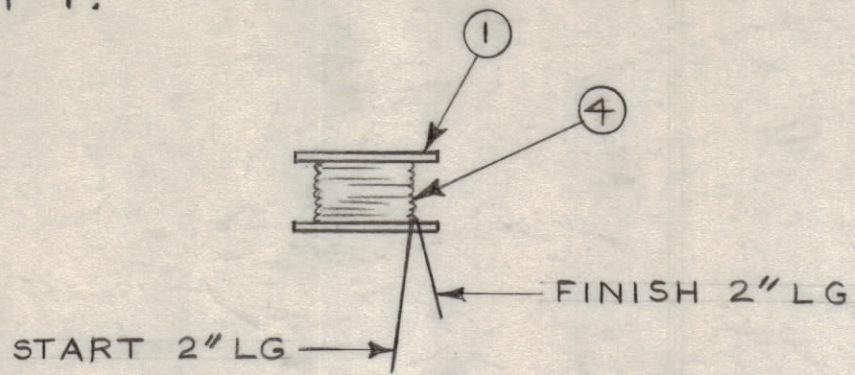
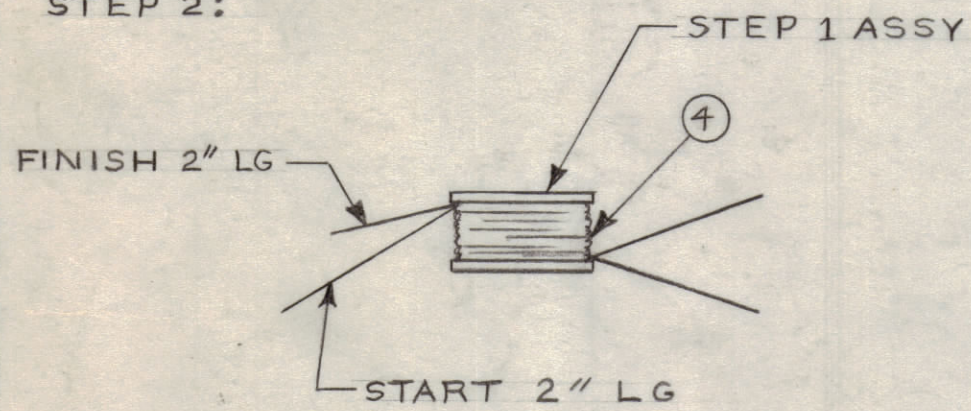


STEP 1:



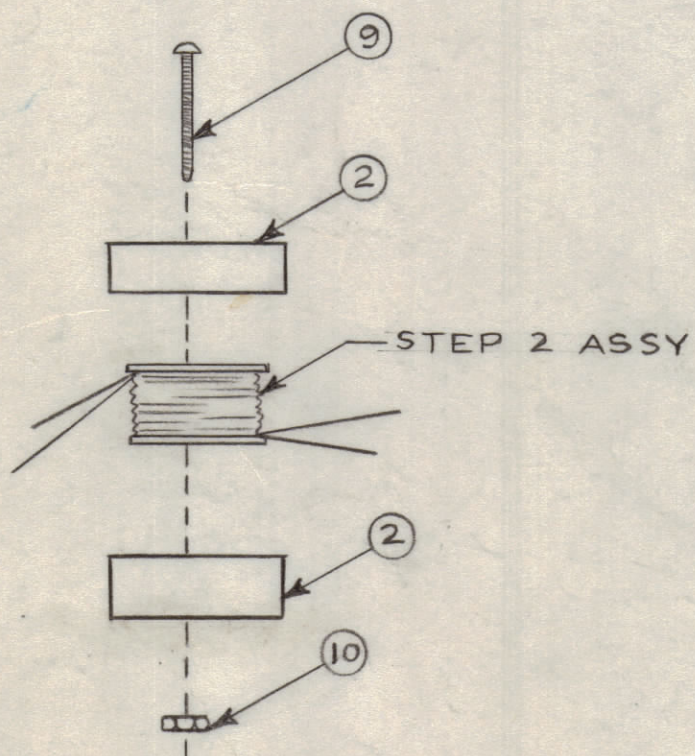
1. WIND 38 TURNS OF #32 MAGNET WIRE ITEM ④ ON BOBBIN ITEM ①.
2. STAKE WITH ITEM ⑦.

STEP 2:



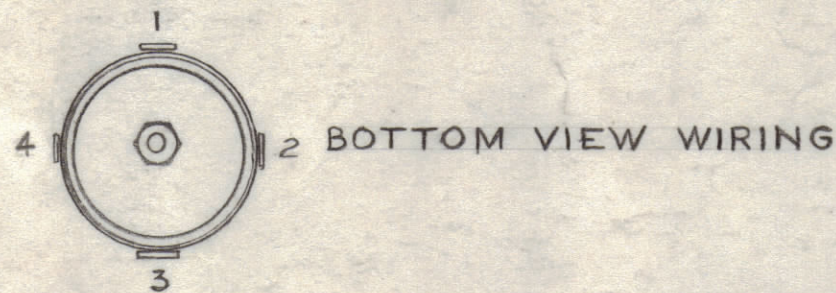
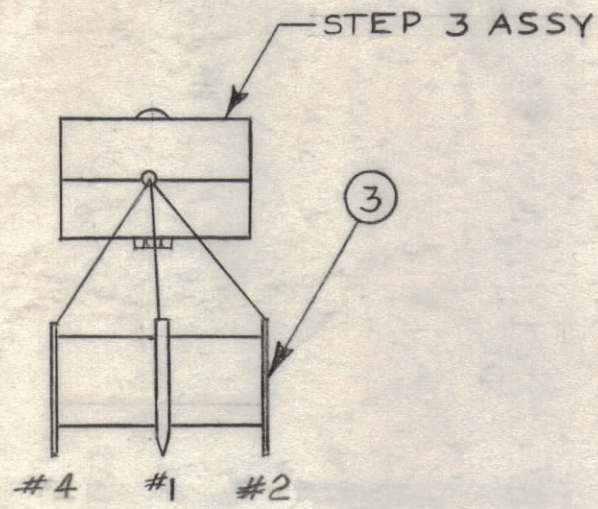
1. WIND 38 TURNS OF MAGNET WIRE ITEM ④ IN SAME DIRECTION AS FIRST 38 TURN WINDING.
2. STAKE WITH ITEM ⑦.
3. BAKE FOR 20 MINUTES AT 150°F.
4. COAT THOROUGHLY WITH Q DOPE ITEM ⑥ IMMEDIATELY AFTER BAKING PROCESS.

