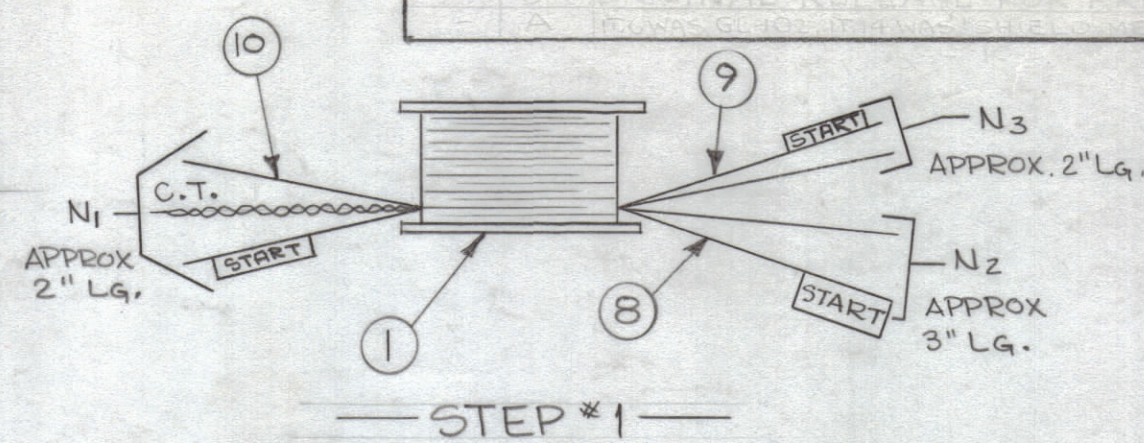
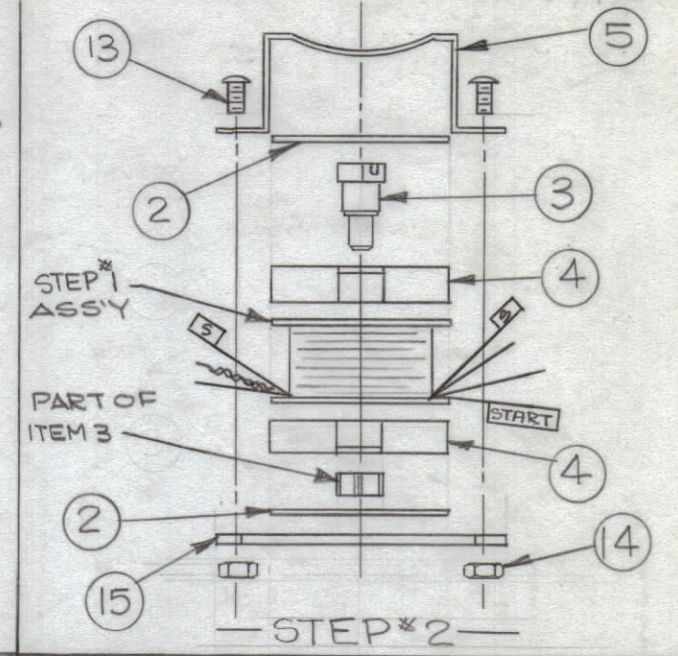


TMC PART NO	NO. OF TURNS	BIFILAR WIND			INDUCTANCE ±2% MH	CENTER FREQ (KC)	OPERATION FREQ RANGE (K.C.)
		N ₁	N ₂	N ₃			
A 3271-11	18	73	13	3.2	11	10-12	
A 3271-13	16	69	11	2.85	13	12-14	
A 3271-16	14	61	14	2.25	16	14-18	
A 3271-21	12	56	8	1.73	21	18-24	
A 3271-27	8	48	6	1.33	27	24-30	
A 3271-60	6	29	4	0.5	60	55-65	

REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD
B		ON CHART (-21), N2 COL. WAS 54; INDUCTANCE COL. WAS 1.68.	12-15-64	13130	g.f.	@
		ITEM 7 WAS GL-100; SPEC. RE-CLASSIFIED AS 5-2-64				
		ORIGINAL RELEASE FOR PRODUCTION				

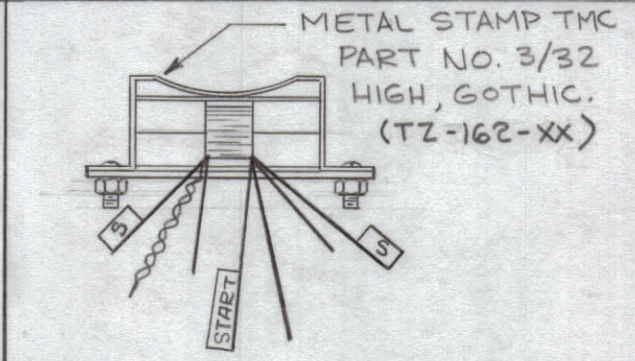


NOTE:
WINDINGS MUST TERMINATE A "START TAG" ON N₂ AS SHOWN. WINDINGS MUST BE PUT ON IN ONE DIRECTION.

