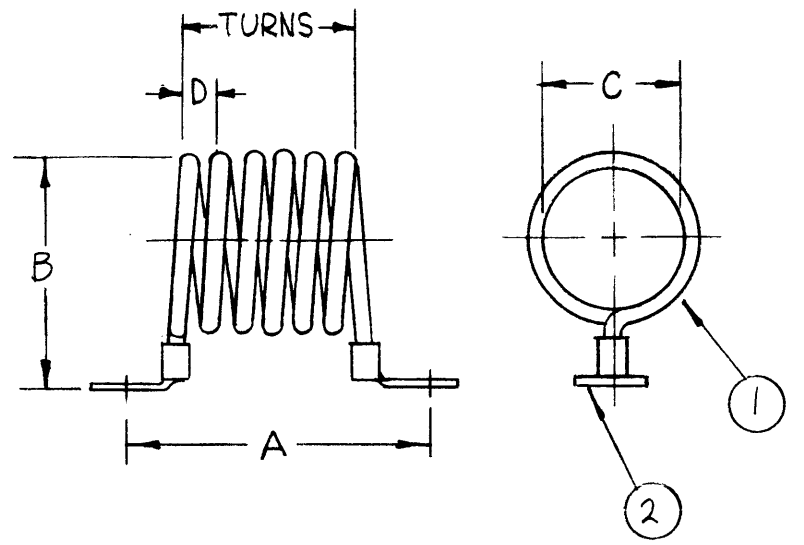
TMC P/N	TURNS	A	B	C	D
CL401-1	3	1-1/4	1-3/16	3/4	5/32
CL401-2	5	1-5/8	1-3/16	3/4	↑
CL401-3	6	1-3/4	1-3/16	3/4	↑
CL401-4	14	3 1/4	1-7/8	1-1/2	↑
CL401-5	15	3-1/2	↑	↑	↑
CL401-6	11	2-5/8	↑	↑	↑
CL401-7	12	2-3/4	↑	↑	↑
CL401-8	8	2-1/2	↑	↑	↑
CL401-9	9	2-5/8	1-7/8	1-1/2	↑
CL401-10	13	2-3/4	1-5/16	3/4	↑
CL401-11	14	3	↑	↑	↑
CL401-12	11	2-1/2	↑	↑	↑
CL401-13	12	2-5/8	↑	↑	↑
CL401-14	6	1-3/4	↑	↑	↑
CL401-15	7	1-7/8	1-5/16	3/4	5/32
CL401-16	16	3-3/4	1-7/8	1-1/2	5/32
CL401-17	10	3	1-7/8	1-1/2	5/32
CL401-18	8	2	1-5/16	3/4	5/32
CL401-19	7-1/2	2-1/2	1-7/8	1-1/2	5/32
CL401-20	1	1	1-5/16	3/4	5/32

4

CL401

REVISIONS

SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X1	REDRAWN & REVISED FROM 1 SIZE	8-1-66	X1			
X2	ITEM 3 WAS BS100	5-24-67	X2			
Ø	OKD FOR RELEASE FOR PRODUCTION	5/25/67	Ø			
A	CL401-16 thru CL401-20 ADDED	5/18/71	20337	CW		



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
	3	BS101	BRAZING ALLOY, SILVER	
	2	TE141-1	TERM, LUG #6	
	1	WL100-1	WIRE, ELECT, BUSS	

F. BUDETTI

LIST OF MATERIAL

MATERIAL: SEE DWG

FINISH: S245 SILVER PLATE
S423 SILVER KOTE

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

TITLE: COIL, RF

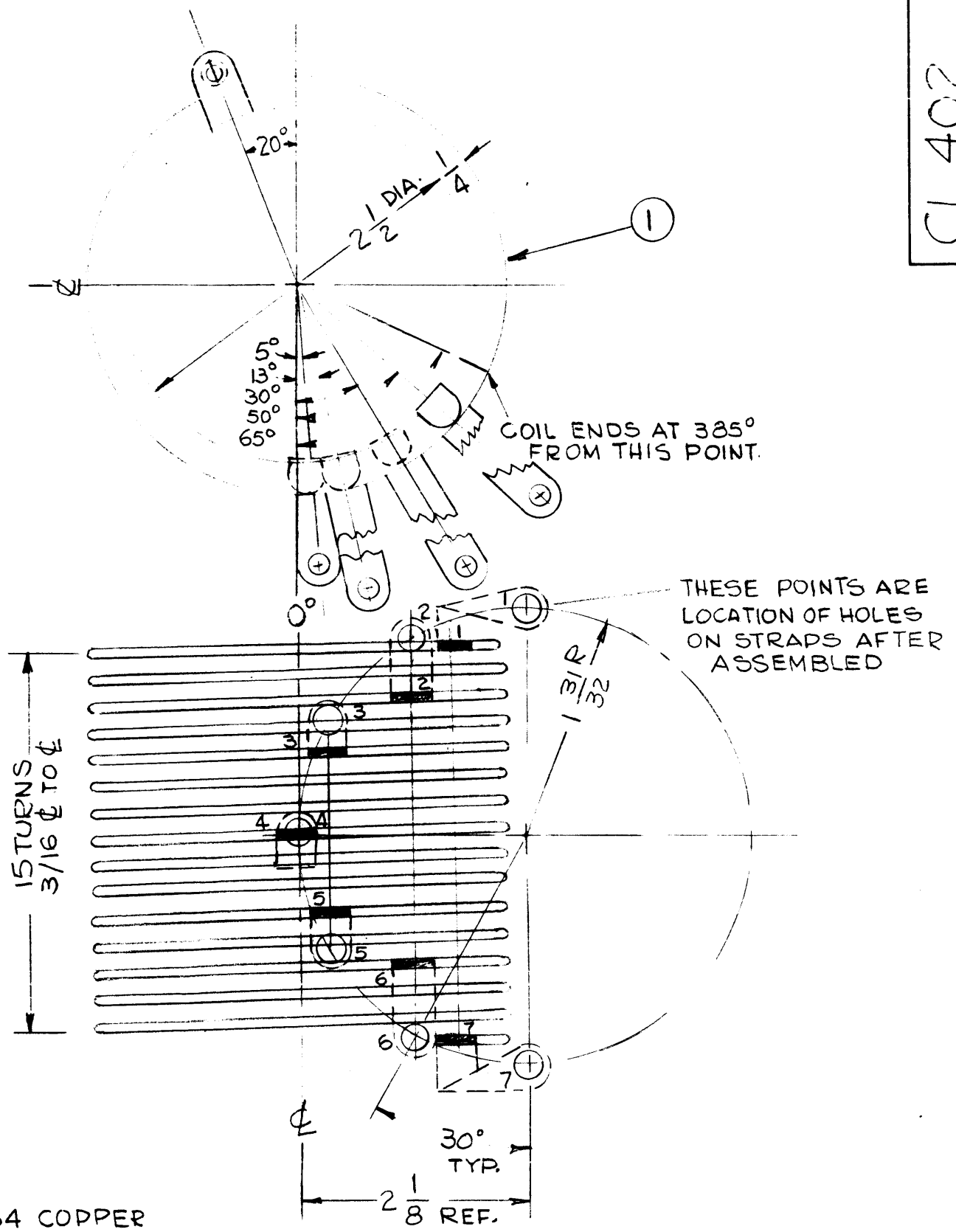
DRAWN	DATE 8-1-66	FINAL APPROVAL	DATE 5/25/67
CHECKED	DATE 5-24-67		
ELECT. DES.	DATE	CL401	A
MECH. DES.	DATE 5/24/67	SHEET	REV. LTR.

