

CL-130 A

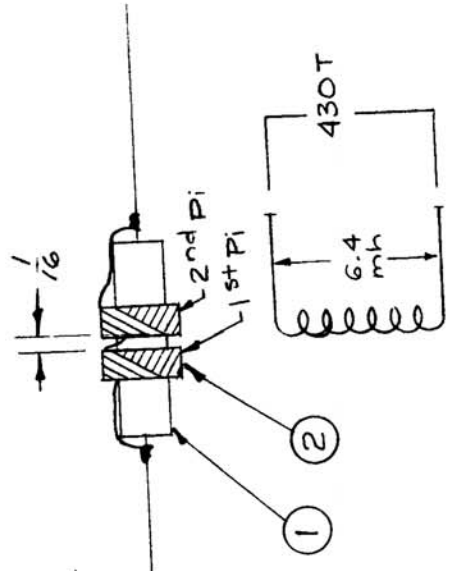
USED ON
 REQ. PER UNIT: 1
 MODEL: MSR-3
 SYMBOL NO.: L3
 DATE: 4-10-58

COIL MACHINE DATA
 Driver Gear - 100
 Cam Gear - 104
 Cam - .156

WINDING DATA

1. Start 1st Pi 5/16" from end of core.
2. Wind on 215 turns. To form 1st Pi.
3. End 2nd Pi at approx. 430 Turns.
4. Add or Subtract Turns to meet inductance
5. Stake ends with GL-103 (item 4).
6. Strip coil leads and wrap and solder to core leads.
7. Bake for 1/2 hour. at 215 degrees F.
8. Saturate coil with GL-104-2 and air dry. for 10 min.
9. Bake for 2 hours at 215 degrees F.
10. Test as below.

TEST DATA: Use Boonton "Q" Meter or equivalent
 Inductance - 6.4 (6.1 - 6.7) millihenries.
 Q _____ 50 or greater.
 Freq. _____ 250 KC



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 5	HS-100	Solder, Soft	
X 4	GL-103	Cement, Duco	
X 3	GL-104-2	Insulux, U85	
X 2	WI-120-15	Wire, Magnet, No. 34 DSC	
1	CI-114-1	Core, Fixed, Ferrite	

THE TECHNICAL MATERIAL CORP.
 MAMARONECK, NEW YORK
 COIL, RF, 6.4 MH

STOCK SIZE

MATERIAL

64/10/58
 DRAWN: P. J. K.
 CHECKED: [Signature]
 FINAL APPROVAL: [Signature]

TYPE & TEMPER HEAT TREAT. SPEC. ELEC. DES. APP. MECH. DES. APP.
 FINISH & SPEC. NO. CL-130 A

ISSUE ITEM: A
 CHANGED FROM: WIND. DATA 34 UPDATED 11/20/67 Q WAS 80
 DATE: 18615
 DRAFTS CHECKER: [Signature]
 ENG. APP.: OPA

SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

TOLERANCES
 DEC. DIM. ±
 FRAC. DIM. ±
 ANGULAR DIM. ±