

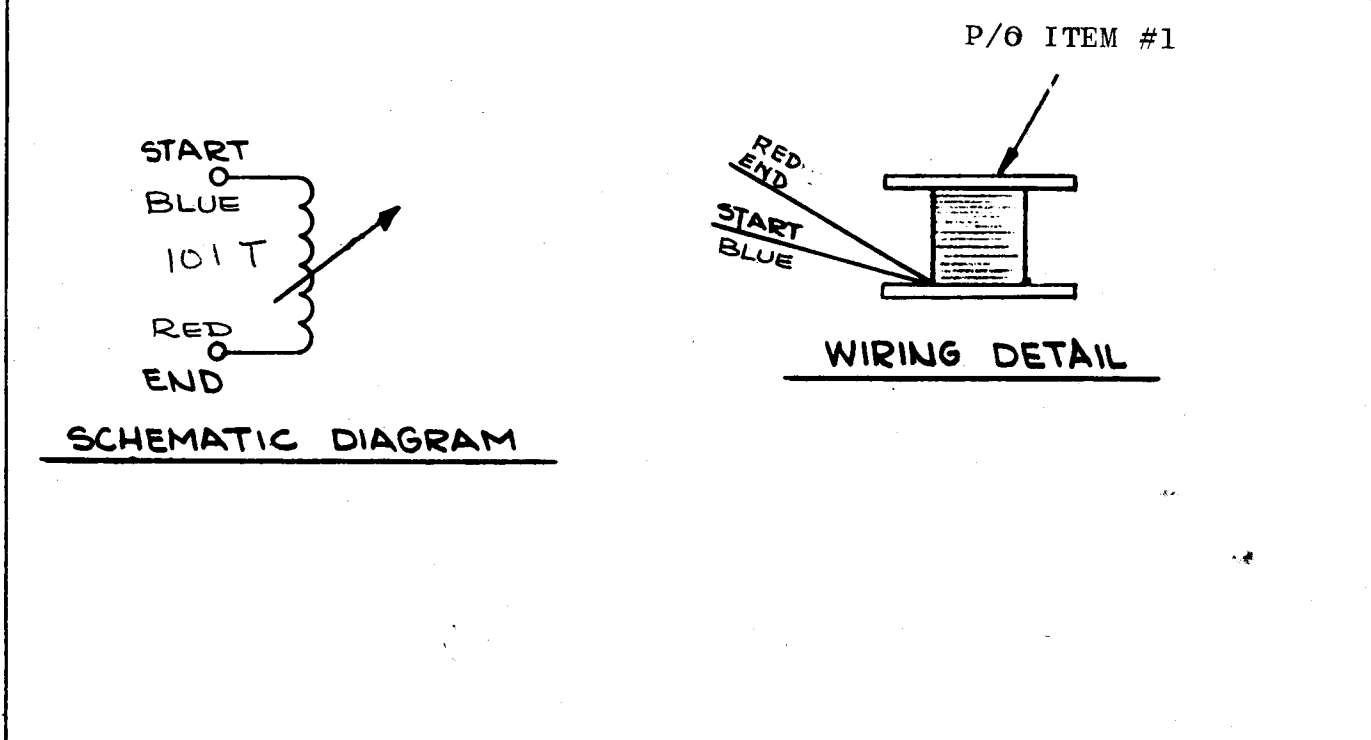
"Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	NO. CODE	SYMBOL	INDUCTANCE 10KC BRIDGE
400 KCS	50	1300	#	#	120.4 ± 5μh

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPER. RELEASE	3-24-65	X	ALA	
Ø	ORIGINAL RELEASE FOR PRODUCTION	5-4-65	Ø	SP	
A	IT. 2 WAS WI107-17-DSC	8-16-65	14679	H.V.	MMVA

A3923

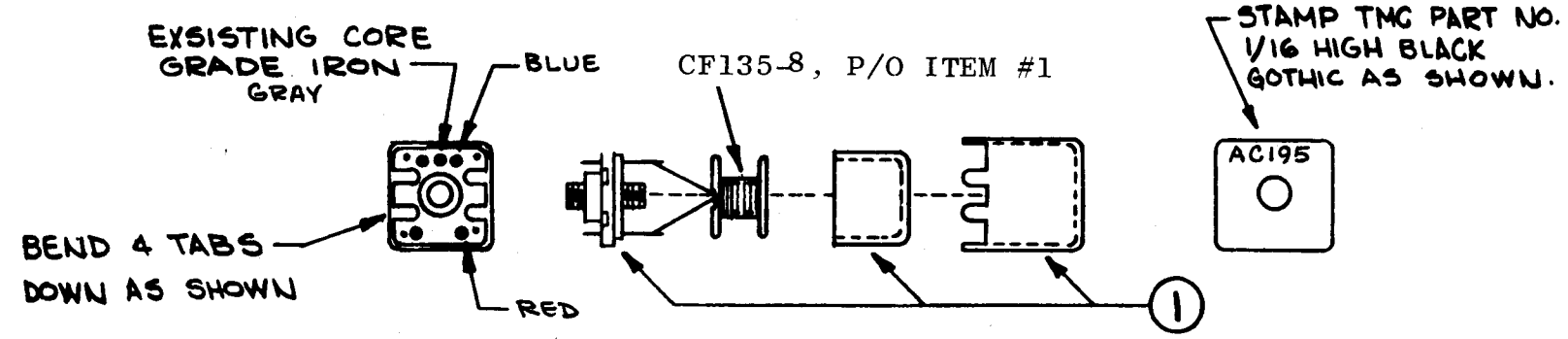
WINDING PROCEDURE

- 1- WIND 101 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	WI-107-17	WIRE, ELECTRICAL, #36	
#	#	#	#	
1	1	CI-136-1	CORE, ADJUSTABLE TUNING	

MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH		TITLE AC195 COIL, RF, ADJUSTABLE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN H. Austin CHECKED H. Austin ELECT. DES. MAB MECH. DES.	DATE 3-24-65 DATE 5-3-65 DATE DATE DATE SHEET
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		FRACTIONS ± 1/64 ANGLES ± 0° 30'	FINAL APPROVAL DATE 5/4/65 A3923 REV. LTR.



1	VLRB-1	A-3681
QTY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE #	CODE A	
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NOTES