

STANDARD DRAWING

*Q- Taken Without Shunting Resistor

TMC NO	COLOR CODE	±10% INDUCT	F	#Q	CHOKE FORM	NO OF P.I.'S	WIRE	TURNS PER FT	TOTAL TURNS	SPACING	WINDING MACHINE DATA			R/C APP
											CAM GEAR	DRIVER	CAM	
CL-108-1	VIOLET	200 uh	790 Kc	55	RC-32GF-225J	2	WI-104-341-SNE	105	210	1/16	90	85	.125	
CL-108-2	BLUE	250 uh	790 Kc	--	RC-32GF-123J	2	WI-104-341-SNE	115	230	1/16	90	85	.125	
CL-108-3	GREEN	300 uh	790 Kc	55	RC-32GF-225J	2	WI-104-341-SNE	125	250	1/16	90	85	.125	
CL-108-4	YELLOW	112 uh	790 Kc	50	RC-20GF-474J	2	WI-104-341-SNE	100	200	1/16	91	85	.093	
CL-108-5	BLACK	142 uh	790 Kc	35	RC-32GF-225J	1	WI-107-17	150	150	----	88	85	.187	
CL-108-6	RED	200 uh	790 Kc	--	RC-32GF-822J	2	WI-104-341-SNE	105	210	1/16	90	85	.125	9.0
CL-108-7	ORANGE	200 uh	790 Kc	--	RC-323F-272J	2	WI-104-341-SNE	105	210	1/16	90	85	.125	
CL-108-8	WHITE	250 uh	790 Kc	--	RC-32GF-822J	2	WI-104-341-SNE	115	230	1/16	90	85	.125	

NOTE: L measurement on Bonton 160A Q-meter or equiv.
R measurement on Simpson Model 260 Ohmmeter or equiv.

NOTICE TO PERSONS RECEIVING THIS DRAWING

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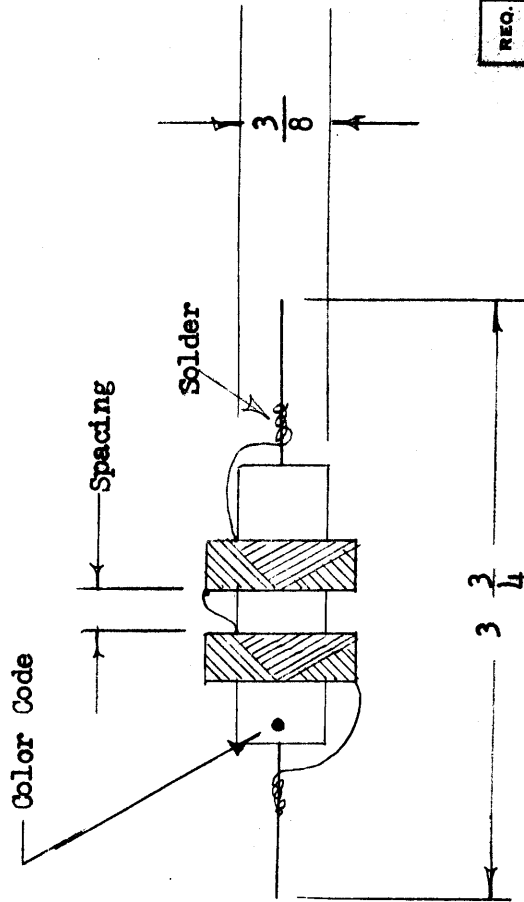
Property of:

THE TECHNICAL MATERIEL CORPORATION

MAMARONECK, NEW YORK

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

CHOKE, RF



NOTE:

1. Dry 15 Minutes at 212°
2. Paint A-27, Q-Max. (GL-102)
3. Dry 15 Minutes.

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
H	ADDED ±10% INDUCT.	3-6-67	17920	L.P.K.	[Signature]	[Signature]
G	ON CL108-1 THRU CL108-8 CHOCHE FORM TOL WAS 1/16"	9-27-68	16870	[Signature]	[Signature]	[Signature]

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

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

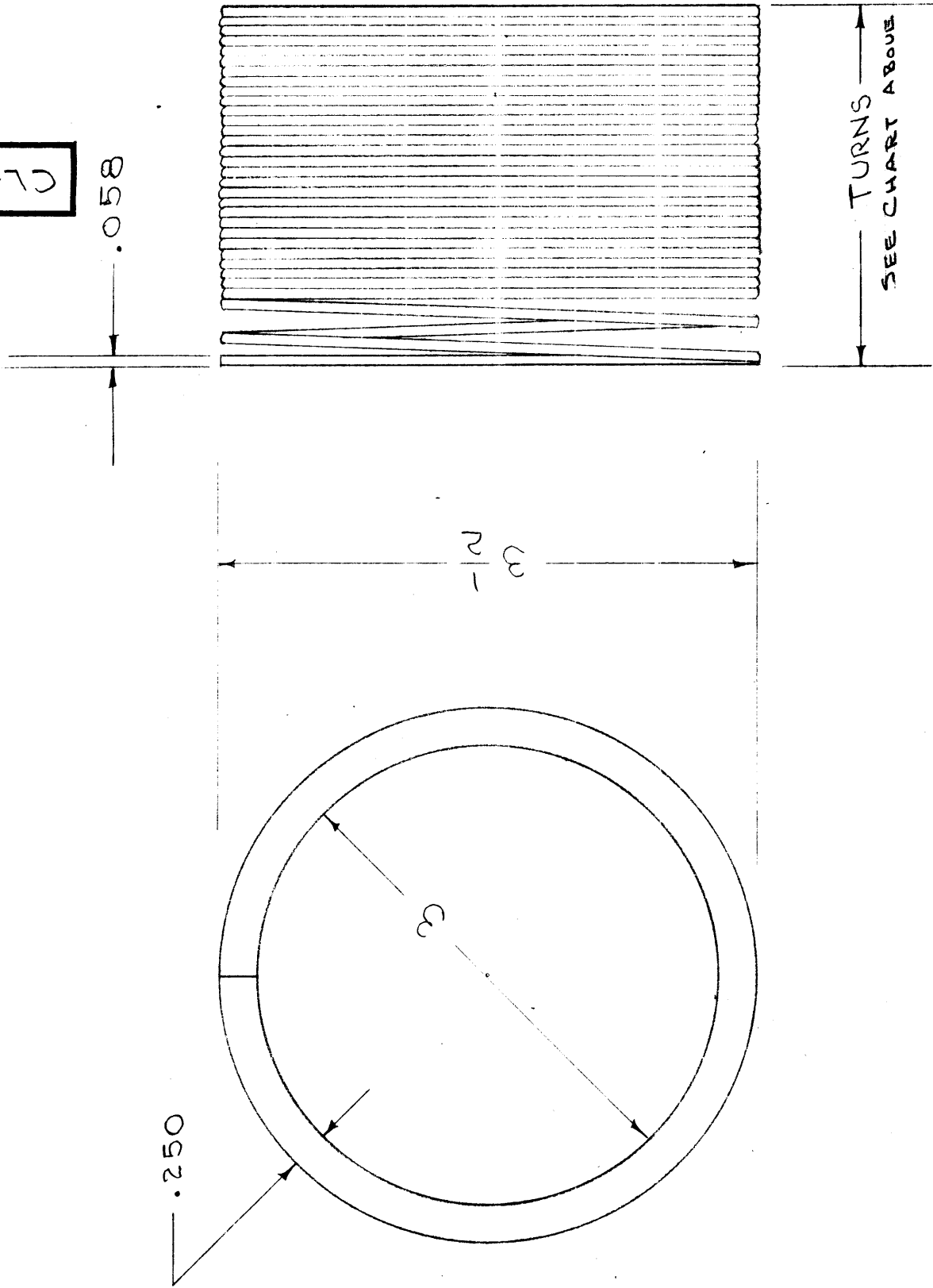
REQ. UNIT	MODEL	PROJECT NO.	ASBY. NO.	DATE

REQ. ITEM	PART NO.	SYMBOL
STOCK SIZE		
MATERIAL		
TYPE & TEMPER. HEAT TREAT. SPEC.		
DRAWN		
CHECKED		
FINAL APPROVAL		

CL-108

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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



TMC NO	TURNS	WINDING	REQ PER UN
CL-114-1	34 1/4	CLOCK WISE	1
CL-114-2	29	COUNTERCLOCKWISE	1
CL-114-3	40	CLOCKWISE	1
CL-114-4	22	CLOCKWISE	1
CL-114-5	20 1/2	CLOCKWISE	1

NOTE

CL-114-1 AND CL-115-1 HAVE BEEN COMBINED MAKING A TOTAL OF 34 1/4 TURNS.

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ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
E 1	CL 114-5 ADDED	9-26-57	21170	GDL	AL	AL
D	CL-114-2 WAS 28 3/4 TURNS	3-12-64	11036	ATB	Yde	Yde
C 1	-4 WAS 21 TURNS	9/21/59	1358	HO	HO	HO
B 1	CL-114-3 ADDED	12/11/57	2	ALW	ALW	ALW
A 1	CL-114-1 WAS 28 3/4 TURNS CL-115-1 combined w/CL-114-1	11/1/57	1	Yde	Yde	Yde

SCALE: _____
TOLERANCES
DEC. DIM. ± .005
FRAC. DIM. ± 1/64
AN ULAR DIM. ± _____
DRILL, PUNCH, COMMERCIAL STOCK
SIZES AND MANUFACTURERS
TOLERANCES ARE NOT INCLUDED.

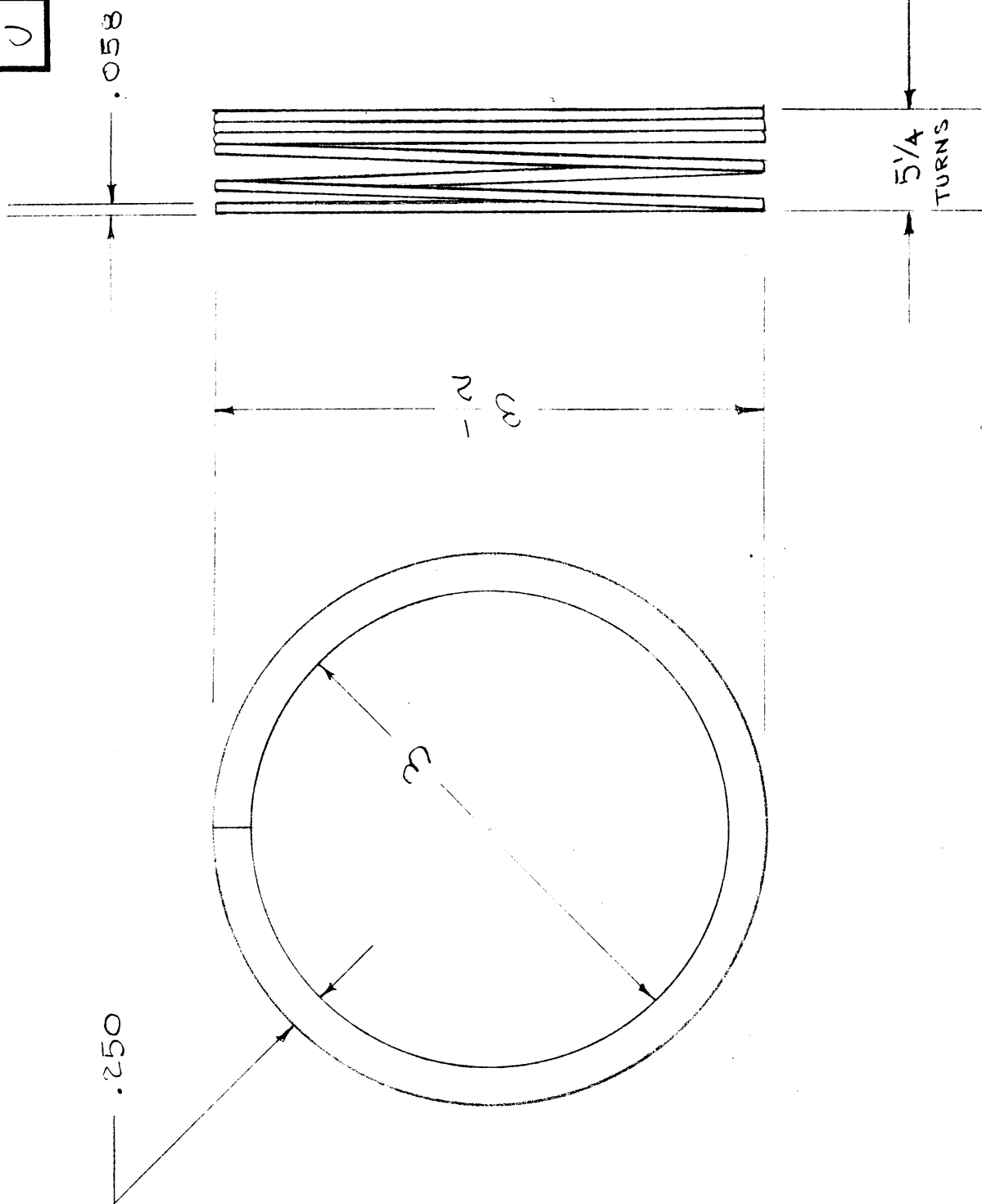
AT S-TU	653	6-8-59
TAC-1	132	12-11-57
PROJECT NO.	A-675-677	1-7-54
ASST. NO.	A-676	
DATE		