NOTES

Q'T'Y./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE A	STANDARD

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

DECIMALS: .X ± .05, .XX ± .01, .XXX ± .005
TOLERANCES
FRACTIONS: ± 1/64
ANGLES: ± 0° 30'



MAT'L - (COIL) .054 COPPER

NOTE - SILVER SOLDER ALL PARTS AS SHOWN

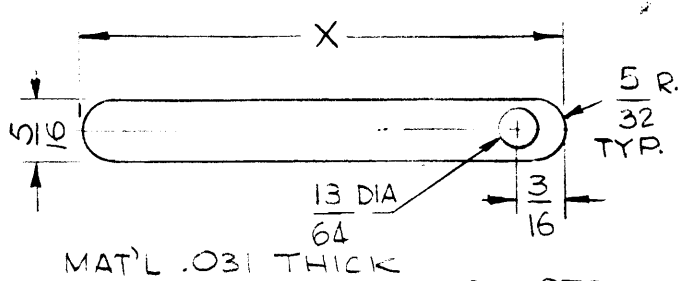
NOTES

Ø

CL 402

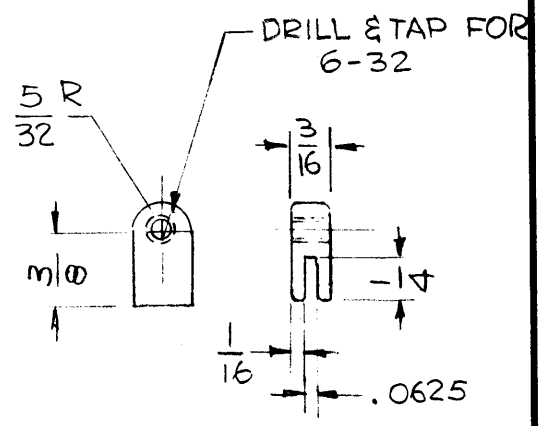
REVISIONS

SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X	EXPERIMENTAL RELEASE	7.1966		SRG		
X1	STRAP #7 WAS 2-1/4 LONG	8-22-66				
Ø	ORIGINAL RELEASE FOR PRODUCTION	11.11.66		SRG		



MAT'L .031 THICK HOT ROLLED COPPER.

STRAP	X	DEGREE FROM 0	FROM	TO
1	2-3/8	50°	1	1
2	1-7/8	30°	2	2
3	1-11/16	13°	3	3
4	1-5/8	5°	4	4
5	1-11/16	13°	5	5
6	1-7/8	30°	6	6
7	1-3/4	50°	7	7



ROUND ALL EDGES & CORNERS

MATERIAL - HALF HARD BRASS

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
1	1	CL 133-3-R-15-CW	COIL, RF	

F. BUDETTI — **LIST OF MATERIAL**

Q'T'Y./UNIT	1
MODEL USED ON	TLAA-2.5K
ASS'Y. NO.	AS128
SCALE	1:1
CODE	A

MATERIAL: SEE DWG

FINISH: S245 SILVER PLATE; S423 SILVER KOTE

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

DECIMALS: .X ± .05; .XX ± .01; .XXX ± .005
TOLERANCES
FRACTIONS ± 1/64
ANGLES ± 0° 30'

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

TITLE: COIL, RF "L" SECTION

DRAWN	SRG	DATE	3-1-65
CHECKED		DATE	
ELECT. DES.		DATE	11-9-66
MECH. DES.		DATE	
FINAL APPROVAL		DATE	
SHEET		REV. LTR.	Ø

CL 402

M/L — 11/11/66

REPROVEL NO. 44 H 23858

CL410 Ø

WINDING ~

33 TURNS CLOSE WOUND OF ITEM 6, WI-123-12

FABRICATION ~.

1 ~ BUILD UP FERRAMIC CORE ITEM 4 WITH TAPE, ITEM 3, TO 3/8" DIA. AS SHOWN IN STEP 1.

2 ~ PRESS FIT CORE INTO COIL FORM ITEM 2, LEAVE 3/8" SPACE EACH END OF FORM AS SHOWN IN STEP 2.

3 ~ ASSEMBLE END PIECES ITEM 1 INTO COIL FORM.

4 ~ MEASURING IN 5/32 FROM EACH END OF COIL FORM DRILL WITH NO. 53 THRU AS SHOWN IN STEP 3.

5 ~ WIND 33 TURNS OF WIRE ITEM 6 ON COIL FORM, START WINDING 1/2" FROM END AS SHOWN IN STEP 4.

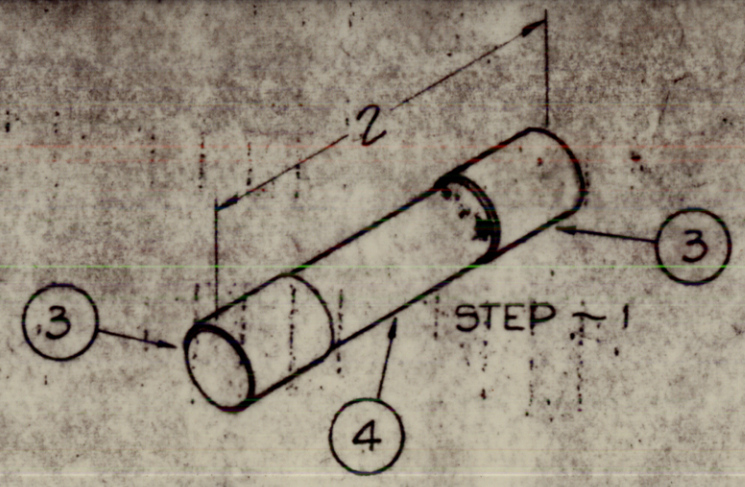
6 ~ SOLDER WIRE ENDS TO END PIECES.

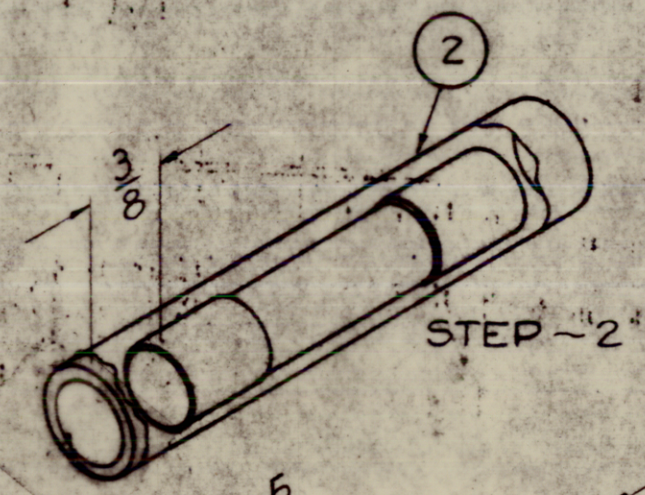
TEST DATA ~

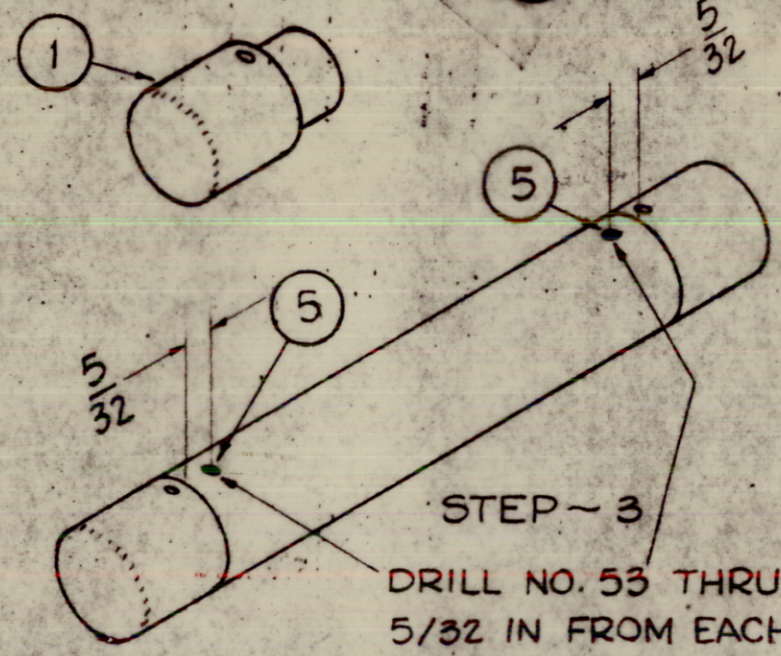
L - 15.0 MICROHENRIES MIN.

