

THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.

REQ. PER UNIT

3

MODEL

HFS-1

USED ON

ASS'Y. NO.

3500

DATE

8-15-62

A-2441

F

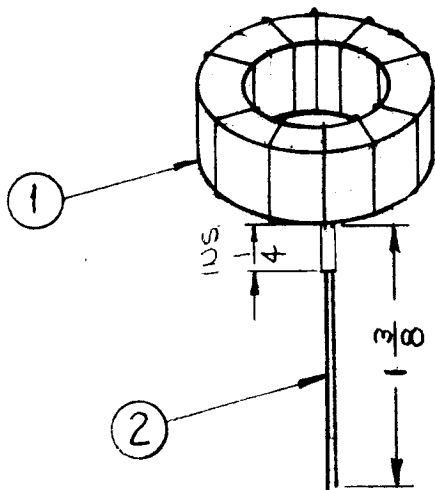
PROCEDURE

1. WIND WI-123-18 (ITEM 2) 10 TURNS EVENLY SPACED ON FULL CIRCUMFERENCE OF CI-127-1 (ITEM 1).
2. STRIP & TIN ENDS 1/4" FROM COIL FORM
3. PUSH TURNS TOGETHER OR SPREAD APART TO MEET INDUCTANCE SHOWN IN ELECTRICAL SPECS.
4. COAT ENTIRE COIL WITH GL-102 (ITEM 3).

ELECTRICAL SPEC~

L ~ .47 ± .02 μh
 Q ~ 190 OR GREATER
 TEST FREQ ~ 25 MC

NOTE~ USE BOONTON CORP. Q METER MODEL 160A OR EQUIV.



X	4	BS-100	SOLDER, SOFT
X	3	GL-102	Q-DOPE
X	2	WI-123-18	WIRE, MAGNET #18
1	1	CI-127-1	CORE, TORROID

F	CHG'D WORDING ON 3	12-13-66	17488	RME	<i>[Signature]</i>	<i>[Signature]</i>
E	DIM STEP 2 WAS 1/2	5/27/66	16306	WFW	<i>[Signature]</i>	<i>[Signature]</i>
D	STEP 1 REV.; STEPS DELETED L WAS .40 ± .05 μh; Q WAS 160 30° APPROX DELETED; 1 3/8 RELOC.	4/29/64	1126	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

REQ. ITEM	PART NO.	J STRUMER	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK CL-293 ASS'Y (COIL R.F., 40.5 MC)				
STOCK SIZE				
MATERIAL				
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
		<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
FINISH & SPEC. NO.		REC. DES. APP.	MECH. DES. APP.	
		<i>[Signature]</i>	<i>[Signature]</i>	A-2441 F

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON
 FRAC. ± 1/64 DEC. ± .005 ANGLES ± 1/2°

SCALE: DO NOT SCALE
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
 REMOVE ALL BURRS AND SHARP EDGES

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REQ. PER UNIT
3

MODEL
HFR-1/T

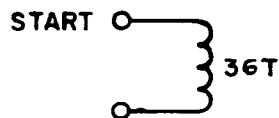
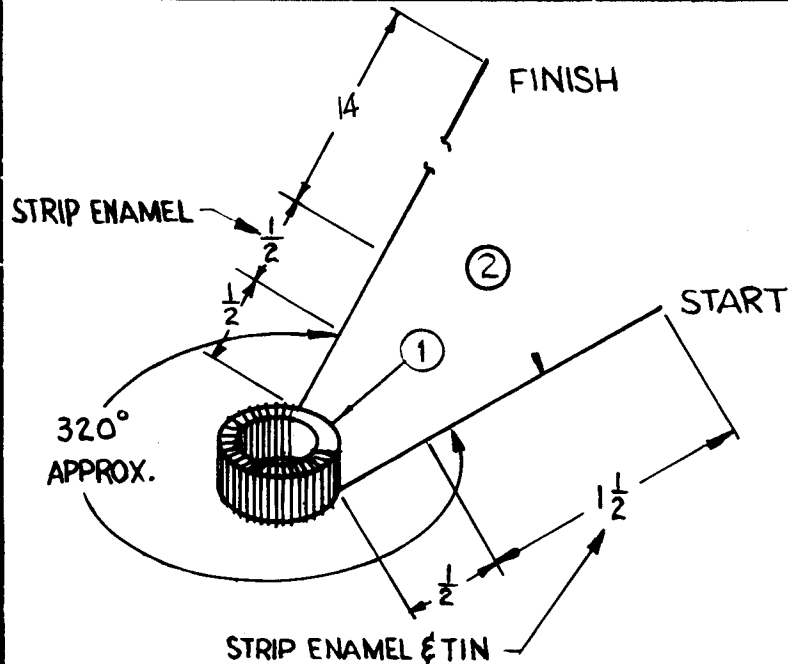
USED ON

ASS'Y. NO

DATE

6-9-62

A-2476 B



SCHEMATIC

PROCEDURE

- 1- APPROX. 36 TURNS CLOSE WOUND IN THE DIRECTION SHOWN.
- 2- REMOVE OR ADD TURNS TO MEET INDUCTANCE SHOWN IN TEST SPECS.
- 3- BAKE FOR 1/2 HOUR AT 215°F TO REMOVE MOISTURE.
- 4- COAT COIL & CORE WITH GL-102 Q-MAX AND BAKE FOR 1/2 HOUR AT 215°F.

TEST SPECIFICATIONS

* NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.
 INDUCTANCE = 4.85 μ h \pm 0.11 WITH COIL CLAMPED INTO Q-METER 1/2" AWAY FROM TERMINALS WITH FINISH END OF COIL TO LOW SIDE.
 Q = 215 MIN. AT 5MC C_{dist} = 1.3 μ hf (REF ONLY).
 OPER. FREQ. RANGE = 4-6 MC.

SYMBOL USED

L1024A, L1025A, L1026A

X	3	GL-102	Q-MAX
X	2	WI-122-24	MAGNET WIRE, SINGLE #24
1	1	CI-127-1	CORE, TOROID

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL										
			ANGER											
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK														
B	NOTE ADDED	1-12-67 17575	RME GDL											
A	WINDING WAS 35 TURNS C _{dist} ADDED, IND WAS 4.65	6-10-63 9221												
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	MATERIAL	TYPE & TEMPER	HEAT TREAT. SP. C.	DRAWN	CHECKED	FINAL APPROVAL		
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. \pm 1/64 DEC. \pm .005 ANGLES \pm 1/2°							SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES							
							FINISH & EPRC. NO.		ELEC. DES. APP.		MECH. DES. APP.		A-2476 B	

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REQ. PER UNIT
3

MODEL
HFR-1/T

USED ON

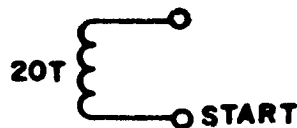
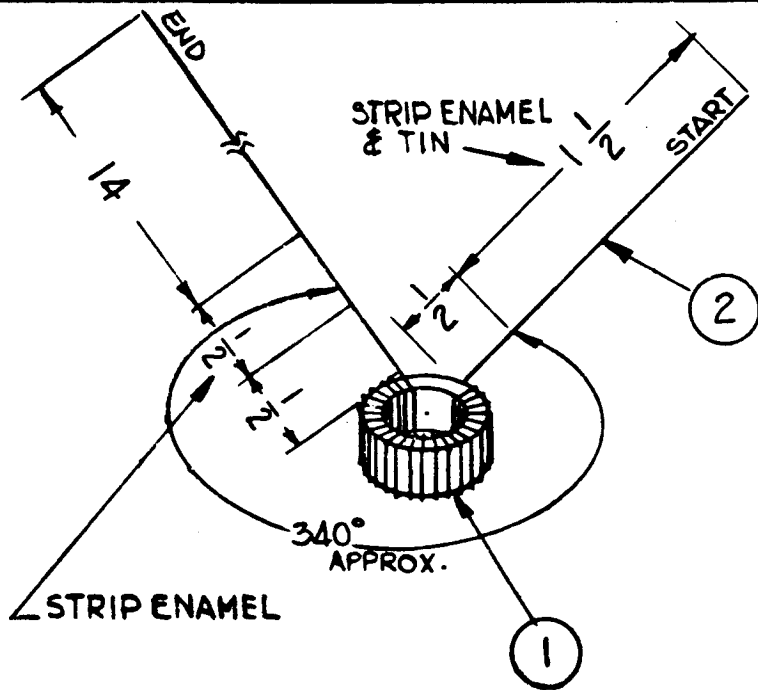
ASS'Y. NO.

DATE

6-9-62

A-2477

A



SCHEMATIC

— PROCEDURE —

- 1- WIND 20 TURNS EVENLY SPACED OVER A 340 ANGLE. WIND TURNS IN THE DIRECTION SHOWN.
- 2- PUSH TURNS TOGETHER OR SPREAD APART AS NEEDED. TO MEET INDUCTANCE SHOWN IN TEST SPECS.
- 3- BAKE FOR 1/2 HR. AT 215°F TO REMOVE MOISTURE
- 4- COAT COIL & CORE WITH GL-102 Q-MAX AND BAKE FOR 1/2 HR. AT 215°F.

— TEST SPECIFICATIONS —

$L = 1.7 \mu h \pm 0.05 \mu h$
WITH COIL CLAMPED INTO Q-METER 1/2" AWAY FROM TERMINALS WITH FINISH OF COIL TO LOW SIDE

$Q = 180 \text{ MIN. AT } 7 \text{ MC.}$

OPER FREQ. RANGE: 6 - 8 MC.

— SYMBOL USED —

L1029A, L1030A, L1031A

* NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.

X	3	GL-102	Q-MAX
X	2	WI-122-24	MAGNET WIRE, SINGLE #24
1	1	CI-127-1	CORE, TOROID

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL		COIL, RF ASS'Y BAND*4 2, 3, 4 RF	
TYPE & TEMPER	HEATTREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

A NOTE ADDED

11267 17575 RME GDL

SYM DESCRIPTION DATE CH. NO. DRAFTS CHECKER ENG. APP.