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
.058 X .250		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
COPPER		TANK COIL	
MATERIAL		TAC-1	
SOFT DRAWN		C.P.D.	
TYPE & TEMPER		DRAWN	
HEAT TREAT. PEG.		CHECKED	
		FINAL APPROV.	
		CL-114-1 B	

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4
1011-70



NOTE
CL-115-1 HAS BEEN ADDED TO CL-114-1.
(REF CL-114-1)

~~CL-115-1 5/4 TURNS CLOCKWISE~~ DELETE
CL-115-2 5/4 TURNS COUNTER CLOCKWISE

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REQ. PER UNIT
~~CL-115-1 1 REQ.~~ DELETE
CL-115-2 1 REQ.

ISSUE ITEM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
A 1	4/19/57	1	JAG	MA	ATJ
<p>CL-115-1 DELETED AND 4/19/57 COMBINED W/ CL-114-1</p>					
<p>CHANGED FROM</p>					
<p>TOLERANCES</p>					
<p>DEC. DIM. $\pm .005$ FRAC. DIM. $\pm 1/64$ ANGULAR DIM. \pm</p>					
<p>DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.</p>					

MODEL	PROJECT NO.	ASSY. NO.	DATE
TAC-1	132	A-678	1-7-54
USED ON			

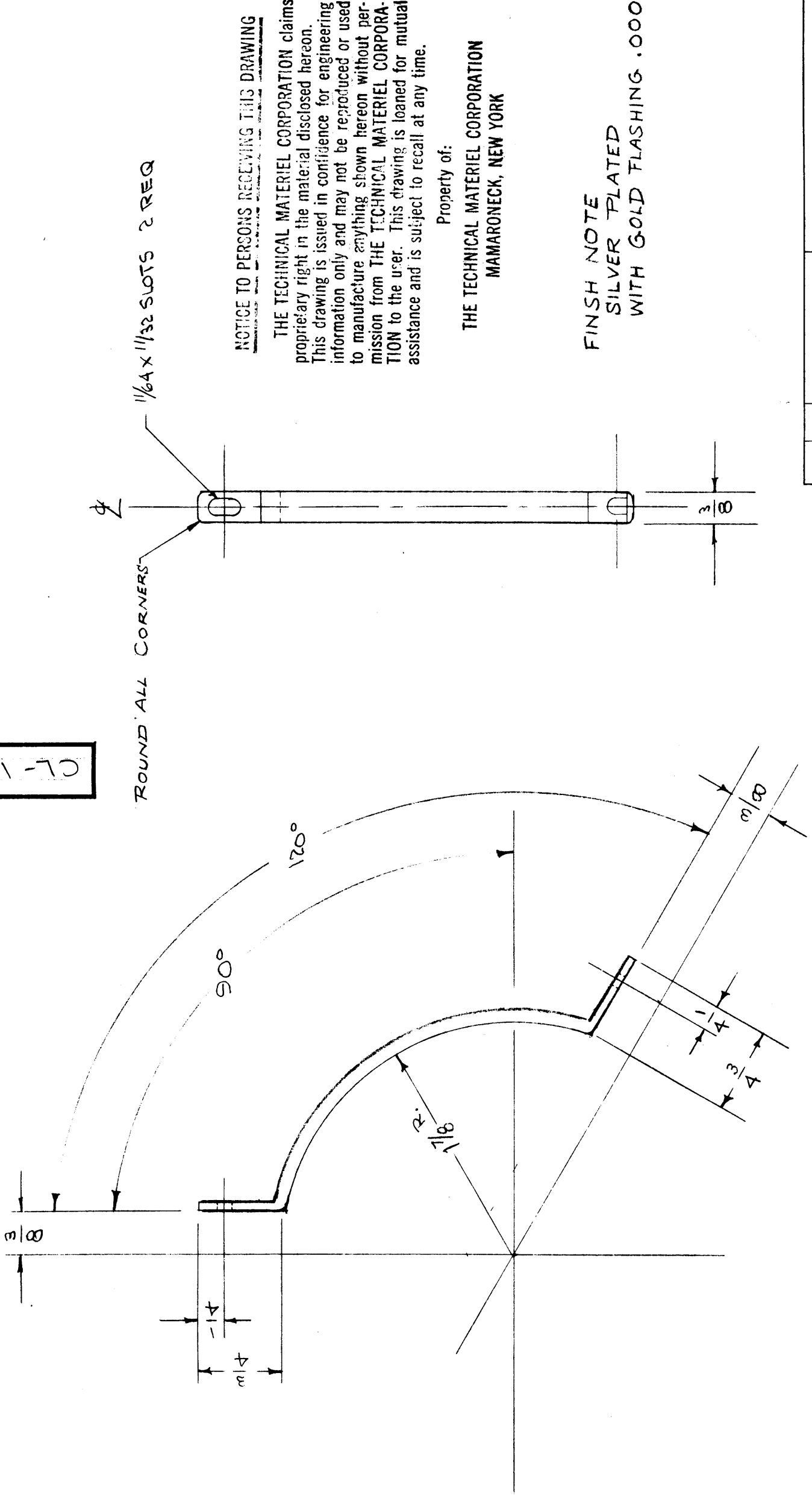
REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
.058 X .250		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
COPPER	#	LINK COIL	
MATERIAL	WEIGHT PER PC.	TAC-1	
SOFT DRAWN			
TYPE & TEMPER			
#			
HEAT TREAT. SPEC.			
#			
FINISH & SPEC. NO.			

CDR.	ARB	WOC
DRAWN	ARB	ELEC. DES. APP.
CHECKED	ARB	MECH. DES. APP.
		FINAL APPROVAL
		CL-115

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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

CL-116



ROUND ALL CORNERS

1/64 X 11/32 SLOTS 2 REQ

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FINISH NOTE
SILVER PLATED
WITH GOLD FLASHING .000025

ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
3	NOTE ADDED						
4	Rect. 3/8 x 1/8 WAS						
5	1/64 x 11/32 SLOT WAS 3/64 x 11/32		9/15/60	5974	R U220		
6	1/2 DIM. 178 R WAS 2R DIM. 3/4						

3	ATS-70TU	1-24-58
3	ATS-50TU	1-24-58
6	TAC-1	1-18-54
PER	MODEL	DATE
UNIT	PROJECT NO. 132	ASSY. NO. A-674
		USED ON

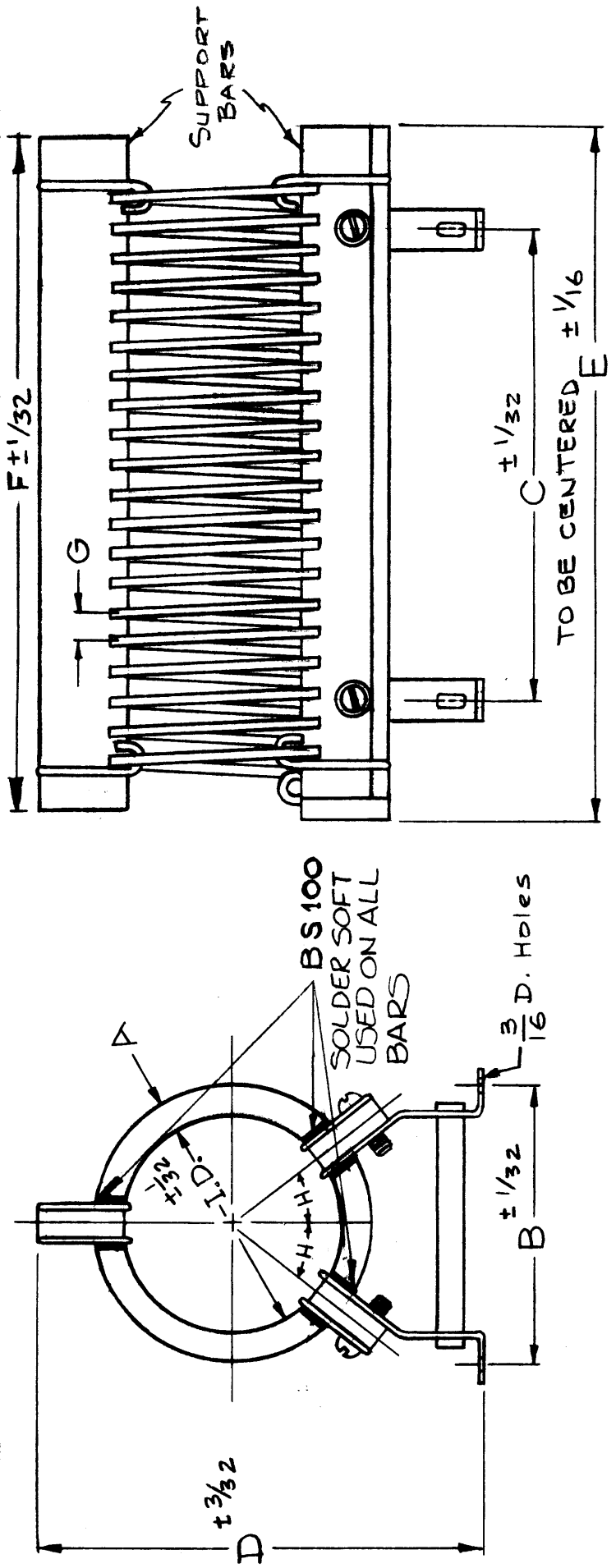
TOLERANCES
DEC. DIM. ±
FRAC. DIM. ± 1/64
ANGULAR DIM. ± 2°

DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
RECT. BAR	3/8 x 1/8	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
COPPER	—	COIL, EXTERNAL COUPLING TAC-1	
MATERIAL	WEIGHT PER PC.		
COMMERCIAL, SOFT			
TYPE & TEMPER			
HEAT TREAT. SPEC.			
SEE NOTE			
FINI H & SPEC. NO.			