F - 10 KCS

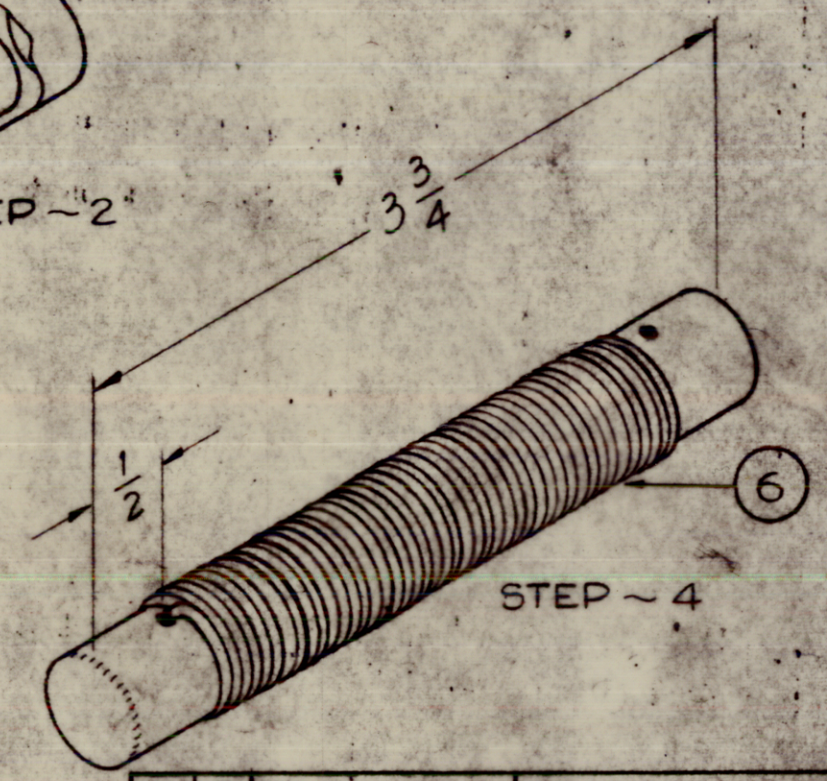
TEST ON MARCONI $\frac{1}{4}$ % IMPEDANCE BRIDGE.







DRILL NO. 53 THRU 5/32 IN FROM EACH END OF COIL FORM PIN WITH ITEM 5



REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	7	BS 100	SOLDER, SOFT	
X	6	WI 123-12	WIRE, MAGNET, HEAVY	12GA
2	5	PN 109-2	PIN, ROLL	
1	4	CI 112Q-2ROF	CORE, FERRAMIC	
X	3	TA 100-2	TAPE, VINYL PLASTIC	
1	2	CF 120-2.75	COIL FORM, 1/2 O.D.	
2	1	PM 606-2	END PIECE, R.F. FIXER	

STOCK SIZE

MATERIAL

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

THE TECHNICAL MATERIEL CORP.
MAMARONECK. NEW YORK

COIL, R.F. FIXED, INTERCONN. FILTER

DRAWN | CHECKED | FINAL APPROVAL

ELEC. DES. APP. | MECH. DES. APP. | CL410 Ø

REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
3	ATLA-2.5K	RAK-111-2	AS586	8-25-66
3	TST( )2.5K	RAK-110-2	AS586	8-25-66

USED ON

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
Ø		ORIGINAL RELEASE FOR PRODUCTION	12.1.66	++	WHO		
A	1	EXP. RELEASE	8-25-66	X			

TOLERANCES

DEC. DIM. ±
FRAC. DIM. ± 1/64
ANGULAR DIM. ±

SCALE: FULL (DO NOT SCALE)

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

FORM 706-A

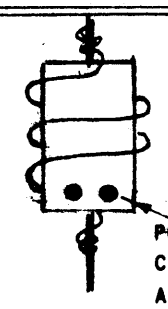
COIL NUMBER	L μh ±	Q MIN	TEST FREQ	TYPE WIRE	APPROX NO OF TURNS	COIL FORM	DWG NO	USED ON
CL412-1	3.80 ±4%	55	7.9 mc	WI141-30SP	40-3/4	RC32GF226J	A	FILTER CARD
-2	2.69	55	7.9 mc	"	30	"	"	"
-3	2.49	55	"	"	28-1/2	"	"	"
-4	2.41	55	"	"	27-1/2	"	"	"
-5	1.78	55	"	"	21-3/4	"	"	"
-6	1.68	55	"	"	21	"	"	"
-7	1.32	55	7.9 mc	WI141-30SP	17-1/4	"	"	"
-8	.85	55	25 mc	WI141-24SP	17-1/4	"	"	"
-9	.78	55	"	"	16	"	"	"
-10	.76	55	"	"	15-3/4	"	"	"
-11	.52	55	"	"	11-3/4	"	"	"
-12	.48	55	"	"	11	"	"	"
-13	.47	55	"	"	10-3/4	"	"	"
-14	.34	55	"	"	8-1/4	"	"	"
-15	.31	55	"	"	8	"	"	FILTER CARD
-16	.21	55	"	"	5-3/4	"	"	RF CARD
-17	.19 ±4%	55	25 mc	WI141-24SP	5-1/4	RC32GF226J	"	RF CARD
-18	DELETED							
-19	DELETED							
-20	1.15 ±4%	35	7.9 mc	WI141-32SP	24-3/4	RC20GF226J	"	TRANSLATOR
-21	1.33	35	7.9 mc	WI141-32SP	28	"	"	"
-22	1.30	35	7.9 mc	WI141-32SP	27-3/4	RC20GF226J	A	TRANSLATOR
-23	.077	*	*	WI141-24SP	2-3/4	PX370-8-7	B	TRANSLATOR
-24	.63	35	25 mc	WI141-30SP	18 1/4	RC20GF226J	A	TRANSLATOR
-25	.36	35	25 mc	WI141-30SP	12	RC20GF226J	A	TRANSLATOR
-26	.64	60	25 mc	WI141-24SP	13-3/4	RC32GF226J	A	
-27	12.8	100	2.5 mc	WI104-741DSQS	41	CI 114	A	LFE-1 FILTER CARDS
-28	7.5	90	7.9 mc	WI104-1243SNE	30	"	"	"
-29	6.7	100	"	"	28	"	"	"
-30	5.5	100	"	"	24	"	"	"
-31	4.5	100	"	"	21	"	"	"
-32	4.3	95	"	"	20	"	"	"
-33	4.0	100	"	"	19	"	"	"
-34	2.5	95	"	"	14	"	"	"
-35	2.3 ±4%	90	7.9 mc	WI104-1243SNE	13	CI 114	A	LFE-1 FILTER CARDS
-36	.1uh ±10%	40	25	WI141-32SP	6-1/2	RC07GF106J	A	STEP GEN C
-37	.085 uh	*	*	WI141-32SP	5	RC07GF106J	A	"
-38	.205	*	25	WI141-26-2	9	RC20GF471J	A	"
-39	.176	*	25	WI141-26-2	8	RC20GF471J	A	"
-40	.155 ±10%	*	25	WI141-26-2	7	RC20GF471J	A	STEP GEN C