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES ON
FRAC ± 1/64 DEC. ± .005 ANGLES ± 1/2°

SCALE:
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
REMOVE ALL BURRS AND SHARP EDGES

G.D.L. *Hde* *BP*
DRAWN CHECKED FINAL APPROVAL

J. LANGER
A-2477 A

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REQ. PER UNIT
3

MODEL
HFR-1/T

USED ON

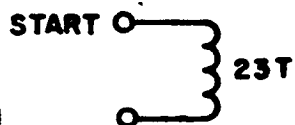
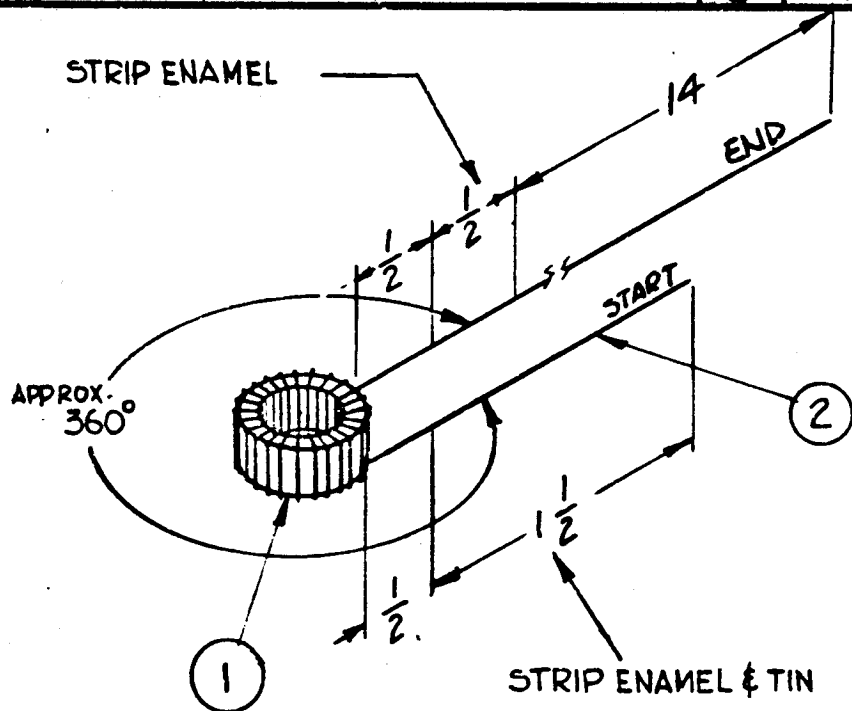
ASS'Y. NO.

DATE

6-9-62

A-2478

A



SCHEMATIC

— SYMBOL USED —
L 1034A, L1035A, L1036A

— PROCEDURE —

- 1 - WIND 23 TURNS EVENLY SPACED OVER A 360° ANGLE. WIND TURNS IN THE DIRECTION SHOWN
- 2 - PUSH TURNS TOGETHER OR REMOVE TURN AS NEEDED TO MEET INDUCTANCE SHOWN IN TEST SPECS.
- 3 - BAKE FOR 1/2 HR. AT 215°F. TO REMOVE MOISTURE.
- 4 - COAT COIL & CORE WITH GL-102 Q-MAX AND BAKE FOR 1/2 HR. AT 215°F.

— TEST SPECIFICATIONS —

L = 2.1 μ h \pm 0.07 μ h
WITH COIL CLAMPED INTO Q METER 1/2" AWAY FROM TERMINALS WITH FINISH END OF COIL TO LOW SIDE.
Q = 200 MIN @ 10 MC
OPER FREQ. RANGE 8-12 MC.

* NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.

X	3	GL-102	Q-MAX
X	2	WI-122-24	MAGNET WIRE, SINGLE #24
1	1	CI-127-1	CORE, TOROID

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	NOTE ADDED	11/26/67	17575	RME	GDL	[Signature]
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. \pm 1/64 DEC. \pm .005 ANGLES \pm 1/2°						
SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES						

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
			COIL, RF, ASS'Y. BAND #5 2, 3, 4 RF	
			DRAWN [Signature]	
			CHECKED [Signature]	
			FINAL APPROVAL [Signature]	
			ELEC. DES. APP. [Signature]	
			MECH. DES. APP.	

A-2478 A

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REQ. PER UNIT
3

M DEL
HFR-1/T

USED ON

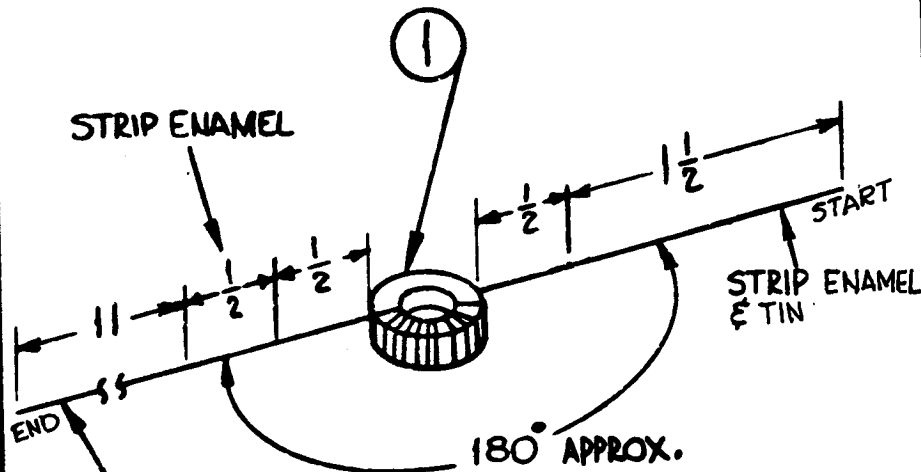
ASS'Y. NO.

DATE

6-9-62

A-2479

A

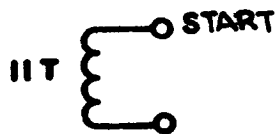


- ### PROCEDURE
- 1- WIND 11 TURNS EVENLY SPACED OVER A 180° ANGLE. WIND TURNS IN THE DIRECTION SHOWN
 - 2- PUSH TURNS TOGETHER OR SPREAD APART AS NEEDED TO MEET INDUCTANCE SHOWN IN TEST SPECIFICATIONS
 - 3- BAKE FOR 1/2 HOUR AT 215° F TO REMOVE MOISTURE
 - 4- COAT COIL & CORE WITH GL-102 Q-MAX AND BAKE FOR 1/2 HOUR AT 215° F.
- * NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.

TEST SPECIFICATIONS

$L = 0.75 \mu h \pm 0.03 \mu h$
 WITH COIL CLAMPED INTO Q-METER 1/2" AWAY FROM TERMINALS WITH FINISH END OF COIL TO LOW SIDE

Q- 180 MIN @ 14 MC
 OPER. FREQ RANGE 12-16 MC.



SCHEMATIC

SYMBOLS USED
 L1039A, L1040A
 L1041A

X	3	GL-102	Q-MAX
X	2	WI-122-24	MAGNET WIRE SINGLE #24
1	1	CI-127-1	CORE, TOROID

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	NOTE ADDED	1-12-67	17575	RME	GDL	<i>[Signature]</i>

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
COIL, RF ASSEMBLY			
BAND G. 2,3,4 R.F			
MATERIAL		R. LIZZO	<i>[Signature]</i>
TYPE & TEMPER		HEATTREAT. SPEC.	DRAWN
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
		J. ANGER	<i>[Signature]</i>
			CHECKED
			FINAL APPROVAL
			A-2479 A

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON
 FRAC. ± 1/64 DEC. ± .005 ANGLES ± 1/2°

SCALE:
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
 REMOVE ALL BURRS AND SHARP EDGES

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REQ. PER UNIT

4

MODEL

HFR-1/T

USED ON

ASS'Y. NO.

DATE

6-9-67

A-2480 B

PROCEDURE

- 1- WIND 11 TURNS EVENLY SPACED OVER A 270° ANGLE, WIND TURNS IN THE DIRECTION SHOWN.
- 2- PUSH TURNS TOGETHER OR SPREAD APART AS NEEDED TO MEET INDUCTANCE SHOWN IN TEST SPECS.
- 3- BAKE FOR 1/2 HOUR AT 215°F TO REMOVE MOISTURE.
- 4- COAT COIL & CORE WITH GL-102 Q-MAX AND BAKE FOR 1/2 HOUR AT 215°F.

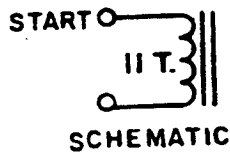
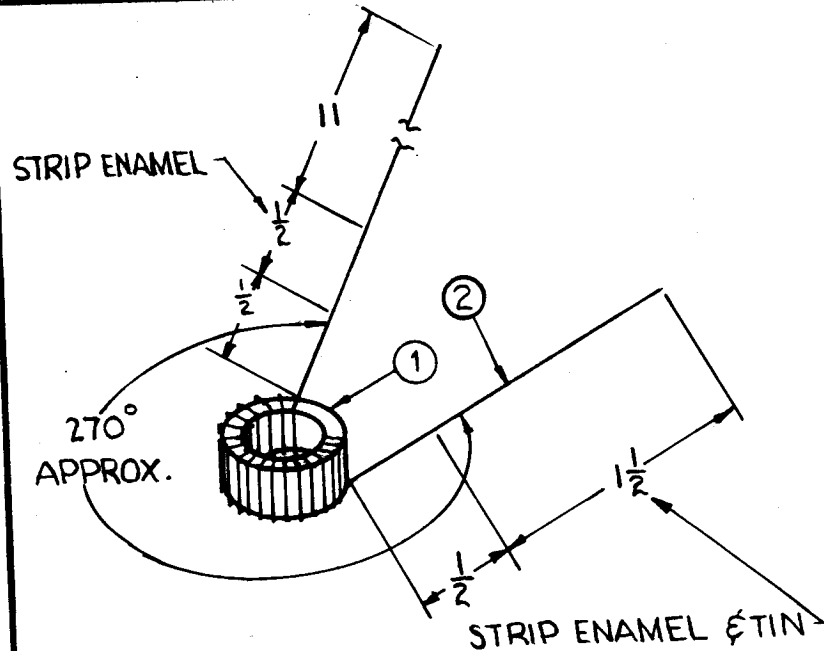
TEST SPECIFICATIONS

INDUCTANCE = 0.574h ± 0.015uh WITH COIL CLAMPED INTO Q-METER 1/2" AWAY FROM TERMINALS, WITH FINISH END OF COIL TO LOW SIDE.
 Q = 185 MIN. AT 20 MC.
 OPER. FREQ. RANGE = 16-24 MC.
 Cdist. = 1.144f (REF ONLY).

