

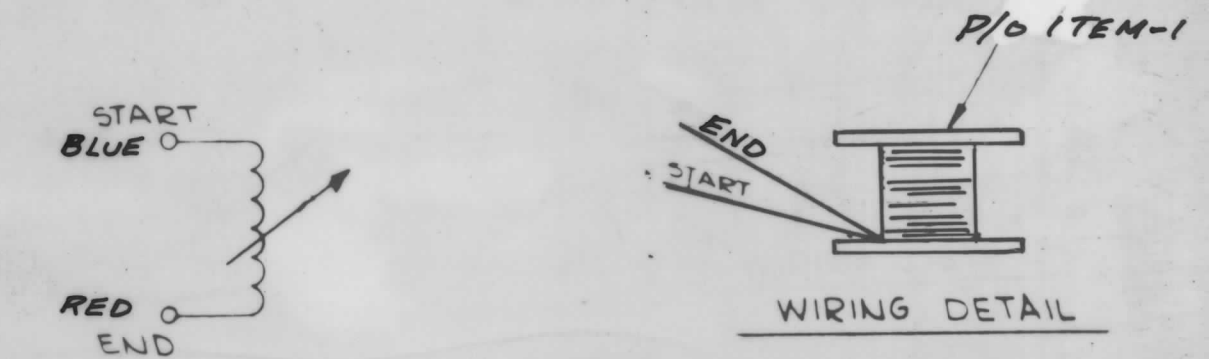
"Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	NO. CODE	SYMBOL	INDUCTANCE
100KHZ	55	5600 PF		L501	450 μH ± 10%

REVISIONS					
SYM	DESCRIPTION	DATE	EMN NO	DRAFT	CHKD
0	ORIGINAL RELEASE FOR PRODUCTION	2-16-66	0		JLO

A4423

WINDING PROCEDURE

1. WIND 178 TURNS OF ITEM 3 ON ITEM 2, STAKE WITH ITEM 4.
2. BAKE COIL FOR 15 MIN. AT 150°F, REMOVE FROM OVEN AND COAT COIL WITH ITEM #5.
3. COLOR CODE TERMINALS ON BASE AS SHOWN.
4. STRIP AND TIN LEADS TO WITHIN 1/4" OF COIL.
5. PLACE ITEM #2 OVER SLUG ON BASE, TAKING CARE TO POSITION NOTCHES ON RAISED PART OF BASE.
6. SOLDER ALL LEADS TO PROPER COLOR-CODED TERMINALS ON BASE.
7. ASSEMBLE AS PER ASSEMBLY DRAWING, PLACE IN CASE; BEND THE 4 TABS DOWN IN THE NOTCHES.
8. DO NOT CUT OFF THE TWO LONG TABS.
- 9.
10. STAMP TMC PART NO. AS SHOWN ABOVE.
11. TEST INDUCTANCE, AND Q AS SHOWN ABOVE.
12. BAKE COMPLETED ASSEMBLY FOR ONE HOUR AT 212°F.
13. REMOVE COMPLETED ASSEMBLY FROM OVEN AND ALLOW TO COOL TO ROOM TEMPERATURE.
14. REPEAT STEP NO. 13.
- 15.
16. TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE AS SHOWN ABOVE.
17. TEST COIL WITH "Q" METER 260A (FOR "Q" ONLY).
18. SET THE TEST FREQUENCY AS SHOWN ABOVE. AND SET THE (MULTIPLY "Q" X ) TO 1.
19. TUNE THE INDUCTANCE DIAL. TO REACH THE MAX. READING ON THE "Q" METER.

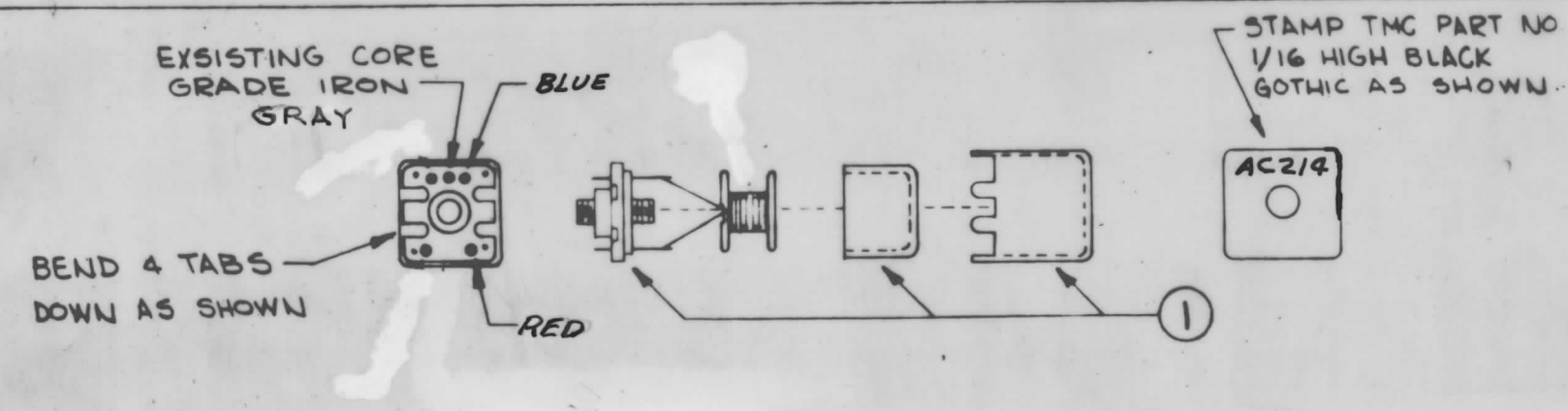


SCHEMATIC DIAGRAM

REQD	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-104-7/41 SNQS	WIRE ELECTRICAL, LITZ	
	2			
1	1	CI-136-1	CORE, ADJUSTABLE TUNING	

POSE - LIST OF MATERIAL

MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH	TITLE AC 214 COIL, RF, ADJUSTABLE			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN JL	DATE 16 20 62	FINAL APPROVAL <i>[Signature]</i>	DATE 2/16/66
DECIMALS I ± .05 II ± .01 XXX ± .005	TOLERANCES	FRACTIONS ± 1/64 ANGLES ± 0° 30'	ELECT. DES <i>[Signature]</i>	DATE 3-16-66
			MECH. DES <i>[Signature]</i>	DATE
			A 4423	
			SHEET	REV. LTR.



1	CDN-3	A4352
QTY/UNIT	MODEL USED ON	ASSY NO
SCALE	CODE	

NOTES

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