

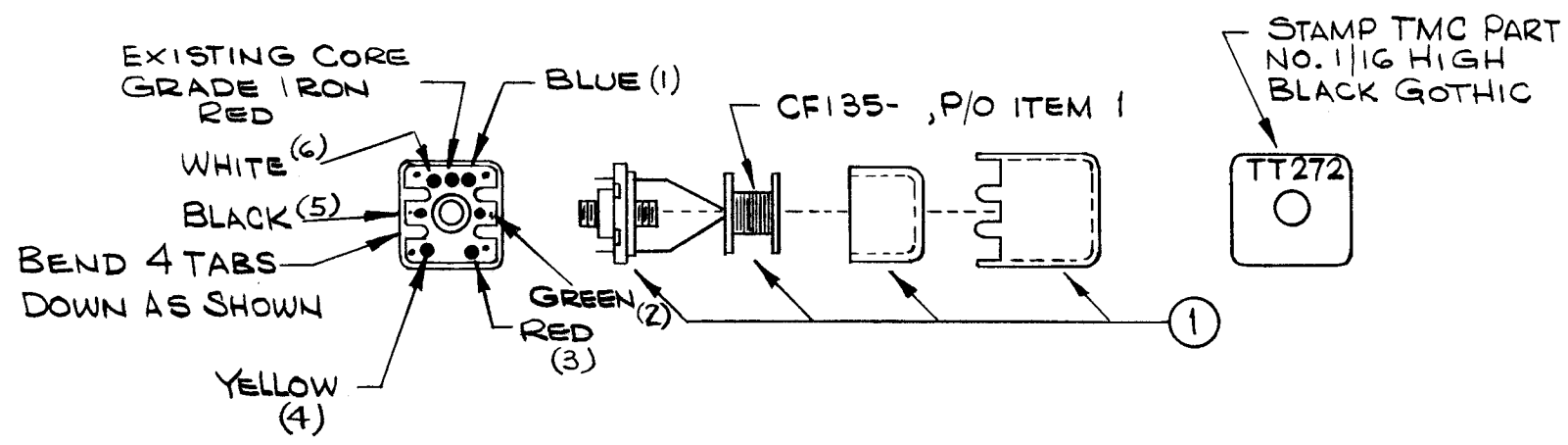
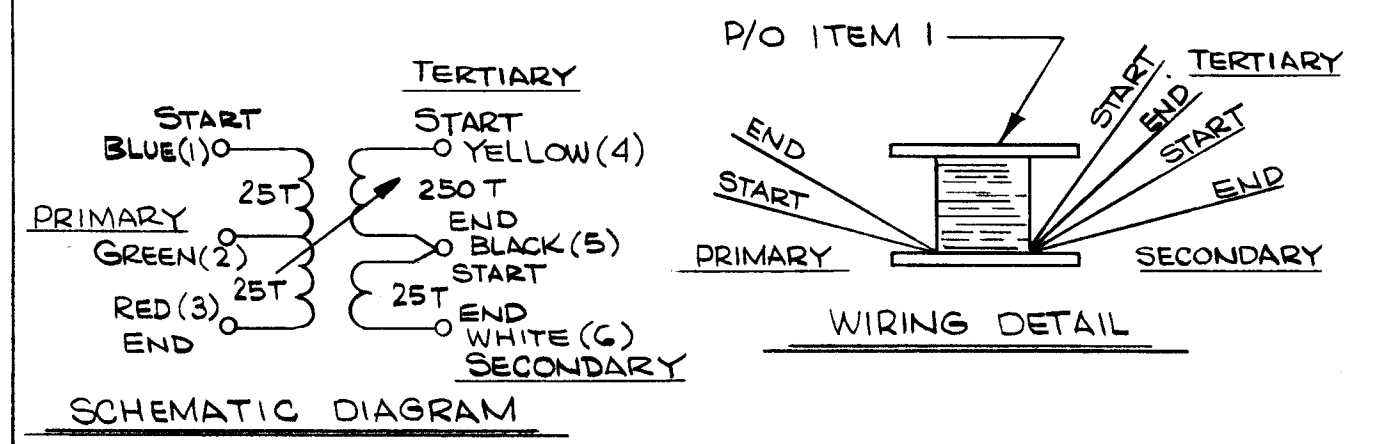
"Q" TEST FREQ.	"Q" MIN.	SYMBOL	INDUCTANCE
400 KC	50	T203	400 uh + AND -10%

REVISIONS						
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
Ø	ORIGINAL RELEASE FOR PRODUCTION	8-19-65	++	£		

A4332

W I N D I N G P R O C E D U R E

- TERTIARY:** Wind 250 Turns of Item #3 On Item #1. Stake with Item #4.
- PRIMARY:** Wind 50 turns of Item #3 over tertiary winding and in same direction, tap at 25 turns. Stake with Item #4.
- SECONDARY:** Wind 25 turns of Item #3 over tertiary and primary windings and in same direction. Stake with Item #4.
- Bake coil for 15 minutes at 150°F. Remove from oven and coat coil with Item #5.
- Color code terminals on base as shown.
- Strip and tin leads to within 1/4" of coil.
- Place bobbin over slug on base taking care to position notches on raised part of base.
- Solder start of tertiary to YELLOW (4).
- Solder end of tertiary and end of secondary to BLACK(5).
- Solder start of Secondary to WHITE(6).
- Solder start of Primary to BLUE (1) tap to GREEN(2) and end to RED(3).
- Assemble as per assembly drawing, place in case, bend the 4 small tabs down in the notches. DO NOT CUT OFF THE 2 LONG TABS.
- Stamp TMC Part No. As shown.
- Test inductance and 'Q' as shown above.
- Bake completed assembly for 1 hour at 212°F.
- Remove from oven. Allow to cool to room temperature.
- Repeat step #14.



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	5	GL130	ADHESIVE, Q-DOPE	
X	4	GL103	ADHESIVE, N-CEL	
X	3	WI104-3/43 SNQS	WIRE, ELECTRICAL, LITZ	
X	2	BS100	SOLDER, SOFT	
1	1	CI136-3	CORE, ADJUSTABLE TUNING	

LIST OF MATERIAL

MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH		TITLE TT-272 TRANSFORMER, RF, ADJUSTABLE			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN H. AUSTIN	DATE 8-17-65	FINAL APPROVAL <i>[Signature]</i>	DATE 8/19/65
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		TOLERANCES		ELECT. DES. <i>[Signature]</i>	DATE
FRACTIONS ± 1/64 ANGLES ± 0° 30'		MECH. DES.		DATE	REV. LTR.
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.		SHEET		A4332	

NOTES

1	VLRE - 1	AX599 A4299
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	
	A	