SYMBOL USED

L1044A, L1045A, L1046A, L1042A

* NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 3	GL-102	Q-MAX	
X 2	WI-122-22	MAGNETWIRE, SINGLE #22	
1 1	CI-127-1	CORE, TOROID	

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
			ANGER	

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	NOTE ADDED	11/2/67	17575	RME	G-D.L	<i>[Signature]</i>
A	SYMBOL L1042A ADDED & BAND #6 OSC ADDED WINDING WAS 12 TURNS Cdist ADDED, IND WAS .64uh ± .03uh	6-10-63	9217	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON
 FRAC. ± 1/64 DEC. ± .005 ANGLES ± 1/2°

SCALE:
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
 REMOVE ALL BURRS AND SHARP EDGES

TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
		J. ANGER	<i>[Signature]</i>	<i>[Signature]</i>

FINISH & SPEC. NO. ELEC. DES. APP. MECH. DES. APP.

A-2480 B

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RFO. PER UNIT

3

USED ON

MODEL

ASS'Y. NO.

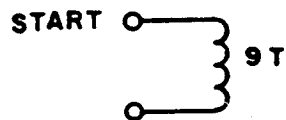
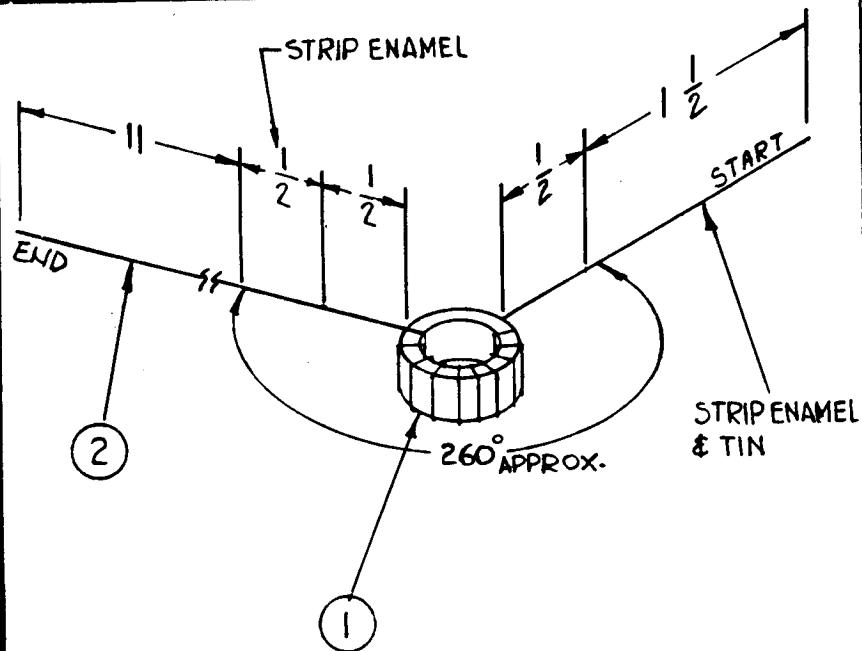
DATE

HFR-1/T

6-9-62

A-2481

C



SCHEMATIC

— PROCEDURE —

- 1-WIND 9 TURNS EVENLY SPACED OVER A 260° ANGLE. WIND TURNS IN DIRECTION SHOWN.
 - 2-PUSH TURNS TOGETHER OR SPREAD APART AS NEEDED TO MEET INDUCTANCE SHOWN IN TEST SPECS.
 - 3-BAKE FOR 1/2 HR. AT 215°F TO REMOVE MOISTURE.
 - 4-COAT COIL & CORE WITH GL-102 Q-MAX AND BAKE FOR 1/2 HR. AT 215°F
- * NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.

— TEST SPECIFICATIONS —

$L = 0.37 \mu h \pm 0.01 \mu h$

WITH COIL CLAMPED INTO Q-METER 1/2" AWAY FROM TERMINALS, WITH FINISH END OF COIL TO LOW SIDE.

$Q = 160 \text{ MIN. AT } 20 \text{ MC.}$

OPER FREQ. RANGE: 24-32 MC

— SYMBOL USED —

L1049A, L1050A, L1051A

X	3	GL-102	Q-MAX
X	2	WI-122-20	MAGNET WIRE, SINGLE #20
I	1	CI-127-1	CORE, TOROID

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
C	NOTE ADDED	11-2-67	17575	RME	G.D.L.	<i>MM</i>
B	DELE. NOTE "APPROX"	2-5-64	10831	A.M.	T.R.	<i>MM</i>
A	APPROX ADDED TO SCHEMATIC PROCEDURE #1 APPROX: ADDED	7-17-63	9603	<i>MM</i>	<i>MM</i>	<i>MM</i>

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES ON
FRAC. $\pm 1/64$ DEC. $\pm .005$ ANGLES $\pm 1/2^\circ$

SCALE:
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATION WILL BE CAUSE FOR REJECTION.
REMOVE ALL BURRS AND SHARP EDGES

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
COIL, RF, ASS'Y. BAND #8, 2, 3, 4 RF			
G.D.L.		<i>JDC</i>	<i>BP</i>
DRAWN		CHECKED	FINAL APPROVAL
<i>J. ANGEL</i>			A-2481
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

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REQ. PER UNIT

1

USED ON

MODEL

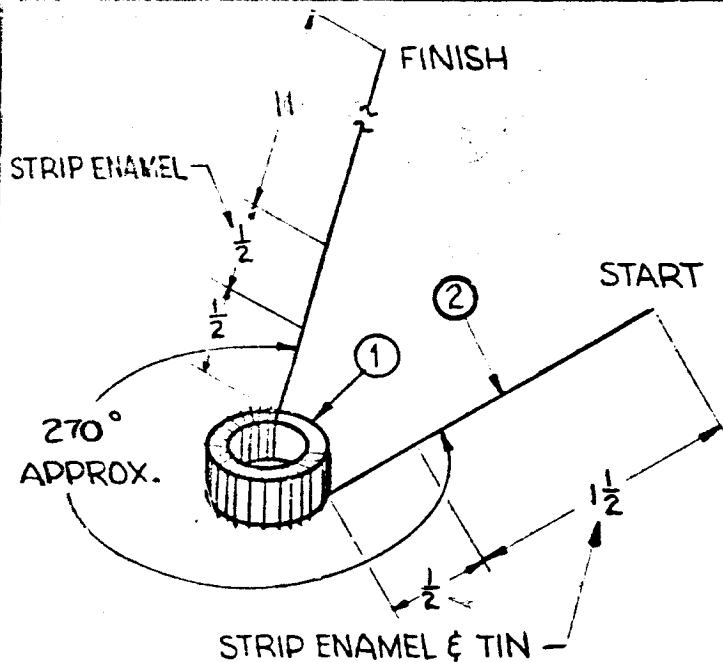
HF-1/T

ASSY. NO.

DATE

6-9-62

A-2482 | c



PROCEDURE

1. WIND 11 TURNS EVENLY SPACED OVER A 270° ANGLE, WIND TURNS IN THE DIRECTION SHOWN.
2. PUSH TURNS TOGETHER OR SPREAD APART AS NEEDED TO MEET INDUCTANCE SHOWN IN TEST SPECS.
3. BAKE FOR 1/2 HOUR AT 215°F TO REMOVE MOISTURE.
4. COAT COIL & CORE WITH GL-102 Q-MAX AND BAKE FOR 1/2 HOUR AT 215°F.

TEST SPECIFICATIONS

INDUCTANCE = 0.575 μ h \pm 0.015 μ h WITH COIL CLAMPED INTO Q-METER 1/2" AWAY FROM TERMINALS WITH FINISH END OF COIL TO LOW SIDE.

> Q = 190 @ 25 MC

OPERATING FREQ. RANGE = 17.75 - 25.75 MC.

C_{dist.} = 1.144f (REF ONLY)

SYMBOL USED

L1047A

* NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.



SCHEMATIC

X	3	GL-102	Q-MAX
X	2	WI-122-22	MAGNET WIRE, SINGLE #22
1	1	CI-127-1	CORE, TOROID

C	NOTE ADDED	1-12-67	17575	RME	S.D.L.	MM
B	CHG'D "Q" FR. >200" TO >190"	8-8-66	16723	RME	QCB	MM
A	OPER FREQ R3 17.75-17.75 MC DELETED Q WAS 190 WIND @ 15.75 MC. SYM L1047A IS WINDING WAS 12 TURNS FOR 310° C _{dis.} ADDED, INDUCT WAS .674	5-7-63	9214	E	8/3	MM
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. \pm 1/64 DEC. \pm .005 ANGLES \pm 1/2°		SCALE: DO NOT SCALE				
		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				

REQ.	ITEM	PART NO.	ANGER DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL			COIL, RE. ASS'Y BAND #7OSC.	
TYPE & TEMPER		HEAT TREAT. SPEC.	LAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	
R. Lurchin			J. Vase	BP
J. ANGER				A-2482 c

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REQ. PER UNIT

1

USED ON

MODEL

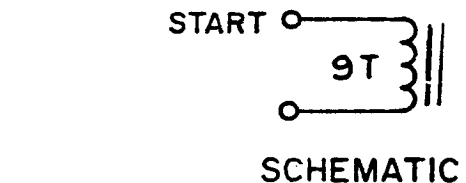
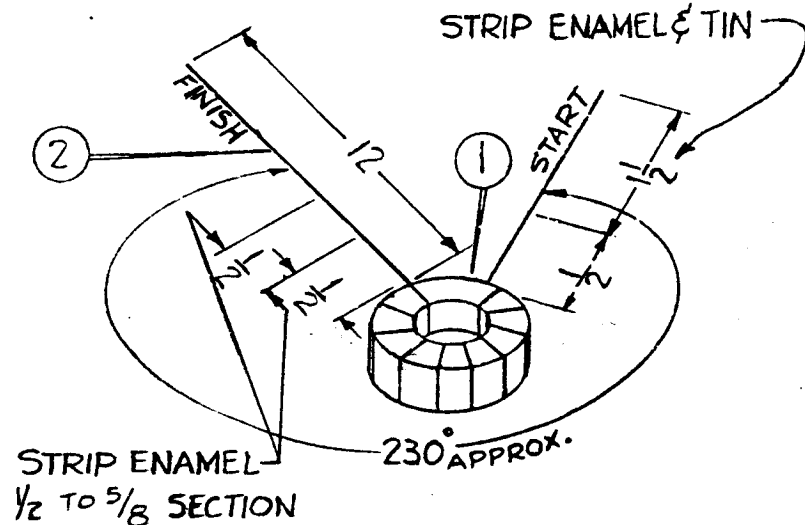
HFR-1/T

ASS'Y. NO.

