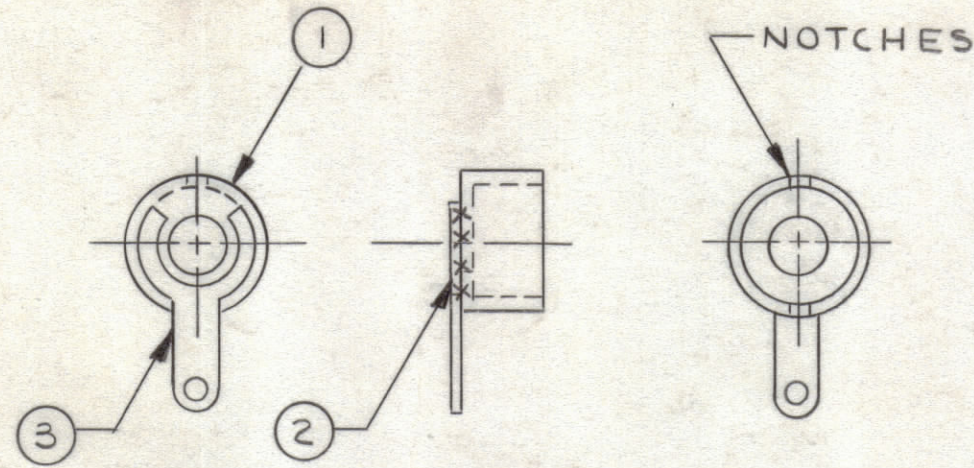
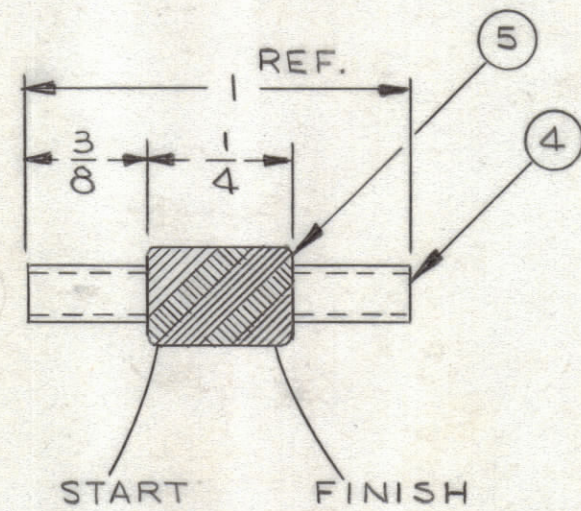


STEP:1



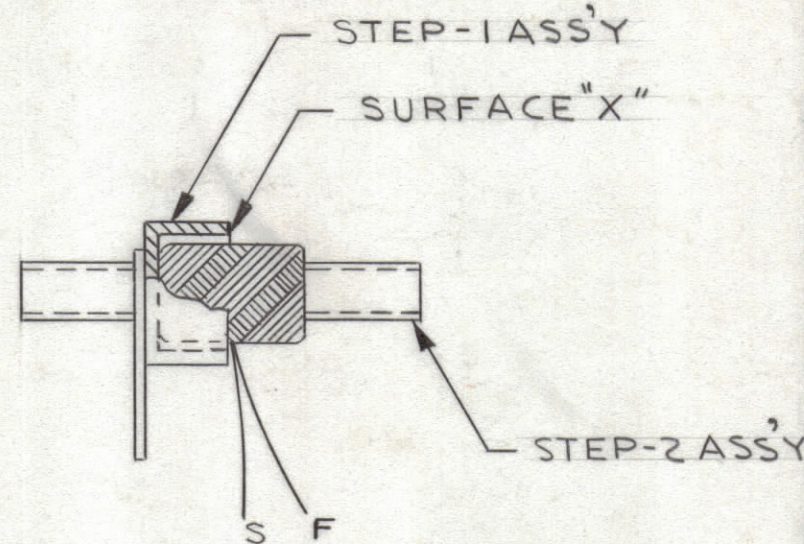
1- CEMENT TERMINAL LUG ITEM ③ TO CUP CORE ITEM ① WITH CEMENT, ITEM ②. NOTCHES ON ITEM ① TO BE LOCATED IN POSITION SHOWN.  
2- ALLOW ITEM ② TO DRY FIRMLY.

