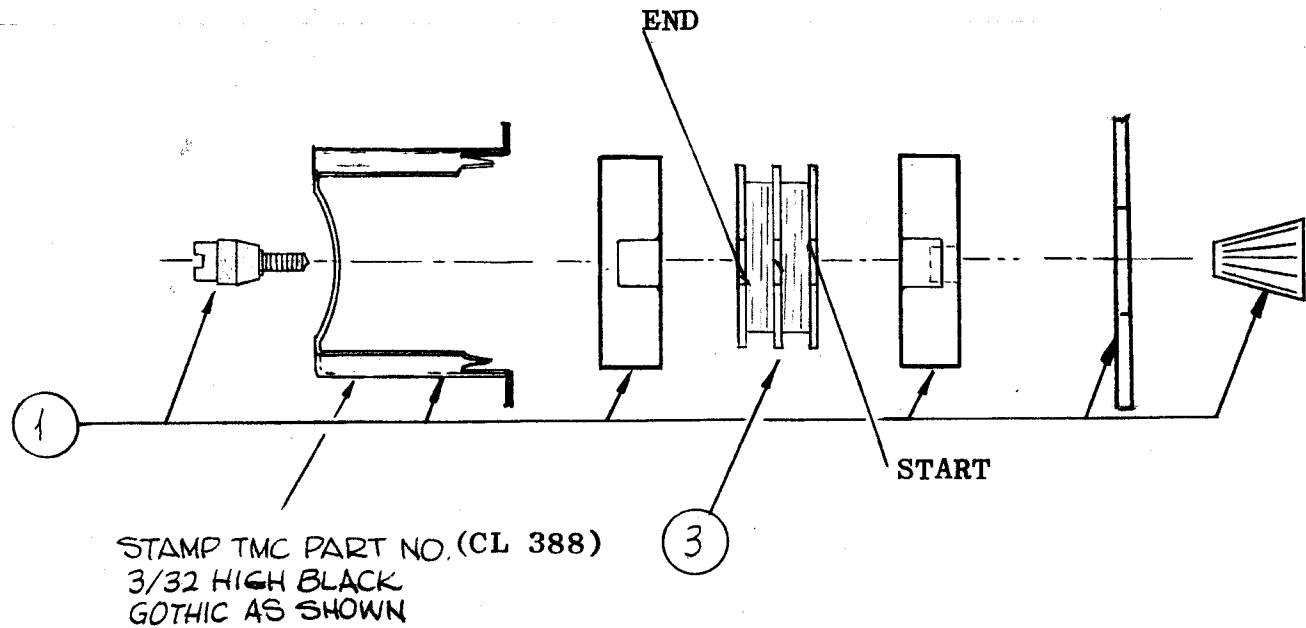


"Q" TEST FREQ.	"Q" MIN.	SYMBOL	INDUCTANCE @ 79KC
50KC	225	L401	25.25 TO 26.5mh



**WINDING PROCEDURE**

1. WIND 194 TURNS OF ITEM 6 ON ITEM 3, STAKE WITH ITEM 5.
2. ITEM 3 IS A SPLIT BOBBIN, SPLIT THE TURNS ON BOTH SIDES.
3. KEEP ALL LEADS 1 1/2" LONG.
4. STRIP AND TIN ALL LEADS TO WITHIN 3/4" OF COIL.
5. COLOR CODE ALL LEADS AS SHOWN IN WIRING DETAIL.
6. BAKE COIL FOR 15 MINUTES AT 150° F. REMOVE FROM OVEN AND COAT COIL WITH ITEM 4.
7. PLACE ITEM 3 INSIDE OF ITEM 1 AND ASSEMBLE AS PER ASSEMBLY DRAWING, EXCEPT FOR THE TUNING SLUG ASSY.
8. STAMP TMC PART NO. AS SHOWN.
9. TEST INDUCTANCE AND "Q" AS SHOWN ABOVE.
10. BAKE COMPLETED ASSEMBLY FOR 1 HOUR AT 212° F.
11. REMOVE COMPLETED ASSEMBLY FROM OVEN AND ALLOW TO COOL TO ROOM TEMPERATURE, THEN ASSEMBLE SLUG TO COIL
12. REPEAT STEP # 11.
13. TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE AS SHOWN ABOVE.
14. TEST COIL WITH "Q" METER TYPE 260A
15. SET THE TEST FREQUENCY AS SHOWN ABOVE
16. TUNE THE INDUCTANCE DIAL, TO REACH THE MAX. READING ON THE "Q" METER.

**NOTE**

CLIP CORES ARE SUPPLIED IN MATCHED PAIRS, CARE SHOULD BE TAKEN TO ENSURE THAT PAIRS ARE KEPT TOGETHER.

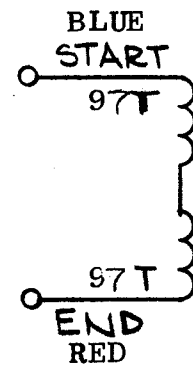
**NOTES**

1	VLRE-1	A4380
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	
	A	

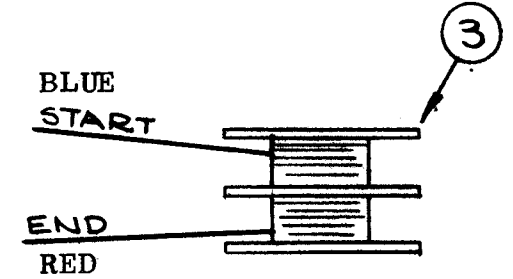
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.

A  
A4382

REVISIONS						
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X	EXPER. RELEASE		X			
Ø	ORIGINAL RELEASE FOR PROD	11/22/65				
A	WDG PRO REVISED "Q MIN" WAS 280 TURNS WAS 90T & 50T; REF ADDED PICTORIAL CLARIFIED.	12/20/66	17530	L401		



**SCHEMATIC DIAGRAM**



**WIRING DIAGRAM**

REF: S401-213

ITEMS 1 & 3 MFR # TC7-04-600-A-2-R

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	7	BS100	SOLDER, TIN ALLOY	
X	6	WI141-34-5	WIRE, ELECTRICAL, MAGNET	
X	5	GL103	ADHESIVE-N-CEL	
X	4	GL130	ADHESIVE-Q-DOPE	
1	3	CF135-13	FORM, COIL, BOBBIN TYPE	
1	2	DELETED		
1	1	CL139-1	CORE, BOBBI, TUNING	

**LIST OF MATERIAL**

MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH	TITLE COIL, RF, ADJUSTABLE CL 388			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN G/S	DATE 11-14-64	FINAL APPROVAL R.B./M
		CHECKED J.H.	DATE 11-22-64	DATE 11/22/65
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		FRACTIONS ± 1/64 ANGLES ± 0° 30'		TOLERANCES
		ELECT. DES. J.N.B.	DATE 11-20-65	A 4382
		MECH. DES.	DATE	SHEET
				REV. LTR.