

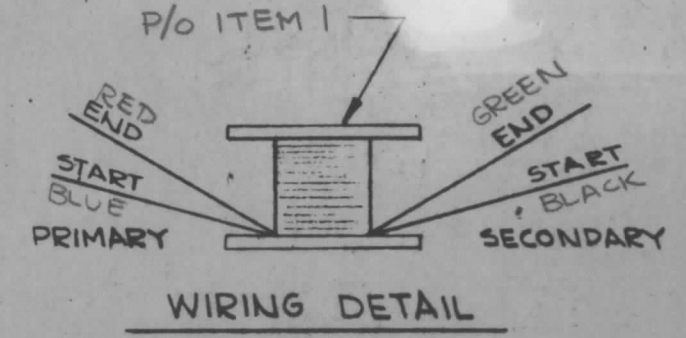
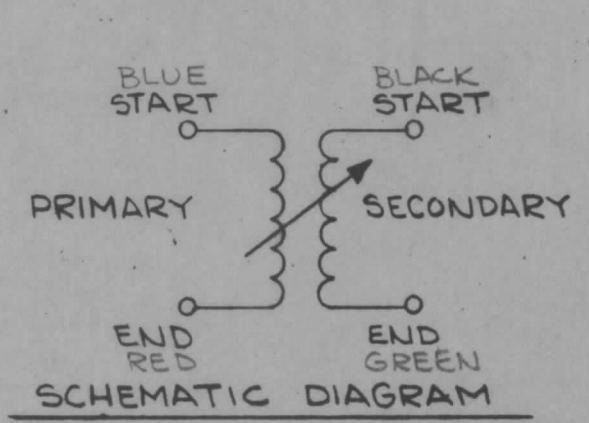
"Q" TEST FREQ.	"Q" MIN.	EXT. CAP Q METER	NO. CODE	SYMBOL	INDUCTANCE 10KC BRIDGE
1 MC	70	—	—	—	175µh ±5%

WINDING PROCEDURE

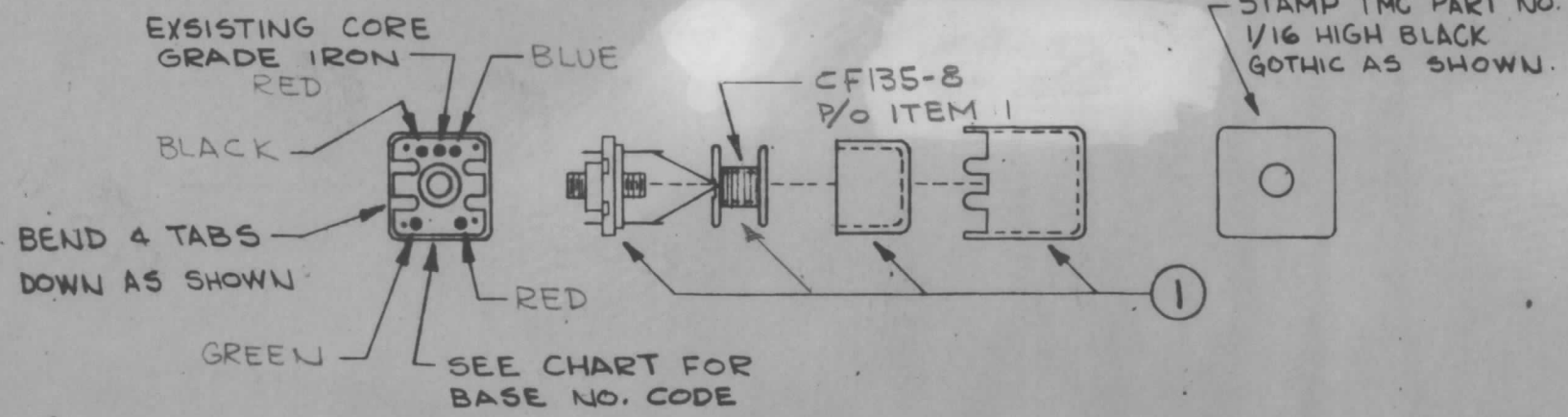
1. PRIMARY WIND 135 TURNS OF ITEM #3 ON ITEM #1, STAKE WITH ITEM #4.
2. SECONDARY - WIND 35 TURNS OF ITEM #7 OVER PRIMARY AND IN THE SAME DIRECTION STAKE WITH ITEM #4
3. SECONDARY WINDING MUST BREAK OUT FROM OPPOSITE SIDE OF PRIMARY.
4. BAKE COIL FOR 15 MIN. AT 150°F, REMOVE FROM OVEN AND COAT COIL WITH ITEM #5.
5. COLOR CODE TERMINALS ON BASE AS SHOWN.
6. STRIP AND TIN LEADS TO WITHIN 1/4" OF COIL.
7. PLACE ITEM #2 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. CODE THE BASE, AS PER CHART.
12. STAMP TMC PART NO. AS SHOWN ABOVE.
13. TEST INDUCTANCE, AND Q AS SHOWN ABOVE.
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.
18. TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE AS SHOWN ABOVE.
19. TEST COIL WITH "Q" METER TYPE 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.

A3964

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPER. RELEASE	10-20-64	X	P. Jan	
X1	ITEM 2, CF135-8 DELETED	10-27-64	X1	P. Jan	
X2	ITEM 3 REVISED	8/27/65	—	JC	
Ø	ORIGINAL RELEASE FOR PRODUCTION	4-14-66	Ø	WV	
A	"Q" MIN WAS 80	3-9-67	.17921	RME	



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	7	WI141-34-2	WIRE, ELECTRICAL	
X	6	BS-100	SOLDER, SOFT	
X	5	GL-130	ADHESIVE, Q-DOPE	
X	4	GL-103	ADHESIVE, N-CEL.	
X	3	WI104-5/41 SNQS	WIRE, ELECTRICAL	
—	2	—	DELETED	
1	1	CI-136-2	CORE, ADJUSTABLE TUNING	



M. GELLMAN		LIST OF MATERIAL			
MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH		TITLE TT-248			
		TRANSFORMER, R.F., ADJUSTABLE			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN P. Jan	DATE 10-20-64	FINAL APPROVAL M. Gellman	DATE 4/13/66
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		CHECKED J. Lee	DATE 4/13/66	A3964	
FRACTIONS ± 1/64 ANGLES ± 0° 30'		ELECT. DES.	DATE	A	
TOLERANCES		MECH. DES.	DATE	SHEET	
				REV. LTR.	

NOTES

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