NOTE:
1. APPLY "Q" MAX. AND BAKE IN OVEN AT 140° FOR 1/2 HOUR.
2. * NO TEST

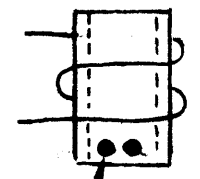
REVISIONS

ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXPERIMENTAL RELEASE	11/7/66	X	RME		
	X1	COMPLETELY REVISED	1/10/67	X1	RME		
	X2	REV. #TURNS ON COILS 20,21,22 & PICTURIAL	2-16-67	X2	L.A.K		
	X3	"DWG" COL ADD; DWG "B" ADD	3.16.67	—	GHO		
	X4	TEST FREQ FOR CL142-8 THRU CL142-19 WAS 2.5 MC	4-18-67	X4	C.D.L		
	X5	-24, 25 ADDED	7/25/67	X5			
	X6	CL412-18 & -19 DELETED - INF. FOR CL142-16 & 17 CLARIFIED	7-19-67	X6	C.D.L		
	X7	-26 ADDED	8/1/67	X7	C.V.		
	Ø	ORIG RELEASE FOR PROD	8/1/67	Ø			
	A	L, Q, TEST FREQ. COL REV. 27 THRU 40 & COLOR CODE ADD	10-3-67	18521	CV		
	B	"L" & NO OF TURNS FOR CL412-16 CL 412-17 MODIFIED SHEET 2 ADD	12-1-67	18652	RG		
	C	ADDED -45 THRU -52	9-25-70	19978	GE		
	D	DELE. ±4% AT L μh	11/17/70	20085	RF		
	E	ADDED ±4% & ±10% TOL.	1/20/72	20526	RG		

DWG A



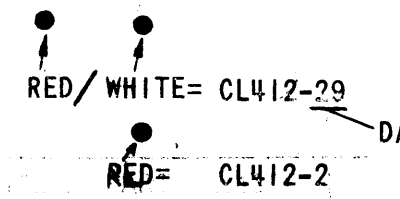
DWG B



ALL COILS SHALL BE COLOR CODED TO INDICATE DASH NUMBER.

COLOR CODE SHALL BE READ FROM LEFT TO RIGHT AS SHOWN IN PICTORIALS

IE:



COLOR CODE CHART

BROWN	1
RED	2
ORANGE	3
YELLOW	4
GREEN	5
BLUE	6
VIOLET	7
GRAY	8
WHITE	9
BLACK	0

QTY / UNIT	MODEL USED ON	ASS'Y NO.
	GHG-()4	
	LFE-1	
	VOX-7	
	MMX-( )	

APPLICATION

S401-451 | CODE A

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

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

MATERIAL

FINISH

POSB

LIST OF MATERIAL

FINAL APPROVAL		DATE 8-1-67
MECH. DES.		DATE
ELECT. DES.		DATE 8-1-67
CHECKED		DATE
DRAWN	RME	DATE 11-7-66

ML: A. Klein 8/1/67

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL, RF

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL412	E

SCALE | SHEET 1 OF 2

FCI-10-179 (10-66)

COIL NUMBER	Lμh	Q MIN	TEST FREQ	TYPE WIRE	APPROX NO OF TURNS	COIL FORM	DWG NO.	USED ON
CL412-41	.128 ±10%	40	25	WI141-32SP	7-1/2	RC07GF106J	A	STEP GEN C
-42	.084±4%	*	*	WI141-24-2	5-1/2	RC20GF226J	A	HF FILTER
-43	.049±4%	*	*	WI141-24-2	2-1/4	RC20GF226J	A	HF FILTER
-44	.055±4%	*	*	WI141-24-2	2-1/2	RC20GF226J	A	HF FILTER
-45	3.69±2%	*	7.9 MC	WI-141-37-2	50	RC20GF226J	A	ANT BOX
-46	2.62±2%	*	7.9 MC	WI-141-34-2	41	RC20GF226J	A	ANT BOX
-47	2.16±2%	*	7.9 MC	WI-141-34-2	37 1/2	RC20GF226J	A	ANT BOX
-48	1.85±2%	*	7.9 MC	WI-141-34-2	33	RC20GF226J	A	ANT BOX
-49	1.72±2%	*	7.9 MC	WI-141-34-2	30	RC20GF226J	A	ANT BOX
-50	1.31±2%	*	7.9MC	WI-141-34-2	27	RC20GF226J	A	ANT BOX
-51	1.12±2%	*	7.9MC	WI-141-34-2	24	RC20GF226J	A	ANT BOX
-52	0.927±2%	*	25 MC	WI-141-34-2	22	RC20GF226J	A	ANT BOX
-53	0.860 ±2%	*	25MC	WI141-30-5	23	RC20GF226J	A	ANT BOX
-54	0.656 ±2%	*	25MC	WI141-30-5	19	RC20GF226J	A	ANT BOX
-55	0.522 ±2%	*	25MC	WI141-30-5	18	RC20GF226J	A	ANT BOX
-56	0.463 ±2%	*	25MC	WI141-30-5	15	RC20GF226J	A	ANT BOX
-57	0.433 ±2%	*	25MC	WI141-30-5	14	RC20GF226J	A	ANT BOX
-58	0.330 ±2%	*	25MC	WI141-30-5	11-1/2	RC20GF226J	A	ANT BOX
-59	0.278 ±2%	*	25MC	WI141-30-5	10	RC20GF226J	A	ANT BOX
-60	0.193 ±2%	*	25MC	WI141-30-5	7	RC20GF226J	A	ANT BOX
-61	0.390 ±2%	*	25MC	WI141-30-5	13	RC20GF226J	A	ANT BOX
-62	0.220 ±2%	*	25MC	WI141-30-5	8-1/2	RC20GF226J	A	ANT BOX

REVISIONS

ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	B	-41,42,43,44 ADDED SEE SHEET 1	12-6-67	18652	G.D.L		OP
	C	ADDED -45 THRU -52	9-25-70	19978	GE		RO
	D	ADD. 53-62 & REVISED	11/17/70	20085	RJ		PEB
	E	SEE SHEET 1	1/20/72	20526	RG	CJ	CJ

	4FRR-4	
	LFE-1	
	CHG-( )4	
	VOX-7	
	MMX-( )	
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