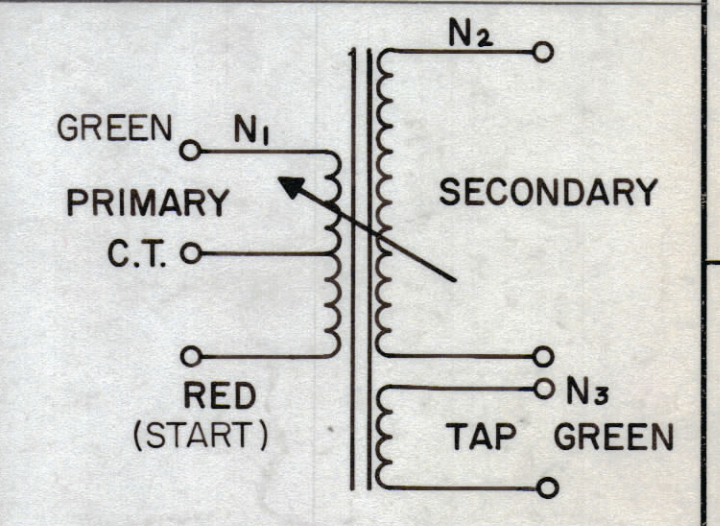


— WINDING PROCEDURE —

- 1 - DIP ITEM 8 WITH ACETONE (APPROX. 3" LONG). PLACE MASKING TAPE ON BEGINNING OF WIRE AND MARK START AS SHOWN IN STEP #1.
- 2 - WIND N₂ WINDING WITH ITEM 8 ONTO ITEM 1, AS IN STEP #1.
- 3 - PLACE ITEM 6 ON FINISH OF WINDING, LET DRY FOR ONE MINUTE AND ASSEMBLE AS SHOWN IN STEP #2. DO NOT USE ITEM 3 FOR THIS MEASUREMENT. DIP ENDS OF LEADS WITH ACETONE.
- 4 - TIN ENDS OF LEADS. MEASURE THE INDUCTANCE AND "Q" WITH THE GENERAL RADIO BRIDGE.
- 5 - THE INDUCTANCE MUST FALL WITHIN ±2% OF THE INDUCTANCE INDICATED. ADJUSTMENT OF ±1 TURN SHOULD BE APPROPRIATE. "Q" SHOULD APPROX. EQUAL 20 (USE GENERAL RADIO BRIDGE).
- 6 - UNASSEMBLE STEP #2 AS SHOWN.
- 7 - WIND ITEM 10 (N₁) ON ITEM 1 AND SECURE WITH ACETONE. LET DRY FOR ONE MINUTE. MARK START WITH MASKING TAPE.
- 8 - WIND ITEM 9 (N₃) ON ITEM 1 AND SECURE WITH ACETONE. LET DRY FOR ONE MINUTE. MARK START WITH MASKING TAPE.
- 9 - BAKE ITEM 1 AT 200°F, FOR 20 MINUTES.
- 10 - APPLY ITEM 6 TO FINISHED TRANSFORMER.
- 11 - SEPARATE RED AND GREEN BIFILAR WIRE.
- 12 - TWIST START (GREEN LEAD) AND END (RED LEAD).
- 13 - TIN ENDS OF LEADS.
- 14 - ASSEMBLE AS SHOWN IN STEP #2. PLACE TRANSFORMER ON GENERAL RADIO BRIDGE AND CHECK "Q" AND INDUCTANCE, WITHOUT TUNING SLUG (ITEM 3).
- 15 - ADD TUNING SLUG (ITEM 3) TO FINISHED TRANSFORMER.
- 16 - CHECK CONTINUITY OF WINDINGS AND FOR SHORTS BETWEEN WINDINGS.
- 17 - ITEMS 13, 14 AND 15, MUST BE REMOVED BEFORE BEING MOUNTED TO THE PRINTED CIRCUIT BOARD.



STEP #3



— SCHEMATIC DIAGRAM —

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
1	15	MS 3488	RETAINER, COIL	
2	14	NTH0256BNG	NUT, HEX.	
2	13	SCBP0256BNG	SCREW, MACHINE	
X	12	BS 100	SOLDER, SOFT	
#	11	DELETED	—	
X	10	WI 148-34-25	HUDSOL WIRE, MAGNETIC, #34	RED/GRN
X	9	WI 141-34-5	HUDSOL WIRE, MAGNETIC, #34	GREEN
X	8	WI 104-4044-SCP-QS	WIRE, LITZ	
#	7	DELETED	—	
X	6	GL 130	ADHESIVE, Q-DOPE	
1	5	CU 148-1	RETAINER, CUP CORE	
2	4	CI 132	CORE, CUP	
1	3	CI 133	CORE, TUNING	
2	2	WA 140-1	WASHER, NON-METALLIC	
1	1	CF 135-4	BOBBIN, NYLON	

M. GELLMAN LIST OF MATERIAL

MATERIAL: —

FINISH: —

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

TITLE: TZ-162 ASSEMBLY

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

DECIMALS: .X ± .05, .XX ± .01, .XXX ± .005

FRACTIONS: ± 1/64, ANGLES: ± 0° 30'

TOLERANCES: ± 1/64, ± 0° 30'

DRAWN: [Signature] DATE: 8-2-63

CHECKED: [Signature] DATE: 5-2-64

ELECT. DES: [Signature] DATE: []

MECH. DES: [Signature] DATE: []

FINAL APPROVAL: [Signature] DATE: []

REV. LTR. [Signature]

1 VLR-1 A-3212

QTY/UNIT: NONE

MODEL USED ON: A

ASSY. NO.:

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NOTES

A-3271 B