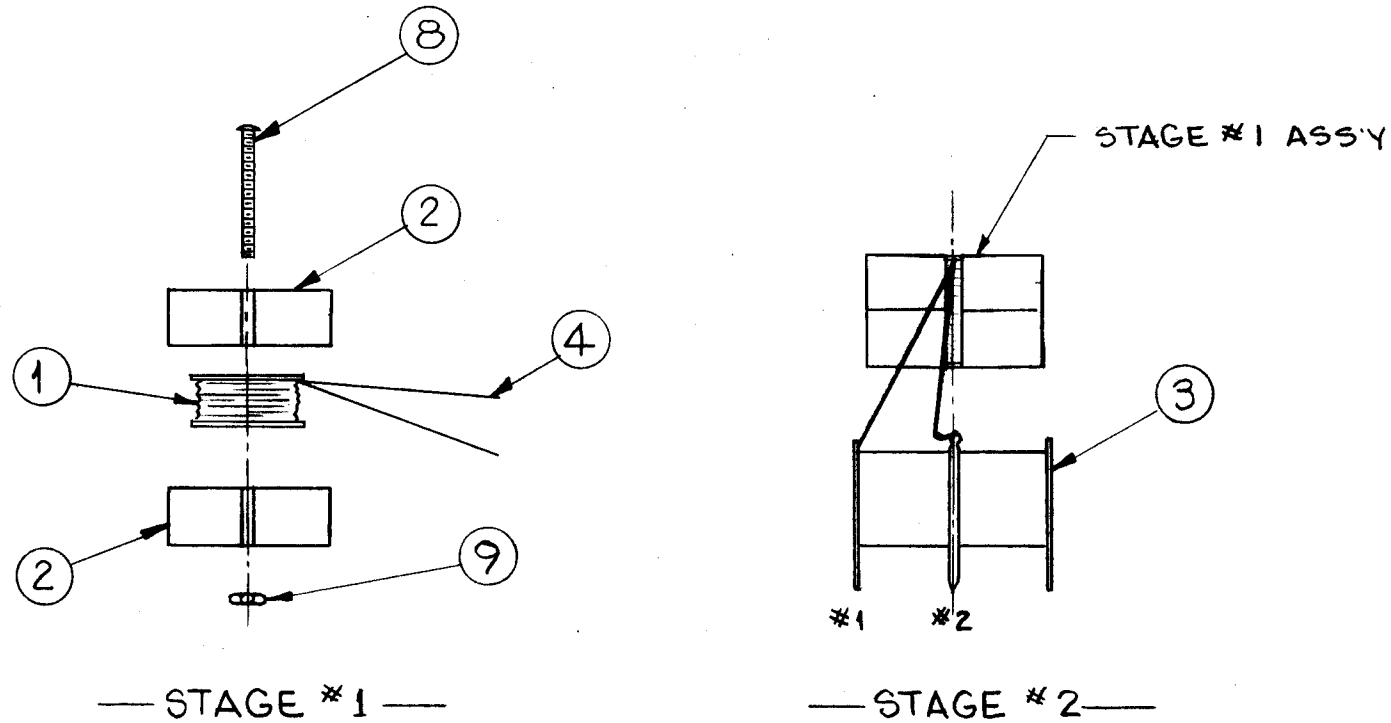
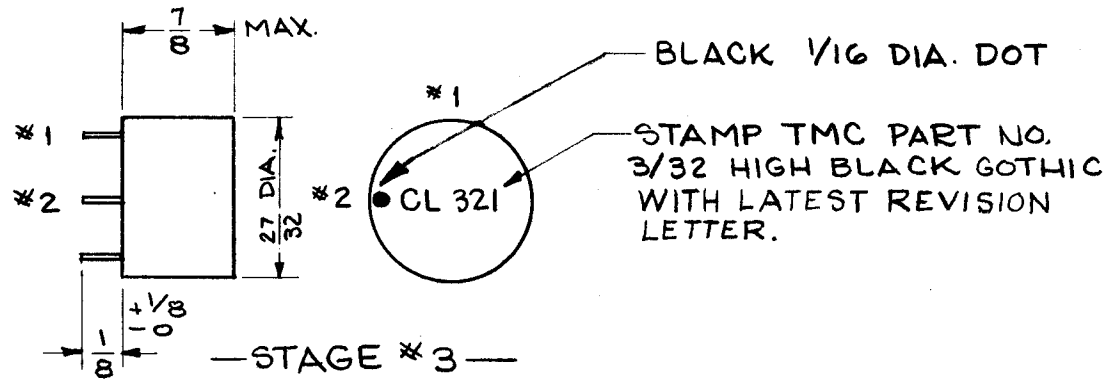