CL-118

TOTAL IND. IN μ hy	MFG. PART NO.	NO. OF TURNS	COIL I.D. $\pm 1/32$	DIM. A COIL WIDTH	DIM. B MTG. WIDTH	DIM. C MTG. LENGTH	DIM. D O/A HEIGHT	DIM. E O/A LENGTH	DIM. F SUPPORT LENGTH	DIM. G COIL CENTERS	"H" LEG ANGLE
2.6	232-627	6	2 1/2"	1/4"	3 1/4"	ONE BASE	4 5/8"	1 5/8"	1 7/16"	3/16"	38°
4.2	232-628	12	2 1/2"	1/4"	3 1/4"	3"	4 5/8"	4 15/16"	4 5/8"	3/8"	38°
5.2	232-630	11	2 1/2"	1/4"	3 1/4"	1 1/4"	4 5/8"	3 7/32"	3"	1/4"	38°
8.2	232-623	10	3 1/4"	1/4"	3 1/4"	1 1/8"	5 3/8"	2 11/32"	2 3/16"	3/16"	33°
10	232-626	18	2 1/2"	1/4"	3 1/4"	3"	4 5/8"	4 31/32"	4 3/4"	1/4"	38°
14	232-611	20	2 1/2"	1/4"	3 1/4"	2 1/4"	4 5/8"	4 7/32"	4 1/16"	3/16"	38°
20	232-624	23	3 1/4"	1/4"	3 1/4"	4 1/4"	5 3/8"	6 7/32"	6"	1/4"	33°
22	232-TA	30	2 1/2"	1/4"	3 1/4"	4 3/8"	4 3/16"	6	6	3/16"	38°
30	232-629	20	4"	1/4"	3 3/4"	2 1/4"	6"	4 7/32"	4 1/16"	3/16"	30°
31	232-610	40	2 1/2"	1/4"	3 1/4"	6"	4 5/8"	7 31/32"	7 13/16"	3/16"	38°
39	232-632	49	2 1/2"	1/4"	3 1/4"	7 11/16"	4 5/8"	9 21/32"	9 1/2"	3/16"	38°
41	232-622	34	3 1/4"	1/4"	3 1/4"	4 5/8"	5 3/8"	6 19/32"	6 7/16"	.180	33°
54	232-631	42	3 1/4"	1/4"	3 1/4"	6 1/16"	5 3/8"	8 1/32"	7 7/8"	.180	33°
84	232-620	46	4"	1/4"	3 3/4"	7 1/8"	6"	9 3/32"	8 15/16"	3/16"	30°
41	232-622-2	34	3 1/4"	1/4"	3 1/4"	4 1/4"	5 3/8"	6 19/32"	6 7/16"	.180	33°



ELEC. SPEC.
 Q = ALL COILS - APPROX 450 @ 25HC
 CURRENT RATING = 5 AMPS.
 MECHANICAL SPEC.
 ALL COILS - CADMIUM PLATED
 COPPER STRIP,
 SUPPORT BARS, GLASS BONDED
 MICA.

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TMC PART NO. TO BE IN THE FOLLOWING FORM
 CL-118-2.6-1
 * SPECIAL DIMENSION
 TOTAL INDUCTANCE
 IN μ hy (see chart)
 BASIC TMC
 PART NO.

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	SCALE	TOLERANCES
E	1 BX-100 SOLDER NOTE ADDED	1-9-63	6173	J.B.	J.B.		5-401-47	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES
D	1 MFG. PART NO. 232-619 deleted	2-7-61	4995	M.A.H.	J.B.			
C	1 TOTAL IND. 20A WAS 20	8/9/60	2730	R.U.	J.B.			
B	1 REDRAWN - REVISED ADDED TO CHART	11-2-59	1528	J.C.B.	J.B.			

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
J	1 ON-22 "C" WAS 4 1/8	1/5/68	18703	H.G.	S.G.	F.B.
H	1 ON-22 "C" WAS 4 3/8 EFF WERE 5 1/8	11/1/67	18585	H.G.	S.G.	F.B.
G	1 -22 ADDED	9/19/67	18515	H.G.	S.G.	F.B.
F	2 TO BE CENTERED NOTE ADD. #41 ADD. ON TMC P/N -1 ADD.	8.12.64	11742	A.B.	J.B.	

DEC. DIM. \pm	FRAC. DIM. \pm	ANGULAR DIM. \pm

REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
	STO			10-29-59

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

TYPE & TEMPER	HEAT TREAT. SPEC.	FINISH & SPEC. NO.

REVISION	DATE	BY	CHKD.	APP.
1				

DESCRIPTION	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK
COIL, RF, FIXED	

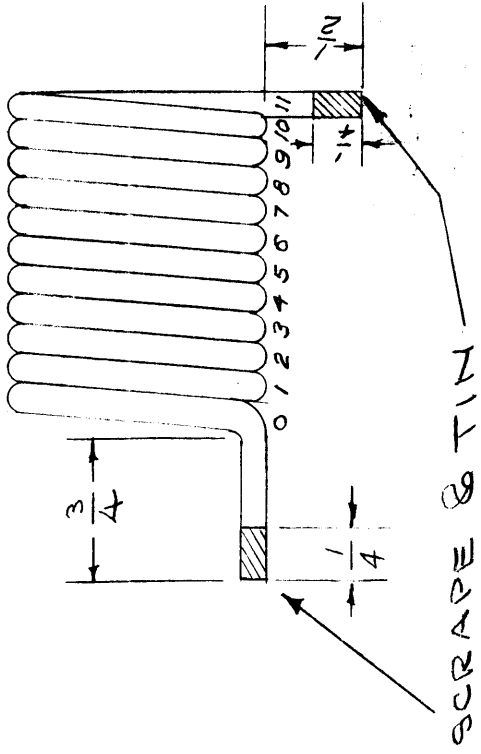
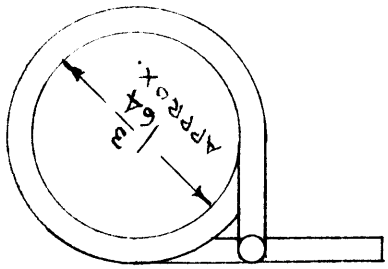
DRAWN	CHECKED	FINAL APPROVAL
J.C. Biele	J.B.	J.B.

CL-118	5

MECHANICAL - DATA

WINDING - 11 TURNS PLUS ADDITIONAL ALLOWANCE FOR 3/4" AND 1/2" ENDS.
CLOSE WOUND OF WI-127-10. TIGHT WIND ON 1" O.D. TUBING. ALLOW TO SPRING.
FINAL COIL I.D. APPROX 1 3/64"

BENDING - BEND AS SHOWN. USE RADIUS JIGS SO ENAMEL COATING WILL NOT BE HARMED.
SCRAPE & TIN AS SHOWN.



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ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
C	1 WAS WI-127-10	11-28-46	17327	WAW	JAB	J
B	3 MECHANICAL DATA REVISED	3-4-57	2	SC	JAB	AJO
A	2 TURNS ADDED TO COIL	2-14-56	1	R	MP	A.J.J.
	1 LUGS DETAIL ADDED					
	1 TEST DATA					

TOLERANCES

SCALE:
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REMOVE ALL BURRS AND SHARP EDGES

ELECTRICAL -

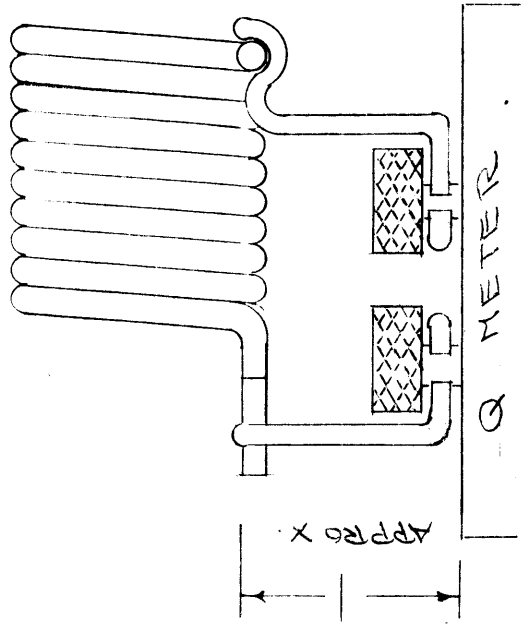
TEST DATA -

TEST ONLY FIRST COIL OF EACH RUN
ALL REMAINING COILS MAY THEN BE PASSED BY VISUAL INSPECTION.

METER - BOONTON "Q" METER
TYPE 160 A OR EQUIVALENT.

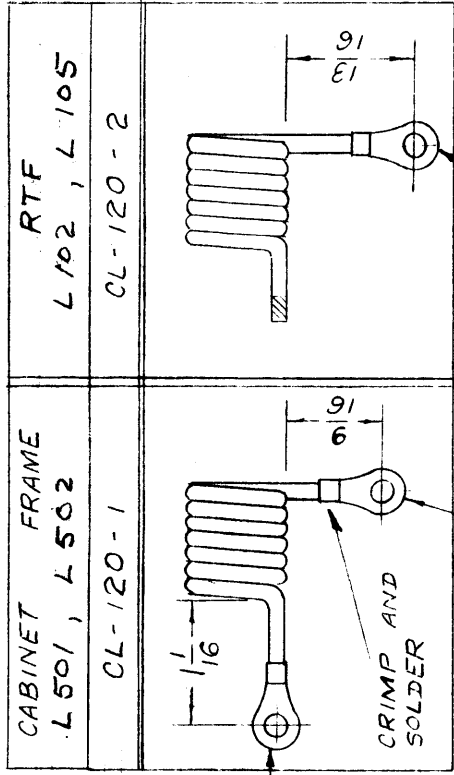
SPECIFICATIONS -

- L - 2 mhy ± .1 mhy
- Q - 200 OR GREATER
- F - 7.9 M.C.



SET UP -

TOUCH SOLDER LIGHTLY TO EACH SUPPORT FOR MEASUREMENTS



REQ. CHART	3	TE-141-3	TERMINAL, LUG.	SYMBOL	
X	2	BS-100	SOLDER, SOFT		
X	1	WI-122-10	WIRE, MAGNET		
REQ. ITEM		PART NO.	DESCRIPTION		
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
MATERIAL			INDUCTOR, CHOKE		
			L102, 5 L501, 2 GPT-150		
			CSD		
			AND		
TYPE & TEMPER			HEAT TREAT. SPEC.	DRAWN	CHECKED
			A.J.J.		
			FINAL APPROVAL		
FINISH & SPEC. NO.			ELEC. DES. APP. MECH. DES. APP.		
			CL-120 C		

DATE

ASSY. NO.

PROJECT NO.

USED ON

REQ. PER UNIT

APPROVED

TMC NO.	NOM. IND. Hy.	INDUCTANCE BETWEEN TERM. 1 & 2 or 2 & 3	Q at 1 Kc MUST BE GREATER THAN	ITEM # 1	ITEM # 2	APPROX. TURNS BETWEEN TERM.		APPROX. LOAD TURNS BETWEEN TERMINALS	
						1 & 2	2 & 3	1 & 2	2 & 3
CL-125-4R0	4.0	0.99 to 1.01	30	C1-103-8	W1-123-37	2480	2480	155	182
CL-125-2R9	2.9	0.715 to 0.735	30	C1-103-8	W1-123-36	2100	2100	130	152
CL-125-OR96	.96	0.235 to 0.245	30	C1-103-8	W1-123-34	1215	1215	76	88
CL-125-OR5	.50	0.124 to 0.126	30	C1-103-8	W1-123-33	875	875	55	64

PROCEDURE

1. Wind required No. of turns between terminals 1 & 2.
2. Bake for 1/2 hour at 215 degrees F.
3. Submerge hot coil in GL-110. (item 5)
4. Measure inductance, using inductance bridge General Radio Model 650A. Remove necessary turns until inductance complies with above chart.
5. Wind required No. of turns between terminals 2 & 3.
6. Bake for 1/2 hour at 215 degrees F.
Note: Temp. must not be lower than 212 degrees F. and not higher than 220 degrees F.
7. Submerge hot coil in GL-110. (item 5)
8. Repeat step No. 4.
9. Tape item 3 to coil with item 6, as shown.
10. Cool coil for 1 hour at room temp. Remove 1 in. of enamel insulation as shown. Submerge coil in GL-110 (item 5)
Note: Final dip must not exceed two seconds.

