

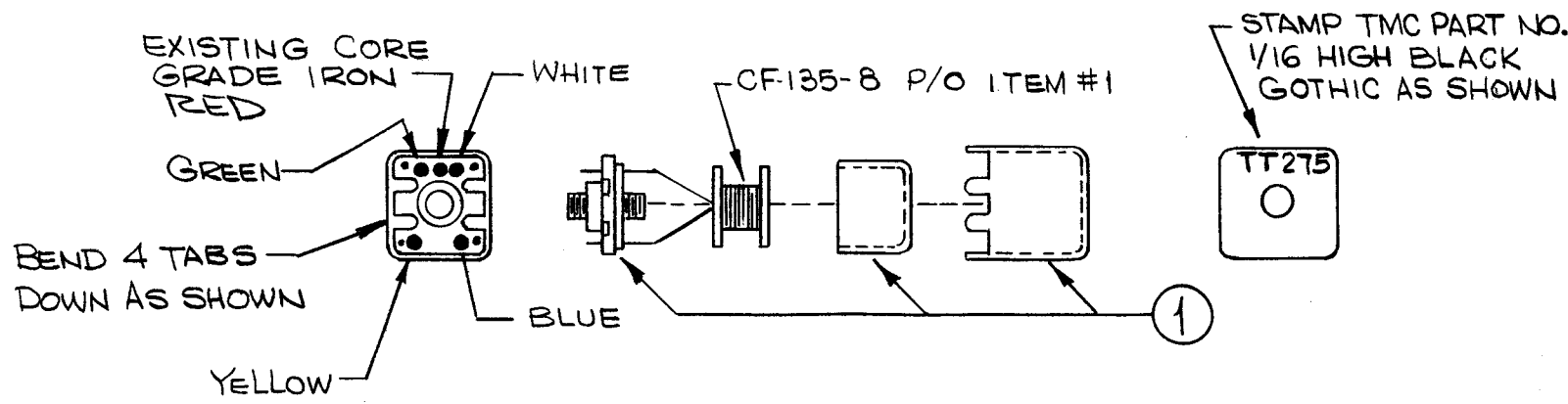
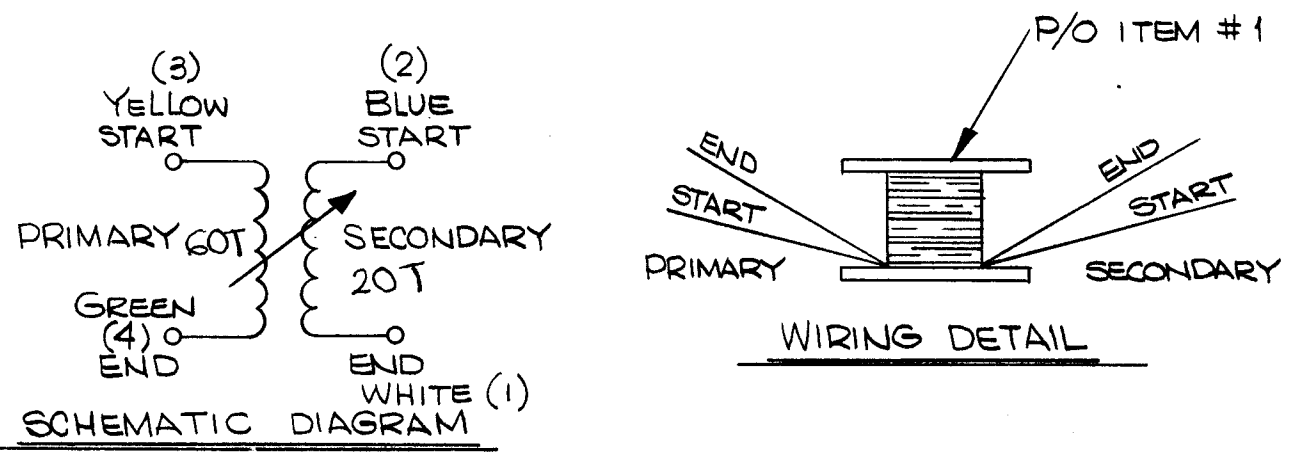
"Q" TEST FREQ.	"Q" MIN. METER	EXT. CAP. Q	SYMBOL	INDUCTANCE
300 Kc	105	5200pf	T2,4,6,	60 $\mu$ h @2.5mc $\pm$ 10%

A4339 B

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X <sub>1</sub>	IT. 7 ADDED, NOTE & PICTORIAL CLARIFIED	9-16-65	+1	C	
<del>Ø</del>	ORIGINAL RELEASE FOR PRODUCTION	10-5-65	+	C	
A	U/CHT. QTY WAS 4 FOR AX596. LINE AX597 ADDED	12/13/65	15417	W.V.	QCB
B	PRI WAS 5T; SEC WAS 17T	12/20/65	17529	WTO	QCB

**WINDING PROCEDURE**

1. PRIMARY WIND 60 TURNS OF ITEM 3 ON ITEM 1, STAKE WITH ITEM 4.
2. SECONDARY WIND 20 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. ASSEMBLY 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. STAMP TMC PART NO. AS SHOWN ABOVE.
12. REMOVE EXISTING SLUG FROM CI-136-2 AND REPLACE WITH CI-121-2.
13. TEST INDUCTANCE, AND Q AS SHOWN ABOVE.
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. 12.
17. TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE AS SHOWN ABOVE.
18. TEST COIL WITH "Q" METER 260A (FOR "Q" ONLY).
19. SET THE TEST FREQUENCY AS SHOWN ABOVE AND SET THE (MULTIPLY "Q") TO X1
20. TUNE THE INDUCTANCE DIAL TO REACH THE MAX. READING ON THE "Q" METER.



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
1	7	CI 121-2	SLUG FERRITE	
X	6	BS100	SOLDER, SOFT	
X	5	GL130	ADHESIVE, Q-DOPE	
X	4	GL103	ADHESIVE, N-CEL	
X	3	WI104-2041-SNQS	WIRE, ELECTRICAL, LITZ	
X	2	WI141-32-5	WIRE, ELECTRICAL	
1	1	CI136-2	CORE, ADJUSTABLE TUNING	

**POSE LIST OF MATERIAL**

**THE TECHNICAL MATERIEL CORP.**  
MAMARONECK, NEW YORK

TITLE: TT 275  
TRANSFORMER, RF, TUNED

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

DECIMALS: .X  $\pm$  .05, .XX  $\pm$  .01, .XXX  $\pm$  .005  
FRACTIONS:  $\pm$  1/64,  $\pm$  0° 30'

DRAWN: H. AUSTIN, DATE: 8-19-65  
CHECKED: [Signature], DATE: 9/16/65  
ELECT. DES: [Signature], MECH. DES: [Signature]

FINAL APPROVAL: [Signature], DATE: 10/5/65

SHEET: A4339, REV. LTR.: B

2	VLRE-1, AX597	A4380
3	VLRE-1, AX596	A4313
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	

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NOTES