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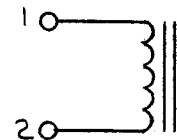
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- NOTES:
- 1~ SOLONID WIND 90 TURNS OF ITEM #4 ON ITEM #1. STAKE ENDS WITH ITEM #6. LEADS TO BE APPROX 3" LONG.
 - 2~ BAKE FOR 20 MINUTES AT 200°F. REMOVE FROM OVEN & COAT WITH ITEM #5, THOROUGHLY. STRIP TIN LEADS 2 1/2".
 - 3~ ASSEMBLE AS PER STAGE #1. CAUTION, CARE SHOULD BE TAKEN IN TIGHTENING ITEM #8. SO AS NOT TO CRACK ITEM #2. HAND TIGHT WILL BE THE MAXIMUM ALLOWENCE.
 - 4~ MEASURE "Q" & INDUCTANCE.
 - 5~ ITEM #9 MUST BE FLUSH WITH BOTTOM OF FORM.
 - 6~ USE ITEM #6 ON INSIDE OF FORM SO THAT CORE WILL NOT MOVE.
 - 7~ MOUNT ASSEMBLED COIL INTO ITEM #3 & STAKE LEADS TO FIT TERMINALS #1 & #2. SOLDER TO ITEM #3.
 - 8~ ENCAPSULATE STAGE #2 ASSY BY INSERTING INTO TMC MOLD #JG-107-1 & POTTING WITH ITEM #7.
 - 9~ STAMP AS PER STAGE #3.
 - 10~ CHECK R, L & Q.



R	L (MHY)	Q AT 1KC
1-2 APPROX	9 TO 15	10 APPROX.



ABOVE READINGS TAKEN WITH GR #1650-A METER OR EQUIV.

REQ.	ITEM	PART NO.	M. GELLMAN DESCRIPTION	SYMBOL
X	10	BS 100	SOLDER, SOFT	
1	9	NTH0256BNG	NUT, HEX.	
1	8	SCBP0256BNG	SCREW, MACHINE	
X	7	GL 128-5	COMPOUND, POTTING	
X	6	GL 103	DUCO, CEMENT	
X	5	GL 102	Q DOPE	
X	4	WI 123-32	WIRE, ELEC. MAG. HT.	
1	3	TM 124-3	TERMINAL, COLLAR	
2	2	CI 119-TI-D	CORE, CUP	
1	1	CF 135-7	FORM, COIL (BOBBIN TYPE)	

REQ. ITEM		PART NO.		M. GELLMAN DESCRIPTION		SYMBOL	
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK							
CL 321 ASSEMBLY							
MATERIAL							
TYPE & TEMPER		HEAT TREAT. SPEC.		DRAWN		CHECKED	
FINISH & SPEC. NO.		ELEC. DES. APP.		MECH. DES. APP.		A 3357 A	

A	ITEM 4 WAS WI132-32	728-64	11943	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
Ø	ORIGINAL RELEASE FOR PRODUCTION	5-11-64	0	A.M.	@	
XI	DWG # WAS AC-177, COMPLETELY REVISED NOTE 8; ITEM 10 WAS JG-107-1.	12/3/63	1	JL	MP.	<i>[Signature]</i>
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°

SCALE: DO NOT SCALE
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
REMOVE ALL BURRS AND SHARP EDGES

1	VLR-1	A-	6-19-63
REQ. PER UNIT	MODEL	SECTION	ASSY. NO.
USED ON			