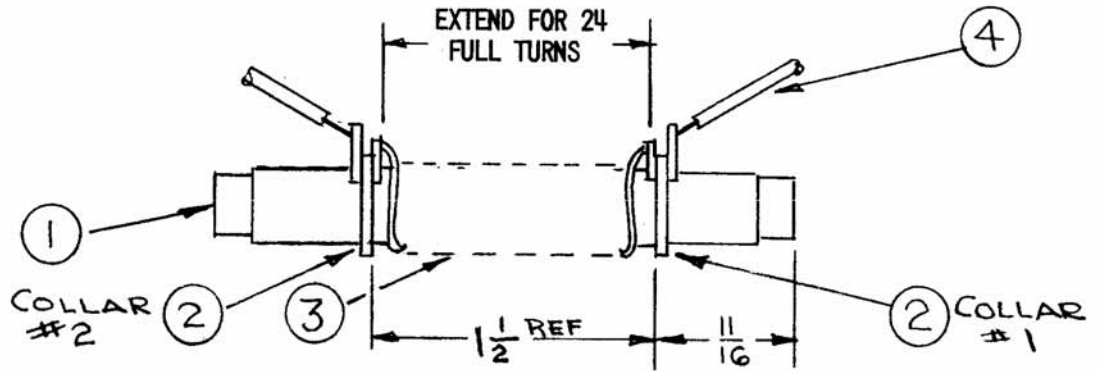


APPLICATION			REVISIONS						
QTY	MODEL USED ON	ASS'Y NO.	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
1	HFRR-4	A0128	X	EXPERIMENTAL RELEASE	9/12/69	X	CV	<i>J. H. ...</i>	<i>[Signature]</i>
			<del>X</del>	ORIGINAL RELEASE	1/9/69		CV		



**PROCEDURE**

1. SECURE ITEM 2 TO ITEM 1 WITH EASTMAN #910, AS SHOWN TO ALLOW 24 FULL TURNS. BAKE FOR 1/2 HOUR AT 215°F.
2. STRIP END OF ITEM 3 AND SOLDER TO ITEM 2. WIND 24 FULL TURNS (TIGHT) AND STRIP AND SOLDER END TO SECOND COLLAR. COAT WITH ITEM 5 AND BAKE FOR 1/2 HOUR AT 215°F
3. COAT INSIDE OF COIL FORM WITH GL114 IMMEDIATELY AFTER REMOVING FROM OVEN
4. SOLDER A 2" LENGTH OF ITEM 4 TO EACH COLLAR AS PIGTAIL

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
X	6	BS100	SOLDER, TIN ALLOY	
X	5	GL102	Q MAX	
X	4	WL100-7	WIRE, ELEC, BUSS #22	
X	3	WI141-22-9	WIRE, ELEC, MAG, INS	
2	2	TE170-1	TERM, COLLAR	
1	1	CF141-5	COIL FORM, THREADED	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES

DECIMALS	FRACTIONS	TOLS.	ANGLES
.X ± .05	1/64		
.XX ± .01			0° - 30'
.XXX ± .005			

MATERIAL	MECH. DES.	DATE
FINISH	ELECT. DES.	DATE
	CHECKED	DATE
	DRAWN	DATE

*P. POSE*  
*[Signatures]*  
 DATE: 12/3/69  
 DATE: 9/16/69  
 DATE: 9/15/69

LIST OF MATERIAL  
**THE TECHNICAL MATERIEL CORP.**  
 MAMARONECK, NEW YORK  
 COIL, RF, OSC.

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	A	82679	CL455	<del>X</del>
SCALE			SHEET	OF