DATE

6-9-62

A-2484 B



WINDING PROCEDURE

1. WIND 9 TURNS EVENLY SPACED OVER A 230° ANGLE. WIND TURNS IN THE DIRECTION SHOWN.
2. PUSH TURNS TOGETHER OR SPREAD APART AS NEEDED TO MEET INDUCTANCE SHOWN IN TEST SPECIFICATIONS.
3. BAKE FOR 1/2 HOUR AT 215°F. TO REMOVE MOISTURE
4. COAT COIL & CORE WITH GL-102 (ITEM 3) AND BAKE FOR 1/2 HOUR @ 215°F.

* NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.

TEST SPECIFICATIONS

INDUCTANCE = 0.45 μ h \pm .01 μ h
 WITH COIL CLAMPED INTO Q METER -
 1/2" AWAY FROM TERMINALS WITH FINISH
 END TO LOW SIDE.

Cdist = 1.0 μ uf (REF ONLY) Q = 180 MIN AT 25 MC
 OPER. FREQ. RANGE = 25.75 - 33.75 MC

SYMBOL USED
L1052 A

X	3	GL-102	Q-MAX
X	2	WI-122-22	MAGNET WIRE SINGLE #22
1	1	CI-127-1	CORE, TOROID

REQ. ITEM	PART I.C.	ANGAR	DESCRIPTION	SYMBOL								
B	NOTE ADDED	1-12-67	17575	RME C.D.L. <i>MM</i>								
A	Q WAS 180 MIN @ 29.75 MC. WINDING WAS 10 TURNS FOR 280° Cdist ADDED, INDUCT WAS .47 μ h	6-7-63	9219	<i>JP</i> <i>WLB</i>								
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	MATERIAL	TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. \pm 1/64 DEC. \pm .005 ANGLES \pm 1/2°		SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES		FINISH & SPEC. NO.		ELEC. DES. APP.		MECH. DES. APP.		A-2484 B		

THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.

REQ. PER UNIT

3

USED ON

MODEL

HFR-1/T

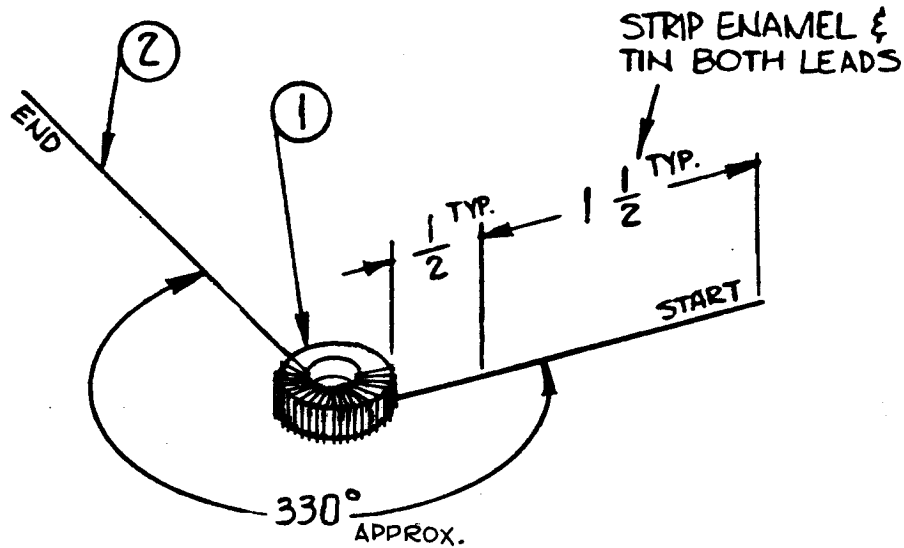
ASBY. NO.

A-2371

DATE

6-8-62

A-2485 B



— PROCEDURE —

- 1-WIND APPROX. 73 TURNS CLOSE WOUND IN THE DIRECTION SHOWN.
- 2-REMOVE OR ADD TURNS TO MEET INDUCTANCE SHOWN IN TEST SPEC.
- 3-BAKE FOR 1/2 HOUR AT 215 F.
- 4-COAT COIL & CORE W. TH GL-10Z (Q-MAX) BAKE FOR 1/2 HOUR AT 215° F

* NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.

ELECTRICAL SPECIFICATIONS

L=21.2 μ h \pm 0.5 μ h
 C. DISTRIB = 1.5 μ mf APPROX.
 Q ~ 150 MIN. AT 2.5 MC

SYMBOL USED

L1004, L1006 & L1008

SCHEMATIC



X	3	GL-10Z	Q-MAX
X	2	WI-122-30	MAGNET WIRE, SINGLE #30
1	1	CI-127-1	CORE, TOROID

B	NOTE ADDED	11267	17575	RME	GDL	MM
A	C. DISTRIB ADDED ±0.5 μ h ADDED TO "L"	12263	8040	EX	JW	USE
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

REQ. ITEM	PART NO.	ANGER	DESCRIPTION	SYMBOL
STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
MATERIAL		CL-296 ASS'Y COIL, RF, TOROID BAND#1.-23ARF		
TYPE	TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.			J. ANGER	BP
ELEC. DES. APP.		MECH. DES. APP.		A-2485 B

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON
 FRAC. \pm 1/64 DEC. \pm .005 ANGLES \pm 1/2°

SCALE:
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
 REMOVE ALL BURRS AND SHARP EDGES

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REQ. PER UNIT

3

M DEL

HR-1/T

USED ON

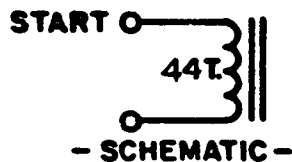
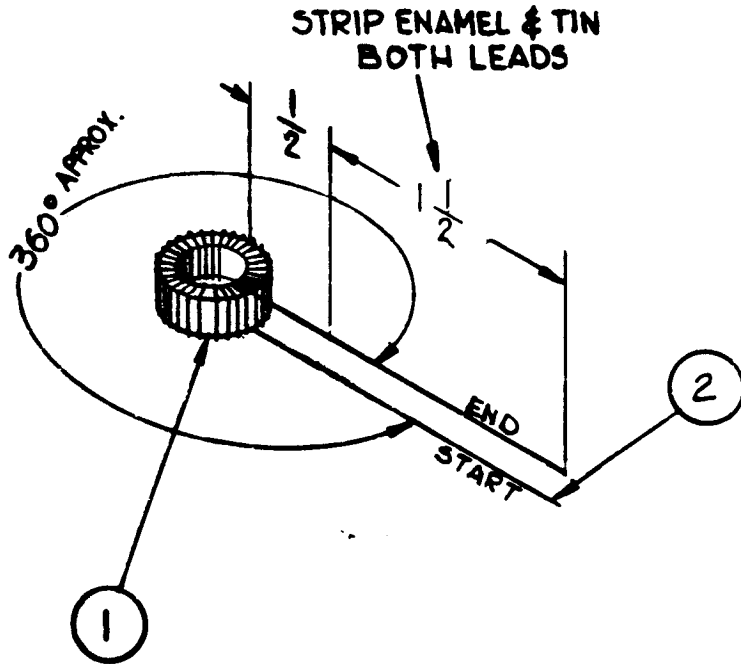
ASS'Y. NO.

DATE

6-6-62

A-2486

A



— PROCEDURE —

- 1 - APPROX. 44 T. CLOSE WOUND IN THE DIRECTION SHOWN
- 2 - REMOVE OR ADD TURNS TO MEET INDUCTANCE SHOWN IN TEST SPECS.
- 3 - BAKE FOR 1/2 HR. AT 215°F TO REMOVE MOISTURE
- 4 - COAT COIL & CORE WITH GL-102 Q MAX. AND BAKE FOR 1/2 HR. AT 215°F.

* NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.

TEST SPECIFICATIONS

$L = 7.8 \mu h \pm 0.15 \mu h$

$Q = 200 \text{ MIN. AT } 3.5 \text{ MC.}$

SYMBOL USED

L1016, L1018 & L1020

X	3	GL-102	Q-MAX
X	2	WI-122-25	MAGNET WIRE, SINGLE #25
1	1	CI-127-1	CORE, TOROID

A	NOTE ADDED	1-12-67	17575	RME	G.D.L.	<i>[Signature]</i>
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. ± 1/64 DEC. ± .000 ANGLES ± 1/2°		SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				

REQ.	ITEM	PART NO.	ANGAR	DESCRIPTION	SYMBOL
				THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
				CL-297 ASS'Y	
				COIL, RF, TOROID BAND*2. (2,3,4RF)	
			G.D.L.	<i>[Signature]</i>	<i>[Signature]</i>
			TYPE & TEMPER	HEATTREAT. SPEC.	DRAWN
					CHECKED
					FINAL APPROVAL
			FINISH & SPEC. NO.	ELEC. DES. APP.	MECH. DES. APP.
					A-2486 A

THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.

REQ. PER UNIT

1

MODEL
HFR-1/T

USED ON

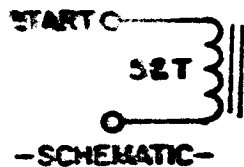
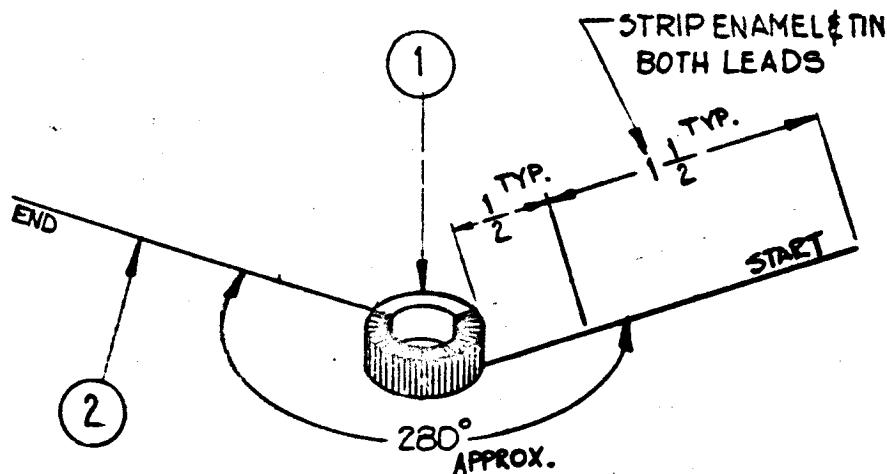
ASSY. NO.

