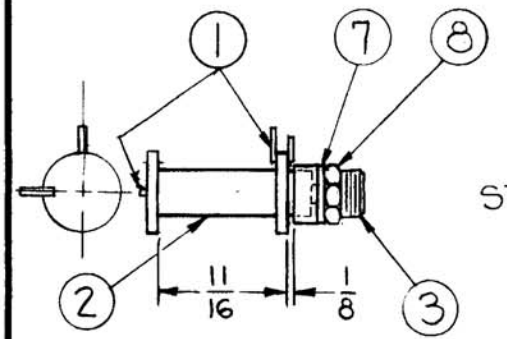
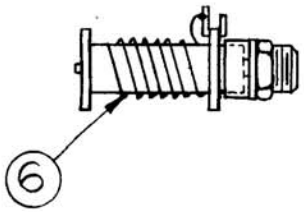
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE FOR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.

REQ. PER UNIT	USED ON MODEL	ASS'Y. NO.	DATE	A-3138	D
1	HFS-1	CL-309	3-14-63		



STAGE-1



STAGE-2

* L TO BE MEASURED WITH LEADS 3/8" LONG OR LESS.

PROCEDURE

1. ASSEMBLE TERMINALS (ITEM 1) & BUSHING (ITEM 3) AND SECURE TO COIL FORM (ITEM 2) AS SHOWN WITH INSULEX (ITEM 9), DO NOT ALLOW INSULEX TO FORM ON TERMINAL TIPS.
2. WIND 6¼ TURNS OF WIRE WI-122-18 (ITEM 6) EVENLY SPACED ON (ITEM 2) AND SOLDER LEADS TO TERM AS SHOWN.
3. COAT WINDING WITH GL-102 (ITEM 5).
4. BAKE FOR ½ HOUR AT 250°.
5. L = .17 µh ±.08 µh AT 25.2 MC. *
6. Q MIN = 160 AT 50 MC.

X	9	GL-104-2	INSULEX, U-85	
1	8	NTH0832BNB	NUT, HEX.	
1	7	LWI08MRN	LOCKWASHER, INTERNAL	
X	6	WI-122-18	MAGNET WIRE, SINGLE	
X	5	GL-102	Q - DOPE	
X	4	BS-100	SOLDER, SOFT	
1	3	SM-140-2	BUSHING, COIL MTG.	
1	2	CF-122-1.00	COIL FORM	
2	1	TE-181-1	TERMINAL, COLLAR	

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
D	BOT. TERM COLLAR REL	6.20.66	16419	WHW		
C	NOTE 5, WAS .22 µh ±.04 UPDATED, NOTE 2	9-23-63	10035	bbd		
B	NOTE 2 WAS 7 TURNS	7-10-63	9495			
A	ITEM(9) WAS GL-104 ITEM(8) WAS NTH0832BNB	3-28-63	8671	RK		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES

TOLERANCES: DECIMALS .X ±.05, .XX ±.01, .XXX ±.005; FRACTIONS ± 1/64; ANGLES ± 0° 30'

SCALE

CODE

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
			J. STRUMER	

STOCK SIZE

MATERIAL

TYPE & TEMPER | HEAT TREAT. SPEC.

FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK. NEW YORK

CL-309 ASSEMBLY

DRAWN	CHECKED	FINAL APPROVAL

ELEC. DES. APP. | MECH. DES. APP.

A-3138 D

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