

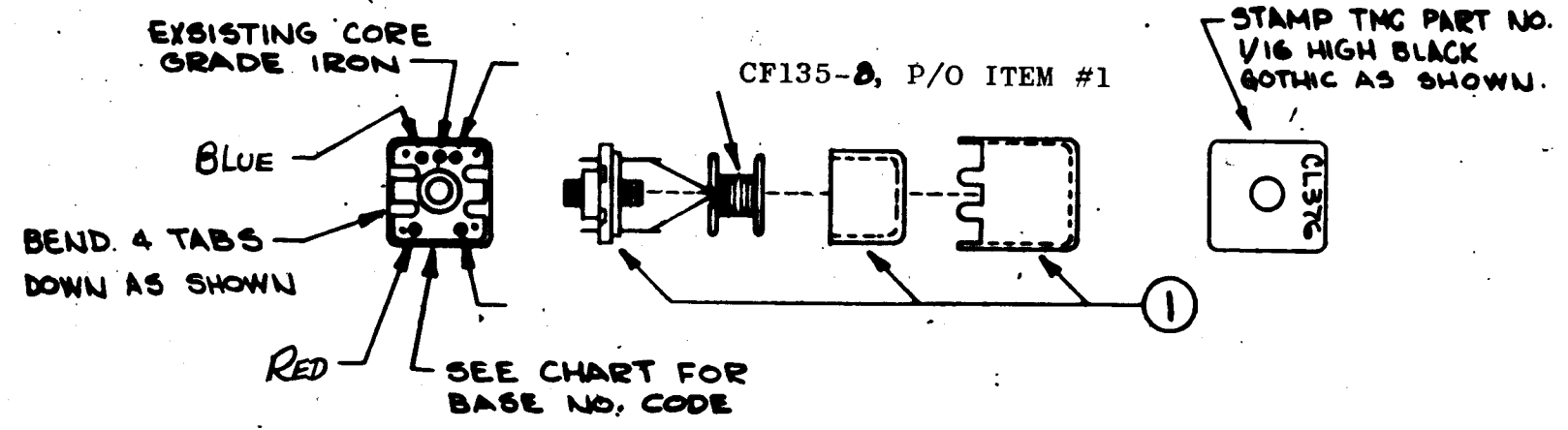
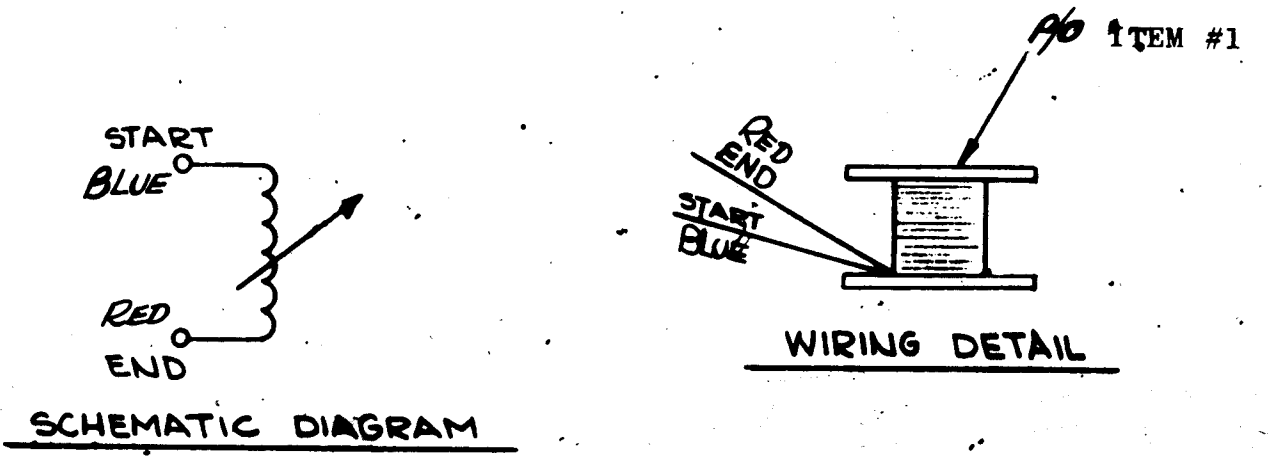
"Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	NO. CODE	SYMBOL	INDUCTANCE "Q" METER 6.0 MHZ
GMC	40	—	—	L5	1.5 $\mu$ h $\pm$ 0.2 $\mu$ h