S401-451 | CODE A

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

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

MATERIAL

FINISH

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
O. POSE			LIST OF MATERIAL	

FINAL APPROVAL		DATE 12-27-67
MECH. DES.		DATE
ELECT. DES.		DATE
CHECKED		DATE 12-27-67
DRAWN G.D.L		DATE 12-6-67

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

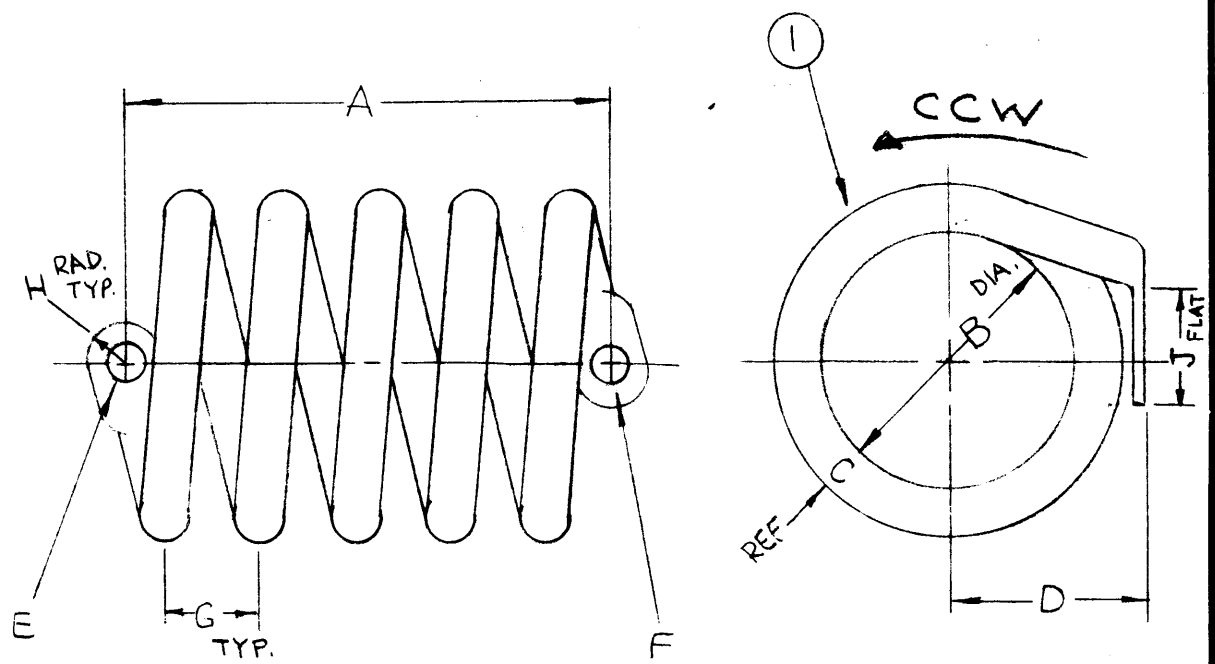
COIL, RF

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL 412	E

SCALE | SHEET 2 OF 2

TMC P/N	A	B	C REF.	D	E	F	G	H	J	TURNS	WINDING DIR.	ITEM 1	INDUCTANCE uh
CL417-1	1-1/2	1-5/16	1/4	29/32	7/32	7/32	1/2	1/4	1/2	3	CCW	TU100-4-S	.26
CL417-2	2-3/16	1-5/16	1/4	29/32	7/32	7/32	1/2	1/4	1/2	4	CW	TU100-4-S	.33
CL417-3	2-5/8	1-5/16	1/4	29/32	7/32	7/32	1/2	1/4	1/2	5	CCW	TU100-4-S	.42
CL417-4	4-1/8	1-5/16	1/4	29/32	7/32	7/32	3/4	1/4	1/2	6	CCW	TU100-4-S	.60

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP. RELEASE	1-4-67				
	X1	"D" WAS 25/32 -1,2,3	1-19-67				
	Ø	ORIG. RELEASE FOR PROD	5/2/67	Ø			
	A	CL417-4 ADDED	11-1-67	18584	HB		FB
	B	CL417-4 (7 TURNS WAS 8)	1-24-68	18734	HB		FB
	C	CL417-4 (UPDATED)	2-6-69	19258	GE		FB



COIL SHOWN IN CCW

X	1	SEE CHART		
REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.

F. BUDETTI — LIST OF MATERIAL

	LPFA-40K	
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

STANDARD — CODE A

NOTICE TO PERSONS RECEIVING THIS DRAWING

THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from **THE TECHNICAL MATERIEL CORPORATION** to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.

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

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

MATERIAL: SEE CHART

FINISH: SEE CHART

FINAL APPROVAL		DATE 5/2/67
MECH. DES.		DATE
ELECT. DES.		DATE
CHECKED		DATE
DRAWN		DATE

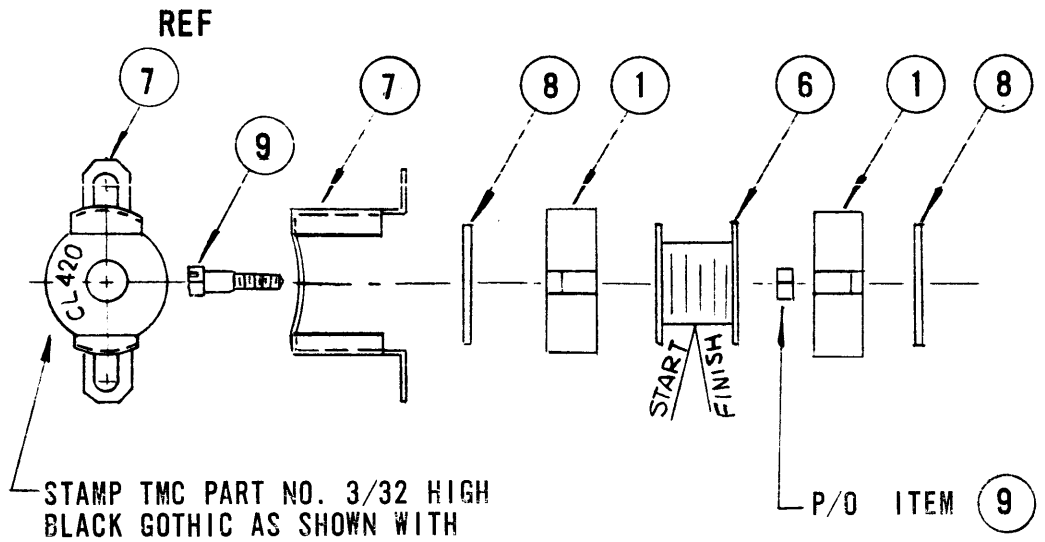
THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL, RF

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL417	C

SCALE — | SHEET OF

FCI-10-170 (10-66)



REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXPERIMENTAL RELEASE	8/8/67	X	C.V.		
	X1	ELEC. SPECS REV.	12-21-67	X	CV		
	Ø	ORIG. RELEASE FOR PROD.	1-3-68	Ø	R.G.		

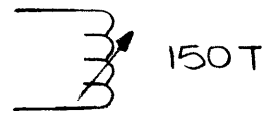
NOTES:

1. SOLENOID WIND 150 TURNS OF ITEM #2 ON ITEM #6.
   STAKE ENDS WITH ITEM #4 (TAG START OF WINDING).
2. BAKE FOR 30 MINUTES AT 150°F. REMOVE FROM OVEN AND COAT COIL WITH ITEM #3.
3. COAT CORE SURFACE (ITEM #1) WITH ITEM #5.
4. ASSEMBLE AS SHOWN.
5. STRIP AND TIN LEADS (MINIMUM LENGTH OF 2 INCHES).
6. CHECK COIL AND VERIFY WITH ELECTRICAL SPECIFICATION.

