

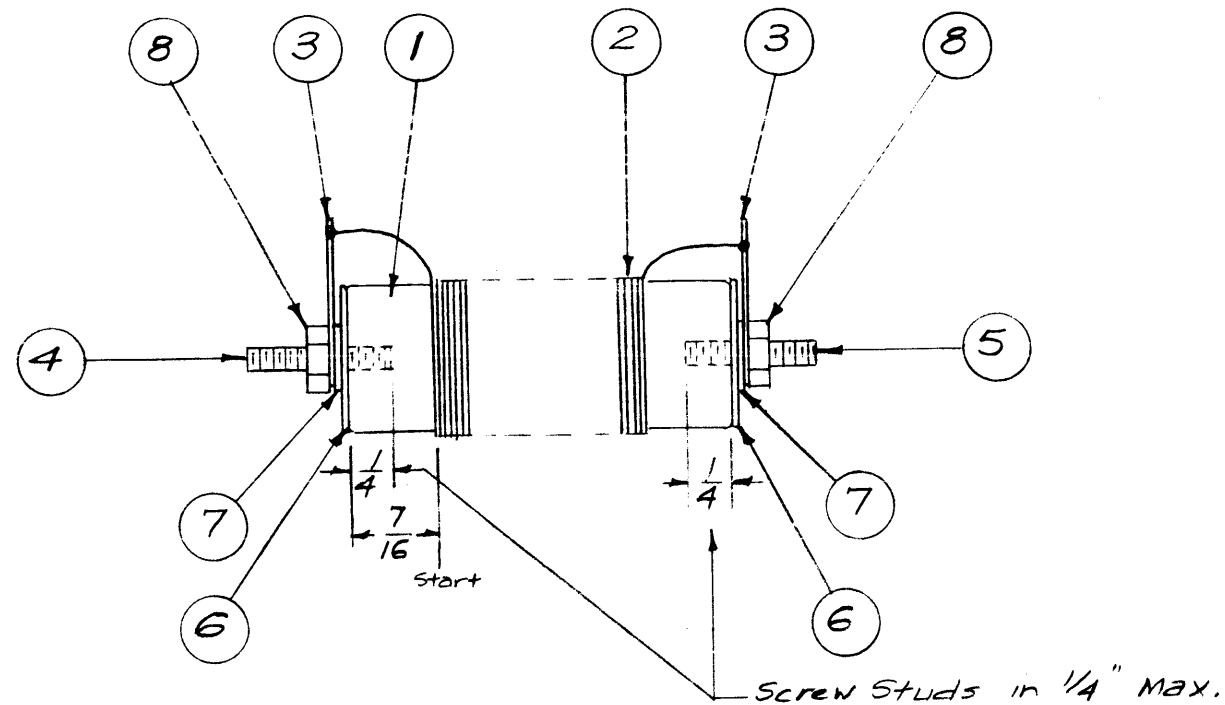
CL-138

PROCEDURE

1. Assemble Insulator and all Hardware tightly together. Threaded Studs must be inserted as shown.
2. Wind 70 turns of item 2 (wire) on insulator as shown.
3. Stake wire ends to insulator body with item 9 (Q-Max.), and solder ends to lugs.
4. Coat Winding with item 10 (Insulex).
5. Bake for 1 hour at 250° F.
6. Allow unit to cool
7. Test unit as below.

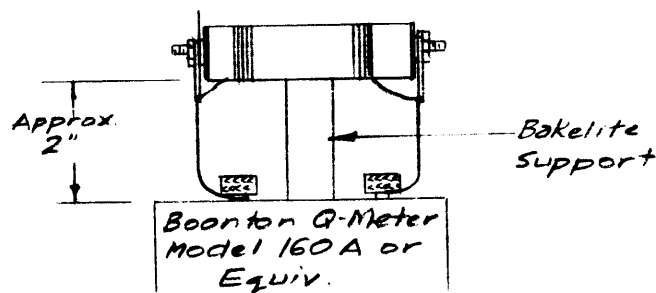
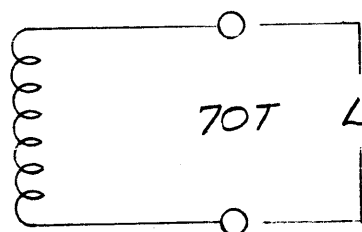
TEST SAMPLING PROCEDURE

1. Test as per, TMC Specification S-365 (Test Sampling Procedure).
2. For the one tested coil, solder 4" leads to terminal lugs.



TEST DATA

L = 50(45-55) μ hy.
 Q = 120 or Greater
 F = 2.5 Mc



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 MAMARONECK, NEW YORK

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	11	BS-100	SOLDER, SOFT	
X	10	GL-104-2	INSULEX, U-85	
X	9	GL-102	CEMENT, Q-MAX.	
2	8	NTH1032 BC10	NUT, HEX	
2	7	FW10HBC	WASHER, FLAT	
2	6	WA-109-56	WASHER, FIBRE	
1	5	SC-127-3	STUD, THREADED (11/16 Long)	
1	4	SC-127-1	STUD, THREADED (7/8 Long)	
2	3	TE-104-4	TERMINAL, LOCKING	
X	2	WI-125-12	WIRE, MAGNET, CEROC "T" (#27)	
1	1	NS3W0316	INSULATOR, PILLAR, ROUND	
			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
STOCK SIZE			COIL, RF, PA OUTPUT (L207)	
MATERIAL				
TYPE & TEMPER			HEAT TREAT. SPEC.	DRAWN
FINISH & SPEC. NO.			ELEC. DES. APP.	MECH. DES. APP.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.				
FRAC. DIM. ±			REMOVE ALL BURRS AND SHARP EDGES				
ANGULAR DIM. ±							

1	RFA-1	PAL-350	L207	5-29-58
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
USED ON				