DATE

6-6-62

A-2487

B



~ PROCEDURE ~

- 1-WI-122-28 (ITEM 2) CLOSE WOUND APPROX. 52 TURNS IN THE DIRECTION SHOWN.
- 2-REMOVE OR ADD TURNS TO MEET IND. SHOWN IN TEST SPEC.
- 3-BAKE FOR 1/2 HOUR AT 215°F TO REMOVE MOISTURE.
- 4-COAT COIL & CORE WITH GL-102 (ITEM 3) AND BAKE FOR 1/2 HOUR AT 215°F.

* NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.

~ TEST SPECIFICATIONS ~

$L = 10.65 \mu h \pm 0.2 \mu h$
 $Q = 200 \text{ MIN @ } 4.25 \text{ MC}$
 $C_{\text{DIST}} = 1.3 \mu f \text{ (REF ONLY)}$
SYMBOL USED
 L1012

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	3	GL-102	G. MAX	
X	2	WI-122-28	MAGNET WIRE, SINGLE # 28	
1	1	CI-127-1	CORE, TOROID	
ANGE:R THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
CL-298 ASS'Y. (COIL, RF TOROID, BAND 1 OSC.)				
UNLESS OTHERWISE SPECIFIED:		SCALE:		
DIMENSIONS ARE IN INCHES		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUTIONED BY MARK.		
TOLERANCES ON		FINISH & SPEC.		
FRAC. $\pm 1/64$ DEC. $\pm .005$ HOLE $\pm 1/32$		ELEC. DES. APP. MECH. DES. APP.		

SYMBOL	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	NOTE ADDED	1-12-67	17575	RME	G.D.L.	<i>MM</i>
A	CHG. AD. 2 L=10.65 uH WINDING 52 TURNS ITEM (2) WAS WI-122-30	6-7-63	9220		<i>MM</i>	<i>MM</i>

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON
 FRAC. $\pm 1/64$ DEC. $\pm .005$ HOLE $\pm 1/32$

SCALE:
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUTIONED BY MARK.
 FINISH & SPEC.

W.A.F. *AW* *BP*
 DRAWN CHECKED FINAL APPROVAL
 V. LANGER
 ELEC. DES. APP. MECH. DES. APP.
 A-2487 B

THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.

REQ. PER UNIT

1

USED ON

MODEL

HFR-1/T

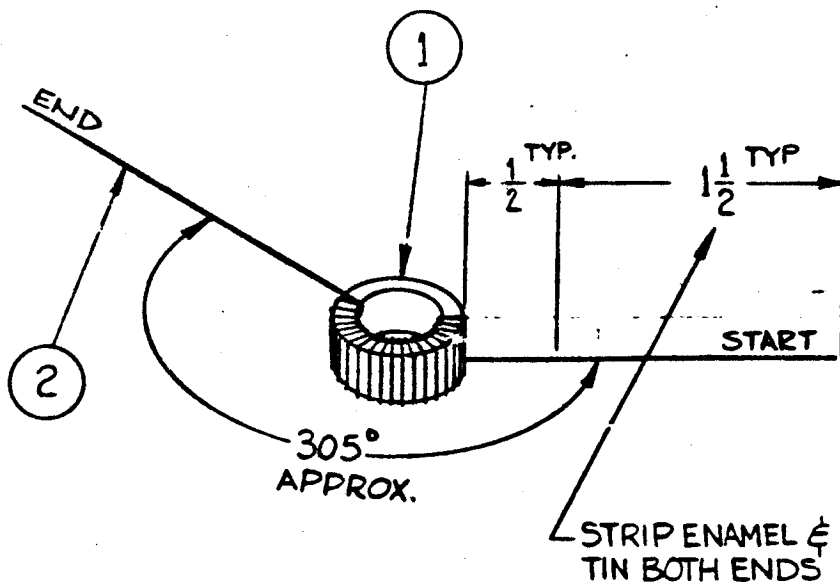
ASSY. NO.

DATE

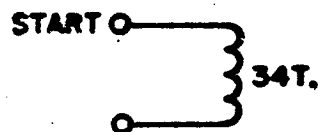
6-7-62

A-2488

A



SCHMATIC



— PROCEDURE —

- 1- APPROX. 34 TURNS CLOSE WOUND IN THE DIRECTION SHOWN.
 - 2- REMOVE OR ADD TURNS TO MEET INDUCTANCE SHOWN IN TEST SPECS.
 - 3- BAKE FOR 1/2 HR. AT 215°F TO REMOVE MOISTURE.
 - 4- COAT COIL & CORE WITH GL-102 Q-MAX. AND BAKE FOR 1/2 HR AT 215°F.
- * NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.

— TEST SPECIFICATIONS —

$L = 4.5 \mu h \pm 0.1 \mu h$
 $Q = 220 \text{ MIN @ } 5.25 \text{ MC}$

SYMBOL USED

L1022

X	3	GL-102	Q-MAX.
X	2	WI-122-24	MAGNET WIRE, SINGLE #24
1	1	CI-127-1	CORE, TOROID

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
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STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAKARONECK, NEW YORK	
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CL-299 ASSEMBLY			(COIL, RF, TOROID BAND #2 OSC.)	
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MATERIAL		V.R.R.	<i>Ho</i>	<i>KL</i>
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TYPE & TEMPER.	HEAT TREAT. SPEC.	DRAWN	CHECKED	APPROVAL
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FINISH & SPEC. NO.		<i>V. LANGER</i>	A-2488	
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ELEC. DES. APP.		MCH. DES. APP.		A
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A	NOTE ADDED	1-12-67	17575	RME	<i>S.D.L.</i>	<i>KL</i>
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. $\pm 1/64$ DEC. $\pm .008$ ANGLES $\pm 1/2^\circ$		SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				

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REQ. PER UNIT

1

MODEL

HFR-1/T

USED ON

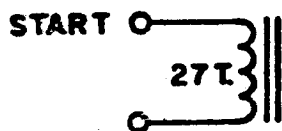
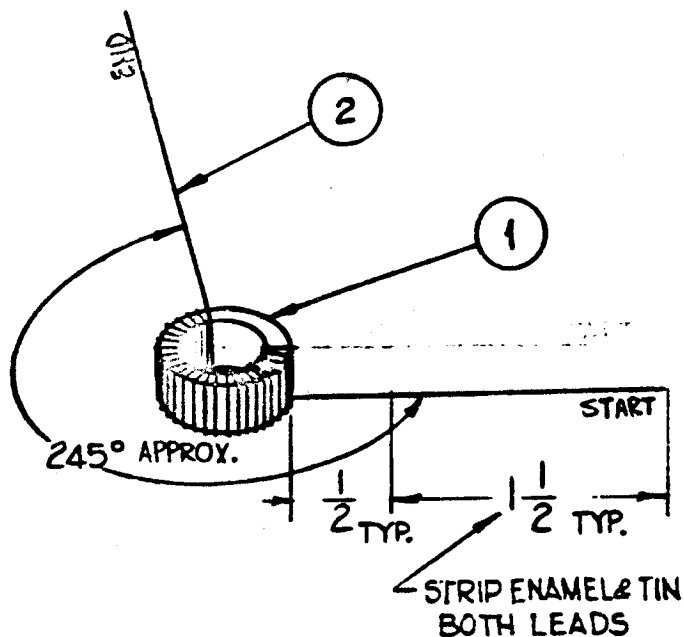
ASSY. NO.

DATE

6-8-62

A-2489

A



SCHEMATIC

— PROCEDURE —

- 1- APPROX. 27 TURNS CLOSE WOUND IN THE DIRECTION SHOWN.
- 2- REMOVE OR ADD TURNS TO MEET INDUCTANCE SHOWN IN TEST SPECS.
- 3- BAKE FOR 1/2 HR. AT 215°F. TO REMOVE MOISTURE.
- 4- COAT COIL & CORE WITH GL-102 Q-MAX AND BAKE FOR 1/2 HR. AT 215°F.

* NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.

— TEST SPECIFICATIONS —

L = 3.3 μ h \pm 0.1 μ h
 Q = 185 MIN. AT 6.75 MC.

SYMBOL USED

L1027

REQ.	ITEM	PART NO.	ANGAR	DESCRIPTION	SYMBOL
X	3	GL-102		Q-MAX	
X	2	WI-122-24		MAGNET WIRE, SINGLE #24	
1	1	CI-127-1		CORE, TOROID	
			THE TECHNICAL MATERIEL CORP. MAMARONCK, NEW YORK CL-300 ASS'Y (COIL, RF, TOROID BAND 3 OSC)		
A NOTE ADDED UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. \pm 1/64 DEC. \pm 0.005 ANGLES \pm 1/2°			SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES		
		DATE	CK. NO.	DRAWN	CHECKED
		1-12-67	17575	RME	C.D.C.
				TYPE & TEMPER	HEAT TREAT. SPEC.
				FINISH & SPEC. NO.	ELEC. DES. APP. MECH. DES. APP.
				G.D.L. V. ANGER	J.H. B.P.
				A-2489 A	

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REQ. PER UNIT

1

USED ON

MODEL

HFR-1/T

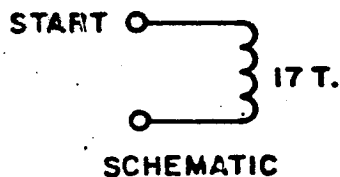
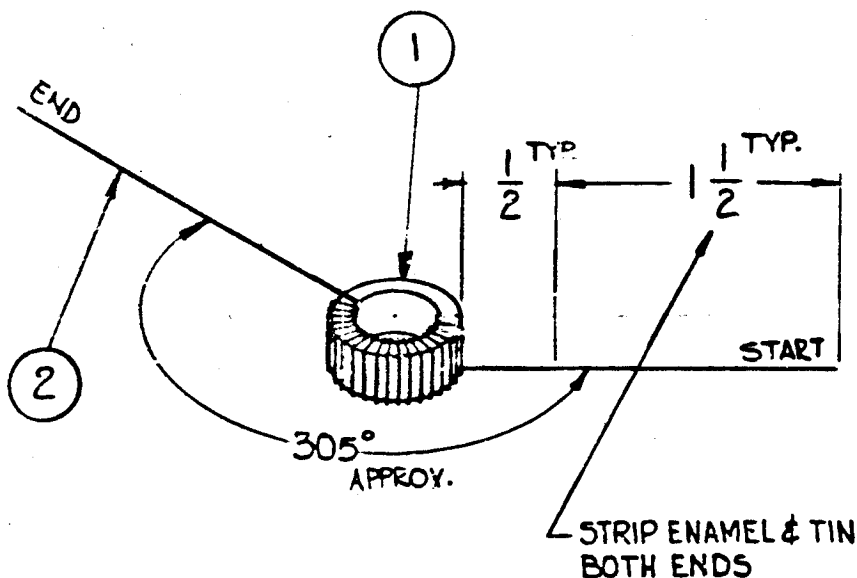
ASSY. NO.