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CL-125-4R0

TMC NO. _____ INDUCTANCE (hy.) _____

Note - Letter "R", if used, shall indicate decimal point.
(Example - CL-125-4R0 = 4.0 hy)

See Chart

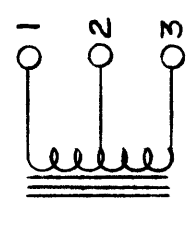
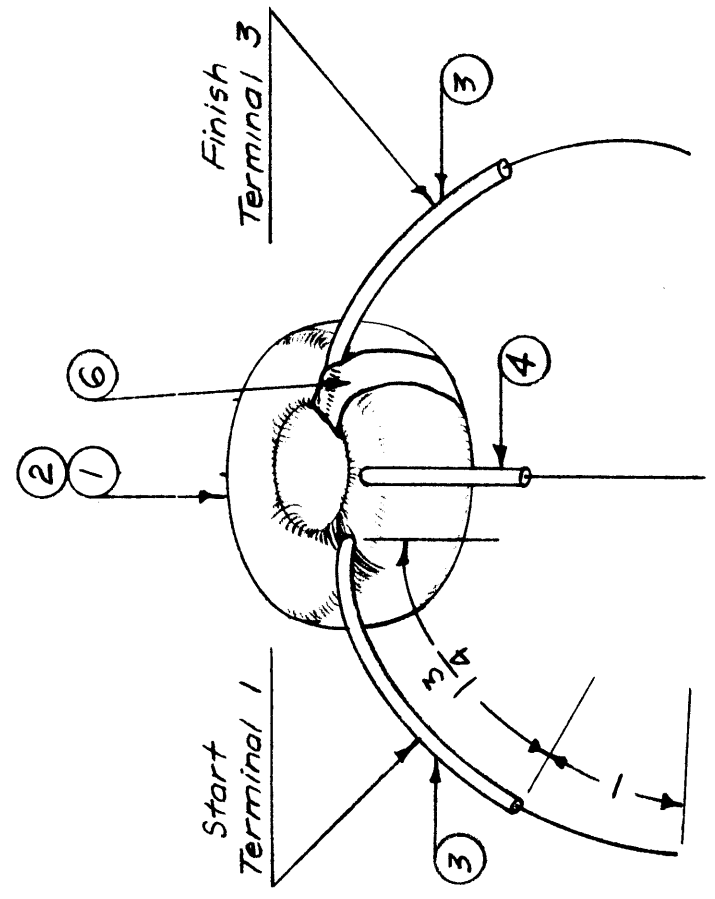
ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

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

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

REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE

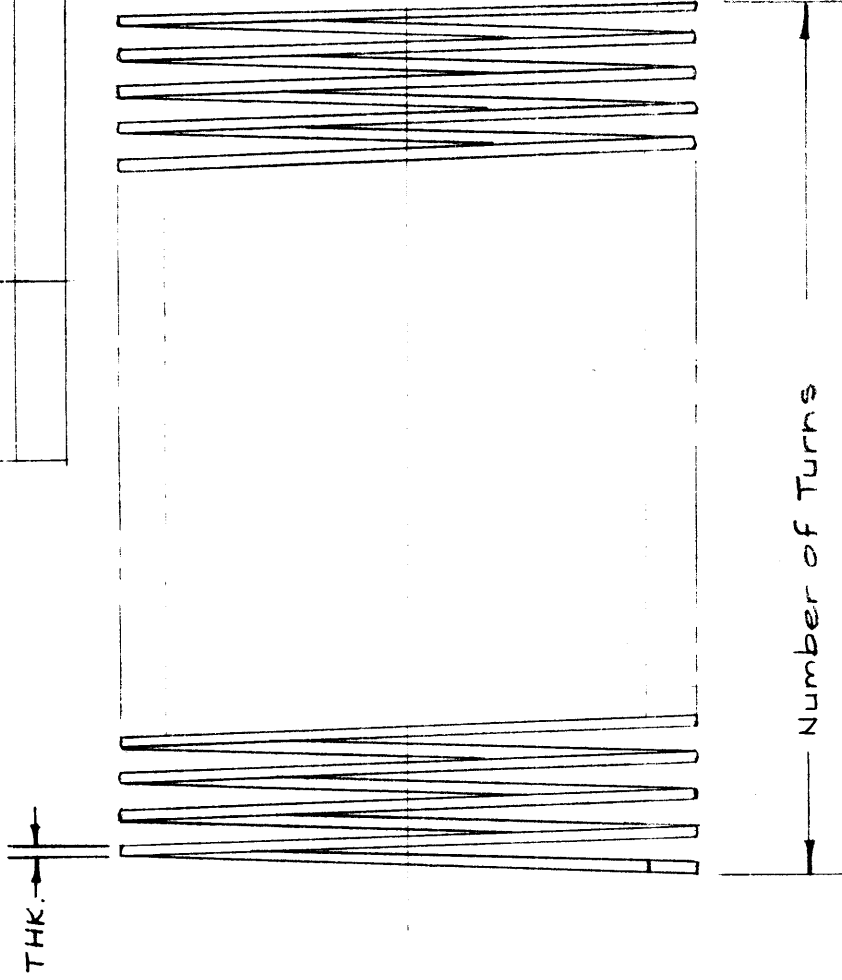
USED ON



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 6	TA-102-2	Tape, Paper	
X 5	GL-110	Compound, Potting	
2" 4	PX-104-1-.022	Insulation, Sleeving	BIK.
4" 3	PX-104-2-.022	Insulation, Sleeving	Yel.
X 2	W1-	Wire, Magnet	
X 1	C1-	Core, Toroid	
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		TRANSFORMER, A.F.	
		TOROIDAL	
		62-11-57	A. J. J.
		ANDR	FINAL APPROVAL
		CHECKED	
		WIP	CL-125
		ELEC. DES. APP.	
		MECH. DES. APP.	

STANDARD DRAWING

FINISH CHART	
CODE	FINISH
R	NO FINISH
S	Silver Plate S245 SILVER-KOTE IRIDIUM, S423



TMC NO.	O.D. (in.)	I.D. (in.)	THK.
CL-133-1	3	2-1/2	.056
CL-133-2	3	2-1/2	.125
CL-133-3	3	2-1/2	.054
CL-133-4	6 1/2	5-1/2	.091
CL-133-5	3 1/2	3	.054
CL-133-6	3-3/4	3	.072
CL-133-7			
CL-133-8			
CL-133-9			
CL-133-10			
CL-133-11			
CL-133-12			

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MAMARONECK, NEW YORK

Type Designation to be as follows:

CL-133-1 R 24 CW

NOTES:
 1. DETERMINING DIRECTION OF TURNS:
 COUNTER CLOCKWISE - A direction which, when viewed axially (from either end), winds in a clockwise and receding (away from viewer) direction.
 COUNTER CLOCKWISE - A direction which, when viewed axially winds in a counterclockwise and receding direction.

TMC DWG NO. FINISH NO. OF TURNS DIRECTION OF TURNS
 & SIZE CODE (see chart) REQ. (SEE NOTE 1)
 (See chart) CW = Clockwise
 CC = Counter-Clockwise

Example - CL-133-1R25.50CC = Coil, RF; Size 1; No Finish; 25 1/2 Turns; Counter Clockwise Direction.

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
F	ADDED - G	5/8/72	21070	CS		
E	CL-133-4 WAS 125 THK (NO LONGER AVAILABLE)	6/20/72	20748	GE	g	g
D	ADD S401-47	4/28/72	20649	GE	g	g
C	-5 ADDED	4/10/70	19809	CV		
B	S423 ADDED TO S. 2, 4, 5	9/9/65	14531	hvk		
A	ADDED TO CHART	4-27-65	13951	hvk		

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

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

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		COPPER	
SOFT DRAWN		MATERIAL	
TYPE & TEMPER	HEAT TREAT. SPEC	DRAWN	CHECKED
SEE CHART		6/20/58	hvk
FINISH & SPEC. NO.			FINAL APPROVAL
			A.J.J.
			CL-133
			F

S401-47

TMC NO.	ITEM NO. (WIRE)	TOTAL NO. OF TURNS	INDUCTANCE (MHV)		TEST FREQ. (MCS)	Q AT TEST FREQ. MUST BE MORE THAN	COLOR CODE	QUAN. PER UNIT	SCHEMATIC SYMBOL	OPER. FREQ. (MCS)
			MIN. MUST BE LESS THAN	MAX. MUST BE MORE THAN						
CL-135-1	WI-104-541D5Q5	40	28	39	2.5	50	Black	1	L	2-4
CL-135-2	WI-107-15	22	4.5	7.2	7.9	80	Brown	1	L	4-8
CL-135-3	WI-107-5	12	1.4	1.8	7.9	80	Red	1	L	8-16

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 6	B5-100	Solder, Soft	
X 5	GL-104-2	Insulex, L-85	
X 4	GL-102	Cement, Q-Max	
X 3	See Chart	Wire	
2	TE-153-2	Terminal, Ring Type	
1	CF-107-2N	Coil Form	

DEC. DIM. ±	FRAC. DIM. ±	ANGULAR DIM. ±	TYPE & TEMPER.	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL
					6/24/58	Use	A. J. J.
					guy		
							CL-135

REVISION	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	3/8 to start of winding was 7/16	5/26/58	1			Use

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

WINDING MACHINE DATA

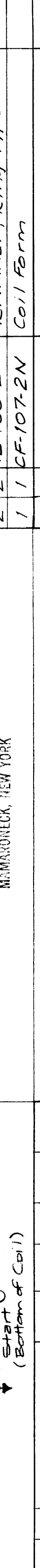
CL-135-1 will use a .125 Cam, 49 Cam Gear, and 95 Driver.

CL-135-2 & 3 will be close wound, single layer.

PROCEDURE

1. Secure terminals (item 2) to coil form with Insulex (item 5).
2. Wind required number of turns of item 3 (wire) on coil form as per chart above.
3. Stake wire ends to coil form with Q-Max (item 4).
4. Solder coil leads to terminals.
5. Bake for 1/2 hour at 210°F.
6. Paint coil with Insulex (item 5).
7. Test unit as per chart and schematic with core. Minimum & Maximum inductance accomplished by adjusting tuning slug.

(Use Beonten Q-Meter Model 160A or Equiv.)



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INDUCTANCE (MHV)		TEST FREQ. (MCS)	Q AT TEST FREQ. MUST BE MORE THAN	COLOR CODE	QUAN. PER UNIT	SCHEMATIC SYMBOL	OPER. FREQ. (MCS)
MIN. MUST BE LESS THAN	MAX. MUST BE MORE THAN						
28	39	2.5	50	Black	1	L	2-4
4.5	7.2	7.9	80	Brown	1	L	4-8
1.4	1.8	7.9	80	Red	1	L	8-16

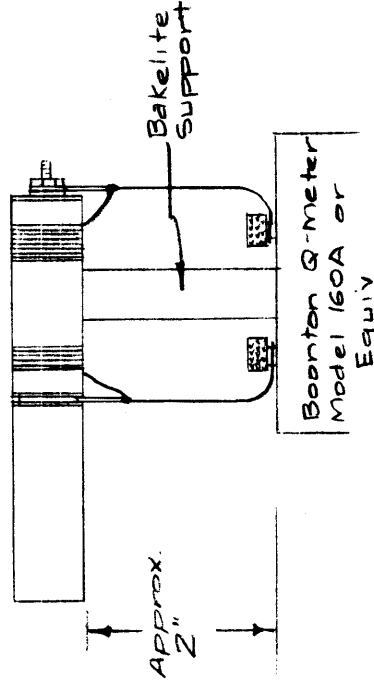
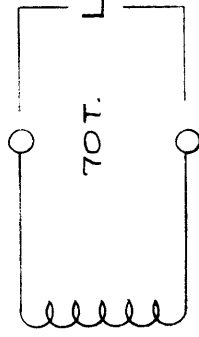
PROCEDURE

1. Assemble Insulators and all Hardware tightly together. Threaded Studs (item 6) 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.

