

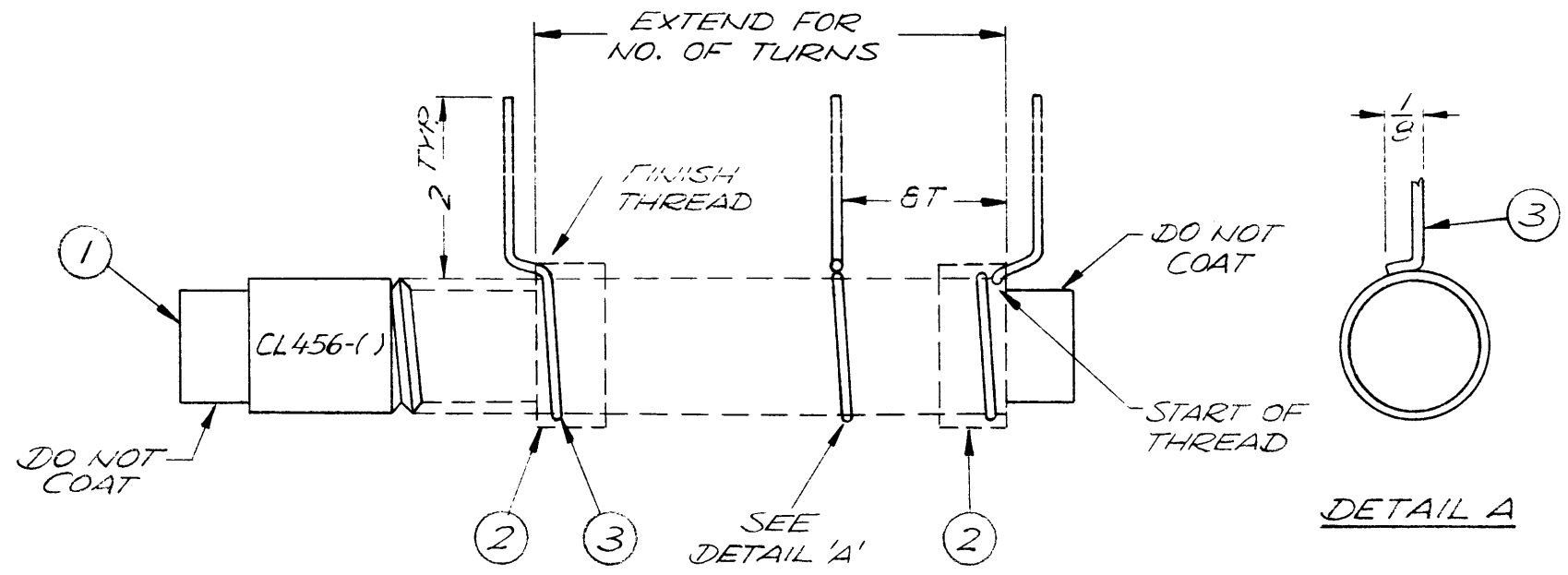
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REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
	X1	REDRAWN WITH CHANG.	10/6/69		K.H.	M.S.
	Ø	ORIG RELEASE FOR PROD	4/9/70		CV	

PROCEDURE

- ASSEMBLE COIL FROM ITEM 1 ON A .250 MANDREL CAPABLE OF HOLDING COIL FORM SECURE AND UNDEAGED AGAINST WINDING TENSION OF 2.5 TO 3.0 INCH-POUNDS AS MEASURED ACROSS MANDREL WITH INCH-POUNDS SCALE.
 - WIND COIL USING ITEM 3 IN START THREAD OF ITEM 1. SECURE START WINDING USING ITEM 2 SO THAT START THREAD IS VISIBLE. SET TENSION AT 2.5 TO 3.0 INCH-POUNDS AND HAND WIND REQUIRED TURNS ENDING IN LINE WITH START THREAD. TAPE END OF WINDING WITH ITEM 2 BEYOND LAST TURN. BAKE AT 215°F FOR 1/2 HOUR TO REMOVE MOISTURE.
 - COAT EXPOSED COIL TURNS WITH ITEM 4. DO NOT COAT HOLDING TAPE OR MACHINED ENDS OF ITEM 1. BAKE AT 215°F FOR 1 HOUR.
 - CAREFULLY REMOVE HOLDING TAPE AT BOTH ENDS. APPLY NEW ITEM 2 DIRECTLY OVER COIL TURNS AND FLUSH WITH ENDS OF WINDING. SEAL WITH ITEM 4. TRIM LEADS TO 2". STRIP AND TIN TO WITHIN 3/8" OF COIL FORM MARK WITH TMC PART NUMBER.
- *5 ON CL456-4, AFTER STEP 2 ABOVE, COUNT OFF EIGHT (8) TURNS FROM START TURN AND IN LINE WITH SAME, STRIP AND TIN 1/8". STRIP AND TIN AND BUTT SOLDER FOR 1/8" A LENGTH OF ITEM 3 TO THIS TURN PER DETAIL A.

PART NO.	ITEM 1	NUMBER OF TURNS	SYMBOL NUMBERS
CL 456-1	CF141-4	42	L1, L2, L3
CL 456-2	CF141-3	30	L4, L5, L6
CL 456-3	CF141-2	18	L7, L8, L9
* CL 456-4	CF141-1	16	L10, L11, L12

* NOTE:
SHOULD BE TAPPED AT 8 TURNS IN LINE WITH START.

REQ'D ITEM	PART NUMBER	DESCRIPTION	SYM.
X 5	BS 100	SOLDER, TIN ALLOY	
X 4	GL 104-2	INSULEX, U85	
X 3	WI141-22-9	WIRE, ELEC, MAG. INS.	
X 2	TA 101-1	TAPE, FIBERGLASS	
1	SEE CHART	COIL FORM THREADED	

POSE LIST OF MATERIAL

QTY / UNIT 3 MODEL USED ON HERR - 4 ASS'Y NO. AX5005			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		FINAL APPROVAL MECH. DES. [Signature] DATE 4-3-70		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK						
APPLICATION			DECIMALS .X ± .05 FRACTIONS 1/64 TOLS. .XX ± .01 ANGLES .XXX ± .005 0° -30'		ELECT. DES. [Signature] CHECKED [Signature] DATE 10/17/69						COIL, RF, TUNER		
CODE			MATERIAL		DRAWN [Signature] DATE 10/6/69		SIZE B		CODE IDENT. NO. 82679				
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