

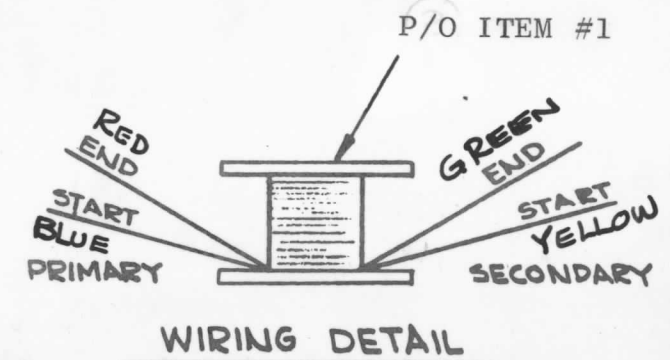
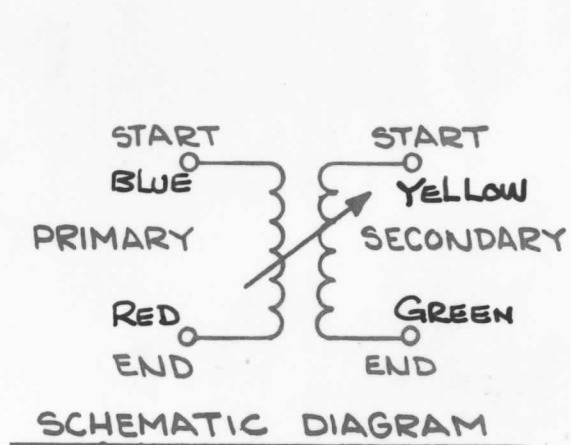
"Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	NO. CODE	SYMBOL	INDUCTANCE Q METER
1.75 MC	40		RED DOT	TI	10 μ h \pm 1.0 μ h

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPER. RELEASE	5-3-65	X	HLA	
Ø	ORIGINAL RELEASE FOR PRODUCTION	5-19-65	X	CIL	
A	IND. TOL. WAS. 10.5 μ h ADDED FREQ 1.75 MHZ	7-19-66	16576	RME	<i>[Signature]</i>

WINDING PROCEDURE

1. PRIMARY WIND 70 TURNS OF ITEM 3 ON ITEM 1, STAKE WITH ITEM 4.
2. SECONDARY- WIND 5 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.

A4277

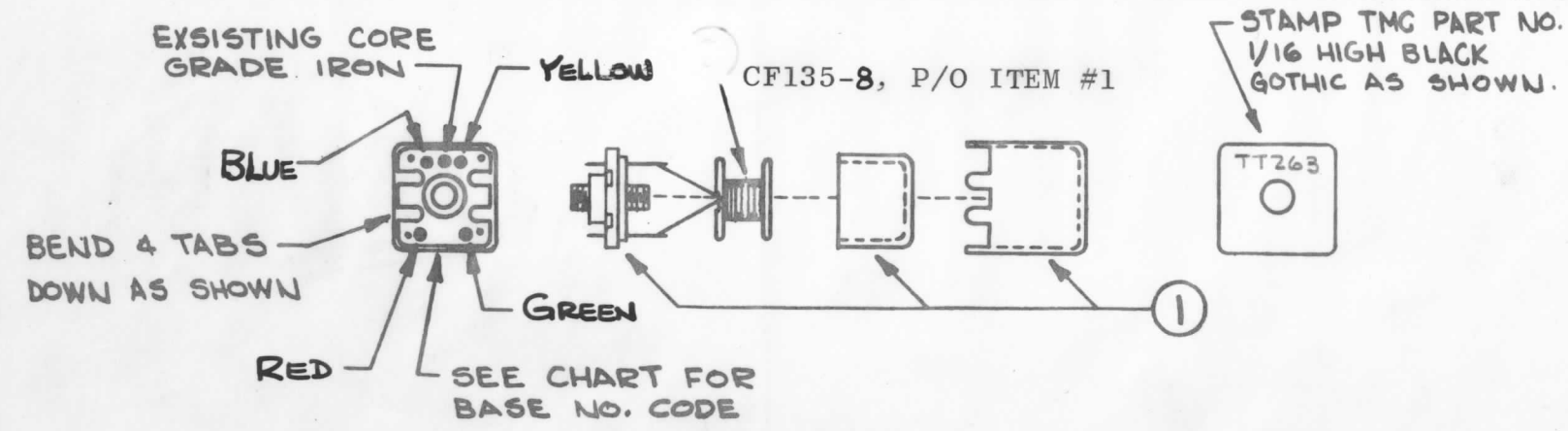


NOT TO BE RELEASED
W/O AUTHORIZATION

AUTH. BY: _____
DATE: _____

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-104-743 SNQ5	WIRE, ELECTRICAL,	
X	2	WI-141-32-5	WIRE, ELECTRICAL	
1	1	CI-136-2	CORE, ADJUSTABLE TUNING	

MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH		TITLE TT 263 ASSY SYN-A-TI			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN HLA	DATE 5-3-65	FINAL APPROVAL <i>[Signature]</i>	DATE 5/14/65
DECIMALS .X \pm .05 .XX \pm .01 .XXX \pm .005		CHECKED HLA	DATE 5/13/65	SHEET A4277	
FRACTIONS \pm 1/64 ANGLES \pm 0° 30'		ELECT. DES. JP	DATE	REV. LTR. A	



1	CMRA-1	A421G
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE A	

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.