B  
A4264

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPER. RELEASE	5/17/65	X	HLA	
XI	WINDING PROCEDURE #16 TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE SHOWN ABOVE. DELETED.	5/24/65	—	HLA	
Ø	ORIGINAL RELEASE FOR PRODUCTION.	5/21/65	—	HLA	
A	IND. TOL. WAS 2.0 $\mu$ h ADDED FREQ. 6.0 MHZ	7/18/66	16571	RME	
B	"CL376" RELOCATED	12.6.66	17374	LHW	

**WINDING PROCEDURE**

- 1- WIND 27 TURNS OF ITEM 3 ON ITEM 1, STAKE WITH ITEM 4.
  - 2- BAKE COIL FOR 15 MIN. AT 150°F, REMOVE FROM OVEN AND COAT COIL WITH ITEM #5.
  - 3- COLOR CODE TERMINALS ON BASE AS SHOWN.
  - 4- STRIP AND TIN LEADS TO WITHIN 1/4" OF COIL.
  - 5- PLACE BOBBIN 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- CODE THE BASE, AS PER CHART.
  - 10- STAMP TMC PART NO. AS SHOWN ABOVE.
  - 11- TEST INDUCTANCE, AND Q AS SHOWN ABOVE. (W/O SLUG).
  - 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- DELETED.
- TEST COIL WITH "Q" METER 260A.  
SET THE TEST FREQUENCY AS SHOWN ABOVE. AND SET THE (MULTIPLY "Q" X ) TO 1.  
TUNE THE INDUCTANCE DIAL. TO REACH THE MAX. READING ON THE "Q" METER.



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	6	BS-100	SOLDER, SOFT	
X	5	GL-130	ADHESIVE, Q-DOPE	
X	4	GL-103	ADHESIVE, N-CEL	
X	3	WI-141-32-9	WIRE, ELECTRICAL,	
—	2	—	—	
1	1	CI-136-2	CORE, ADJUSTABLE TUNING	

**LIST OF MATERIAL**

THE TECHNICAL MATERIEL CORP.  
MAMARONECK, NEW YORK

TITLE: CL-376 Ass'y.  
SYN-A-L5

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES

DECIMALS: I ± .05, II ± .01, III ± .005  
FRACTIONS: ± 1/64, ANGLES ± 0° 30'

SCALE: MODEL USED ON: ASSY. NO. A4216

DATE: 5/17/65  
DATE: 5/21/65  
DATE: 5/24/65

FINAL APPROVAL: [Signature]  
DATE: 5/24/65

ELECT. DES. [Signature]  
MECH. DES. [Signature]

SHEET: A4264  
OF: B

**NOTES**

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.

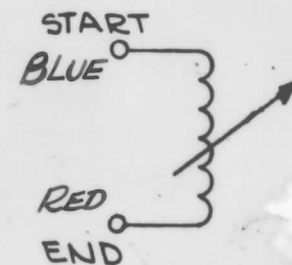
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B  
A4264

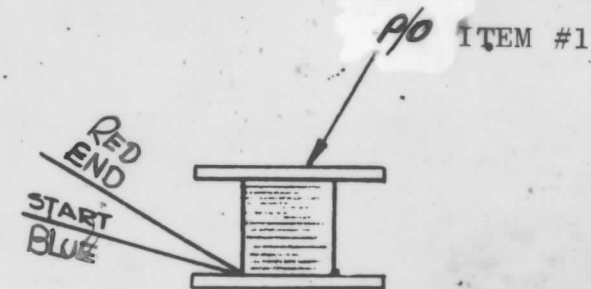
REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPER. RELEASE	5/17/65	X	HLA	
XI	WINDING PROCEDURE #16 TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE SHOWN ABOVE. DELETED.	5/20/65	A	HLA	
Ø	ORIGINAL RELEASE FOR PRODUCTION.	5/21/65	A	HLA	
A	IND. TOL. WAS 2.0 $\mu$ h ADDED FREQ. 6.0 MHZ	7/18/66	16571	RME	JCK
B	"CL376" RELOCATED	12.6.66	17374	LHO	JCK

