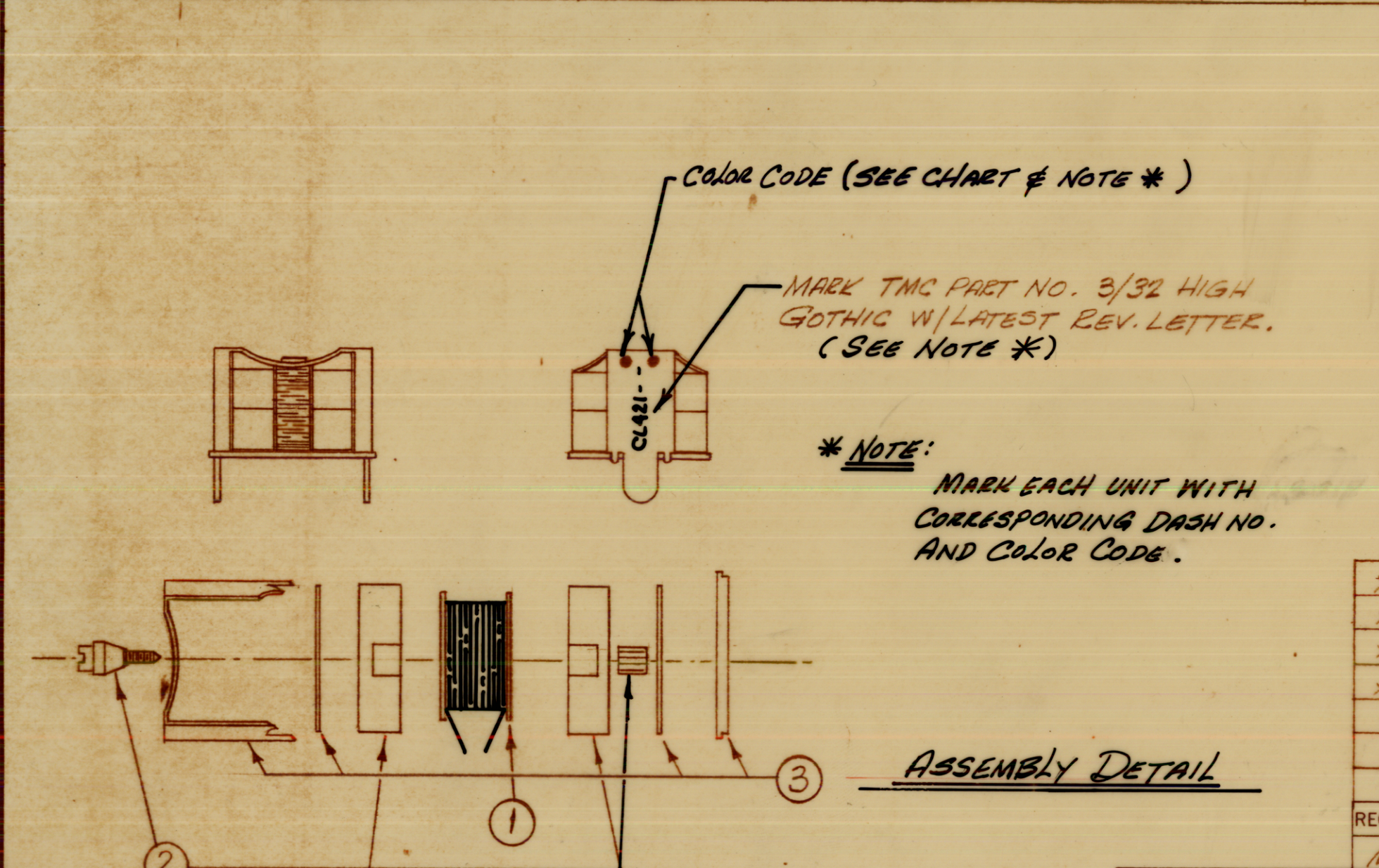


TMC PART NO.	SYMBOL	NO. OF TURNS	TEST FREQUENCY						DISTR. CAP.	COLOR CODE	BAND	REQ.
			L1 ± 1%									
			L1	F	L			Q				
		SET	MIN	MAX								
CL421-1	L1,2,3	35	10KC	194 μH	181.0	201.7	60	0.180	10pF	—	1	3
CL421-2	L1,2,3	46	10KC	348.8 μH	345.0	381.2	60	0.3740	17.3pF	—	2	3
CL421-3	L1,2,3	35	10KC	200 μH	191.0	210.7	60	0.173	18.6pF	—	3	3