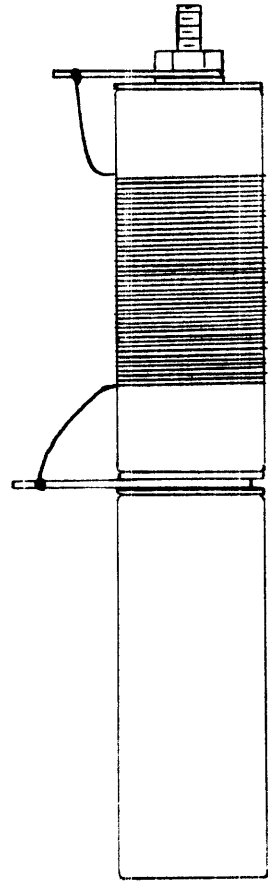
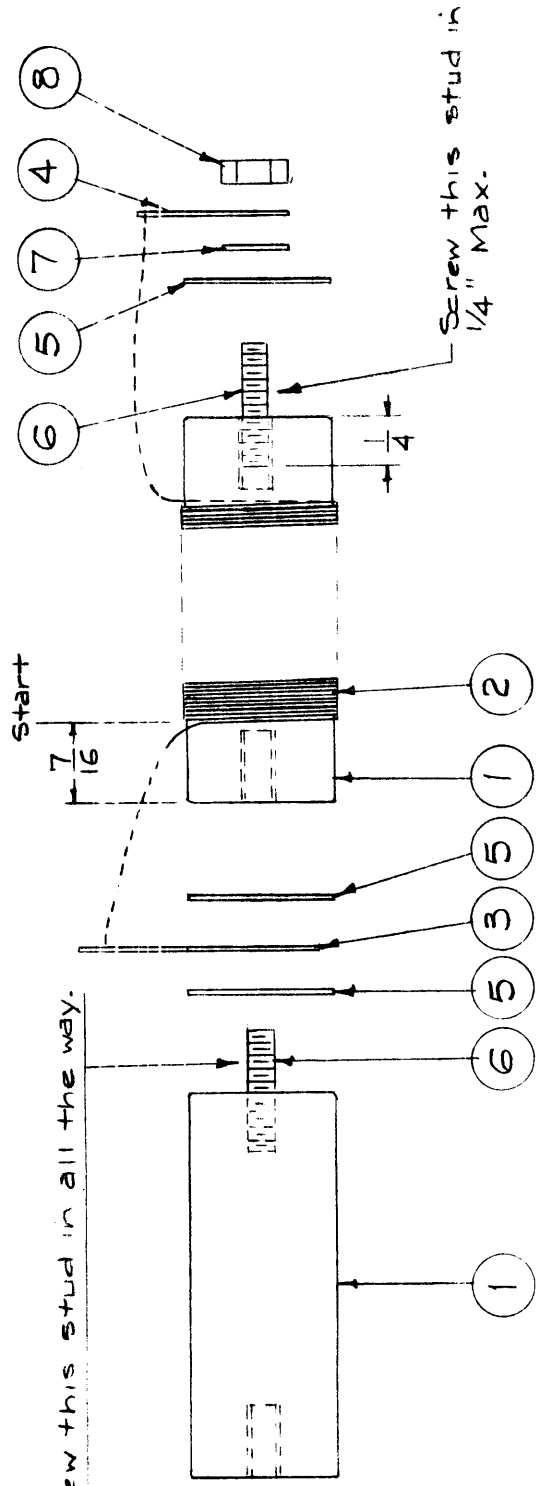
Note: It is only necessary to test one coil per batch of 50.
For the one tested coil, solder 4" leads to terminal lugs.

TEST DATA

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



Screw this stud in all the way.



FULL SCALE ASS'Y.

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REQ. PER UNIT	1	MODEL	RFA-1	PROJECT NO.	PAL-350	ASSY. NO.	L 212	DATE	5-26-58
---------------	---	-------	-------	-------------	---------	-----------	-------	------	---------

USED ON

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

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	
1	NTH1032BC10	Nut, Hex.	
1	FW10HBC	Washer, Flat	
2	SC-127-3	Stud, Threaded (11/16 Long)	
3	WA-109-56	Washer, Fibre	
1	TE-104-4	Terminal, Locking	
1	TE-162	Lug, Solder	
X 2	WI-125-12	Wire, Magnet, Ceroc "T" (#27)	
2	NS3W0316	Insulator, Pillar, Round	
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
COIL, RF, PA PLATE (L 212)			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
		6/26/58	AWJ
FINISH & SPEC. NO.		ELEC. DES. APP. MECH. DES. APP.	
		CL-137	
		FINAL APPROVAL	

PROCEDURE

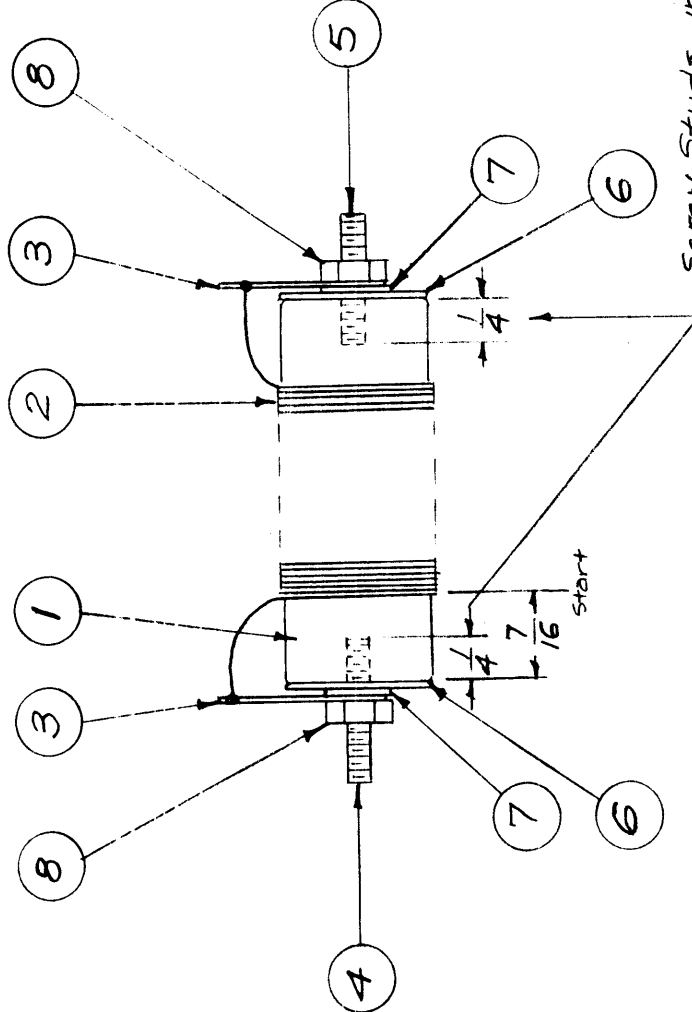
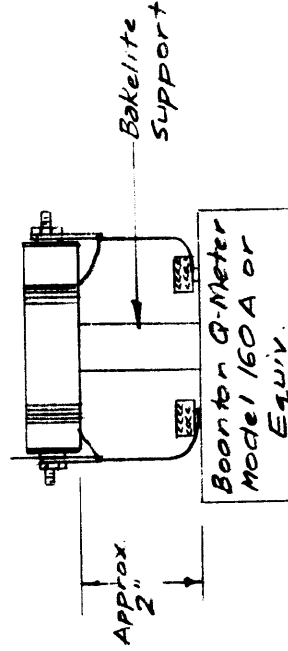
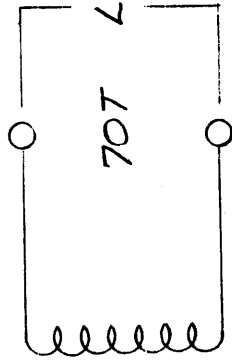
1. Assemble Insulator and all Hardware tightly together. Threaded Studs must be inserted as shown.
2. Wind 70 turns of item 2 (wire) on insulator as shown.
3. Stake wire ends to insulator body with item 9 (Q-Max.), and solder ends to lugs.
4. Coat Winding with item 10 (Insulex).
5. Bake for 1 hour at 2500 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 1/4" leads to terminal lugs.

TEST DATA

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



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X	11	BS-100	SOLDER, SOFT
X	10	GL-104-2	INSULEX, U-85
X	9	GL-102	CEMENT, Q-MAX.
2	8	NTH1032BC10	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
REQ. ITEM		PART NO.	DESCRIPTION
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
MATERIAL			
COIL, RF, PA OUTPUT (L207)			
DRAWN: H.S./29/58			
CHECKED: J.D.			
FINAL APPROVAL: J.S.J.			
CL-138			

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

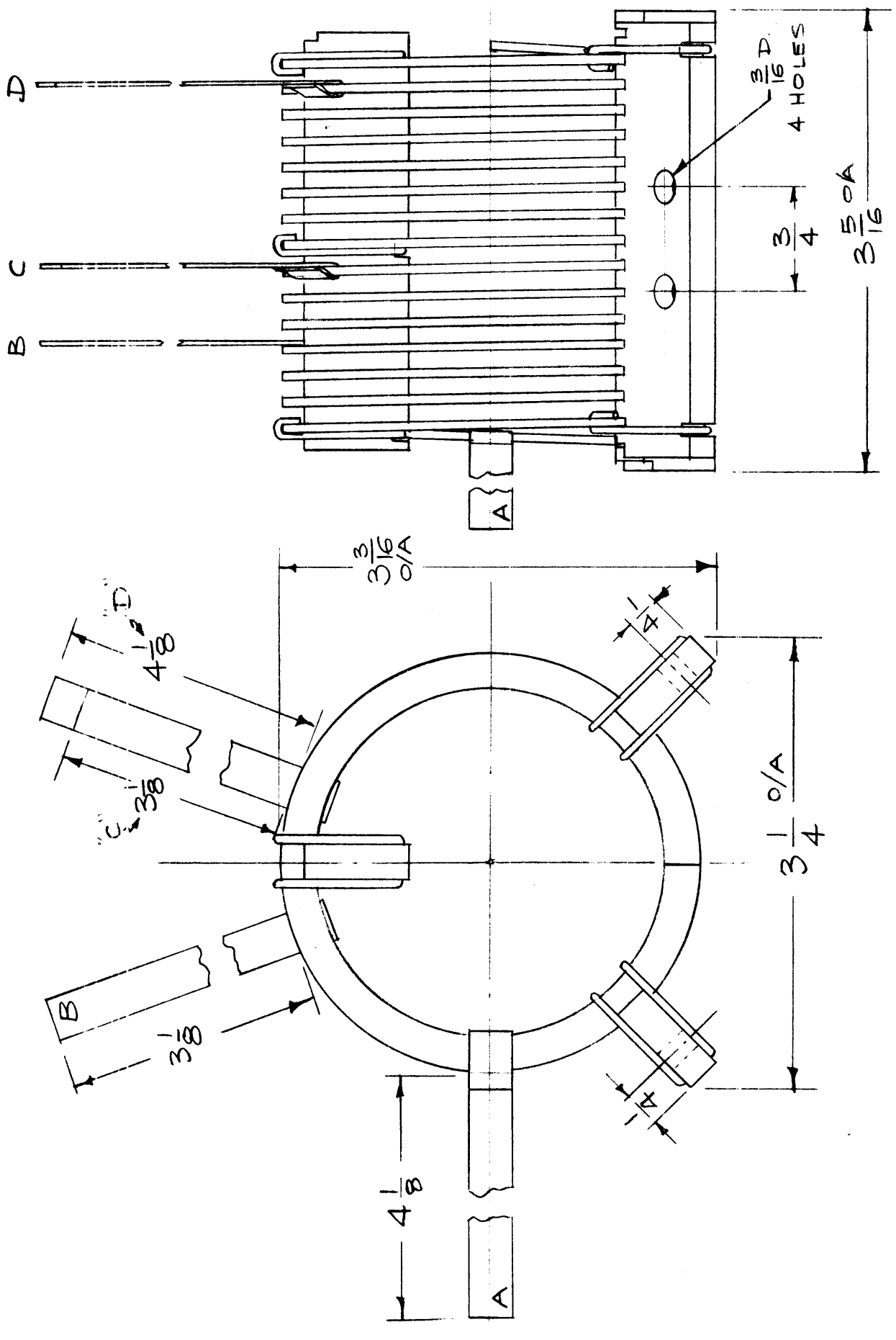
TOLERANCES
 DEC. DIM. ±
 FRAC. DIM. ±
 ANGULAR DIM. ±

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

CL-142

ELECTRICAL SPEC.
 INDUCTANCE (TOTAL) - 10.9 μHY.

