

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
2	HFR-1	ASSY. NO.
		DATE
		4-10-62

A-2425

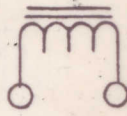
**CORE & TERMINAL RING ASSEMBLY:**

1. Assemble Terminal Rings (Item 1) to Ferramic Core (Item 2), Maintaining 1-1/2" Between Rings, As Shown.
2. Apply GL-104-2 (Item 3) Around Terminal Rings (Item 1)
3. Bake for One-Half Hour at 215°F.

**WINDING DATA:**

1. Starting Close to Terminal Ring as Shown, Solenoid Wind 53 Turns of WI-123-22 (Item 4) Onto Core Sub-Assembly, Leaving Approximately 1" Bare Lead Lengths. (Do Not Remove.)
2. Stake Leads to Terminal Rings with BS-100 (Item 5).
3. Check Inductance.
4. Saturate Coil Assembly with GL-104-2 (Item 3).
5. Bake for One-Half Hour at 215°F.

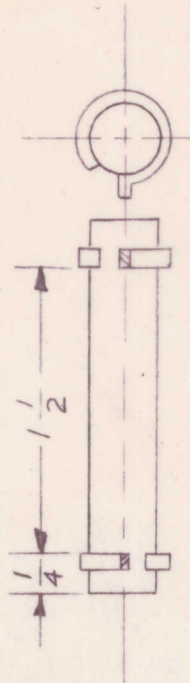
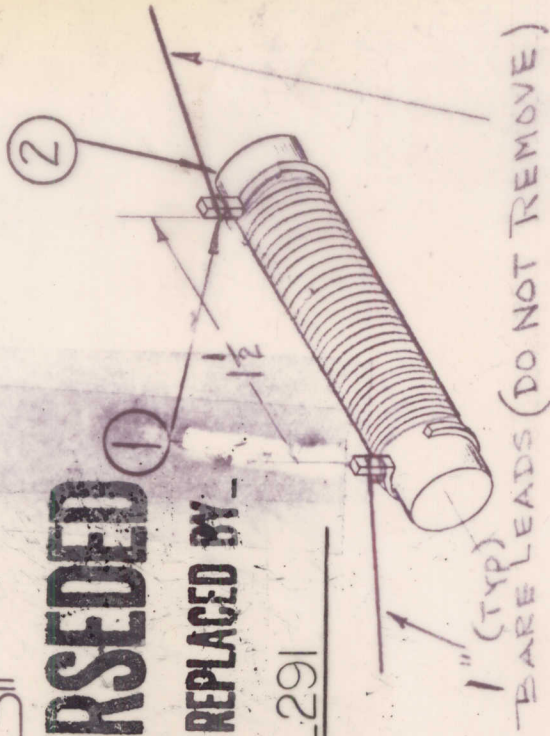
SCHEMATIC



**SUPERSEDED**

**DIRECTLY REPLACED BY -**

CL291



TOP VIEW - NOTE  
POSITION OF LUGS

X	5	BS-100	SOLDER, SOFT
X	4	WI-123-22	WIRE, ELECTRICAL, MAGNET, SZ22
X	3	GL-104-2	INSULATING VARNISH, ELECTRICAL
1	2	CI-112Q1-2R0F	CORE, FIXED, ROD
2	1	TE 153-2	TERMINAL, LUG, RING
REQ. ITEM	PART NO.	GELLMAN DESCRIPTION	
		SYMBOL	

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
CL-291 ASSEMBLY	
STOCK SIZE	
MATERIAL	
TYPE & TEMPER	HEAT TREAT. SPEC.
FINISH & SPEC. NO.	
DRAWN	CHECKED
ELEC. DES. APP.	MECH. DES. APP.
FINAL APPROVAL	
A-2425	
F	

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
F	Replaced by CL291	11/1/61	2025		W	R.C.B.
E	WAS 36 MIN	11/2/66	17145	R.M.E.	J.F.S.	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. ± 1/64 DEC. ± .005 ANGLES ± 1/20						
SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES						