

A 1981 E

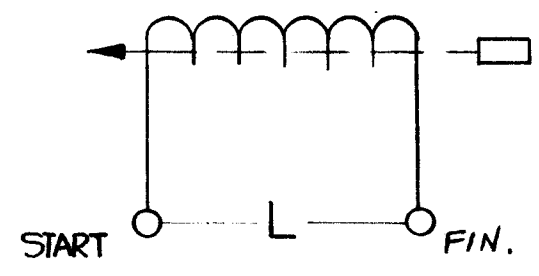
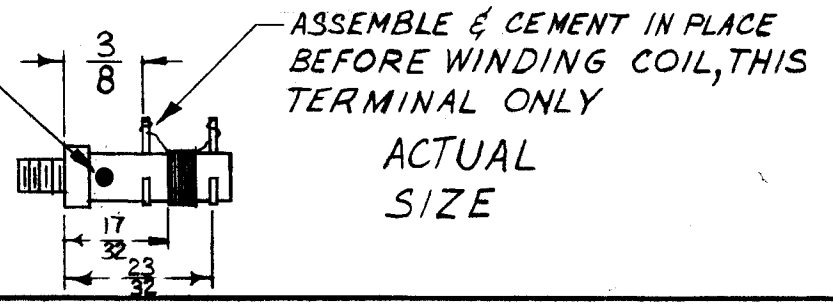
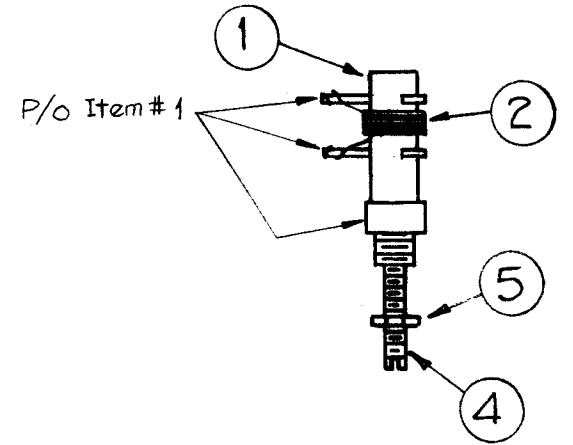
TMC MFG. ASSY NO	TMC PART NUMBER	NO OF COIL TURNS	NOMINAL IND (why) % CORE *	TEST FREQ.	Q at test Freq MUST BE GREATER THAN	OPERATING FREQ (MCS)	BAND	CHG SYMBOLS
A-1981-1	CL-246	15	1.23 ±10%	7.9 mc	65	16	9	L 1115
A-1981-2	CL-247	12	0.92 ±10%	7.9 mc	55	18, 20, 20, 20	(12) 10, 11	L 1114, 1122, 1108, 1144
A-1981-3	CL-248	NOT USED						
A-1981-4	CL-249	9	0.63 ±10%	25 mc	90	22, 22, 24, 24	3, 12, 4, 13	L 1121, 1109, 1110, 1120
A-1981-5	CL-250	NOT USED						
A-1981-6	CL-251	7	0.45 ±10%	25 mc	85	26, 26, 28	5, 14, 15	L 1119, 1111, 1112
A-1981-7	CL-252	NOT USED						
A-1981-8	CL-253	6	0.36 ±10%	25 mc	80	30	16	L 1113

WINDING DATA

1. Start winding 17/32 from end of bushing as shown
2. End winding at specified turns for particular frequency required (see chart).
3. Keep all leads approximately 3" long.
4. Stake leads to coil form with item 7.
5. Assemble ring terminal on end of form as shown and stake with item 7.
6. Fasten end of item 2 to ring terminals.
7. Bake unit for 1/2 hour at 215° F.
8. Coat windings and ring terminals with item 8.
9. Bake hard for 1/2 hour at 215° F.
10. Test according to specifications in chart.

COLOR NO.	CODE COLOR	REQUIRED PER UNIT
CL-246	BLACK	1
CL-247	BROWN	4
CL-249	RED	4
CL-251	ORANGE	3
CL-253	YELLOW	1

NOTE
* "L" TO BE MEASURED WITH LEADS 1" LONG.



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 8	GL-104-2	Insulex, U85	
X 7	GL-103	Duco Cement	
	6	DELETED	
1 5	NTH0348BN6	Nut, Hex	
1 4	CI-116-5	Core, Tuning	RED
	3	DELETED	
X 2	WI-107-15	Magnet Wire, DSC (Size 34)	
1 1	CF-110-N-1	Coil Form, .250 O.D.	

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK
MULTIPLIER COILS
MODEL CHG-1

E	ADD * NOTE, ADD * TO NOMINAL IND.	1-25-67	17724	RME	QC		
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES		SCALE:					
DEC. DIM. ±		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.					
FRAC. DIM. ±		REMOVE ALL BURRS AND SHARP EDGES					
ANGULAR DIM. ±							

1	CHG-1	MF/RF		9-23-60
REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
USED ON				

TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
		A.R.F.		A 1981 E
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	