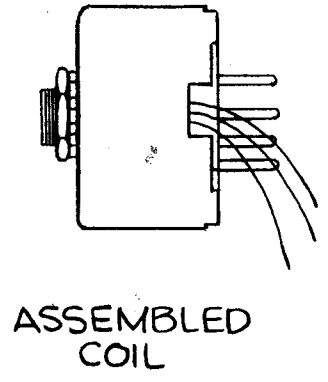


NOTE:
REMOVE ALL PINS FROM ITEM 4 BASE (DO NOT CUT MOUNTING TABS FROM CAN) ALIGN BASE NOTCHES WITH NOTCHES IN CORE AND CAN.



A4457 B

REVISIONS

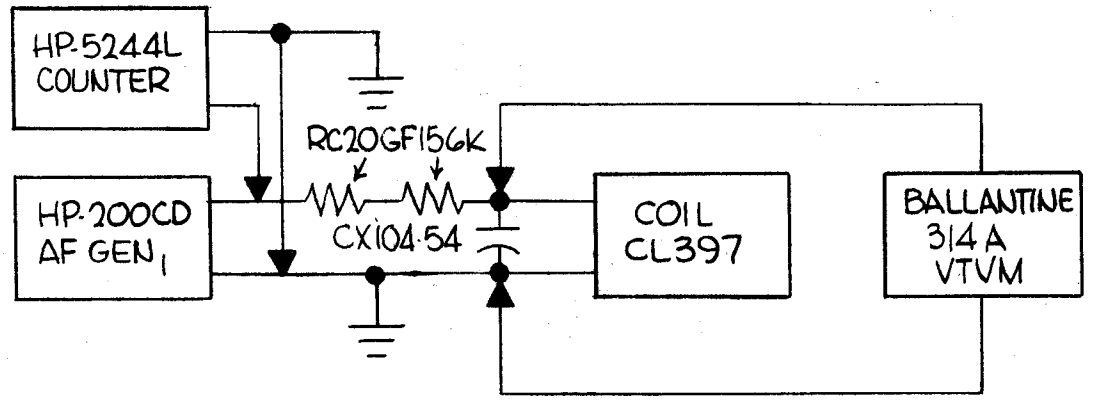
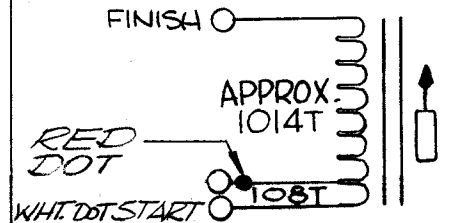
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X1	FABRICATION REVISED, IT WAS W123-37, IT 8 ADDED	8-3-66	-M-	Jc	JCB	GD
X2	REVISED #9 ON FABRICATION, IND. WAS 750 Ω ± 5%	8/23/66	-M-	Jc	JCB	GD
Ø	ORIGINAL RELEASE FOR PRODUCTION	9-27-66	Ø	RME		
A	IT. 4 WAS CU165-1	11/3/66	17162	RME		
B	ADD RED DOT TO 108T RELOC. WHT. DOT TO START	5/1/70	19841	GE		

FABRICATION

- WIND 374 TURNS OF ITEM 1 IN EACH OF THE 3 BOBBIN SECTIONS, TAP FIRST SECTION AT 108 TURNS. STAKE WITH ITEM 8.
- KEEP ALL LEADS 1 1/2 INCH. LONG
- TIN TO WITHIN 1/4 INCH. OF COIL
- COLOR CODE ALL LEADS AS SHOWN
- BAKE COIL FOR 15 MIN AT 150°F REMOVE FROM OVEN AND COAT COIL WITH ITEM 6.
- PLACE ITEM 2 INSIDE OF ITEM 3 AND ASSEMBLE AS PER ASSEMBLY DRAWING.
- BEND THE 3 TABS DOWN
- STAMP TMC PART NUMBER AS SHOWN.
- USING MARCONI MOD. TF-1313 1/4% BRIDGE, SET IND. PRECISELY TO 750 MH (# OF TURNS MAY BE ALTERED TO MEET 750 MH). SECURE BOBBIN W/ITEM 6.
- CHECK "Q" AS SHOWN
- BAKE COMPLETED ASSEMBLY FOR ONE HOUR AT 212°F.
- REMOVE COMPLETED ASSEMBLY FROM OVEN AND ALLOW TO COOL TO ROOM TEMP.
- REPEAT STEP 9 AND 10 THEN SEAL ADJUSTOR WITH ITEM 5.

ELECTRICAL SPECIFICATIONS

INDUCTANCE: 750 mh ± .5% @ 1KC
 "Q" UNLOADED: 100 MIN AT 2550 CPS
 D.C. RESISTANCE: APPROX. 92 OHM



TEST SET UP FOR "Q" MEASUREMENT

- CONNECT TEST SET UP AS SHOWN.
- ADJUST GENERATOR FREQ. FOR A PEAK ON IV SCALE OF METER. (SHOULD PEAK NEAR 2550CPS).
- SET GENERATOR OUTPUT SO METER READS 10DB. (RECORD FREQ.)
- ADJUST GENERATOR UP IN FREQ. TILL METER READS 7DB. (RECORD FREQ.)
- ADJUST GENERATOR DOWN IN FREQ. PASSING THRU THE PEAK AND STOPPING WHERE THE METER READS 7DB. AGAIN. (RECORD FREQ.)

6. $Q = \frac{\text{FREQ. IN STEP 3}}{\text{FREQ. IN STEP 4} - \text{FREQ. IN STEP 5}} = 100 \text{ MINIMUM}$

Ref. CL 397

4	CFA-2	A4476
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	

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NOTES

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
	8	GL103	ADHESIVE, N CEL	
	7	BS100	SOLDER, TIN ALLOY	
	6	GL102	Q DOPE	
	5	GL110	WAX, IMPREGNATING	
	1	4	CU165	
	1	3	CI137-10	
	1	2	CF135-15	
	1	WI141-36-9	WIRE, MAGNET	

DUDDLES LIST OF MATERIAL

MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH		TITLE COIL, AF ADJUSTABLE			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN Jc	DATE	FINAL APPROV. [Signature]	DATE 9/24/66
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		CHECKED [Signature]	DATE	A4457	
FRACTIONS ± 1/64 ANGLES ± 0° 30'		ELECT. DES. [Signature]	DATE 9-23-66	SHEET	
TOLERANCES		MECH. DES.	DATE		