

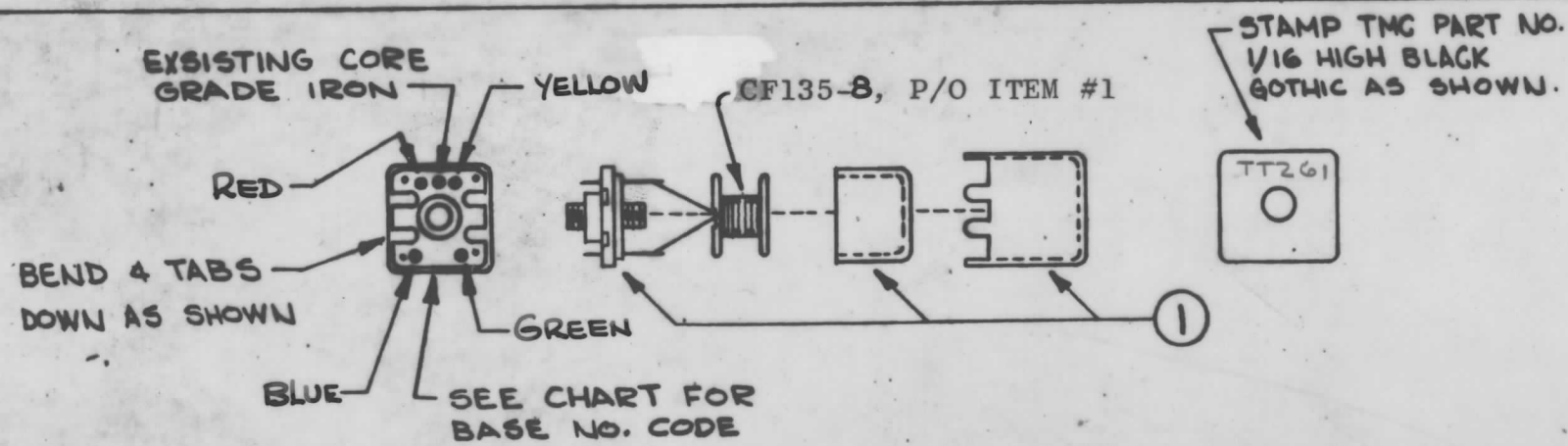
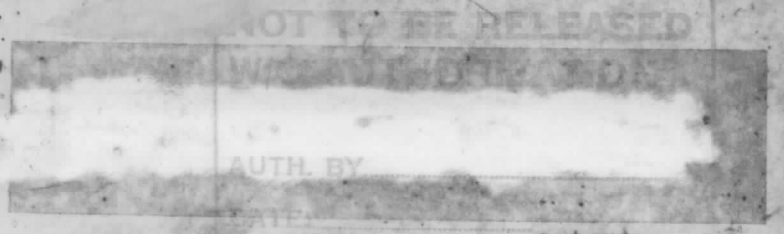
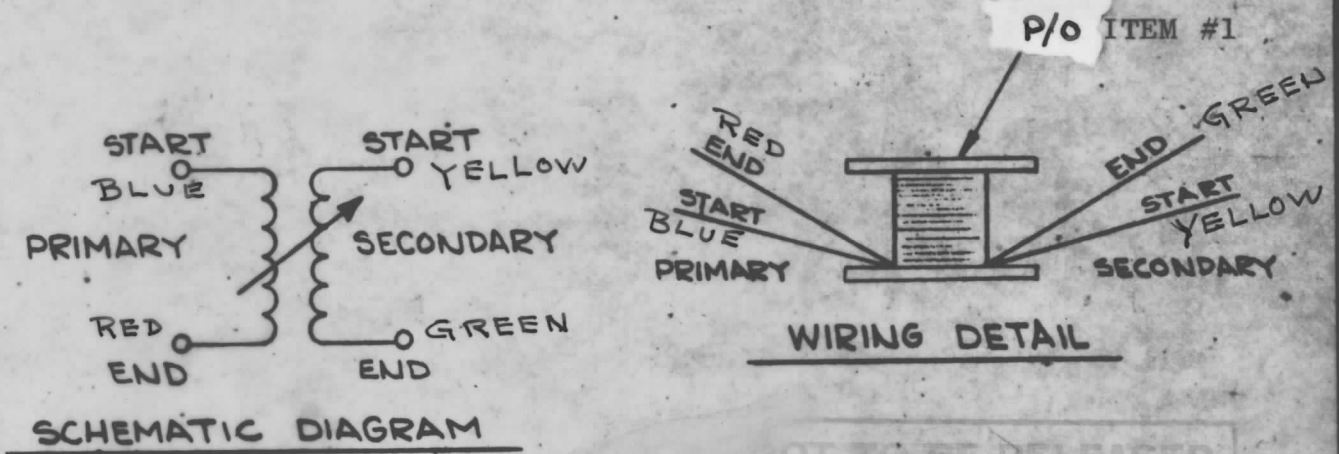
"Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	NO. CODE	SYMBOL	INDUCTANCE "Q" METER 1.75 MHZ
1.75 MC	15	-	-	TG	9.5 μ h \pm 1.0 μ h

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHRD APPD
X	EXPER. RELEASE	5-11-65	X	HLA	
Ø	ORIGINAL RELEASE FOR PRODUCTION	5-19-65	X	CJL	
A	Q MIN. WAS 20. IND. TOL. WAS \pm 0.5 μ h ADDED FREQ. 1.75 MHZ	7/13/66	16576	RME	<i>[Signature]</i>

A
A4274

WINDING PROCEDURE

1. PRIMARY WIND 70 TURNS OF ITEM 3 ON ITEM 1, STAKE WITH ITEM 4.
2. SECONDARY - WIND 35 TURNS OF ITEM 2 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 BOBBIN 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. (W/O SLUG)
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. DELETED.
18. TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE AS SHOWN ABOVE.
19. TEST COIL WITH "Q" METER 260A.
20. SET THE TEST FREQUENCY AS SHOWN ABOVE. AND SET THE (MULTIPLY "Q") TO 1.
21. 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,	
X	2	WI-141-32-5	WIRE, ELECTRICAL	
1	1	CI-136-2	CORE, ADJUSTABLE TUNING	

POSE		LIST OF MATERIAL			
MATERIAL	<i>[Handwritten]</i>	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH	<i>[Handwritten]</i>	TITLE TT261 ASS'Y. IF-TG			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN H. Austin	DATE 5-11-65	FINAL APPROVAL <i>[Signature]</i>	DATE 5/14/65
DECIMALS .X \pm .05 .XX \pm .01 .XXX \pm .005		CHECKED <i>[Signature]</i>	DATE 5/13/65	A4274	
FRACTIONS \pm 1/64		ELECT. DES. <i>[Signature]</i>	DATE 5/13/65	A	
TOLERANCES ANGLES \pm 0° 30'		MECH. DES.	DATE	REV. LTR.	

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.

4	CMRA-1	A4220
QTY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE A	