ELECTRICAL SPECIFICATION

TEST IN Q METER (FLUSH CORE)

SET FREQ= 79 Kc
L= 14 mH ±6 mH
Q= 50 MIN



SCHEMATIC

* MEASURED WITH BOONTON " Q" METER MODEL 260A OR EQUIVALENT. TUNING SLUG ITEM #9, FLUSH

X	10	BS100	SOLDER, TIN ALLOY	
1	9	CI133	CORE, ADJ, TUNING	
2	8	WA140-1	WASHER, NON-METALLIC	
1	7	CU148-1	RETAINER, CUP CORE	
1	6	CF135-4	FORM, COIL, 2 FLG	
X	5	GL129	ADHESIVE, QUICK SETTING	
X	4	GL103	ADHESIVE N-CEL	
X	3	GL130	ADHESIVE, Q DOPE	
X	2	WI141-30-5	WIRE, ELECTRICAL, MAGNET, INS	
X	1	CI132	CORE, CUP	
REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.

O. POSE — LIST OF MATERIAL

1	LFE-1	
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE A — S401-451

NOTICE TO PERSONS RECEIVING THIS DRAWING
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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES

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

MATERIAL

FINISH

FINAL APPROVAL		DATE
MECH. DES.		DATE
ELECT. DES.		DATE 11-24-67
CHECKED		DATE 1-3-67
DRAWN		DATE 8-8-67

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

CHOKE, TUNABLE

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL 420	Ø

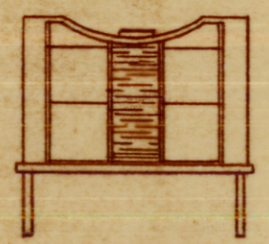
SCALE — SHEET OF

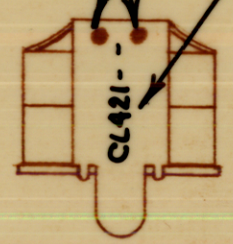
FCI-10-170 (10-66)

TMC PART NO.	SYMBOL	NO. OF TURNS	TEST FREQUENCY L1 ± 1%						DISTR. CAP.	COLOR CODE	BAND	REQ.
		L1	F	L SET	L MIN	L MAX	Q	R				
CL421-1	L1,2,3	35	10KC	194 µH	181.8	201.7	60	0.180	16pF	——	1	3
CL421-2	L1,2,3	46	10KC	348.8µH	345.0	381.2	60	0.3740	17.3pF	——	2	3
CL421-3	L1,2,3	35	10KC	200µH	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	—	HRA		
	Ø	ORIG. RELEASE FOR PROD.	1-8-68	Ø	R.G.		

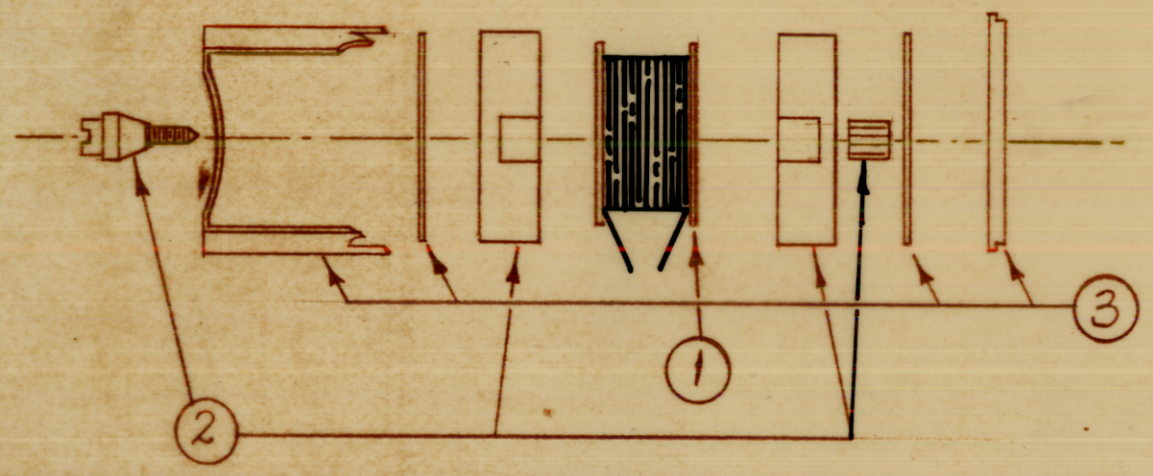




COLOR CODE (SEE CHART & NOTE *)

MARK TMC PART NO. 3/32 HIGH GOTHIC W/LATEST REV. LETTER. (SEE NOTE *)

*NOTE: MARK EACH UNIT WITH CORRESPONDING DASH NO. AND COLOR CODE.



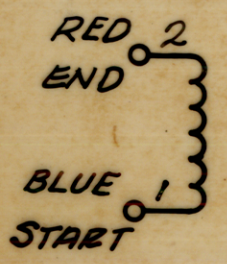
ASSEMBLY DETAIL

WINDING PROCEDURE

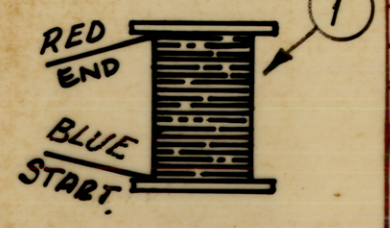
1. WIND REQ. TURNS (SEE CHART) OF ITEM 4 ON ITEM 1 STAKE WITH ITEM 6.
2. KEEP ALL LEADS 1-1/2" LONG.
3. STRIP AND TIN ALL LEADS TO WITHIN 3/4" OF COIL.
4. COLOR CODE ALL LEADS AS SHOWN IN WIRING DETAIL
5. BAKE COIL FOR 15 MINUTES AT 150° F. REMOVE FROM OVEN AND COAT WITH ITEM 5.
6. ASSEMBLE ITEMS 1, 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



SCHEMATIC DIAGRAM



WIRING DETAIL

9	VLRC-1	
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE A — 5401-451

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

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

MATERIAL

FINISH

FINAL APPROVAL	SPM	DATE 1-3-68
MECH. DES.		DATE 1-5-68
ELECT. DES.		DATE
CHECKED		DATE 1-5-68
DRAWN	H. AUSTIN	DATE 10-11-67

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL, RF, FIXED

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL421	Ø

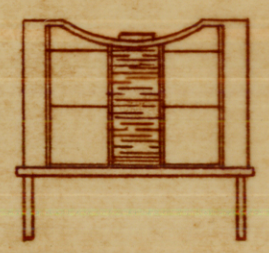
SCALE — SHEET OF

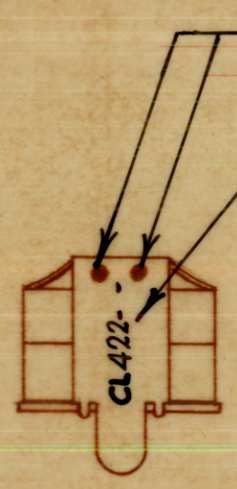
FCI-10-170 (10-66)

TMC PART NO.	SYMBOL	NO. OF TURNS	TEST FREQUENCY L1 ± 1%						DISTR. CAP.	COLOR CODE	BAND	REQ.
		L1	F	L SET	L MIN	L MAX	Q	R				
CL422-1	L1	97	100KC	1.610mH	1.48	1.625	200	1.492	13pF	———	OSC	1
CL422-2	L2	99	100KC	1.60mH	1.548	1.706	200	1.508	13pF	———	OSC	1
CL422-3	L3	82	100KC	1.13mH	1.050	1.162	200	1.238	13pF	———	OSC	1

REVISIONS

ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP. RELEASE	10-10-67	—	HLA		
	Ø	ORIG. RELEASE FOR PROD.	1-8-68	Ø	R.G.		
	A	L1, L2, L3 WAS L9, L5, L6	3 11 68	18807	[illegible]		EFH