DATE

6-7-62

A-2490

A



— PROCEDURE —

- 1 - WIND 17 TURNS EVENLY SPACED OVER A 305° ANGLE, WIND TURNS IN THE DIRECTION SHOWN
- 2 - PUSH TURNS TOGETHER OR SPREAD APART AS NEEDED TO MEET INDUCTANCE SHOWN IN TEST SPECS.
- 3 - BAKE FOR 1/2 HR. AT 215°F. TO REMOVE MOISTURE
- 4 - COAT COIL & CORE WITH GL-102 Q MAX. AND BAKE FOR 1/2 HR. AT 215°F.

* NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.

— TEST SPECIFICATIONS —

$L = 1.25 \mu h \pm 0.05$
 $Q = 185 \text{ MIN AT } 8.75 \text{ MC.}$

SYMBOL USED
 LIC32

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 3	GL-102	Q-MAX	
X 2	WI-122-24	MAGNET WIRE, SINGLE #24	
1	CI-127-1	CORE, TOROID	

STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		CL-301 ASS'Y	
		COIL, RF, TOROID BAND #4 OSC	
MATERIAL		G.D.L.	<i>HP</i>
		<i>J. ANGER</i>	<i>BP</i>
TYPE & TEMPER		DRAWN	CHECKED
HEAT TREAT. SPEC.		FINAL APPROVAL	
FINISH & SPEC. NO.		A-2490	
		A	

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	NOTE ADDED	1-12-67	17575	RME	<i>EDL</i>	<i>MA</i>

UNLESS OTHERWISE SPECIFIED:		SCALE:	
DIMENSIONS ARE IN INCHES		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.	
TOLERANCES ON		REMOVE ALL BURRS AND SHARP EDGES	
FRAC. $\pm 1/64$ DEC. $\pm .005$ ANGLES $\pm 1/2^\circ$			

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RQO.
PER
UNIT

MODEL
HFR-1/T

USED ON

ASSY. NO.

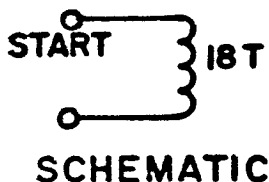
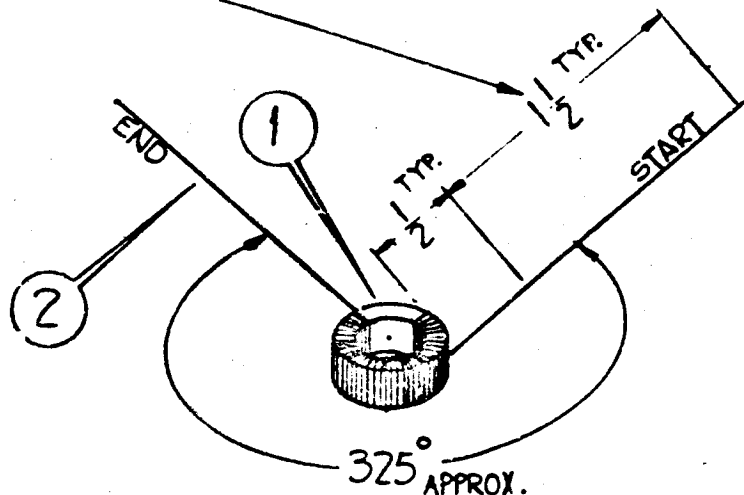
DATE

6-8-62

A-2491

A

STRIP ENAMEL & TIN BOTH LEADS



PROCEDURE

- 1- WIND 18 TURNS EVENLY SPACED OVER A 325° ANGLE, WIND TURNS IN THE DIRECTION SHOWN.
2. PUSH TURNS TOGETHER OR SPREAD APART AS NEEDED TO MEET INDUCTANCE SHOWN IN TEST SPEC.
3. BAKE FOR 1/2 HOUR AT 215°F TO REMOVE MOISTURE.
4. COAT COIL & CORE W/GL-102 (ITEM 3) AND BAKE FOR 1/2 HR. AT 215°F.

* NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.

TEST SPECIFICATIONS

L = 1.48 μ h \pm 0.05 μ h
Q = 210 MIN @ 11.75 MC

SYMBOL USED

L1037

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	3	GL-102	G-MAX	
X	2	WI-122-24	MAGNET WIRE, SINGLE # 24	
1	1	CI-127-1	CORE, TOROID	

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	NOTE ADDED	1-12-67	17575	RME	G.D.L	<i>[Signature]</i>
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. \pm 1/64 DEC. \pm .005 ANGLES \pm 1/2°		SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL			CL-302 ASS'Y. (COIL, RF, TOROID, BAND # 5, OSC.)	
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN <i>J. ANGER</i>	CHECKED <i>H. De</i>
FINISH & SPEC. NO.		ELEC. DES. APP.	FINAL APPROVAL <i>BP</i>	
		MECH. DES. APP.	A-2491 A	

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REQ. PER UNIT
4

MODEL
HFR-1/T

USED ON

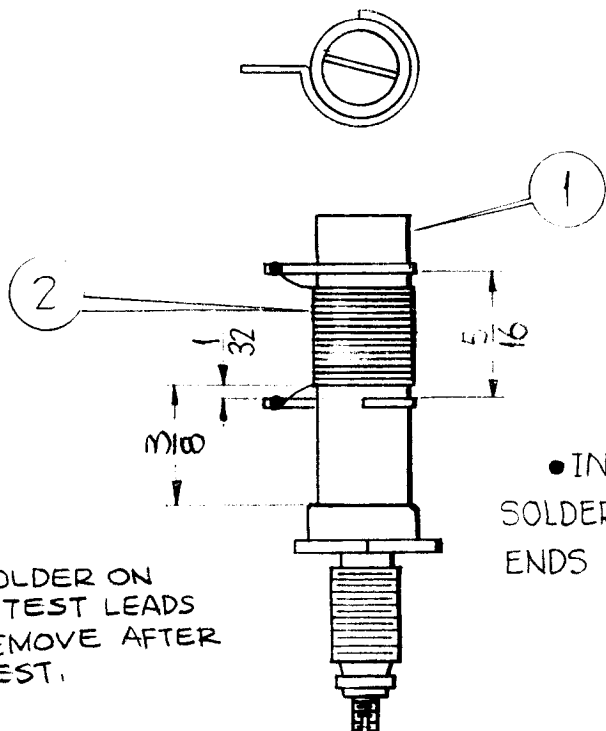
ASS'Y. NO.

DATE

6-9-62

A 2492

C



• INDICATES SOLDER POINTS. SOLDER ENDS AS SHOWN.

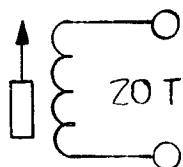
* SOLDER ON 1" TEST LEADS REMOVE AFTER TEST.

WINDING PROCEDURE

1. SECURE TERMINALS TO COIL FORM WITH Q MAX.
2. WIND 20 TURNS ON COIL FORM, SINGLE LAYER CLOSE WOUND.
3. STAKE WIRE ENDS TO COIL FORM WITH Q MAX.
4. STRIP ENDS WRAP AROUND TERMINALS AND SOLDER.
5. BAKE FOR 1/2 HOUR AT 215°F. TO REMOVE MOISTURE.
6. COAT COIL WITH Q MAX. AND BAKE FOR 1/2 HOUR AT 215°F.

* TEST SPECIFICATION

TEST FREQ. = 7.95 MC
 MAX. IND = 4.25 μ h REF.
 MIN. IND = 1.95 μ h REF.
 Q = 45 MIN. @ MIN. IND.



SCHEMATIC SYMBOLS
 L1001, 1005, 1007, 1009

X	4	GL-102	Q-Max
X	3	BS-100	Solder, Soft
X	2	WI-122-30	Wire, Magnet, #30
1	1	CF-134-5-E	Form, Coil, Slug Tuned

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
C	* NOTE ADDED	10-3-66	16958			
B	3/8 DIM. WAS 5/16 TEST SPEC. CLARIFIED	5/2/65	14140			
A	SYM., L1014 & L1023 DELETED	1-23-63	8067			

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON
 FRAC. $\pm 1/64$ DEC. $\pm .005$ ANGLES $\pm 1/2^\circ$

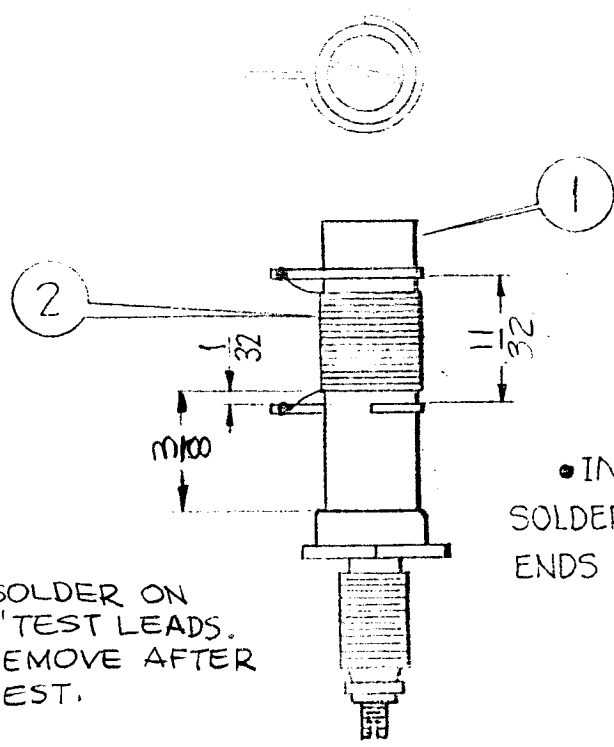
SCALE:
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
 REMOVE ALL BURRS AND SHARP EDGES

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
AC-164 ASS'Y. (COIL, RF TUNED)				
MATERIAL				
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	

DD. Mann
 J. De
 BP
 J. ANGER
 A 2492 C

REPRODUCTION OF THE TECHNICAL MATERIAL CORP. IS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.

