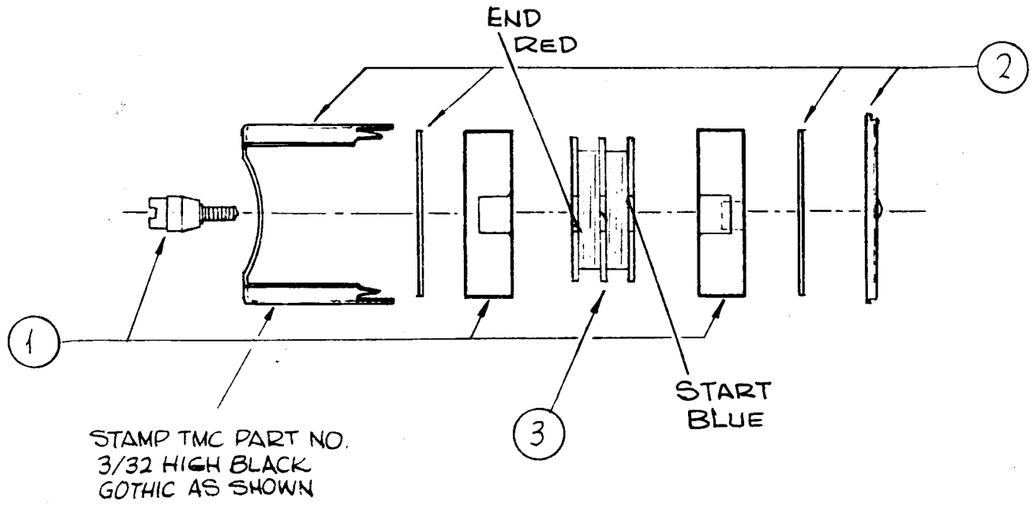
"Q" TEST FREQ.	"Q" MIN.	EXT.CAP. Q METER	NUMBER CODE	SYMBOL	INDUCTANCE 10K BRIDGE
250 KCS	125	125 pf	—	L-907	4.6mh ± .02mh



WINDING PROCEDURE

1. WIND 195 TURNS OF ITEM 6 ON ITEM 3, STAKE WITH ITEM 5.
2. ITEM 3 IS A SPLIT BOBBIN, DIVIDE TURNS EVENLY ON BOTH SIDES.
3. KEEP ALL LEADS 1 1/2" LONG.
4. STRIP AND TIN ALL LEADS TO WITHIN 3/4" OF COIL.
5. COLOR CODE ALL LEADS AS SHOWN IN WIRING DETAIL.
6. BAKE COIL FOR 15 MINUTES AT 150° F. REMOVE FROM OVEN AND COAT COIL WITH ITEM 4.
7. PLACE ITEM 3 INSIDE OF ITEM 1 AND ASSEMBLE AS PER ASSEMBLY DRAWING.
8. BEND THE 4 SMALL TABS DOWN, TOWARD CENTER OF COIL.
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 1 HOUR AT 212° F.
13. REMOVE COMPLETED ASSEMBLY FROM OVEN AND ALLOW TO COOL TO ROOM TEMPERATURE.
14. REPEATE STEP # 11.
15. TEST COIL WITH 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 TYPE 260A (FOR "Q" ONLY).
18. SET THE TEST FREQUENCY AS SHOWN ABOVE , AND SET THE (MULTIPLY "Q" BY) TO 2.
19. TUNE THE INDUCTANCE DIAL, TO REACH THE MAX. READING ON THE "Q" METER.
20. WAX CORE IN PLACE AFTER SETTING.

NOTES

1	VLRB-1	A3681
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.

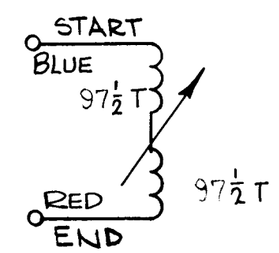
SCALE — CODE A

R

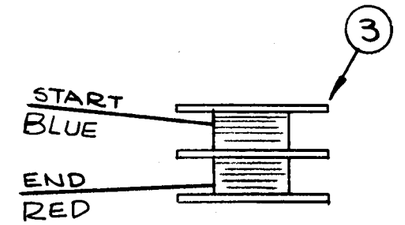
A3917

REVISIONS

SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X	EXPER. RELEASE	3.26.65	X	HLA		
Ø	ORIGINAL RELEASE FOR PRODUCTION	4.7.65	Ø	RL		
A	INDUCTANCE WAS 5.300 MH, SYMBOL L-907 ADDED, WINDING PROCEDURE 20 ADDED 97½ T WAS 103½ T	5-21-65	14120	CJL		
B	IT. 6 WAS WI 104 - 3/43	8.16.65	14679	D.V.V.		



SCHEMATIC DIAGRAM



WIRING DIAGRAM

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	7	BS100	SOLDER, TIN ALLOY	
X	6	WI-104 - 3/43 SNQS	WIRE, ELECTRICAL, MAGNET LITZ (SN)	
X	5	GL103	ADHESIVE-N-CEL	
X	4	GL130	ADHESIVE-Q-DOPE	
1	3	CF135-10	FORM, COIL, 3 FLANGE	
1	2	CU158	RETAINER	
1	1	CI137-8	CORE, ADJUSTABLE, TUNING	

LIST OF MATERIAL

MATERIAL —

FINISH —

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

DECIMALS .X ± .05, .XX ± .01, .XXX ± .005 — TOLERANCES — FRACTIONS ± 1/64, ANGLES ± 0° 30'

THE TECHNICAL MATERIEL CORP.
MAMARONECK. NEW YORK

TITLE
AC 189
COIL, RF, ADJUSTABLE

DRAWN H. Austin	DATE 3.26.65	FINAL APPROVAL	DATE
CHECKED	DATE 3.29.65		
ELECT. DES. MGB	DATE	A 3917	B
MECH. DES.	DATE	SHEET	REV. LTR.