MECHANICAL SPEC.
 COIL ID - 2 1/2" } 15 1/4 TURNS
 COIL OD - 3" }
 TAP STRAPS - 5/16 Wide x .025 Thick
 COPPER STRIPS.
 FINISH - COIL & STRAPS - SILVER PLATE
 SUPPORT BARS - GLASS BONDED MICA



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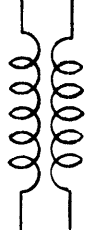
REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
	STOCK SIZE	COIL, RF, FIXED, 10.9 μHY	
	MATERIAL		
	DATE	16 ¹⁰ /1959	
	DRAWN	ASD	
	CHECKED	ASB	
	HEAT TREAT. SPEC.		
	FINISH & SPEC. NO.		CL-142
	TYPE & TEMPER		
	ELEC. DES. APP.		
	MECH. DES. APP.		

REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
	AC-100	RFB-1	A-1618	10-19-59
	USED ON			

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES						
SCALE: 4A1656						
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURNS AND SHARP EDGES						
DEC. DIM. ±						
FRAC. DIM. ±						
ANGULAR DIM. ±						

CL-160
B

No. 10 Screw Clearance Hole

ELECTRICAL SPEC.
 INDUCTANCE - $5 \mu\text{hy} \pm 10\%$ each coil

 SCHEMATIC

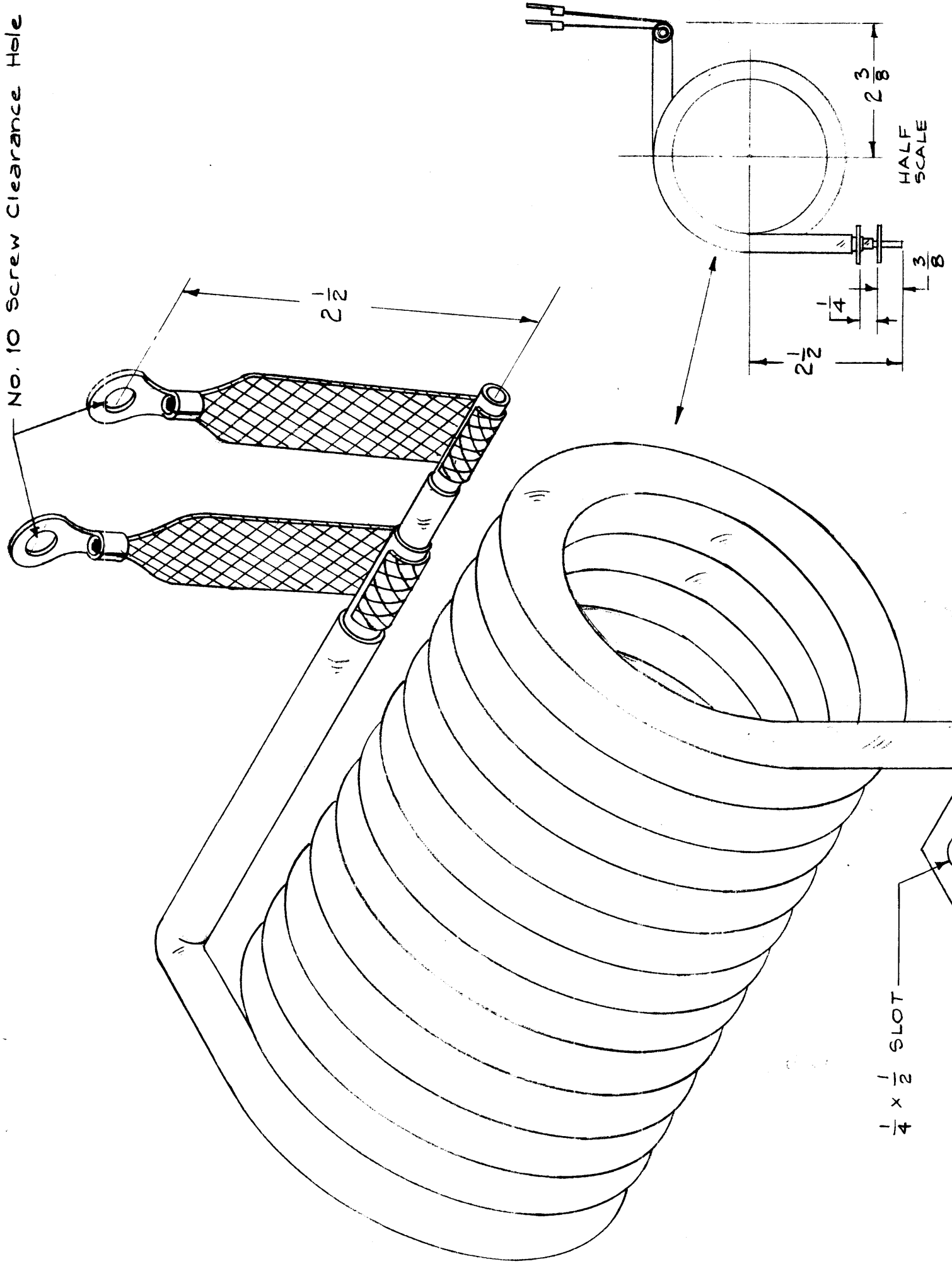
NOTE - Inside Coil completely Insulated from Outside Coil.

MECHANICAL SPEC.
 COIL I.D. - $2 \frac{1}{2}$ "
 COIL O.D. - $3 \frac{1}{4}$ "
 O/A LENGTH - $6 \frac{1}{2}$ " $\pm \frac{1}{4}$ "
 ALL DIMENSIONS ARE FOR REFERENCE UNLESS OTHERWISE NOTED.

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ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
		7-11-67	18394	LAK	JL	GM
		9/29/66	16925	JL	GM	GM

DELETED 11/6/64; ADDED REF. DIM. NOTE.

TOLERANCES
 DIM. \pm
 DIM. \pm
 OR DIM. \pm

SCALE: 4-A-1662

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

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
	STOCK SIZE		
	MATERIAL	COIL, PA FILAMENT (L915)	
	TYPE & TEMPER	HEAT TREAT. SPEC.	
	DATE	DRAWN	FINAL APPROVAL
		16 4/12/59	GM
		GG.	CL-160
	FINISH & SPEC. NO.	ELEC. DES. APP. MECH. DES. APP.	B

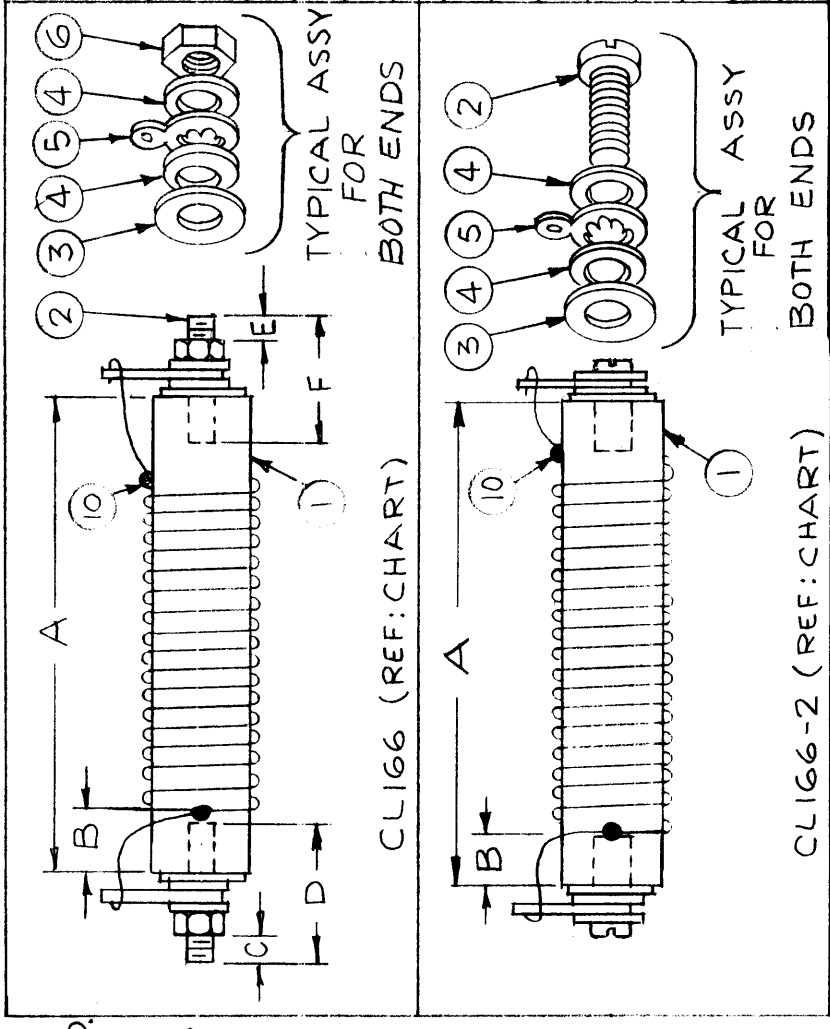
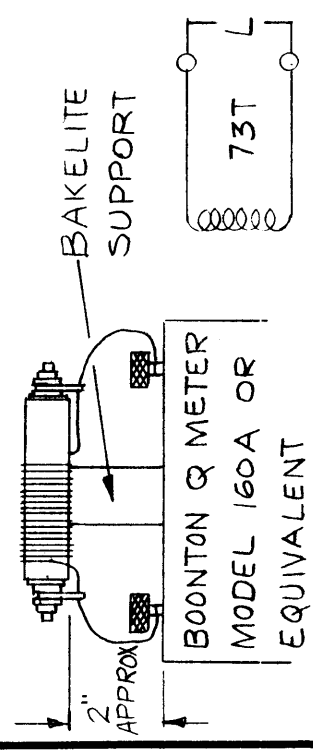
REQ. PER UNIT	MODEL	PROJECT NO.	DATE
1	GPT-10K	AX-137	4-12-59
		ASSY. NO.	
		USED ON	

TMC P/N	A	B	C	D	E	F	ITEM 1	ITEM 2	ITEM 6
CL166	5	5/8	3/8	1-1/4	3/8	1-1/4	NS3W0440	SM2520BNI.250	NTH2520BNI4
CL166-2	4	1/8	N/A	N/A	N/A	N/A	NS3W0432	SCBP2520BNI4	N/A

ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	A	COMPLETELY REV. & REDRAWN CL166-2 ADDED	6/4/68	18923	ARJ		FB