**WINDING PROCEDURE**

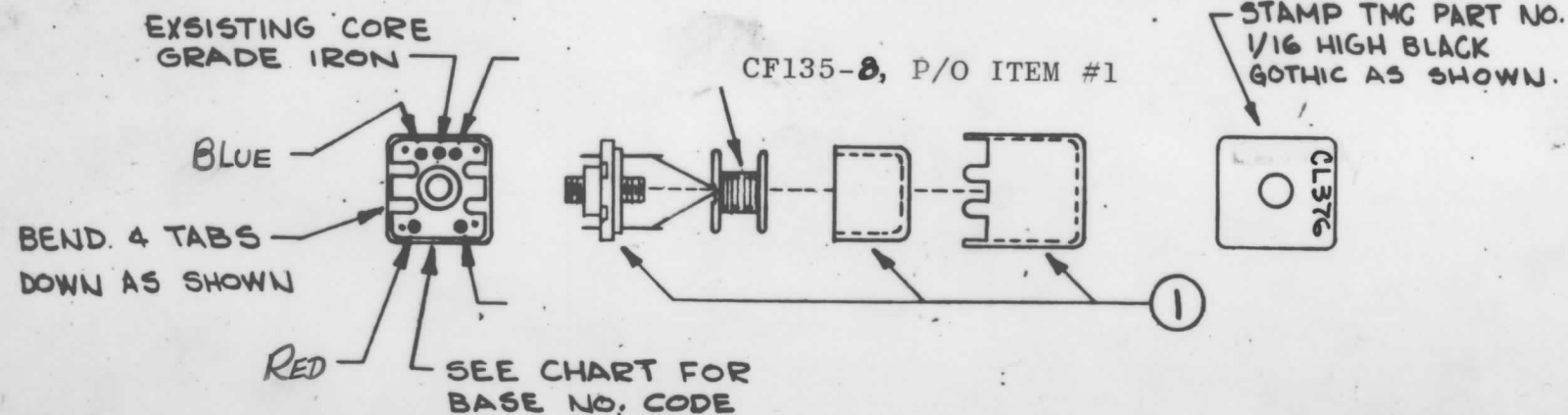
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- 14- REPEAT STEP NO. 11.
- 15- DELETED.
- 16-
- 17- TEST COIL WITH "Q" METER 260A.
- 18- SET THE TEST FREQUENCY AS SHOWN ABOVE. AND SET THE (MULTIPLY "Q" X ) TO 1.
- 19- TUNE THE INDUCTANCE DIAL. TO REACH THE MAX. READING ON THE "Q" METER.



**SCHEMATIC DIAGRAM**



**WIRING DETAIL**



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	6	BS-100	SOLDER, SOFT	
X	5	GL-130	ADHESIVE, Q-DOPE	
X	4	GL-103	ADHESIVE, N-CEL	
X	3	WI-141-32-9	WIRE, ELECTRICAL,	
<del>X</del>	<del>2</del>	<del>---</del>	<del>---</del>	
1	1	CI-136-2	CORE, ADJUSTABLE TUNING	

LIST OF MATERIAL			
MATERIAL	FINISH	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		TITLE	
		CL-376 Ass'y. SYN-A-L5	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN H. AUSTIN	DATE 5-17-65
DECIMALS .X $\pm$ .05 .XX $\pm$ .01 .XXX $\pm$ .005		CHECKED JCK	DATE 5/21/65
FRACTIONS $\pm$ 1/64 ANGLES $\pm$ 0° 30'		DATE 5/21/65	DATE 5/21/65
TOLERANCES		FINAL APPROVAL [Signature]	
		A4264	
		B	
		SHEET	
		REV. LTR.	

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1	CMRA-1	A4216
QTY./UNIT	MODEL USED ON	ASSY. NO.
SCALE	CODE	