

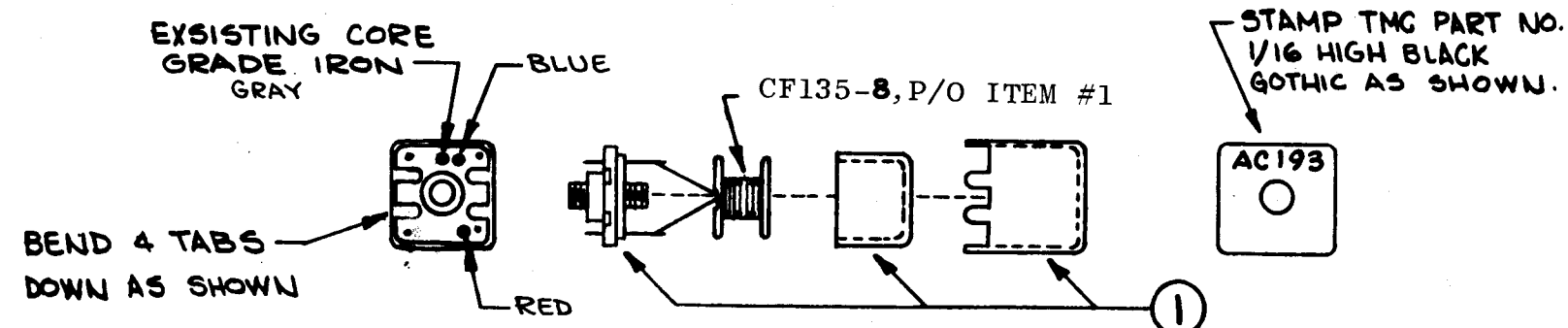
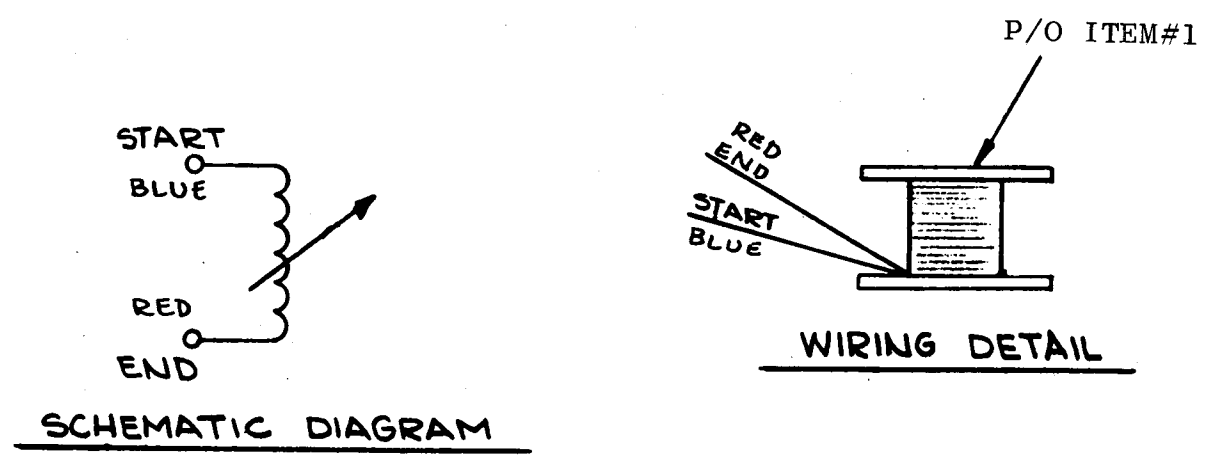
"Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	NO. CODE	SYMBOL	INDUCTANCE 10KC BRIDGE
200 KCS	65	600 PF	-	-	820 μ h \pm 20 μ h

A
A3921

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPER. RELEASE	3-18-65	X	HLA	
B	ORIGINAL RELEASE FOR PRODUCTION	4-7-65	2	HLA	
A	IT 2 WAS WI 107-17 DSC		4679		

WINDING PROCEDURE

- 1- WIND 250 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.



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	WI107-17	WIRE, ELECTRICAL, #36	
-	-	-	-	
1	1	CI-136-1	CORE, ADJUSTABLE TUNING	

LIST OF MATERIAL			
MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
FINISH	TITLE AC 193 COIL, RF, ADJUSTABLE		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN	DATE	FINAL APPROVAL
	W. AUSTIN	3-18-65	[Signature]
DECIMALS .X \pm .05 .XX \pm .01 .XXX \pm .005	CHECKED	DATE	SHEET
	[Signature]	3-29-65	
FRACTIONS \pm 1/64 ANGLES \pm 6° 30'	ELECT. DES.	DATE	REV. LTR.
	Mech. Des.	DATE	
TOLERANCES		A3921	

NOTES

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1	VLRB-1	A3681
QTY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	
-	A	