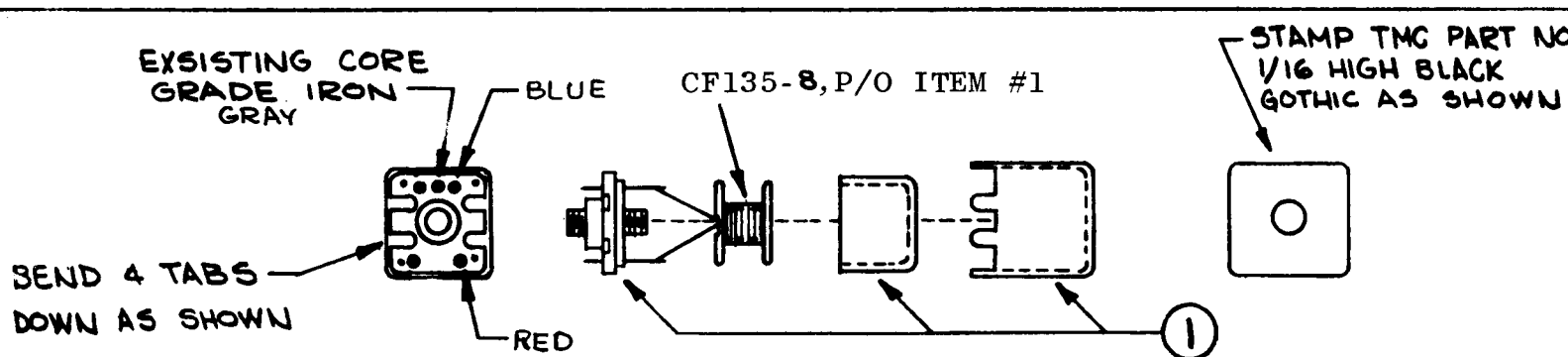
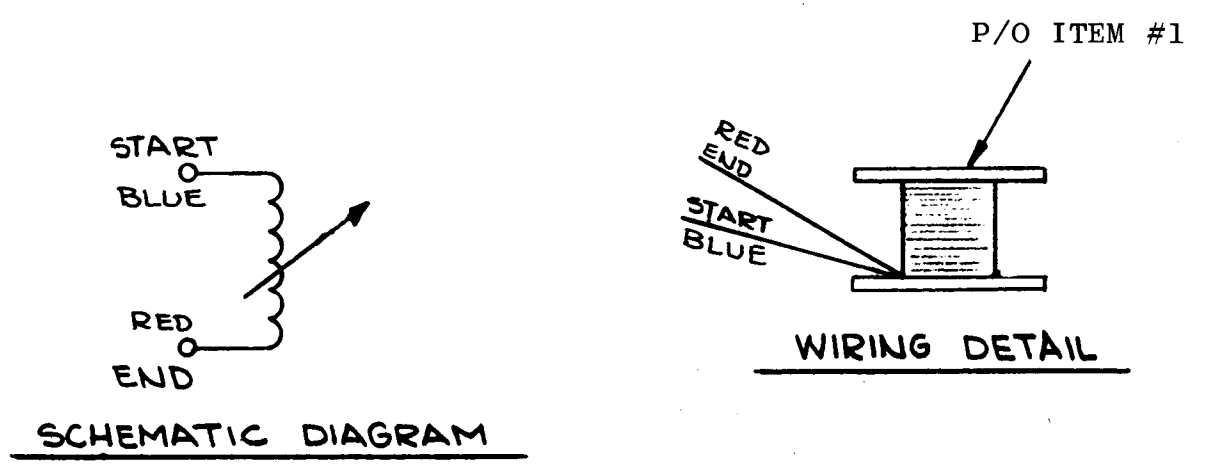


"Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	NO. CODE	SYMBOL	INDUCTANCE 10KC BRIDGE
100 KC	55	10600PF	—#—	—#—	235 μ H \pm 4 μ H

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPER. RELEASE	10-20	X		
0	ORIGINAL RELEASE FOR PRODUCTION	11-20-65	0	92	

A3889

- 1- WIND 129 TURNS OF ITEM 3 ON ITEM 1, STAKE WITH ITEM 4.
- 2- BAKE COIL FOR 15 MIN. AT 150°F, REMOVE FROM OVEN AND COAT COIL WITH ITEM #5.
- 3- COLOR CODE TERMINALS ON BASE AS SHOWN.
- 4- STRIP AND TIN LEADS TO WITHIN 1/4" OF COIL.
- 5- PLACE BOBBIN 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-
- 10- STAMP TMC PART NO. AS SHOWN ABOVE.
- 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.



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	6	BS-100	SOLDER, SOFT	
X	5	GL-130	ADHESIVE, Q-DOPE	
X	4	GL-103	ADHESIVE, N-CEL	
X	3	WI104-7-41-SN	WIRE, ELECTRICAL,	
#	2			
1	1	CI-136-1	CORE, ADJUSTABLE TUNING	

M. GELLMAN LIST OF MATERIAL

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

TITLE: AC182 ASSEMBLY

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN: G. Jensen DATE: 10-20-64	FINAL APPROVAL: [Signature]	DATE:
DECIMALS: .X \pm .05, .XX \pm .01, .XXX \pm .005	TOLERANCES:	FRACTIONS: \pm 1/64, ANGLES: \pm 0° 30'	ELECT. DES. DATE: MECH. DES. DATE:

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NOTES

QTY./UNIT: 2, MODEL USED ON: VLRB-1, ASSY. NO.: A3653

SCALE: #, CODE: A

REVISIONS: A3889