STEP:2



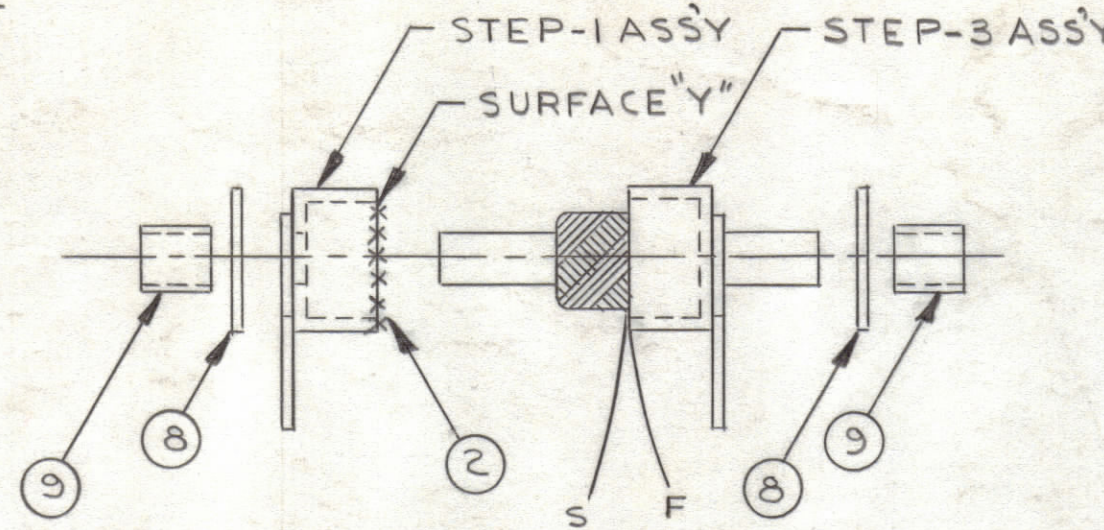
1- WIND 920 TURNS OF WIRE ITEM ⑤ ON COIL FORM ITEM ④ AS SHOWN.  
2- STAKE START & FINISH OF WINDING WITH DUCO CEMENT ITEM ⑥.  
3- TRIM LEADS TO APPROX. 1" INCH IN LENGTH.  
4- CHECK PER STEP-6B.

STEP:3



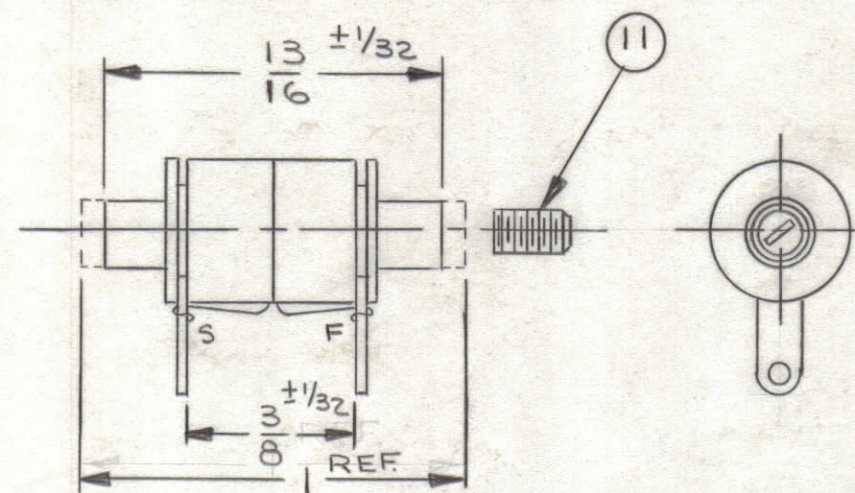
1- COAT STEP-2 ASS'Y WITH Q-DOPE ITEM ⑦ ON OUTSIDE OF WINDING, & PLACE INSIDE STEP-1 ASS'Y. TAKE CARE TO KEEP SURFACE "X" FREE OF ITEM ⑦.  
2- STEP-2 ASS'Y START & FINISH LEADS TO BE LOCATED NEAR BOTTOM OF STEP-1 ASS'Y.  
3- BAKE FOR 20 MINUTES AT 150° F.