REQ. PER UNIT 3	MODEL HFR-1/T	USED ON		A 2493	C
		ASS'Y. NO. A-2372	DATE 6-9-62		



• INDICATES SOLDER POINTS, SOLDER ENDS AS SHOWN.

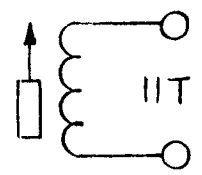
*-SOLDER ON 1" TEST LEADS. REMOVE AFTER TEST.

WINDING PROCEDURE

1. Secure Terminals to coil form with Q-Max.
2. Wind 11 turns on coil form, Single Layer Close wound.
3. Stake wire ends to coil form with Q-Max.
4. Strip ends wrap around terminals and solder.
5. Bake for 1/2 Hour @ 215°F. to remove moisture
6. Coat Coil with Q-Max. and Bake for 1/2 Hour @ 215°F.

* TEST SPECIFICATION

TEST FREQ. = 25 MC
 MAX. IND = 1.3 uh REF.
 MIN. IND = 0.6 uh REF.
 Q = 70 MIN @ MIN IND.



SCHEMATIC SYMBOLS
 L1015; 1017; 1019

X	4	GL-102	Q-Max.
X	3	BS-100	Solder, Soft
X	2	WI-122-24	Wire, Magnet #24
1	1	CF-134-5-E	Form, Coil, Slug Tuned

C	* NOTE ADDED	10-3-66	16958	<i>MW</i>	<i>JLS</i>	<i>Q</i>
B	3/8 DIM. WAS 5/16 TEST SPEC. CLARIFIED	5/25/66	14140	<i>CJL</i>	<i>JLS</i>	<i>Q</i>
A	SYMBOLS L1028, L1033 DELETED ASSEMBLY NO. ADDED	12-28-62	7698	<i>CF</i>	<i>JLS</i>	<i>Q</i>

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIAL CORP. MAMARONECK, NEW YORK				
AC-165 ASS'Y. (COIL, RF TUNED)				
TYPE & TEMPER		HEATTREAT. SPEC.	DRAWN <i>D.J. Mann</i>	CHECKED <i>A. De</i>
FINISH & SPEC. NO.		ELEC. DES. APP.	FINAL APPROVAL <i>BP</i>	
			<i>V. ANGER</i>	A 2493
				C

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON
 FRAC. ± 1/64 DEC. ± .005 ANGLES ± 1/2°

SCALE:
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
 REMOVE ALL BURRS AND SHARP EDGES

THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.

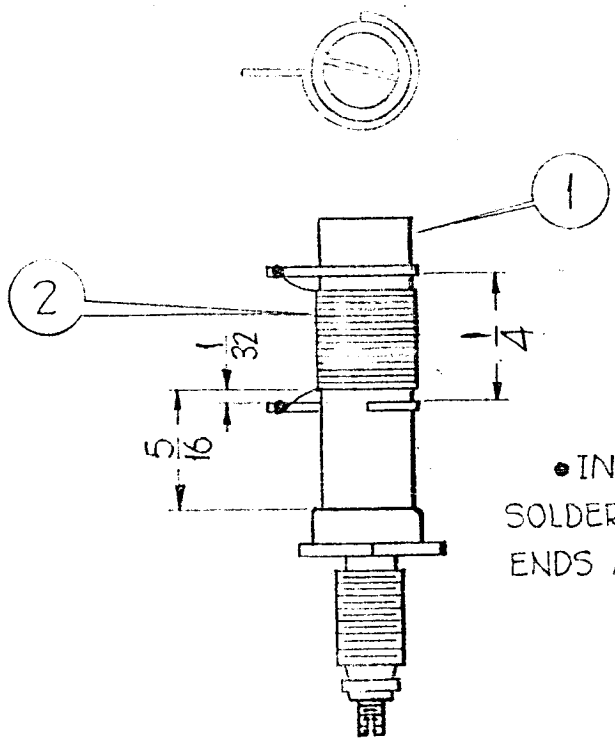
REQ. PER UNIT	MODEL	USED ON	DATE	A-2494	A
		ASSY. NO.			

WINDING PROCEDURE

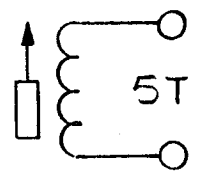
1. Secure Terminals To Coil Form With Q-Max.
2. Wind 5 Turns on coil Form, Single Layer Close Wound.
3. Stake Wire Ends To Coil Form with Q-Max.
4. Strip Ends Wrap Around Terminals and Solder.
5. Bake For 1/2 Hour @ 215°F To Remove Moisture.
6. Coat Coil with Q-Max and Bake for 1/2 Hour @ 215°F.

TEST SPECIFICATION

TEST FREQ. = 25. MC
 MAX. IND = 0.35 μ h OR MORE
 MIN. IND = 0.21 μ h OR LESS
 Q = 60 MIN



• INDICATES
 SOLDER POINTS, SOLDER
 ENDS AS SHOWN.



SCHEMATIC

X	4	GL-102	Q-Max
X	3	BS-100	Solder, Soft
X	2	WI-122-22	Wire, Magnet, #22
1	1	CF-134-5-E	Form, Coil, Slug Tuned

MODEL HFB-1/T, 2 REQ DELETED SYM. L1038 & L1043 DELETED	11-27-62	7696				
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. ± 1/64 DEC. ± .005 ANGLES ± 1/2°		SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK AC-166 ASS'Y. (COIL, RF TUNED)	
MATERIAL				
TYPE & TEMPER HEATTREAT. SPEC.				
FINISH & SPEC. NO.			DRAWN: J. ANGER CHECKED: [Signature] FINAL APPROVAL: [Signature]	A-2494 A

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REQ. PER UNIT

MODEL

USED ON

ASSY. NO.

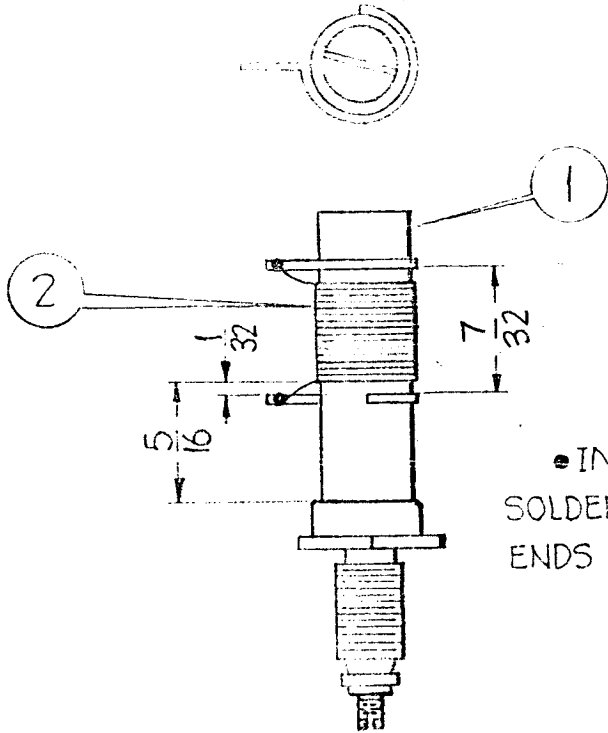
DATE

A-2495

A

WINDING PROCEDURE

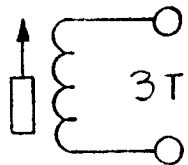
1. Secure Terminals To Coil Form With Q-Max.
2. Wind 3 Turns on Coil Form, Single Layer, Close wound.
3. Stake Wire Ends To Coil Form With Q-Max.
4. Strip Ends Wrap Around Terminals and Solder.
5. Bake For 1/2 Hour @ 215°F. To Remove Moisture.
6. Coat Coil with Q-Max. and Bake For 1/2 Hour @ 215°F.



• INDICATES
SOLDER POINTS, SOLDER
ENDS AS SHOWN.

TEST SPECIFICATION

TEST FREQ. = 25 MC
 MAX. IND = 0.15 μ h OR MORE
 MIN. IND = 0.10 μ h OR LESS
 Q = 35 MIN.



SCHEMATIC

X	4	GL-102	Q-Max
X	3	BS-100	Solder, Soft
X	2	WI-122-20	Wire, Magnet, #20
1	1	CF-134-5-0	Form, Coil, Slug Tuned

A	MODEL HFR-1/T DELETED	11-27-62	7697				
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. $\pm 1/64$ DEC. $\pm .005$ ANGLES $\pm 1/2^\circ$		SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES					

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL			AC-167 ASS'Y. (COIL, RF TUNED)	
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	FINAL APPROVAL

A-2495 | A

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REQ. PER UNIT
1

MODFL
4FR-1/T

USED ON

ASSY. NO.