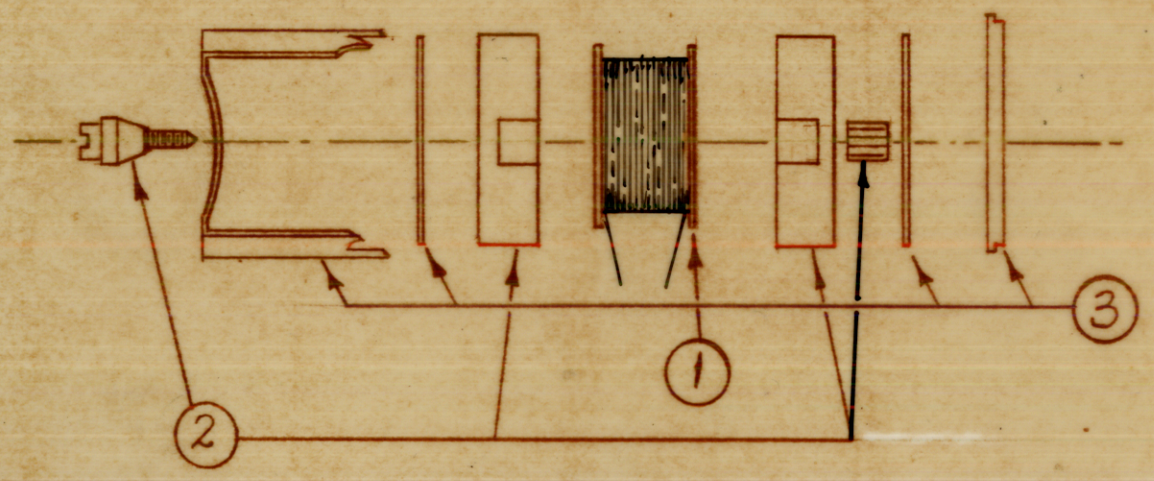
COLOR CODE (SEE CHART & NOTE *)

MARK TMC PART NO. 3/32 HIGH GOTHIC W/LATEST REV. LETTER. (SEE NOTE *)

*NOTE: MARK EACH UNIT WITH CORRESPONDING DASH NO. AND COLOR CODE.

WINDING PROCEDURE

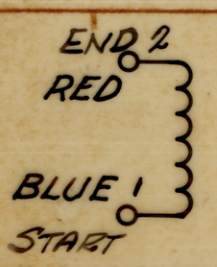
1. WIND REQ. TURNS (SEE CHART) OF ITEM 4 ON ITEM 1 STAKE WITH ITEM 6.
2. KEEP ALL LEADS 1-1/2" LONG.
3. STRIP AND TIN ALL LEADS TO WITHIN 3/4" OF COIL.
4. COLOR CODE ALL LEADS AS SHOWN IN WIRING DETAIL
5. BAKE COIL FOR 15 MINUTES AT 150° F. REMOVE FROM OVEN AND COAT WITH ITEM 5.
6. ASSEMBLE ITEMS 1, 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.



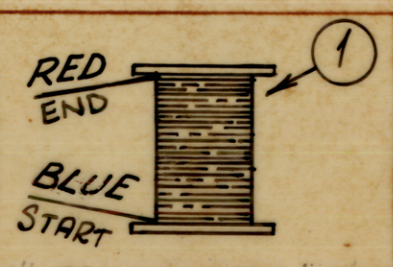
ASSEMBLY DETAIL

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	WI104-1141-SNQS	WIRE, ELEC, LITZ	
1	3	CU158-2	RETAINER, CUP CORE	
1	2	CI137-13	CORE, ADJ TUNING (YELLOW)	
1	1	CF135-17	FORM, COIL (BOBBIN TYPE)	

MARTINENGO LIST OF MATERIAL



SCHEMATIC DIAGRAM



WIRING DETAIL

3	VLRC-1	
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE A — S401-451

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

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

MATERIAL

FINISH

FINAL APPROVAL	[signature]	DATE 1-8-68
MECH. DES.	[signature]	DATE 1-5-68
ELECT. DES.	[signature]	DATE
CHECKED	[signature]	DATE 1-5-68
DRAWN	H. AUSTIN	DATE 10-10-67

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL, RF, FIXED

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL422	A

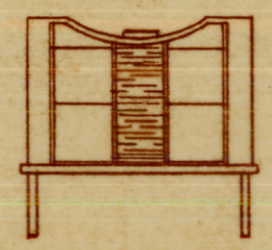
SCALE — SHEET OF

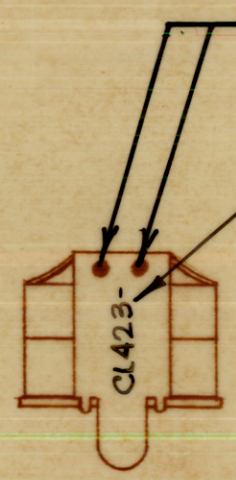
FCI-10-170 (10-66)

TMC PART NO.	SYMBOL	NO. OF TURNS	TEST FREQUENCY L1 ± 1%						DISTR. CAP.	COLOR CODE	BAND	REQ.
		L1	F	L SET	L MIN	L MAX	Q	R				
CL423-1	L4	110	100KC	831μH	797	879.5	200	1.2	13pF	———	OSC	1

REVISIONS

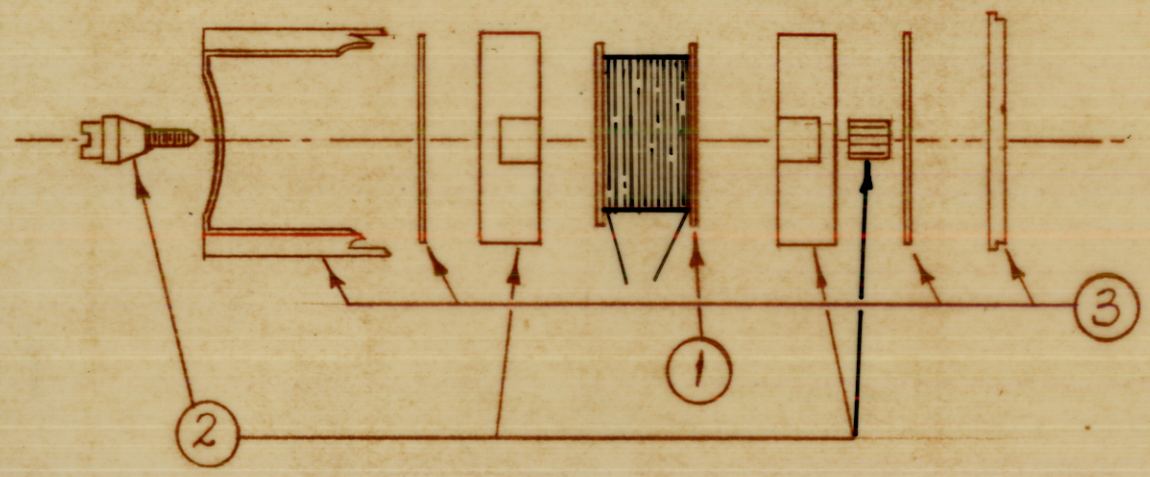
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP. RELEASE	10-10-67	—	HLQ		
	Ø	ORIG. RELEASE FOR PROD	1-8-68	Ø	R.G.		
	A	L4 WAS L7	3-11-68	18807	L.A		E.P.H





COLOR CODE (SEE CHART)

MARK TMC PART NO. 3/32 HIGH GOTHIC W/CORRESPONDING DASH NUMBER & LASTEST REVISION LETTER.



