

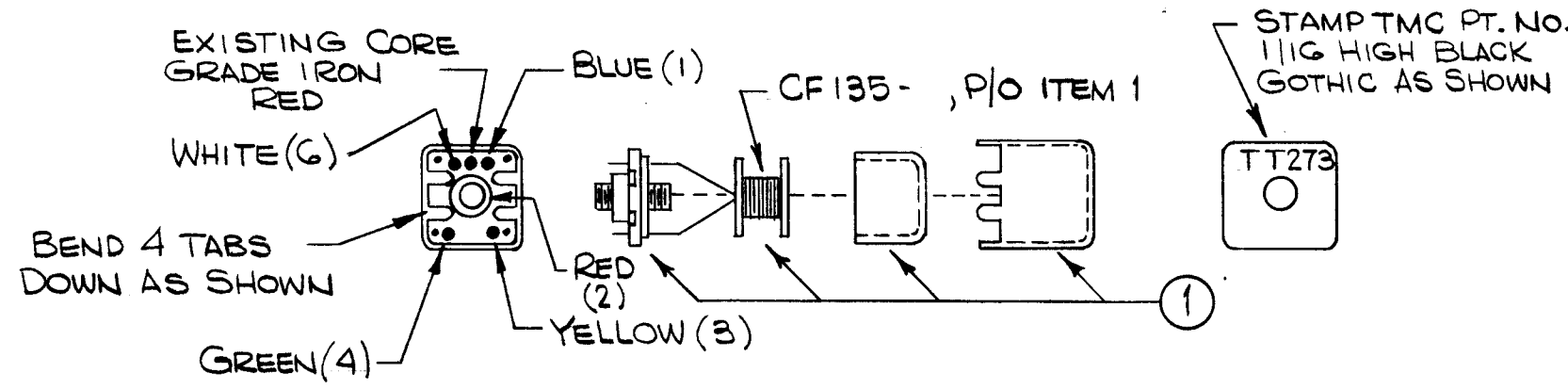
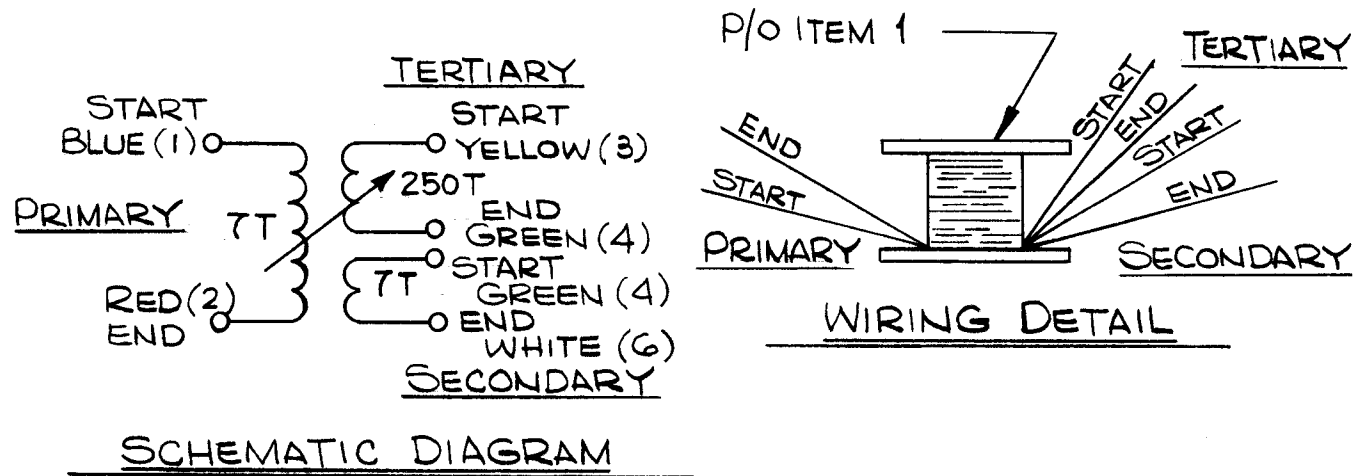
"Q" TEST FREQ.	"Q"	SYMBOL	INDUCTANCE
400KC	50	T201	400 uh + AND-10% @790KC

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

A4333

W I N D I N G   P R O C E D U R E

1. TERTIARY: Wind 250 Turns of Item #3 On Item #1. Stake with Item #4.
2. PRIMARY: Wind 7 turns of Item #3 over tertiary winding, and in same direction, stake with Item #4.
3. SECONDARY: Wind 7 turns of Item #3 over tertiary and primary in same direction. Stake with Item #4.
4. Bake coil for 15 minutes 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 start of tertiary to YELLOW (3) and end to GREEN(4).
9. Solder start of primary to BLUE(1) and end to RED(2)
10. Solder start of secondary to GREEN(4) and end to WHITE(6).
11. Assemble as per Assembly drawing. Place in case. Bend the four(4) tabs down in the notches. DO NOT CUT OFF THE 2 LONG TABS.
12. Stamp TMC Part No. as shown.
13. Test inductance and 'Q' as shown above.
14. Bake completed assembly for 1 hour at 212°F.
15. Remove from oven. Allow to cool to room temperature.
16. Repeat Step #13.



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	5	GL130	ADHESIVE, Q-DOPE	
X	4	GL103	ADHESIVE, N-CEL	
X	3	WI10413/43 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 TT273 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>
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		CHECKED <i>[Signature]</i>	DATE 8-19-65	DATE 8/19/65
FRACTIONS ± 1/64 ANGLES ± 0° 30'		ELECT. DES. <i>[Signature]</i>	DATE	A4333
TOLERANCES		MECH. DES.	DATE	Ø
				REV. LTR.

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

NOTES

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