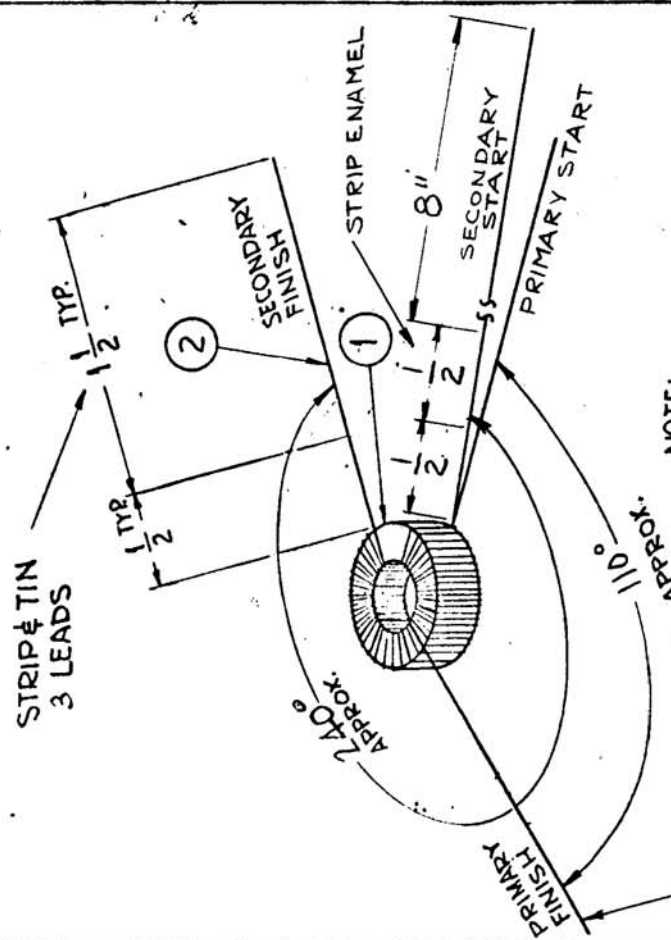
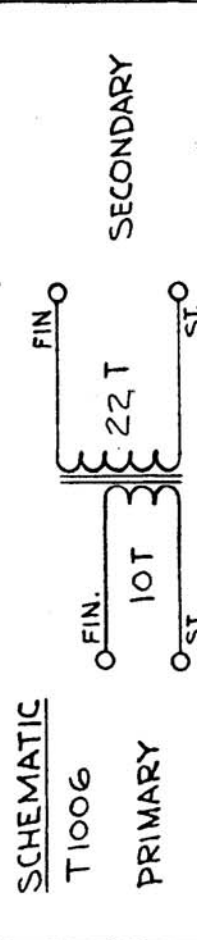


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REQ. PER UNIT	MODEL	ASSY. NO.	DATE
1	HFR-1A	A 3538	3-12-64
1	HFR-2	A 3538	3-12-64

A 3536 B



**NOTE:**  
PRIMARY TO BE WOUND OVER (ON TOP OF) SECONDARY WINDING.



- WINDING PROCEDURE ~**
1. WIND SECONDARY APPROX. 22 TURNS EQUALLY SPACED OVER THE ANGLE  $\phi$  IN THE DIRECTION SHOWN.
  2. REMOVE OR ADD TURNS TO MEET INDUCTANCE.
  3. STAKE LEADS SECURELY WITH Q-MAX
  4. WIND PRIMARY 10 TURNS EQUALLY SPACED OVER THE ANGLE  $\phi$  IN THE DIRECTION SHOWN.
  5. STAKE LEADS SECURELY WITH Q-MAX.
  6. BAKE FOR 1/2 HR. AT 215° F TO REMOVE MOISTURE.
  7. COAT COIL & CORE WITH Q-MAX & BAKE 1/2 HR. AT 215° F.

\* NOTE: USE TMC COIL STANDARDS FOR TEST REFERENCE. ELECTRICAL SPECS ~

**SECONDARY**  $L = 2.32 \mu h \pm 0.05 \mu h$ .  
WITH COIL CLAMPED INTO Q-METER 1/2" AWAY FROM TERMINALS, WITH START END OF COIL TO LOW SIDE

$Q = 180$  MIN AT 7.9 MC  
 $C_{dist} = 0.8 \mu u f$  (FOR REF. ONLY)

**PRIMARY**  $L = 0.79 \mu h \pm 0.04 \mu h$ .  
 $Q = 75$  MIN. AT 9.5 MC  
 $C_{dist.} = 2 \mu u f$  (FOR REF. ONLY)

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

TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
		<i>Aunger</i>		
FINISH & SPEC. NO.				
ELEC. DES. APP. MECH. DES. APP.				

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	ON PRIM. ELEC. SPECS. Q=75 WAS Q=85	4-10-67			G.D.L	
A	NOTE ADDED ORIGINAL RELEASE FOR PRODUCTION	1-12-67			RME	G.D.L
X	EXPERIMENTAL RELEASE	8-30-64				

SCALE: DO NOT SCALE

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC.  $\pm 1/64$  DEC.  $\pm .008$  ANGLES  $\pm 1/2^\circ$

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES