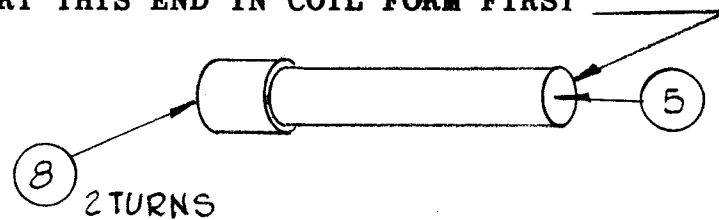


**ASSEMBLY PROCEDURE:**

1. POSITION LUGS ON COIL FORM AS SHOWN. SECURE WITH ITEM 6 (U-85).
2. WIND ON 66 CLOSE WOUND TURNS OF ITEM 3 (ALLOW 3" STRIPPED LEADS EACH END FOR TEST PURPOSES. REMOVE AFTER TEST.).
3. STAKE COIL ENDS WITH ITEM 4.
4. SOLDER LEADS TO LUGS AS SHOWN.
5. COAT THE ENTIRE COIL, COIL FORM AND INNER SURFACE OF THE COIL FORM WITH ITEM 6 (U-85).
6. WIND 2 TURNS OF ITEM 8 (TAPE) ON CORE TO INSURE A SNUG FIT IN COIL FORM (SEE BELOW).
7. COAT ITEM 5 (CORE) WITH ITEM 6 (U-85) THEN INSERT CORE INTO COIL FORM AS SHOWN. CORE MUST FIT FORM SECURELY.
8. BAKE FOR ONE HOUR AT 270° F.
9. TEST WITH CORE.
10. STAMP COIL FORM AS SHOWN.

INSERT THIS END IN COIL FORM FIRST



**NOTES**

1	TTR-10	AX-418
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE $\frac{1}{8}$	CODE 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.		

A		REVISIONS				
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
A	IT.1 WAS CF-119-2.817	8.26.64	12228	MB	JH	

A-3174

**TEST DATA, WITH CORE:**

L = 180 uh (170-180 uh)

Q = 120 OR GREATER

F = 790 KC

USE BOONTON Q-METER 160A OR EQUIVALENT

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	8	TA-100-2	TAPE, VINYL PLASTIC (1/2" WIDE)	BLACK
X	7	BS-100	SOLDER, SOFT	
X	6	GL-104-2	RESIN, SYNTHETIC (U-85)	
1	5	CE-112Q2R0F	CORE, POWDERED IRON	
X	4	GL-103	CEMENT, DUCO	
X	3	WI-107-11	MAGNET, WIRE, #30 DEC	
2	2	TE-153-3	LUG, RING TYPE	
1	1	CF-119-2.812	COIL FORM	

R. Kohn		LIST OF MATERIAL		E 3037-35	
MATERIAL			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
FINISH			TITLE GL-319-ASSEMBLY COIL, R.F., FIXED		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN G.D.L.	DATE 5-24-63	FINAL APPROVAL	
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		CHECKED Jde	DATE 6-6-63	BPO	
FRACTIONS ± 1/64 ANGLES ± 0° 30'		ELECT. DES. RonKohn	DATE 6-14-63	A-3174	
TOLERANCES		MECH. DES.	DATE	SHEET	
			REV. LTR.		A