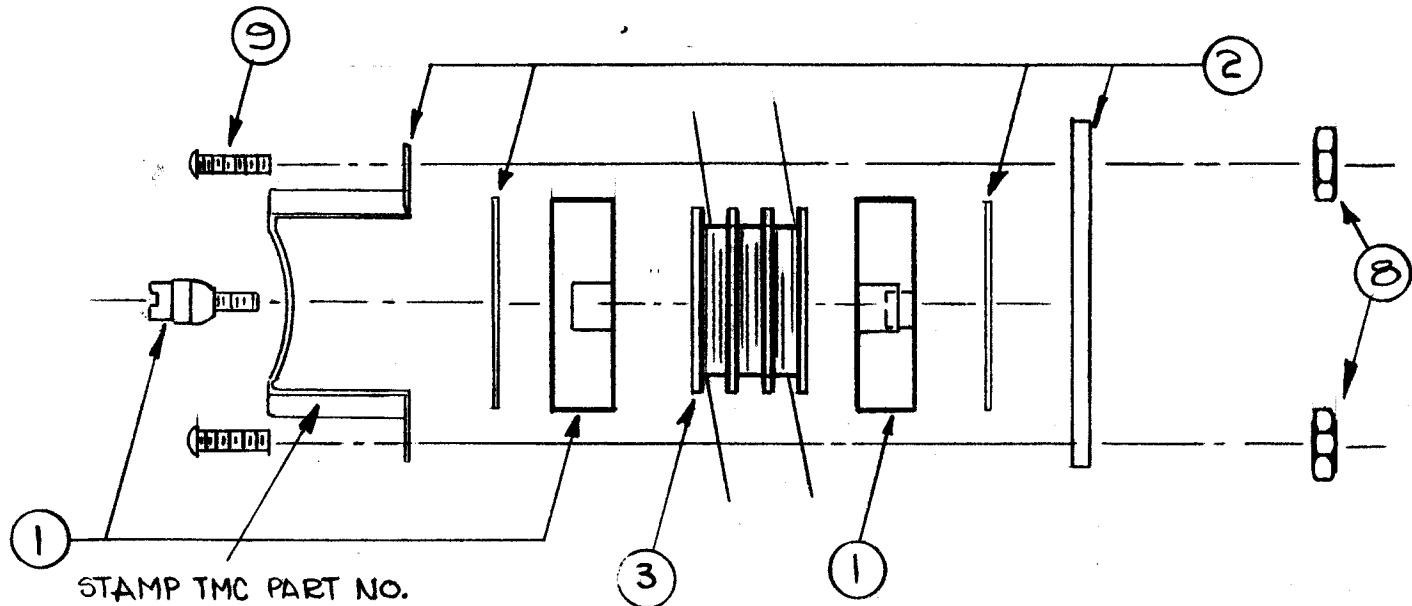


"Q" TEST FREQ.	"Q" MIN.	TEST FREQ.	INDUCTANCE
50 KC	300	79.0 KC	59mh ±10%



STAMP TMC PART NO.
3/32 HIGH BLACK GOTHIC
AS SHOWN W/LATEST
REV. LETTER.

