

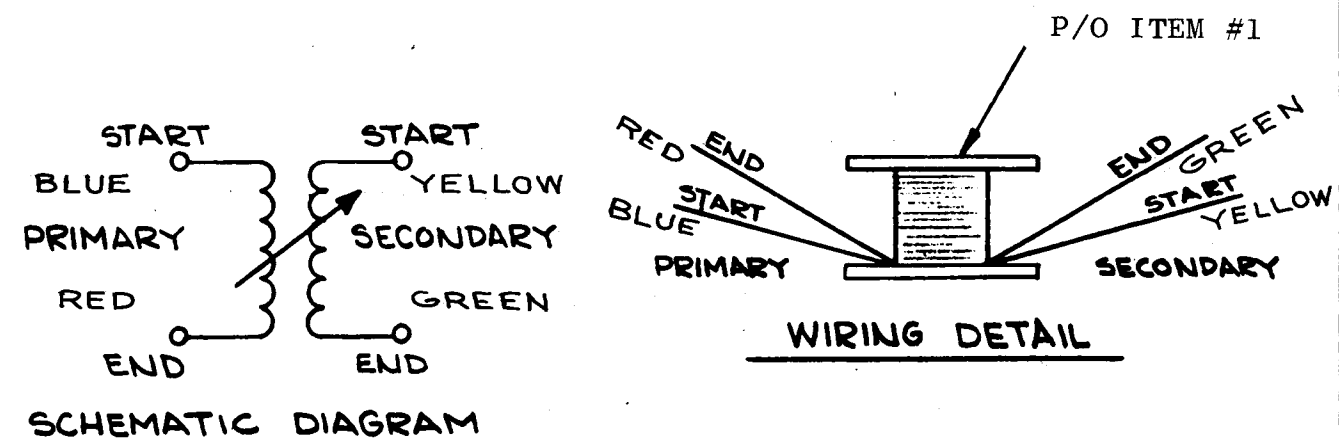
"Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	NO. CODE	SYMBOL	INDUCTANCE 10KC BRIDGE
6 MC	60	—#—	—#—	—#—	6.24 ₄ H ± .5 ₄ H

A3905

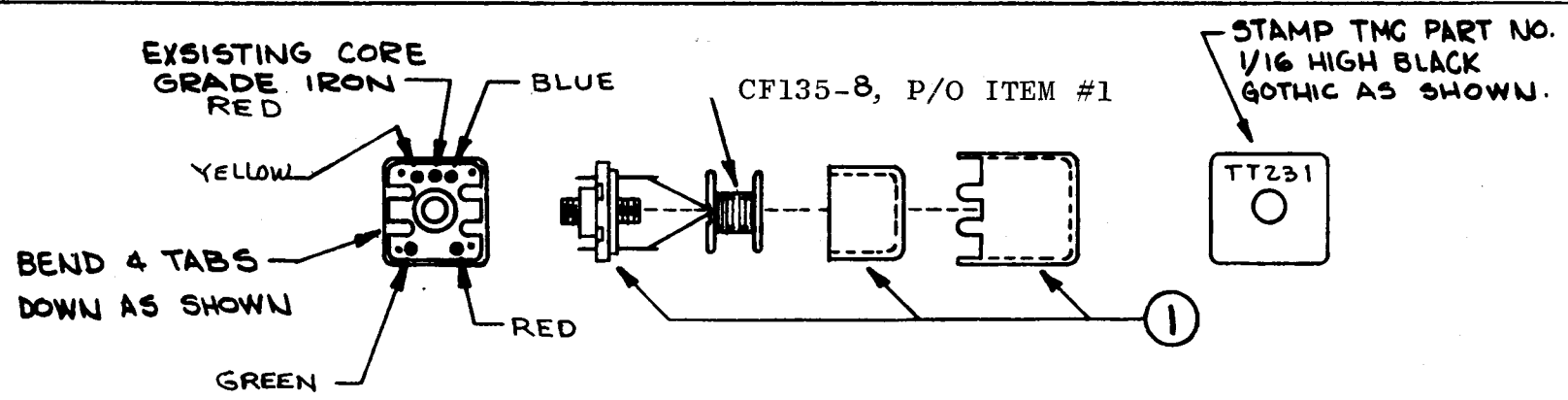
REVISIONS						
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X	EXPER. RELEASE	10-20	X			
Ø	ORIGINAL RELEASE FOR PRODUCTION	4-20-65	Ø			

WINDING PROCEDURE

1. PRIMARY WIND 28 TURNS OF ITEM 2 ON ITEM 1, STAKE WITH ITEM 4.
2. SECONDARY- WIND 5 TURNS OF ITEM 3 OVER PRIMARY AND IN THE SAME DIRECTION STAKE WITH ITEM 4
3. SECONDARY WINDING MUST BREAK OUT FROM OPPOSITE SIDE OF PRIMARY.
4. BAKE COIL FOR 15 MIN. AT 150°F, REMOVE FROM OVEN AND COAT COIL WITH ITEM #5.
5. COLOR CODE TERMINALS ON BASE AS SHOWN.
6. STRIP AND TIN LEADS TO WITHIN 1/4" OF COIL.
7. PLACE BOBBIN OVER SLUG ON BASE, TAKING CARE TO POSITION NOTCHES ON RAISED PART OF BASE.
8. SOLDER ALL LEADS TO PROPER COLOR-CODED TERMINALS ON BASE.
9. ASSEMBLE AS PER ASSEMBLY DRAWING, PLACE IN CASE; BEND THE 4 TABS DOWN IN THE NOTCHES.
10. DO NOT CUT OFF THE TWO LONG TABS.
- 11.
12. STAMP TMC PART NO. AS SHOWN ABOVE.
13. TEST INDUCTANCE, AND Q AS SHOWN ABOVE. SET INDUCTANCE FIRST.
14. BAKE COMPLETED ASSEMBLY FOR ONE HOUR AT 212°F.
15. REMOVE COMPLETED ASSEMBLY FROM OVEN AND ALLOW TO COOL TO ROOM TEMPERATURE.
16. REPEAT STEP NO. 13.
17. TEST COIL WITH A 1/4 10KC UNIVERSAL BRIDGE.(INDUCTANCE ONLY)
18. TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE AS SHOWN ABOVE.
19. TEST COIL WITH "Q" METER 260A(FOR "Q" ONLY).
20. SET THE TEST FREQUENCY AS SHOWN ABOVE. AND SET THE (MULTIPLY "Q" X) TO 1
21. 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	WI 141-34-5	WIRE, ELECTRICAL,	
X	2	WI 141-34-2	WIRE, ELECTRICAL	
1	1	CI-136-2	CORE, ADJUSTABLE TUNING	



M. GELLMAN LIST OF MATERIAL

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

TITLE TT 231
TRANSFORMER, RF, ADJUSTABLE

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES

DECIMALS: .X ± .08, .XX ± .01, .XXX ± .005
FRACTIONS: ± 1/64, ANGLES: ± 0° 30'

DRAWN: [Signature] DATE: 10-20-64
CHECKED: [Signature] DATE: [Signature]
ELECT. DES: [Signature] DATE: [Signature]
MECH. DES: [Signature] DATE: [Signature]

FINAL APPROVAL: [Signature] DATE: [Signature]

SHEET: **A3905** REV. LTR. [Signature]

1	VLRB-1	A3655
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	

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NOTES