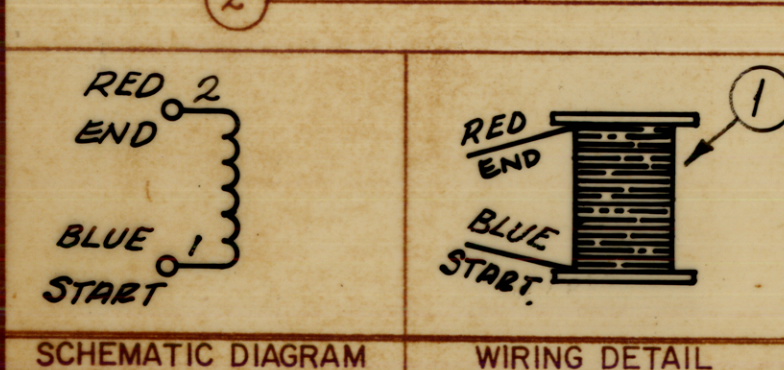
REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
	X	EXP. RELEASE	10-11-67	-	RD	File
	Ø	ORIG. RELEASE FOR PROD.	1-8-68	Ø	R.G.	File



- WINDING PROCEDURE
1. WIND REQ. TURNS (SEE CHART) OF ITEM 4 ON ITEM 1 STAKE WITH ITEM 6.
 2. KEEP ALL LEADS 1-1/2" LONG.
 3. STRIP AND TIN ALL LEADS TO WITHIN 3/4" OF COIL.
 4. COLOR CODE ALL LEADS AS SHOWN IN WIRING DETAIL
 5. BAKE COIL FOR 15 MINUTES AT 150°F. REMOVE FROM OVEN AND COAT WITH ITEM 5.
 6. ASSEMBLE ITEMS 1, 2, 3 AS PER ASSEMBLY DETAIL SHOWN.
 7. BEND THE 4 SMALL TABS DOWN, TOWARD CENTER OF COIL
 8. STAMP TMC P/N AS SHOWN. (SEE CHART)
 9. TEST INDUCTANCE AND "Q" AS SHOWN. SET INDUCTANCE FIRST.
 10. BAKE COMPLETE ASSEMBLY FOR 1 HOUR AT 212°F.
 11. REMOVE COMPLETED ASSEMBLY FROM OVEN AND ALLOW TO COOL TO ROOM TEMPERATURE.
 12. REPEAT STEP # 9.
 13. TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE AS SHOWN.
 14. TEST COIL WITH "Q" METER TYPE 260A
 15. WAX CORE IN PLACE AFTER SETTING.

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
X	7	BS100	SOLDER, TIN ALLOY	
X	6	GL103	ADHESIVE - N-CEL	
X	5	GL130	ADHESIVE - Q-DOPE	
X	4	WI141-26-2	WIRE, ELEC, MAG, T	
1	3	CU158-1	RETAINER, CUP CORE	
1	2	CI137-11	CORE, ADJ TUNING (WHITE)	
1	1	CF135-17	FORM, COIL (BOBBIN TYPE)	

MARTINENGO LIST OF MATERIAL



9	VLRC-1	
QTY / UNIT	MODEL USED ON	ASS'Y NO.
	APPLICATION	
	CODE A	5401-451

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	FINAL APPROVAL	DATE
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	MECH. DES.	DATE
FRACTIONS 1/64 TOLS. ANGLES 0° - 30'	ELECT. DES.	DATE
MATERIAL	CHECKED	DATE
FINISH	DRAWN	DATE

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
COIL, RF, FIXED			
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL421	Ø
SCALE	SHEET		OF