

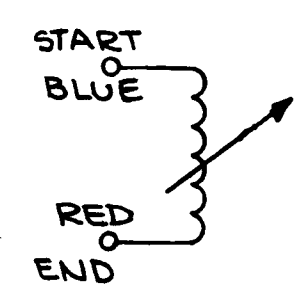
"Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	NO. CODE	SYMBOL	INDUCTANCE 10KC BRIDGE
100 KC	35	36,600 Pf.	*	L1, L2, L3	70uh ± 1μh

A3796

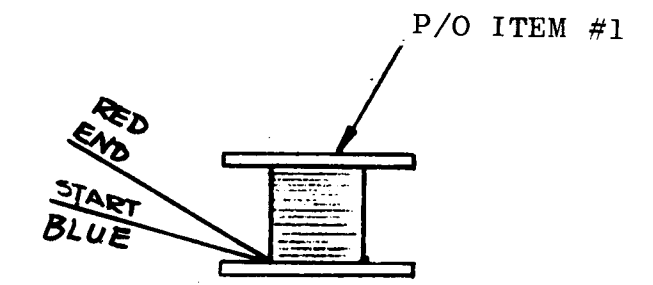
REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPER. RELEASE	3-25-65	X	HLA	
0	ORIGINAL RELEASE FOR PRODUCTION	4-7-65	0	96	

WINDING PROCEDURE

- 1- WIND 66 TURNS OF ITEM 2 ON ITEM 1, STAKE WITH ITEM 3.
- 2- BAKE COIL FOR 15 MIN. AT 150°F, REMOVE FROM OVEN AND COAT COIL WITH ITEM 4.
- 3- COLOR CODE TERMINALS ON BASE AS SHOWN.
- 4- STRIP AND TIN LEADS TO WITHIN 1/4" OF COIL.
- 5- PLACE ITEM 1 OVER SLUG ON BASE, TAKING CARE TO POSITION NOTCHES ON RAISED PART OF BASE.
- 6- SOLDER ALL LEADS TO PROPER COLOR-CODED TERMINALS ON BASE.
- 7- ASSEMBLE AS PER ASSEMBLY DRAWING, PLACE IN CASE; BEND THE 4 TABS DOWN IN THE NOTCHES.
- 8- DO NOT CUT OFF THE TWO LONG TABS.
- 9- DELETED.
- 10- STAMP TMC PART NO. AS SHOWN
- 11- TEST INDUCTANCE, AND Q AS SHOWN ABOVE. SET INDUCTANCE FIRST.
- 12- BAKE COMPLETED ASSEMBLY FOR ONE HOUR AT 212°F.
- 13- REMOVE COMPLETED ASSEMBLY FROM OVEN AND ALLOW TO COOL TO ROOM TEMPERATURE.
- 14- REPEAT STEP NO. 11.
- 15- TEST COIL WITH A 1/4% 10KC UNIVERSAL BRIDGE.(INDUCTANCE ONLY)
- 16- TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE AS SHOWN ABOVE.
- 17- TEST COIL WITH "Q" METER 260A(FOR "Q" ONLY).
- 18- SET THE TEST FREQUENCY AS SHOWN ABOVE. AND SET THE (MULTIPLY "Q" X) TO 1.
- 19- TUNE THE INDUCTANCE DIAL. TO REACH THE MAX. READING ON THE "Q" METER.



SCHEMATIC DIAGRAM

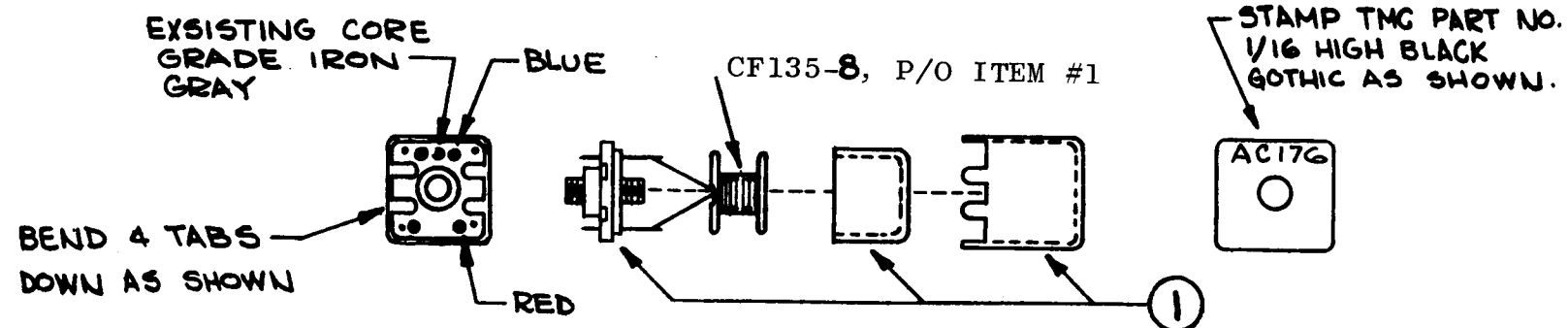


WIRING DETAIL

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	5	BS-100	SOLDER, SOFT	
X	4	GL-130	ADHESIVE, Q-DOPE	
X	3	GL-103	ADHESIVE, N-CEL	
X	2	WI-104-12/43-SNQS	WIRE, ELECTRICAL, LITZ	
1	1	CI-136-1	CORE, ADJUSTABLE TUNING	

LIST OF MATERIAL

MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
FINISH	TITLE AC176 COIL, RF, ADJUSTABLE		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN H. AUSTIN	DATE 3-25-65	FINAL APPROVAL
	CHECKED	DATE 3-24-65	
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	TOLERANCES	FRACTIONS ± 1/64 ANGLES ± 0° 30'	ELECT. DES. MECH. DES.
NOTES		DATE	REV. LTR.



3	VLRB-1	A3662
QTY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	
*	A	

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