- WINDING**
70 TURNS CLOSE WOUND OF (ITEM 7) WI125-2
- FABRICATION**
- 1-ASSEMBLE ITEM 2 INTO INSULATOR (ITEM 1)
 - 2-ASSEMBLE ITEM 3,4,5,4 IN ORDER, AS SHOWN, AND SECURE TIGHTLY.
 - 3-WIND 70 TURNS OF WIRE (ITEM 7) ON INSULATOR (ITEM 1), START "B" FROM END.
 - 4-STAKE WIRE TO INSULATOR BODY WITH (ITEM 10) AND SOLDER ENDS TO (ITEM 5).
 - 5-COAT WINDING WITH (ITEM 9) INSULEX
 - 6-BAKE FOR 1 HR AT 250°F
 - 7-ALLOW UNIT TO COOL
 - 8-TEST AS SHOWN

TEST DATA
L - 35 μ hy \pm 3 μ hy
Q - 180 OR GREATER
F - 2.5 mc



1	GPT-10K	ANT. TUNER
QTY / UNIT	MODEL USED ON	ASSY NO.
APPLICATION		
CODE		
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REQD ITEM	PART NUMBER	DESCRIPTION	SYM.
X 10	GL125	CEMENT, EPOXY	
X 9	GL104-2	INSULEX, U-85	
X 8	BS100	SOLDER, SOFT	
X 7	WI125-2	WIRE, MAGNET, CEROC "T"	
2 6	SEE CHART	NUT, HEXAGON, DOUBLE CHAMFER	
2 5	TE104-5	TERMINAL, LOCKING	
4 4	FW25HBN	WASHER, FLAT	
2 3	WA109-55	WASHER, FIBRE	
2 2	SEE CHART	ROD, THREADED	
1 1	SEE CHART	INSULATOR, PILLAR ROUND	

FINAL APPROVAL	DATE	MECH. DES.	DATE	ELECT. DES.	DATE	CHECKED	DATE	DRAWN	DATE
AR.B.				J.G.		J.D.E.		J.C.BIELE	4.28.59

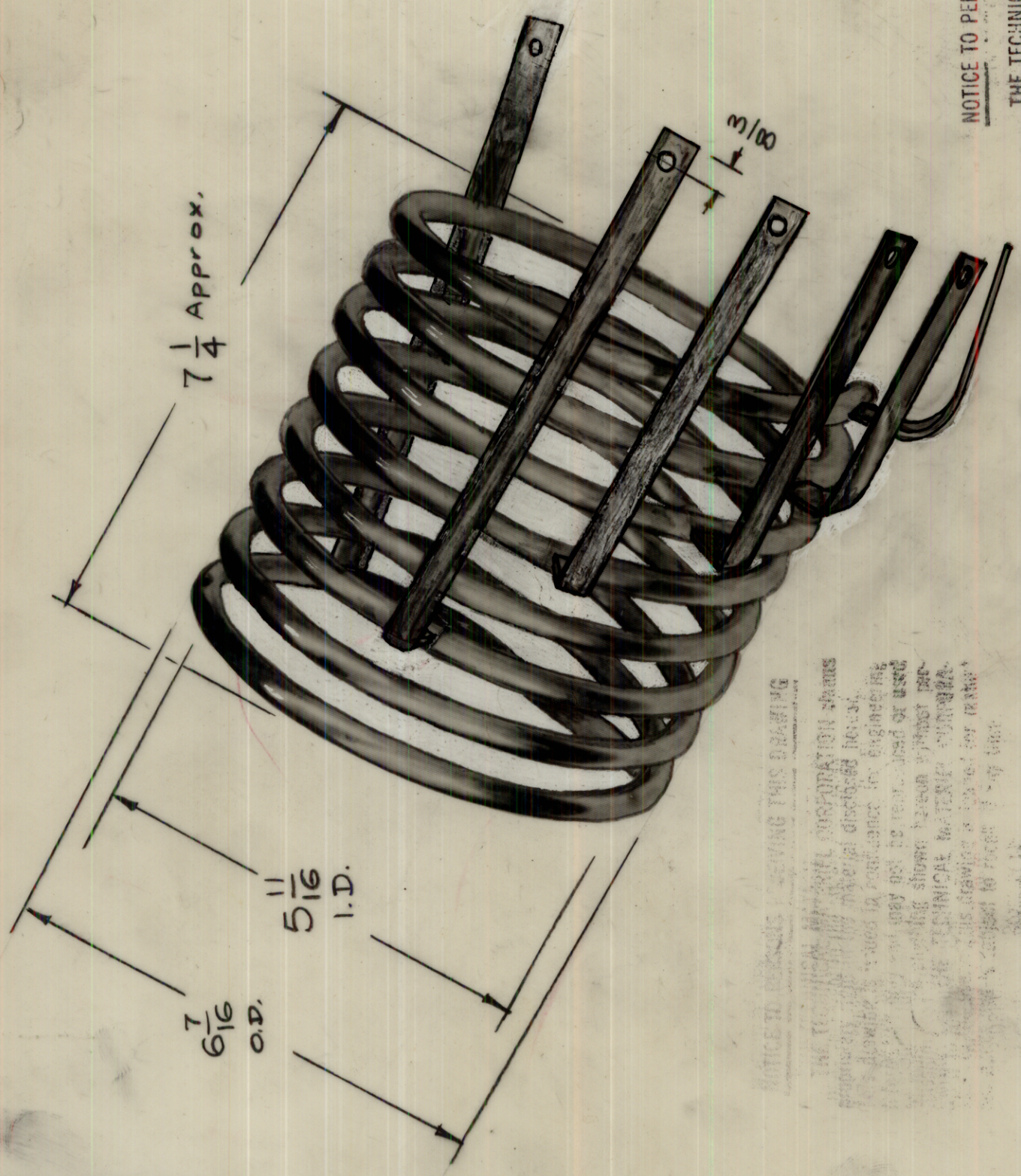
THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

STATIC CHOKE, ASSEMBLY

SIZE **B** CODE IDENT. NO. **82679** DWG NO. **CL166** ISSUE **A**

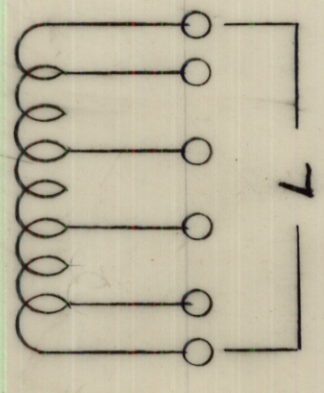
LIST OF MATERIAL

CL-168 A



ELECT. SPECS.
 L- 7 microhenries
 Q- 400 or Greater
 F (Test)-7.9
 Operating Freq. - 4 to 28 MCS

MECH. SPECS.
 COIL- 3/8 O.D. COPPER TUBING
 TAPS- 1/8 x 1/2 STRAP
 FINISH- SILVER PLATE



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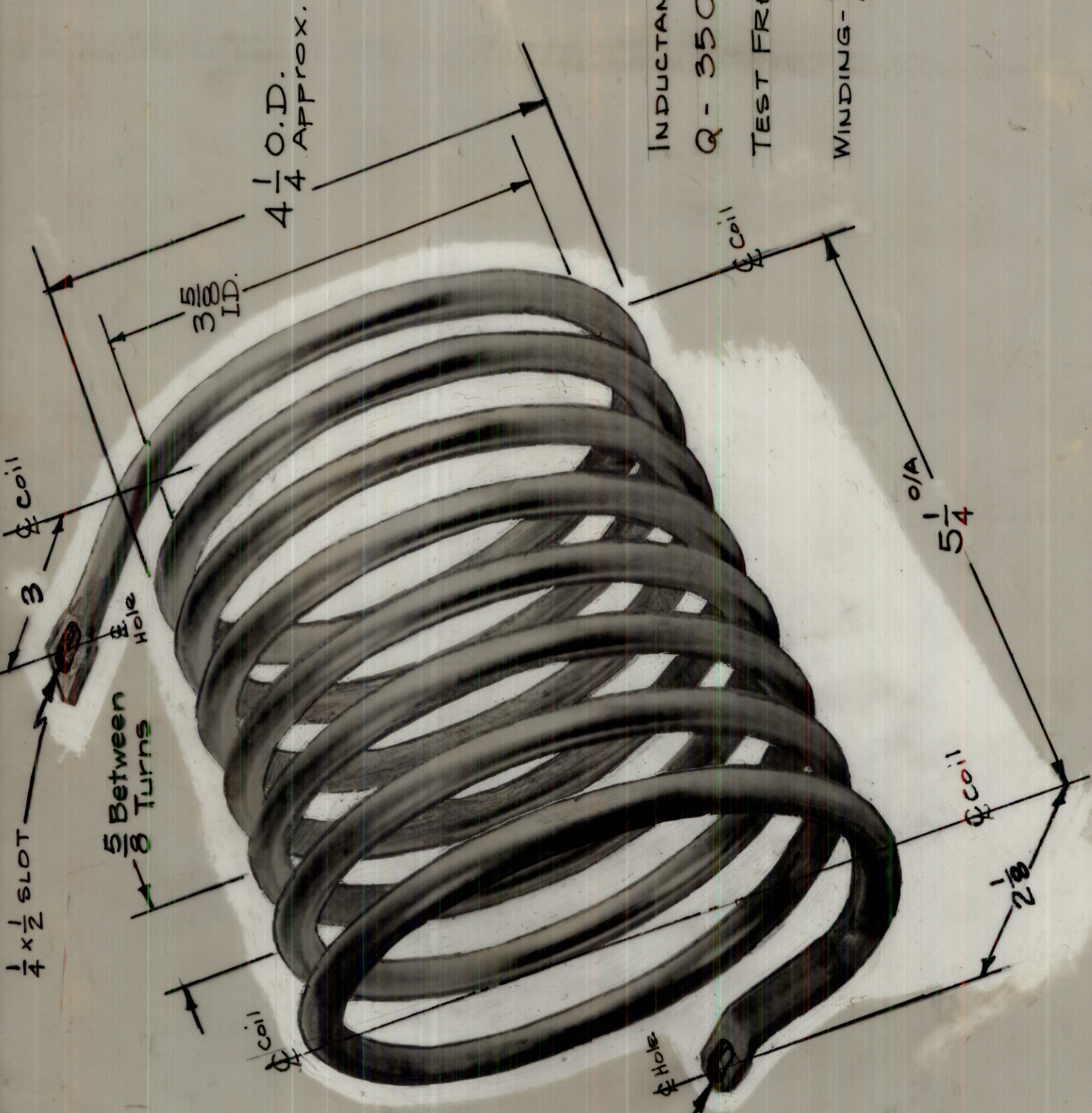
Property of:
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ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A 1	Taps changed from tubing to straps	7/26/60	2675	DJM	J. De...	[Signature]
TOLERANCES						
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES						
DEC. DIM. ±						
FRAC. DIM. ±						
ANGULAR DIM. ±						

REQ. PER UNIT	1	PROJECT NO.	AS-102	DATE	12-7-59
MODEL	GPT-10K	ASSY. NO.			
USED ON					

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		COIL, FINAL RF	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
		16 12/7/59	J. De... [Signature]
FINISH & SPEC. NO.		ELEC. DES. APP. MECH. DES. APP.	FINAL APPROVAL
			CL-168 A

CL-169



$\frac{7}{32} \times \frac{3}{4}$ SLOT

INDUCTANCE - 2.5 μ hy.
 Q - 350 or Greater
 TEST FREQ. - 7.9 MC

WINDING - $\frac{5}{16}$ D. Copper Tubing,
 Silver Plated
 7 1/2 TURNS

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Property of:

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ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES						
DEC. DIM. \pm						
FRAC. DIM. \pm						
ANGULAR DIM. \pm						

SCALE: -H-
 NO NPL 4A1733
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		COIL; RF, FIXED	
		MATERIAL	
		STOCK SIZE	
		HEAT TREAT. SPEC.	
		TYPE & TEMPER	
		FINISH & SPEC. NO.	

