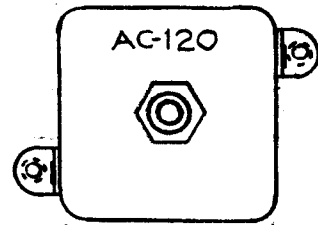


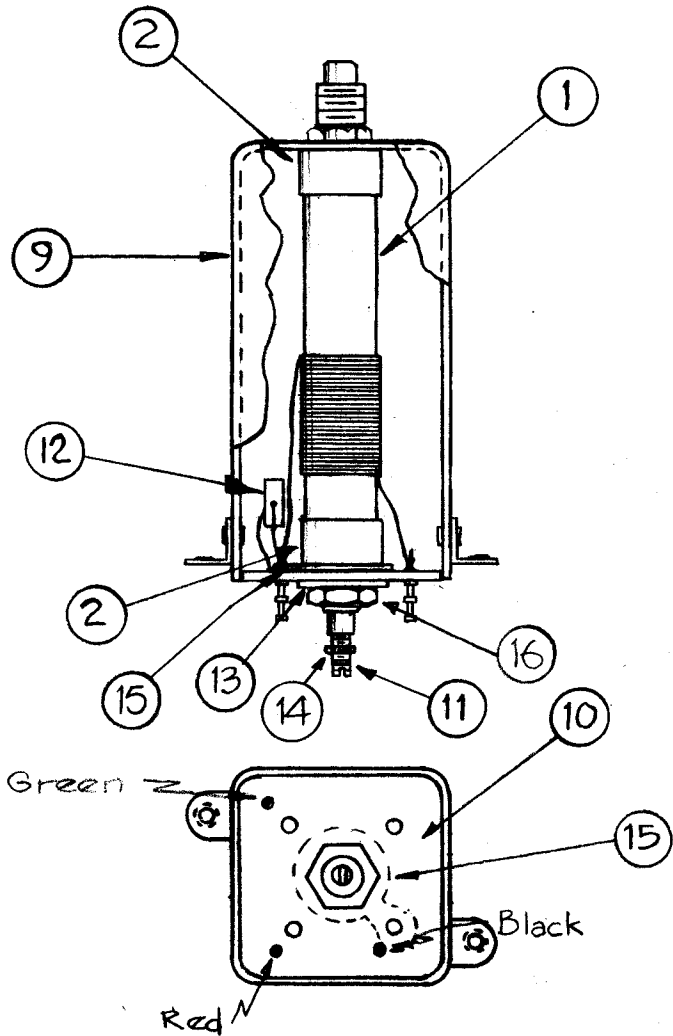
A-1870

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 Board as shown.

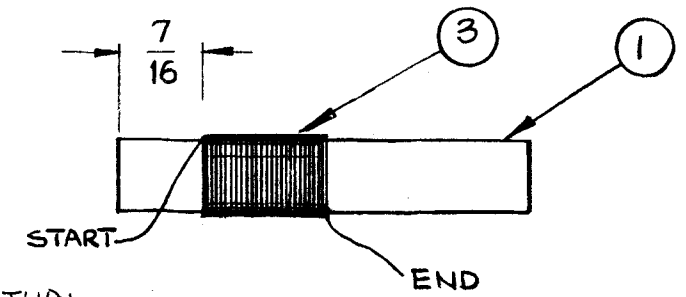
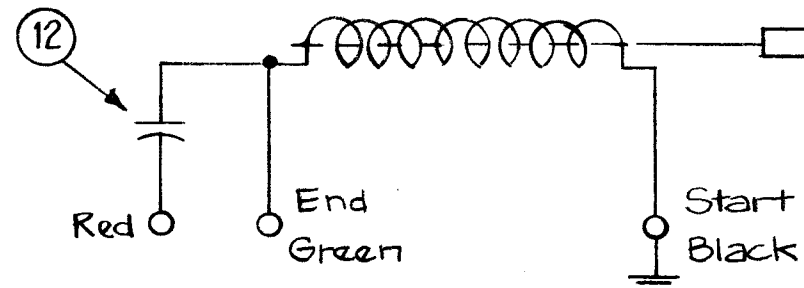
WINDING DATA

1. Start winding 7/16 from end of form.
2. End winding at 52 turns.
3. Keep all leads approximately 3" long.
4. Stake leads to coil form W/GL-103. (ITEM 7)
5. Fasten ends of WI-106-15 (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 = 15 (±1) uh
 Q = 75 or greater
 FREQ. = 2.5 mc.

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	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-547	TERMINAL BOARD
1	9	A-1864	ASSEMBLY, CAN
X	8	GL-104-2	INSULEX, U85
X	7	GL-103	CEMENT, DUCO
	6		
	5		
	4		
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
THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK			
STOCK SIZE			
AC-120 ASSEMBLY			
COIL, RF, TUNED, T301			
MATERIAL			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	FINAL APPROVAL
		A.R.F.	A-1870 E
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
E		B/M UPDATED	1-16-67	17673	440		
D	2	PICT. UPDATED, IT. 5 WL-100-8 DEL. IT. 4 TE-153-2, IT. 8 PX-104-5 DELE	9-18-64	12394	WJB		
C	2	ON TEST DATA L WAS 18 ± 1 uh	3-1-61	4250	W.A.F.		
B	2	ON TEST DATA #2 WAS 58 TURNS					
B	1	ON TEST DATA L WAS 19 uh	12-14-60	3715	W.A.F.		
A	2	ON WINDING DATA #2 WAS 64 TURNS					
A	1	1/8 DIM. ADDED	9	3069	W		
A	1	1-3/16 DIM. ADDED	2360	3069	W		

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