

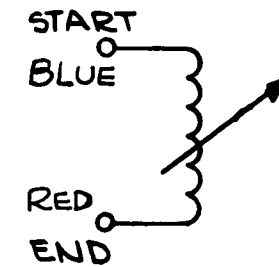
"Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	NO. CODE	SYMBOL	INDUCTANCE "Q" METER
795 Kc	40	—	—	L1	370 μH ±25 μh

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPER. RELEASE	5-3-65	X	HLA	
XI	WINDING PROCEDURE #16 TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE SHOWN ABOVE DELETED.	5/20/65	—	HLA	
Ø	ORIGINAL RELEASE FOR PRODUCTION	5/21/65	—	HLA	
A	IND. WAS 300 TURNS ON STEP 1 WAS 263	8-9-65	14636	H.V.V.	<i>[Signature]</i>
B	CL374 RELOCATED	12.6.66	17374	WPO	<i>[Signature]</i>

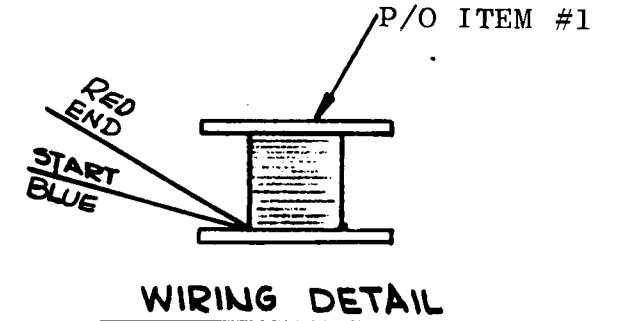
A4268

WINDING PROCEDURE

- 1- WIND 278 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.
- 16- DELETED.
- 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.



SCHMATIC 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 104-343-SNGS	WIRE, ELECTRICAL,	
—	—	—	—	
1	1	CI-136-2	CORE, ADJUSTABLE TUNING	

POSE LIST OF MATERIAL

MATERIAL: ~~—~~

FINISH: ~~—~~

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

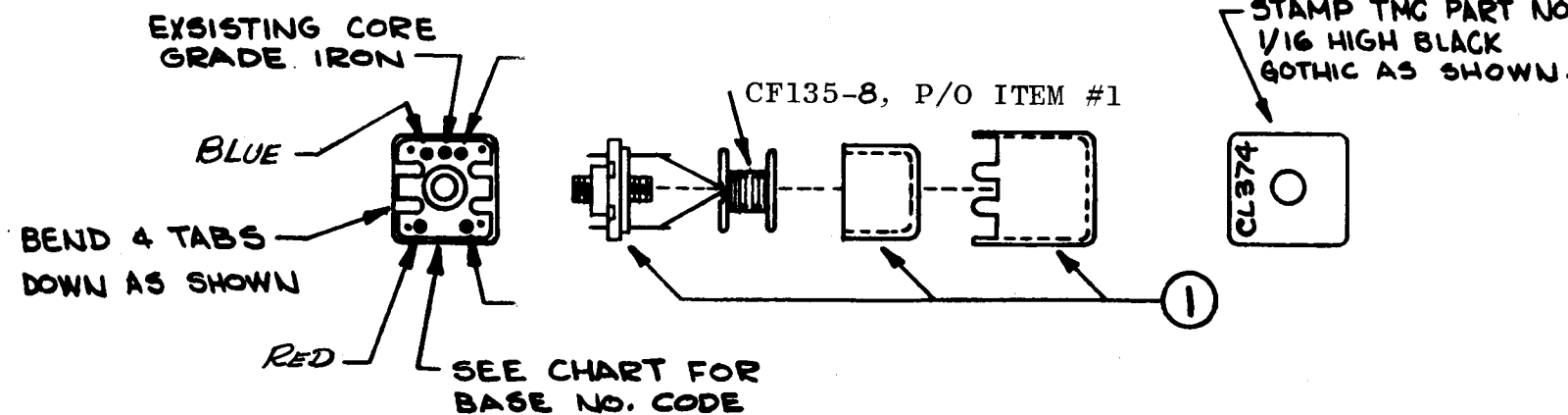
TITLE: CL 374 Ass'y.
SYN-B-L1

DRAWN: H.L.A.	DATE: 5-3-65	FINAL APPROVAL: <i>[Signature]</i>	DATE: 5/2/65
CHECKED: <i>[Signature]</i>	DATE: 5/21/65		
ELECT. DES. <i>[Signature]</i>	DATE: 5/21/65		
MECH. DES.	DATE:		

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

DECIMALS .X ± .08 .XX ± .01 .XXX ± .008	TOLERANCES	FRACTIONS ± 1/64 ANGLES ± 0° 30'
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REVISIONS: A4268 B



1	CMRA-1	A4218
QTY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	

NOTES

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