DATE

6-9-62

A 2496

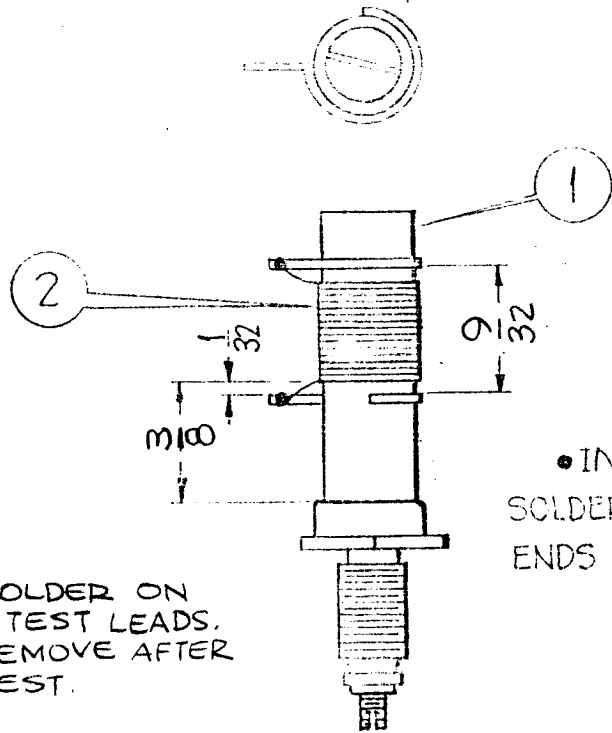
B

WINDING PROCEDURE

1. Secure Terminals To Coil Form With Q-Max.
2. Wind 9 Turns on coil Form, Single Layer, Close Wound.
3. Stake Wire Ends To Coil Form With Q-Max.
4. Strip Ends Wrap Around Terminals and Solder.
5. Bake For 1/2 Hour @ 215°F. To Remove Moisture.
6. Coat Coil with Q-Max and Bake for 1/2 Hour @ 215°F.

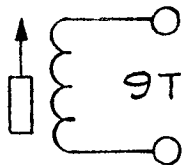
* TEST SPECIFICATION

TEST FREQ. = 25. MC
 MAX. IND = 0.96uh REF.
 MIN. IND = 0.46uh REF.
 Q = 80 MIN. @ MIN. IND.



* SOLDER ON 1" TEST LEADS. REMOVE AFTER TEST.

• INDICATES SOLDER POINTS, SOLDER ENDS AS SHOWN.



SCHEMATIC SYMBOL
L1021

X	4	GL-102	Q-Max.
X	3	BS-100	Solder, Soft
X	2	WI-122-24	Wire, Magnet. #24
1	1	CF-134-5-E	Form, Coil, Slug Tuned

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL							
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK											
AC-168 ASS'Y. (COIL, RF TUNED)											
B	* NOTE ADDED	10-3-66	16958	<i>WPA</i> <i>OCB</i>							
A	3/8 DIM. WAS 5/16 TEST SPEC. CLARIFIED	5, 25, 65	14-140	<i>W</i> <i>OCB</i>							
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.					
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. ± 1/64 DEC. ± .005 ANGLES ± 1/2°		SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES									
		TYPE & TEMPER		HEATTREAT. SPEC.		DRAWN		CHECKED		FINAL APPROVAL	
		FINISH & SPEC. NO.		ELEC. DES. APP.		MECH. DES. APP.		A 2496		B	

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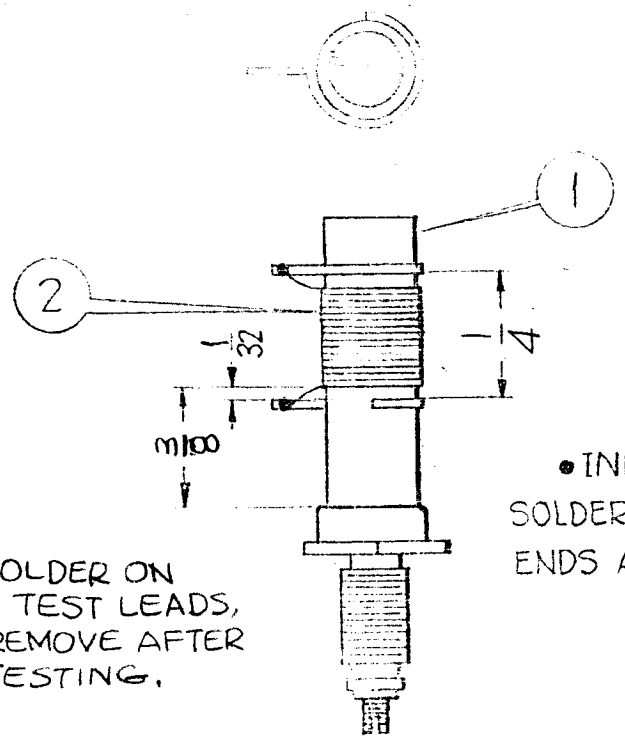
REV. BY UNIT	DESCRIPTION		DATE	A-2497	B
	MODEL	ASSY. NO.			
3	HR-1/T		6-9-62		

WINDING PROCEDURE

1. Secure Terminals to coil forms with Q-Max.
2. Wind 8 Turns on coil form, Single Layer Close Wound.
3. Stake wire ends to coil form with Q-Max.
4. Strip ends wrap around terminals and Solder.
5. Bake for 1/2 Hour @ 215°F. to remove moisture.
6. Coat coil with Q-Max. and bake for 1/2 Hour @ 215°F.

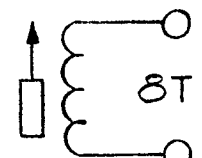
* TEST SPECIFICATION

TEST FREQ. = 25 MC
 MAX. IND = 0.71 uh REF.
 MIN. IND = 0.38 uh REF.
 Q = 75 MIN. @ MIN. IND.



• INDICATES
SOLDER POINTS. SOLDER
ENDS AS SHOWN.

* SOLDER ON
1" TEST LEADS,
REMOVE AFTER
TESTING.



SCHEMATIC
SYMBOLS

L1053; L1054; L1055

X	4	GL-102	Q-Max
X	3	BS-100	Solder, Soft
X	2	WI-122-24	Wire, Magnet, #24
1	1	CF-134-5-E	Form, Coil, Slug Tuned

B	* NOTE ADDED	10-3-66	16972	<i>[Signature]</i>	<i>[Signature]</i>	
A	3/8 DIM. WAS 5/16 TEST SPEC. CLARIFIED	5/2 5/6	14140	<i>[Signature]</i>	<i>[Signature]</i>	
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

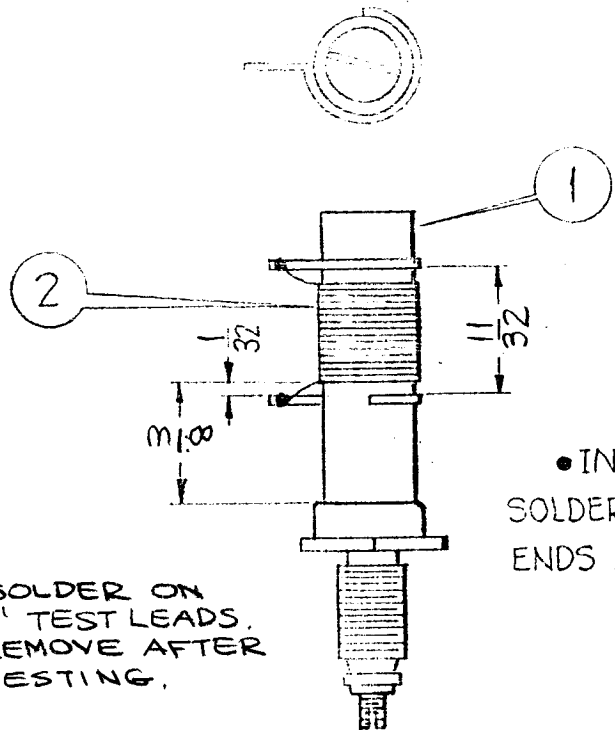
REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL		AC-169 ASS'Y. (COIL, RF TUNED)	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
		<i>[Signature]</i>	<i>[Signature]</i>
		<i>[Signature]</i>	<i>[Signature]</i>
		A-2497 B	

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON
 FRAC. ± 1/64 DEC. ± .005 ANGLES ± 1/2°

SCALE:
 MAXIMUM ALLOWABLE TOLERANCES HAVE
 BEEN DETERMINED AND ANY DEVIATIONS
 WILL BE CAUSE FOR REJECTION.
 REMOVE ALL BURRS AND SHARP EDGES

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REQ. PER UNIT	USED ON			A 2498	D
	MODEL	ARMY NO.	DATE		
1	HFR-1/T	A-2363	6-9-62		
1	HFR-1/T	A-2372	11-27-62		



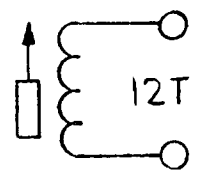
• INDICATES SOLDER POINTS. SOLDER ENDS AS SHOWN.

* SOLDER ON 1" TEST LEADS. REMOVE AFTER TESTING.

WINDING PROCEDURE

1. Secure Terminals to Coil Form with Q-Max.
2. Wind 12 Turns on coil Form, single layer close wound.
3. Stake Wire Ends To Coil Form with Q-Max.
4. Strip ends Wrap Around Terminals and solder.
5. Bake for 1/2 hour @ 215°F to remove moisture.
6. Coat Coil with Q-Max and Bake for 1/2 Hour @ 215°F.

* TEST SPECIFICATION
 TEST FREQ. = 25 MC
 MAX. IND = 1.42 uh REF.
 MIN. IND = 0.69 uh REF.
 Q = "85 MIN., AT MIN. IND."



SCHEMATIC SYMBOL
 L1013, L1014

X	4	GL-102	Q-Max
X	3	BS-100	Solder, Soft
X	2	WI-122-24	Wire, Magnet. # 24
1	1	CF-134-5-E	Form, Coil, Slug Tuned

D	* NOTE ADDED	10366	16958	<i>[Signature]</i>	<i>[Signature]</i>
C	3/8 DIM. WAS 5/16 TEST SPEC CLARIFIED	5/25/65	14140	<i>[Signature]</i>	<i>[Signature]</i>
B	Q WAS 85 MIN.	12/5/63	10552	<i>[Signature]</i>	<i>[Signature]</i>
A	MODEL & SYMBOL ADDED	11-27-62	7699	<i>[Signature]</i>	<i>[Signature]</i>

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
AC-170 ASS'Y. (COIL, RF TUNED)				
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. ± 1/64 DEC. ± .005 ANGLES ± 1/2°				
SCALE:		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES		
TYPE & TEMPER		HEATTREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.	

[Signatures]
 DRAWN: *[Signature]*
 CHECKED: *[Signature]*
 FINAL APPROVAL: *[Signature]*
 A 2498 D