STEP:4



1- COAT STEP-1 ASS'Y SURFACE "Y" WITH CEMENT ITEM ②.  
2- LINE UP TERMINAL LUGS ON STEP-1 & 3 ASSEMBLIES & IMMEDIATELY JOIN BOTH ASSEMBLIES TOGETHER.  
3- CEMENT FIBER WASHER ITEM ⑧ FLUSH AGAINST TERMINAL LUGS ON STEP-1 ASS'Y WITH ITEM ②.  
4- CEMENT COIL FORM ITEM ⑨ OVER COIL FORM ④ FLUSH AGAINST ITEM ⑧ WITH ITEM ②.

STEP:5



1- SOLDER START AND FINISH LEADS TO TERMINAL LUGS WITH SOLDER, ITEM ⑩ AS SHOWN.  
2- REMOVE, USING RAZOR BLADE APPROX. 3/32" FROM EACH END OF COIL FORM ITEM ④.  
3- CLEAN INSIDE THREADS OF ITEM ④ N# 8-32NC-2 TAP.  
4- THREAD ITEM ⑪ THREAD CORE IN PLACE.

STEP:6

A- MACHINE SETUP FOR WINDING, SHOWN IN CHART BELOW.

CAM	GEARS	
	FRONT	REAR
.250	DR= 88 DN= 44	DR= 46 DN= 91

B- CHECK COIL AS PER CHART BELOW.

TEST SPECIFICATION CHART				
TURNS	FREQ.	-L-	-Q-	-R-
920	250 KC	3.3mh±3%	45 ±10%	58-61

NOTES

LFSA-1	
QTY./UNIT	MODEL USED ON
SCALE	ASS'Y. NO.
NONE	A

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REVISIONS					
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT
#	Q	ORIGINAL RELEASE FOR PRODUCTION	7-27-64	Q	G.D.L.
C3	A	IT. II WAS 2 REQ.	10-29-64	12786	HB (2) 5700

PRIMARY TURNS	INDUCTANCE	"Q"	D.C. RESISTANCE	FREQUENCY
920	2.3mh ±3%	45	58-61	250 K.C

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
1	11	CI 121-2	CORE, THREADED, FERRITE	
X	10	BS 100	SOLDER, SOFT	
2	9	CF 130-1	FORM, COIL	
2	8	WA 109-51	WASHER, FIBER	
X	7	GL 130	CEMENT, "Q" DOPE	
X	6	GL 103	DUCO CEMENT	
X	5	WI 141-39-9	WIRE, MAGNET, ELECTRICAL	
1	4	CF-132-1.000-M-0832	FORM, COIL	
2	3	TE 201	TERMINAL LUG	
X	2	GL 129	CEMENT,	
2	1	CI-134-Q1-B	CORE, CUP	

M. GELLMAN		LIST OF MATERIAL	
MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH		TITLE CL 329 ASSEMBLY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN J. LESHINSKI	
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		DATE 10/5/63	
FRACTIONS ± 1/64 ANGLES ± 0° 30'		CHECKED @	
TOLERANCES		DATE 7-27-64	
ELECT. DES.		DATE	
MECH. DES.		DATE	
REV. LTR.		A-3360-A	

A-3360-A