown below.
11. Assemble as shown.

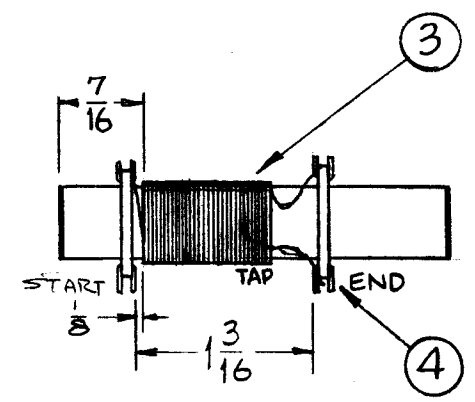
TEST DATA (W/OUT CORE)

L = 17 (± 10%)  
Q = 75 or greater  
FREQ. = 2.5 mc.

Color Codes for Terminal Bd. Shown Below.



ACTUAL SIZE



2	18	CC-100-24	CAPACITOR, FIXED	
X	17	BS-100	SOLDER, SOFT	
1	16	NTH0632BN8	NUT, HEXAGON	
1	15	TE-104-5	TERMINAL, LUG	
2	14	NT102	NUT, HEXAGON	
3	13	LWI25MRN	LOCK WASHER, INTERNAL	
1	12	CM100-11	CAPACITOR, FIXED	
1	11	CI-109-7	CORE, TUNING	
1	10	PX-403	TERMINAL BOARD	
1	9	A-1864	ASSEMBLY, CAN	
X	8	GL-104-2	INSULEX, U85	
X	7	GL-103	CEMENT, DUCO	
X	6	PX-104-5-.022	INSULATION, SLEEVING	GREEN
X	5	WL-100-8	BUSS BAR #24	
2	4	TE-170-2	TERMINALS, COLLAR	
X	3	WI-106-15	WIRE, MAGNET #34 DSB	
2	2	SM-145	BUSHING, COIL MOUNTING	
1	1	CF-117-2.0	COIL FORM, 3/8 OD	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK, NEW YORK			
AC-119, ASSEMBLY			
COIL, RF, TUNED, T302			
MATERIAL		TYPE & TEMPER	HEAT TREAT. SPEC.
STOCK SIZE		DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

REV.	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
1	B/M UPDATED	1-30-67	17680	RME		
TOLERANCES		SCALE:				
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES						

1	CMO	T302	AX-224	4-13-60
REQ. PER UNIT	MODEL	SYM. NO.	ASSY. NO.	DATE
USED ON				

DRAWN: *[Signature]*  
 CHECKED: *[Signature]*  
 FINAL APPROVAL: *[Signature]*  
 ELEC. DES. APP. *A.R.F.* MECH. DES. APP. *[Signature]*  
 A-1869 E