REQ. PER UNIT	PROJECT NO.	ASS'Y. NO.	DATE
1	AC-102	GPT-10K (AT-100)	10-14-59

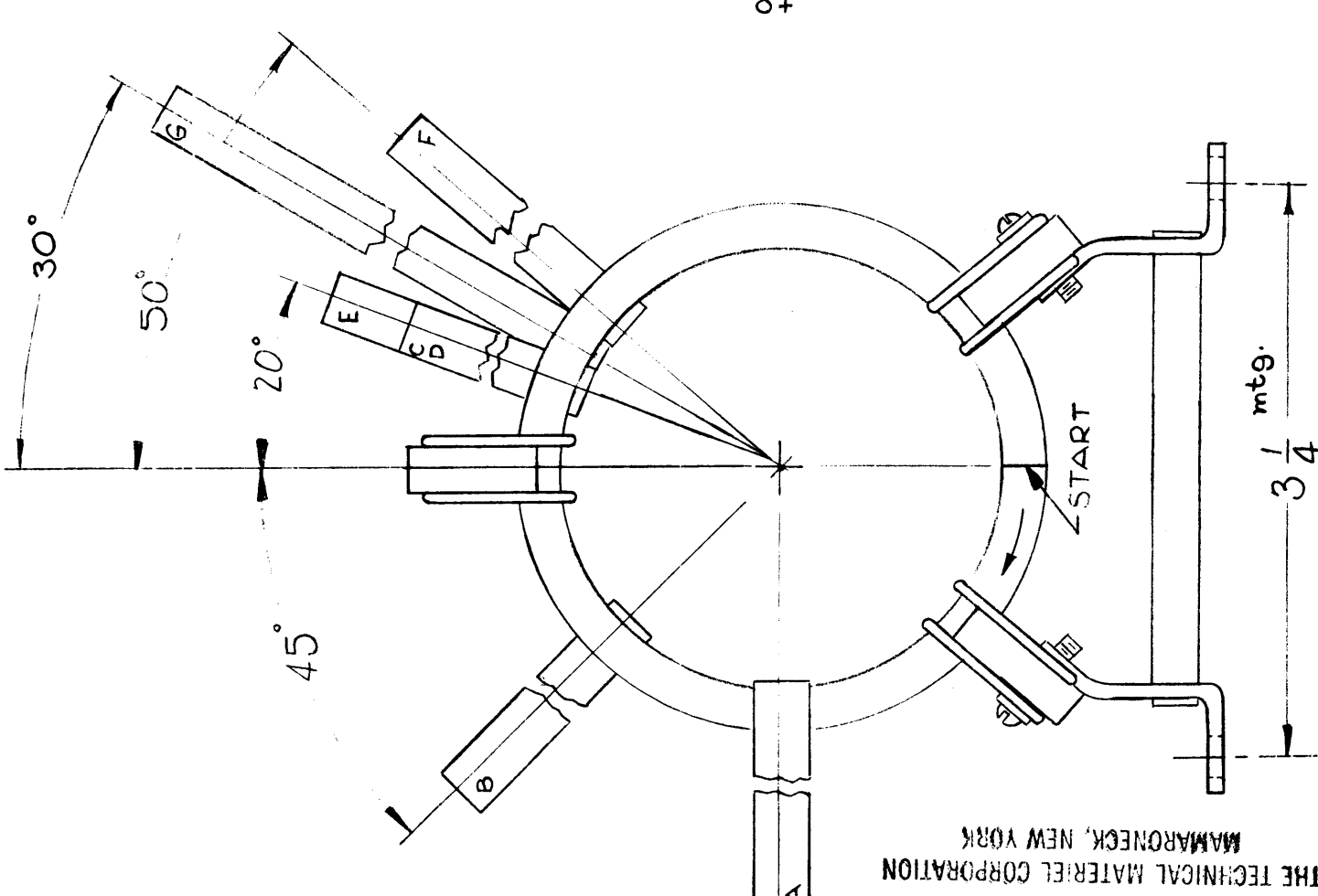
16^{19/14/59}
 DRAWN: [Signature]
 CHECKED: [Signature]
 ELEC. DES. APP. [Signature]
 MECH. DES. APP. [Signature]
 FINAL APPROVAL: [Signature]
 CL-169

CL-174 G

NOTICE TO PERSONS RECEIVING THIS DRAWING

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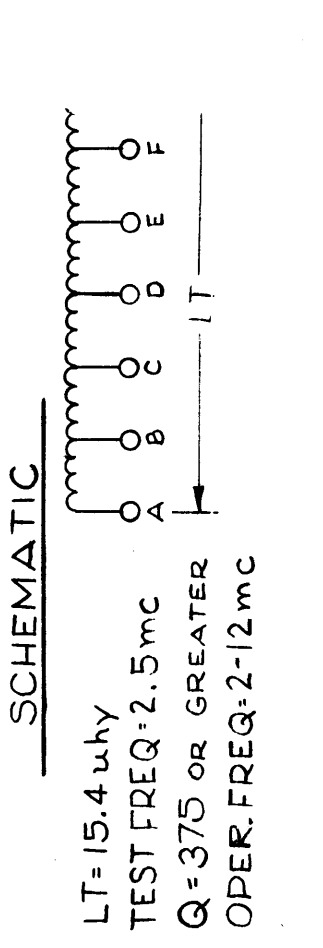


SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
G	DIM: 4 3/16 +0 -1/8, WAS 4 3/16 +0 -1/16	8-9-66	16718	RME		
	CHG'D DIM. FR. 4 5/32 TO 4 5/8	8-26-64	12233	ASB		
F	DIM: 4 3/16 +0 -1/8, WAS 4 5/16 ± 1/16	10-23-62	7434	ASB		
E	4-25/32 DIM WAS 4-5/8	5-15-62	6712	FE		
D	DIRECTION OF WINDING CLARIFIED	4-26-62	6507	FE		
C	TURN NOTATIONS CLARIFIED	4-4-62	6588	FE		
B	PICTORIAL CLARIFIED	7-25-61	5310	RZ		
A	4-5/16 DIM WAS 4-5/8					
	BAR #3 (TOP BAR) REVERSED					
	SCALE: 4 A-1727					
	UNLESS OTHERWISE SPECIFIED:					
	DIMENSIONS ARE IN INCHES					
	TOLERANCES ON FRACTIONS ± 1/64					
	DECIMALS ± .005					
	ANGLES ± 1/20					
	REMOVE ALL BURRS AND SHARP EDGES					
	WILL BE CAUSE FOR REJECTION.					
	BEEN DETERMINED AND ANY DEVIATIONS					
	HAVE					

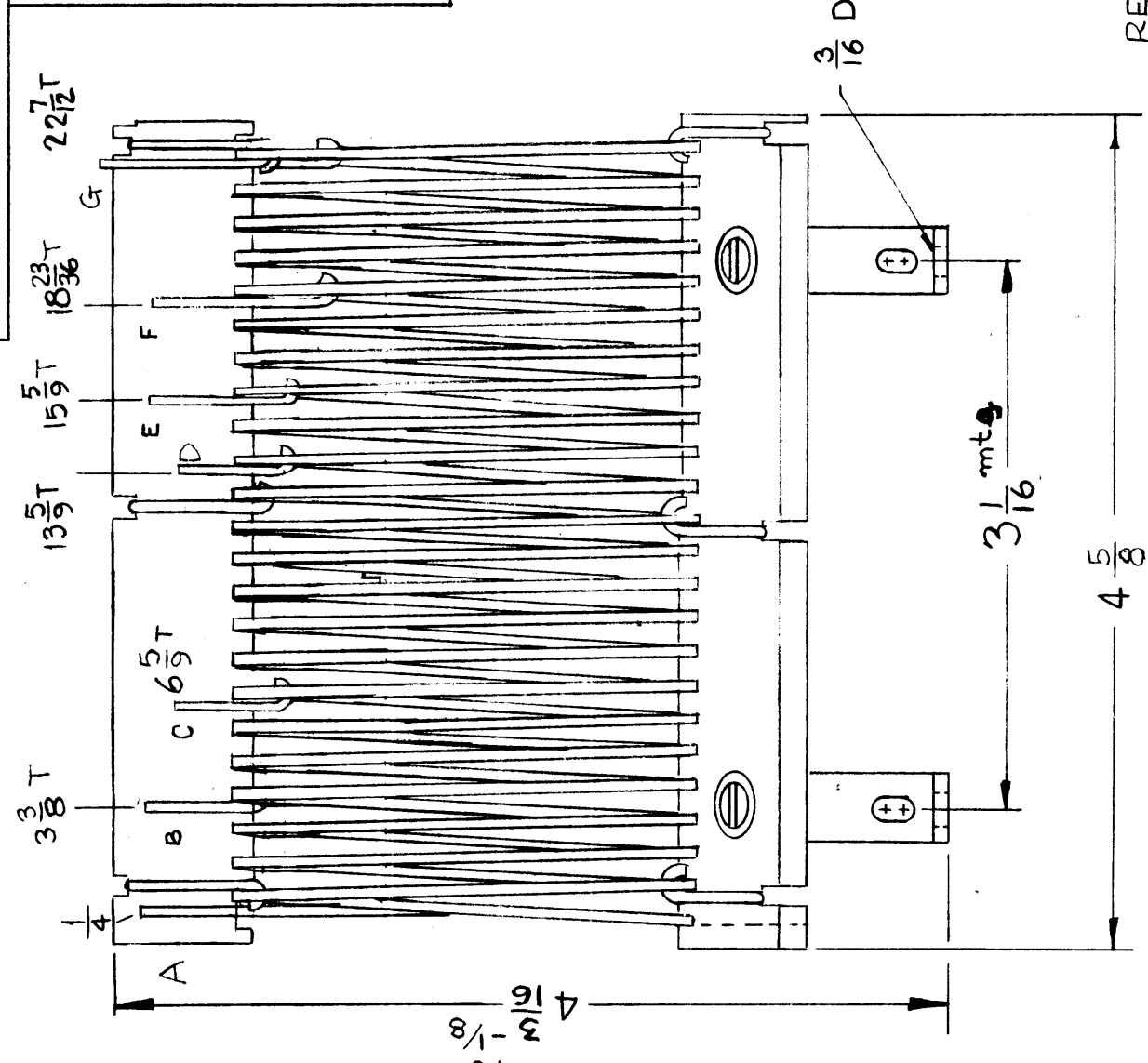
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

DATE: 4 A-1727
 SCALE: 4 A-1727
 UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN INCHES
 TOLERANCES ON FRACTIONS ± 1/64
 DECIMALS ± .005
 ANGLES ± 1/20
 REMOVE ALL BURRS AND SHARP EDGES
 WILL BE CAUSE FOR REJECTION.
 BEEN DETERMINED AND ANY DEVIATIONS
 HAVE

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SPECIFICATIONS
 COIL ~ 3" O.D. x 2 1/2" I.D. COPPER STRIP, 23 TURNS C.W
 STRAPS ~ 5/16" WIDE x .025" THICK COPPER STRIPS
 SUPPORT BARS ~ GLASS BONDED MICA.
 FINISH ~ SILVER PLATE



REF ~ EF JOHNSON CO.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
SEE SPEC.	SEE SPEC.	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
SEE SPEC.	SEE SPEC.	TRANSFORMER, RF, FIXED, 2-12 MC	
		MATERIAL	
		HEAT TREAT. SPEC.	
		TYPE & TEMPER	
		FINISH & SPEC. NO.	
		ELEC. DES. APP. MECH. DES. APP.	
		CHECKER	
		DRAWN	
		FINAL APPROVAL	

REQ. PER UNIT	MODEL	SECTION	ASSY. NO.	DATE
1	RFD-1	PAL-1K		12-27-60

USED ON