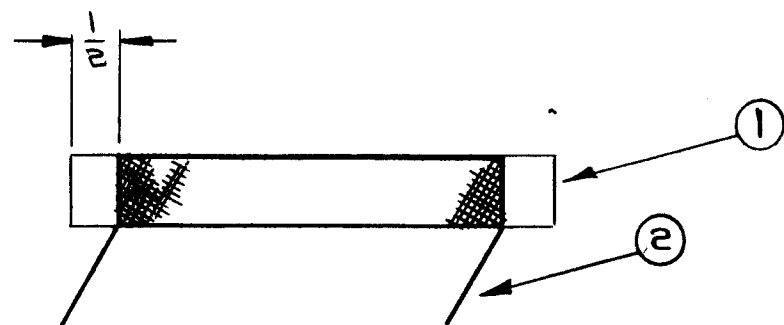


"Q" TEST FREQ.	"Q" MIN.	TEST FREQ.	INDUCTANCE
100 KC	600	250 KC	5.6mh ± 5%



WINDER MACHINE DATA

- 1- CAM GEAR .250
- 2- GEAR RATIO ON FRONT 66:66
- 3- GEAR RATIO ON REAR 80:90 STEP DOWN DRIVER DRIVEN, COUPLED WITH 60 TOOTH IDLER.
- 4- PROGRESSION GEAR RATIO 100:48 DRIVER OVER DRIVEN.
- 5- WIND AT MODERATE SPEED.

WINDING PROCEDURE

- 1- WIND 300 TURNS OF ITEM 2 ON ITEM 1, STARTING 1/2" FROM END. STAKE WITH ITEM 5.
- 2- KEEP ALL LEADS 6" LONG.
- 3- STRIP AND TIN ALL LEADS 3/4" FROM END.
- 4- BAKE COIL FOR 30 MINUTES AT 212°F. REMOVE FROM OVEN AND COAT COIL WITH ITEM 4.
- 5- TEST INDUCTANCE AND "Q" AS SHOWN.

A3992

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPER. RELEASE	12-8-64	X	<i>[Signature]</i>	
Ø	ORIGINAL RELEASE FOR PRODUCTION	5/24/65	AA	<i>[Signature]</i>	
A	IT 2 WAS WI 104-150/44	5/16/65	1468 R	RVV	<i>[Signature]</i>

X	5	GL103	ADHESIVE-N-CEL	
X	4	GL130	ADHESIVE-Q-DOPE	
X	3	BS100	SOLDER, TIN ALLOY	
X	2	WI104-150 44 SNQS	WIRE, ELECTRICAL, LITZ	
1	1	CI112-Q1-7R5L	ROD, FERRITE	
REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL

O. POSE LIST OF MATERIAL

MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH	TITLE CL347 ASSY			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN <i>[Signature]</i>	DATE 12-8-64	FINAL APPROVAL <i>[Signature]</i>
		CHECKED	DATE	DATE 5/5/65
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		ELECT. DES. <i>[Signature]</i>		DATE
FRACTIONS ± 1/64 ANGLES ± 0° 30'		MECH. DES.		DATE
TOLERANCES		SHEET A3992		REV. LTR. A

4	LFRA-1	
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
<i>[Signature]</i>	CODE A	
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NOTES