STEP 3:



1. ASSEMBLE AS SHOWN.
2. CAUTION: CARE SHOULD BE TAKEN IN TIGHTENING ITEM ⑨ SO AS NOT TO CRACK ITEM ②. HAND TIGHT WILL BE THE MAXIMUM ALLOWANCE.

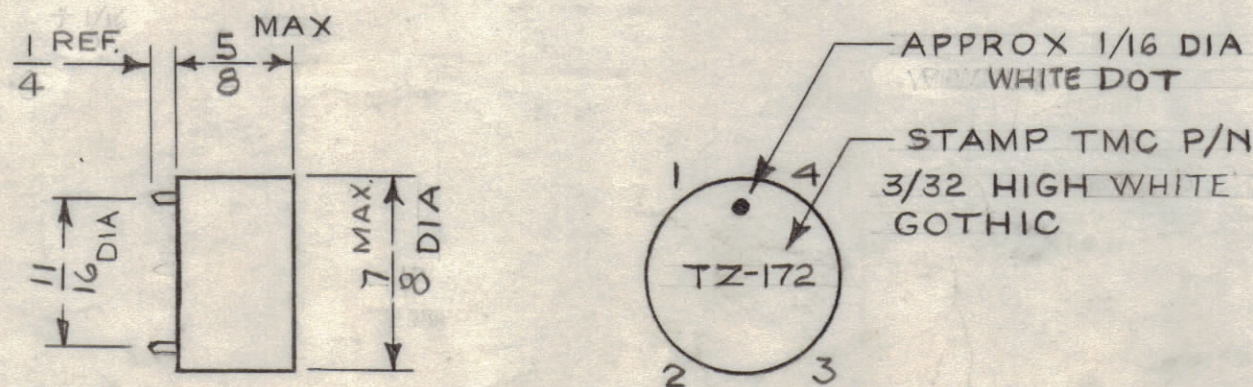
STEP 4:



WIRE TERMINATION:

1. a) START WIRE IN STEP 1 TO TERMINAL 1
 b) FINISH WIRE IN STEP 1 TO TERMINAL 2
 c) START WIRE IN STEP 3 TO TERMINAL 3
 d) FINISH WIRE IN STEP 3 TO TERMINAL 4
2. THE NUT MUST BE FLUSH WITH BOTTOM OF FORM ITEM ③

STEP 5:



1. CHECK FOR CONTINUTY
2. NOMINAL INDUCTANCE: 1-2 ±20% 2.0 MH
 3-4 ±20% 2.0 MH
3. ENCAPSULATE STEP 4 ASSY WITH COMPOUND, POTTING. ITEM ⑧ TO ABOVE DIMENSIONS.

NOTES

1	MCG-1	
QTY./UNIT	MODEL USED ON	ASSY. NO.
SCALE	CODE	
NONE		
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REVISIONS							
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
XI		ON STEP 5 DOTS & STAMP WERE BLACK. NOMINAL INDUCTANCE WAS: 1-2 ±10% .85 MH - 2-3 ±10% .85 MH	6/12/64	XI	A.M.	@	[Signature]
φ		ORIGINAL RELEASE FOR PRODUCTION	6/12/64	φ	A.M.	@	[Signature]
A		TERM NOS. 4 TO 2 & 2 TO 4	9/11/65	14542	JLV		[Signature]
B		ADDED MAX TO 1/8 DIM.; 1/4 REF DIM. WAS 1/8 ±1/16	6/12/66	16911	JL		[Signature]

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
1	10	NTH0256BN6	NUT, HEX	
1	9	SCBP0256BN6	SCREW, MACHINE	
-	8	GL-128-6	COMPOUND, POTTING (BLUE)	
-	7	GL-103	CEMENT, DUCCO	
-	6	GL-130	CEMENT, Q DOPE	
-	5	BS-100	SOLDER, SOFT	
-	4	WI-122-32	WIRE, MAGNET (NATURAL)	
1	3	TM-124-2	TERMINAL, COLLAR	
2	2	CI-119-TI-D	CORE, CUP	
1	1	CF-135-7	BOBBIN, NYLON	

LIST OF MATERIAL				
MATERIAL	#	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
FINISH	#	TITLE TZ-172 ASSEMBLY		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN	DATE	FINAL APPROVAL	DATE
	[Signature]	12-12-63	[Signature]	
	[Signature]	6-12-64		
DECIMALS	FRACTIONS	ELECT. DES.		
X ± .05	± 1/64	[Signature]		
.XX ± .01	ANGLES	DATE		
.XXX ± .005	± 0° 30'	6-12-64		
TOLERANCES		SHEET		
		A-3411		
		REV. LTR.		
		B		

A-3411 B