

STAMP TMC PART NO.
3/32 HIGH BLACK GOTHIC
AS SHOWN WITH LATEST
REVISION LETTER.

	PRIMARY	SECONDARY	TERTIARY
R	3.5 Ω	4.5 Ω	4.5 Ω
*L	27-27.5mhy	6.0-6.4 mhy	6.0-6.4 mhy
*Q	51-57	8.5-9.5	8.5-9.5
*F	1KC	1KC	1KC

* MEASURED WITH GR BRIDGE TYPE 1650-A OR
EQUIVALENT. TUNING SLUG (ITEM *9) REMOVED

NOTES:

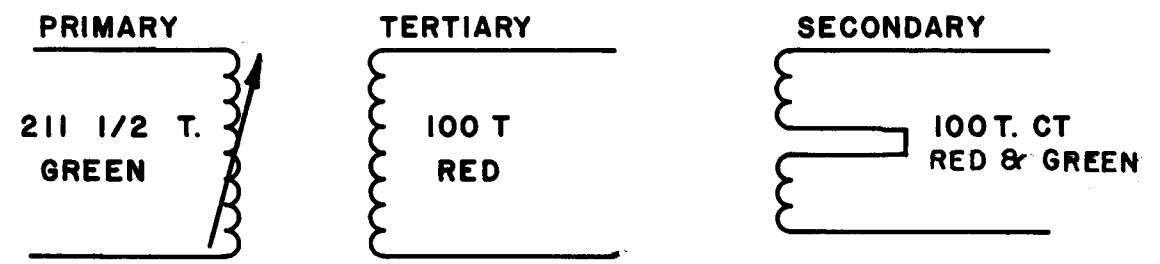
- 1~ SOLENOID WIND PRIMARY 211 1/2 TURNS OF ITEM *2, ON ITEM *6. STAKE ENDS WITH ITEM *4.
- 2~ WIND TERTIARY 100 TURNS OF ITEM #11, STAKE ENDS WITH ITEM *4.
- 3~ BIFILAR WIND SECONDARY 50 TURNS OF ITEMS #11 & 2, STAKE ENDS WITH ITEM *4.
TWIST START OF ONE WINDING WITH FINISH OF OTHER WINDING (SEE PICTORIAL).
- 4~ COLOR CODE ALL START LEADS WITH WHITE DOT AND BAKE FOR 30 MINUTES AT 150°F REMOVE FROM OVEN AND COAT COIL WITH ITEM #3.
- 5~ COAT CORE SURFACE (ITEM *1) WITH ITEM *5.
- 6~ ASSEMBLE AS SHOWN IMMEDIATELY.
- 7~ STRIP & TIN LEADS (MINIMUM LENGTH OF 2 INCHES)
- 8~ CHECK R, L & Q OF WINDINGS.
- 9~ CHECK FOR CONTINUITY BETWEEN WINDINGS.
- 10~ INSERT ITEM #3 INTO BASE OF CORE TO SEAL BOBBIN.

NOTES

1	VLR-1	AX 425
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE DO NOT SCALE	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 3176

REVISIONS						
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
O	ORIGINAL RELEASE FOR PRODUCTION	5-11-64	0	A.M.		
A	IT. 10 WAS WI 141-34-9, NOTE (10 ADDED, 3 & 4 REV) SEC. WAS NATURAL	8.24.67	18469	H.G.		E.F.M.



SCHEMATIC

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	11	WI 141-34-2	WIRE, ELECTRICAL, MAGNET INSUL.	
	10	DELETED		
1	9	CI 133	CORE, TUNING	
2	8	WA 140-1	WASHER, NON-METALLIC	
1	7	CU 148-1	RETAINER, CUP CORE	
1	6	CF 135-4	FORM, COIL	
X	5	GL 129	ADHESIVE, QUICK SETTING	
X	4	GL 103	DUCO	
X	3	GL 130	CEMENT, Q DOPE	
X	2	WI 141-30-5	WIRE, ELECTRICAL, MAGNET INSUL.	
1	1	CI 132	CORE, CUP	

LIST OF MATERIAL				
MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
FINISH		TITLE TT 198 ASSEMBLY		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN G. Suman	DATE 6-3-63	FINAL APPROVAL [Signature]	
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	CHECKED @	DATE 5-5-64	A 3176	
FRACTIONS ± 1/64 ANGLES ± 0° 30'	ELECT. DES. [Signature]	DATE	A	
TOLERANCES	MECH. DES. [Signature]	DATE	SHEET	
			REV. LTR.	