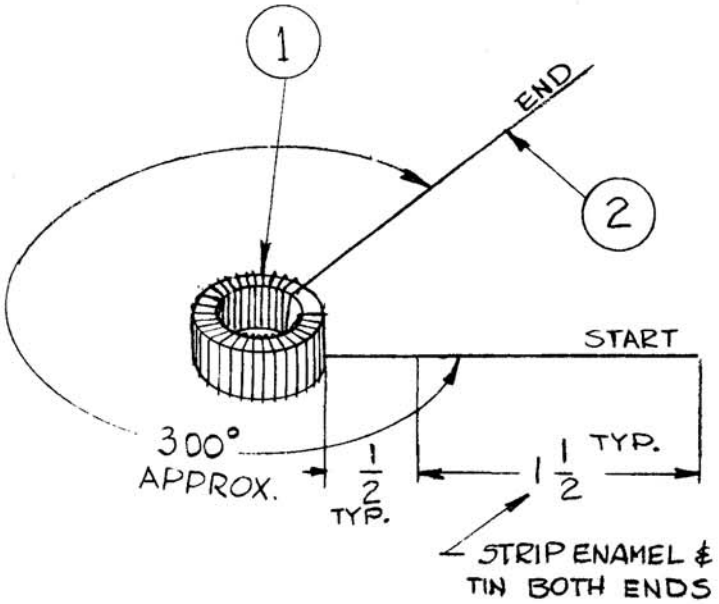
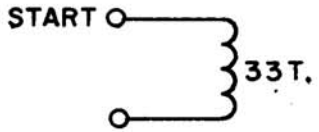
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.

REQ. PER UNIT	USED ON MODEL	ASS'Y. NO.	DATE
1	HFR-1A	A 3494	2-24-64
1	HFR-2	A 3494	

A 3493 | A



SCHEMATIC



PROCEDURE

1- APPROX. 33 TURNS CLOSE WOUND IN THE DIRECTION SHOWN.

2- REMOVE OR ADD TURNS TO MEET INDUCTANCE SHOWN IN TEST SPECS.

3- BAKE FOR ½ HR. AT 215°F TO REMOVE MOISTURE.

4- COAT COIL & CORE WITH GL-102 Q-MAX. AND BAKE FOR ½ HR AT 215°F.

TEST SPECIFICATIONS

*NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE.

L = 4.7 μh ± 0.15 μh

Q = 210 MIN. @ 5.25 MC

Cdist = 0.7 μμf. (REF ONLY)

SYMBOL USED — L1022

	REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	3		GL 102	Q-MAX.	
X	2		WI 141-24-9	MAGNET WIRE, SINGLE #24	
1	1		CI 127-1	CORE, TOROID	

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	NOTE ADDED	1-12-67	17575	RME	GDL	
Q	ORIGINAL RELEASE FOR PRODUCTION	8-13-69	Q			
X	EXPERIMENTAL RELEASE					

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES ON
FRAC. ± 1/64 DEC. ± .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

STOCK SIZE

MATERIAL

TYPE & TEMPER | HEAT TREAT. SPEC.

FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

CL 331 ASSEMBLY
(COIL, RF, TOROID BAND #2 OSC.)

DRAWN	CHECKED	FINAL APPROVAL
G.D.L	Q	
J. Anger		A 3493 A

ELEC. DES. APP. | MECH. DES. APP.