WINDING PROCEDURE

- 1- SECONDARY WIND 82 TURNS OF ITEM 6 ON ITEM 3, STAKE WITH ITEM 5.
- 2- ITEM 3 IS A SPLIT BOBBIN, SPLIT THE TURNS AS SHOWN, IN SCHEMATIC DIAGRAM.
- 3- PRIMARY WIND 357 TURNS OF ITEM 6 ON ITEM 3, STAKE WITH ITEM 5.
- 4- ITEM 3 IS A SPLIT BOBBIN, SPLIT THE TURNS AS SHOWN, IN SCHEMATIC DIAGRAM.
- 5- KEEP ALL LEADS 3" LONG.
- 6- STRIP AND TIN ALL LEADS TO WITHIN 2" OF COIL.
- 7- COLOR ALL LEADS AS SHOWN IN WIRING DETAIL.
- 8- BAKE COIL FOR 15 MINUTES AT 150° F. REMOVE FROM OVEN AND COAT COIL WITH ITEM 4.
- 9- PLACE ITEM 3 INSIDE OF ITEM 1 AND ASSEMBLE AS PER ASSEMBLY DRAWING.
- 10- STAMP TMC PART NO. AS SHOWN.
- 11- TEST INDUCTANCE AND "Q" AS SHOWN ABOVE.
- 12- BAKE COMPLETED ASSEMBLY FOR 1 HOUR AT 212° F.
- 13- REMOVE COMPLETED ASSEMBLY FROM OVEN AND ALLOW TO COOL TO ROOM TEMPERATURE.
- 14- REPEAT STEP NO. 11.
- 15- TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE AS SHOWN ABOVE.
- 16- TEST COIL WITH "Q" METER TYPE 260A.
- 17- SET THE TEST FREQUENCY AS SHOWN ABOVE AND SET THE (MULTIPLY "Q" BY) TO 2.

NOTE:
WIND PRIMARY OVER SECONDARY.

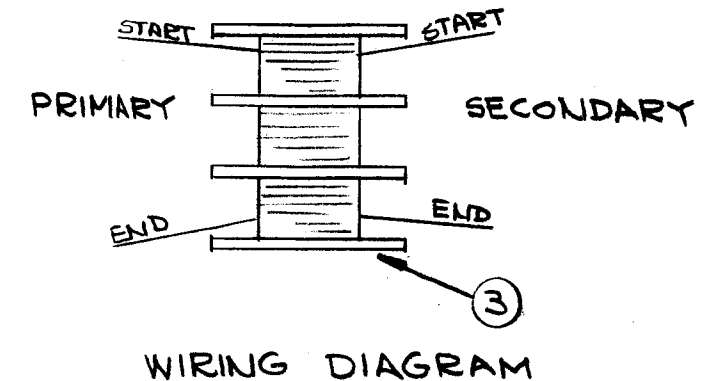
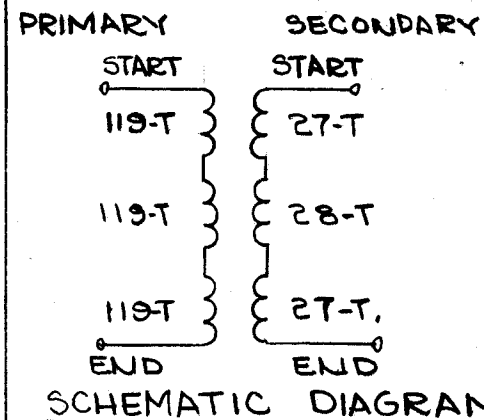
NOTES

1	LFRA-1	A4049
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	
	A	
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.		

A
A3993

REVISIONS

SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
Ø	ORIGINAL RELEASE FOR PRODUCTION	12-7-64	-M			
A	IT. 3 WAS CF 135-11, IT. 6 WAS WI 107-36	8/6/65	14682	AVV	QCB	MM



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL	
	2	9	SCBP0440BN6	SCREW, MACHINE	
	2	8	NTH0440BN8	NUT, HEX	
	x	7	BS100	SOLDER, TIN ALLOY	
	x	6	WI107-17	WIRE, ELECTRICAL, MAGNET SNPQS	5236
	x	5	GL103	ADHESIVE-N-CEL	
	x	4	GL130	ADHESIVE-Q-DOPE	
	1	3	CF135-12	FORM, COIL, 4 FLANGE	
	1	2	CU148-1	RETAINER	
	1	1	CI137-6	CORE, ADJUSTABLE, TUNING	

O. POSE

LIST OF MATERIAL

MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH	TITLE TZ 183 ASSY			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN G. Leman	DATE 12-7-64	FINAL APPROVAL R. H. King
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		CHECKED QCB	DATE 5/24/65	DATE 12/15/65
FRACTIONS ± 1/64 ANGLES ± 0° 30'		ELECT. DES. QCB	DATE	DATE
TOLERANCES		MECH. DES.	DATE	DATE
SHEET			REV. LTR.	