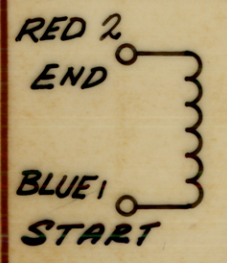
ASSEMBLY DETAIL

WINDING PROCEDURE

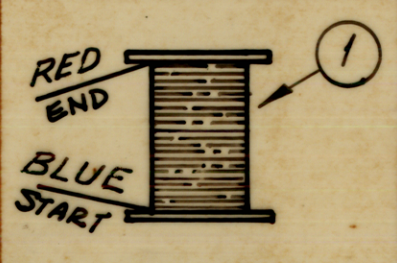
1. WIND REQ. TURNS (SEE CHART) OF ITEM 4 ON ITEM 1 STAKE WITH ITEM 6.
2. KEEP ALL LEADS 1-1/2" LONG.
3. STRIP AND TIN ALL LEADS TO WITHIN 3/4" OF COIL.
4. COLOR CODE ALL LEADS AS SHOWN IN WIRING DETAIL
5. BAKE COIL FOR 15 MINUTES AT 150° F. REMOVE FROM OVEN AND COAT WITH ITEM 5.
6. ASSEMBLE ITEMS 1, 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	WI104-1243-SNQS	WIRE, ELEC, LITZ	
	1	3	CU158-2	RETAINER, CUP CORE	
	1	2	CI137-12	CORE, ADJ TUNING (RED)	
	1	1	CF185-17	FORM, COIL (BOBBIN TYPE)	

MARTINENGO — LIST OF MATERIAL



SCHEMATIC DIAGRAM



WIRING DETAIL

QTY / UNIT	MODEL USED ON	ASS'Y NO.
1	VLRC-1	

APPLICATION

CODE A — S401-451

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

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

MATERIAL

FINISH

FINAL APPROVAL	SFM	DATE 1-3-68
MECH. DES.		DATE 1-5-68
ELECT. DES.		DATE
CHECKED		DATE 1-5-68
DRAWN	H. AUSTIN	DATE 10-10-67

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL, RF, FIXED

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL423	A

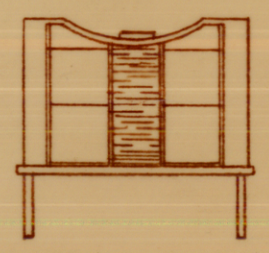
SCALE — | SHEET OF

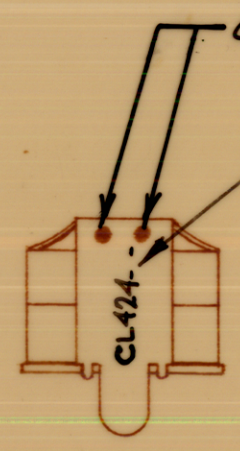
FC1-10-170 (10-66)

TMC PART NO.	SYMBOL	NO. OF TURNS	TEST FREQUENCY L1 ± 1%						DISTR. CAP.	COLOR CODE	BAND	REQ.
		L1	F	L SET	L MIN	L MAX	Q	R				
CL424-1	L5	145	100KC	1.426mH	1.358	1.491	200	2.2	13pF	———	OSC	1
CL424-2	L6	153	100KC	1.615mH	1.533	1.7	200	2.4	13pF	———	OSC	1

REVISIONS

ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP. RELEASE	10.10.67	~~A~~	NLA		
	Ø	ORIG. RELEASE FOR PROD.	1-8-68	Ø	R.G.		
	A	L5 & L6 WAS L8 & L9	3.11.68	18807			JEFM

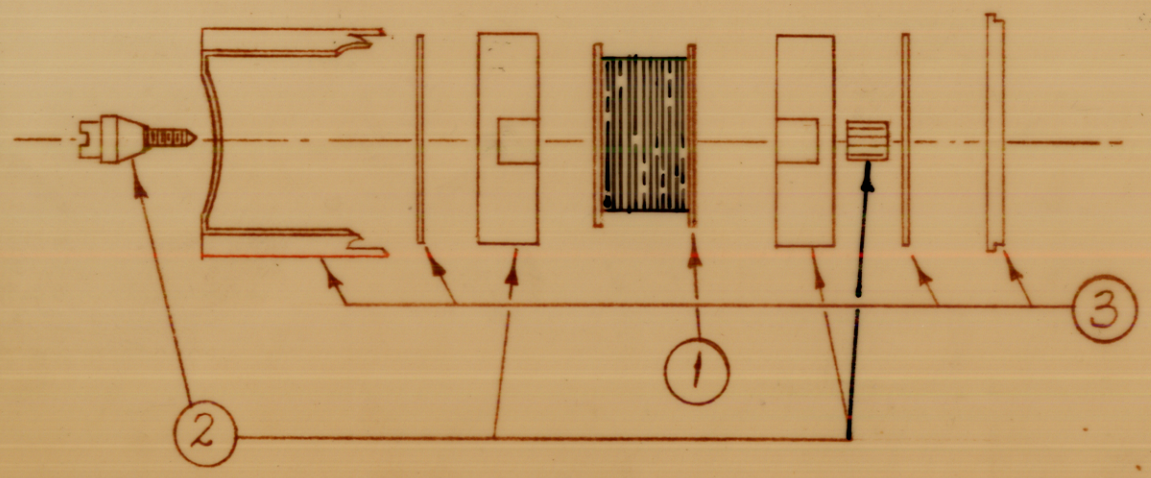




COLOR CODE (SEE CHART & NOTE *)

MARK TMC PART NO. 3/32 HIGH GOTHIC W/LATEST REV. LETTER. (SEE NOTE *)

* NOTE:
MARK EACH UNIT WITH CORRESPONDING DASH No. AND COLOR CODE.



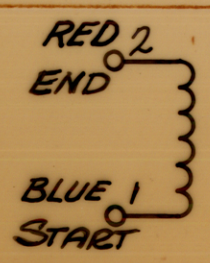
ASSEMBLY DETAIL

WINDING PROCEDURE

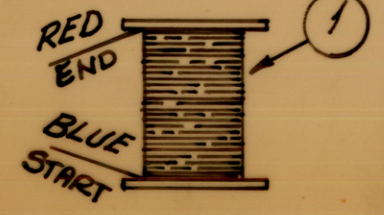
1. WIND REQ. TURNS (SEE CHART) OF ITEM 4 ON ITEM 1 STAKE WITH ITEM 6.
2. KEEP ALL LEADS 1-1/2" LONG.
3. STRIP AND TIN ALL LEADS TO WITHIN 3/4" OF COIL.
4. COLOR CODE ALL LEADS AS SHOWN IN WIRING DETAIL
5. BAKE COIL FOR 15 MINUTES AT 150° F. REMOVE FROM OVEN AND COAT WITH ITEM 5.
6. ASSEMBLE ITEMS 1, 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	WI104-1141-SNQS	WIRE, ELEC, LITZ	
1	3	CU158-2	RETAINER, CUP CORE	
1	2	CI137-12	CORE, ADJ TUNING (RED)	
1	1	CF135-17	FORM, COIL (BOBBIN TYPE)	

MARTINENGO LIST OF MATERIAL



SCHEMATIC DIAGRAM



WIRING DETAIL

QTY / UNIT	MODEL USED ON	ASS'Y NO.
2	VLRC-1	

APPLICATION

CODE A — S401-451

NOTICE TO PERSONS RECEIVING THIS DRAWING
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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES

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

MATERIAL

FINISH

FINAL APPROVAL	SRM	DATE 1-3-68
MECH. DES.		DATE 1-3-68
ELECT. DES.		DATE
CHECKED		DATE 1-3-68
DRAWN	H. AUSTIN	DATE 10-10-67

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

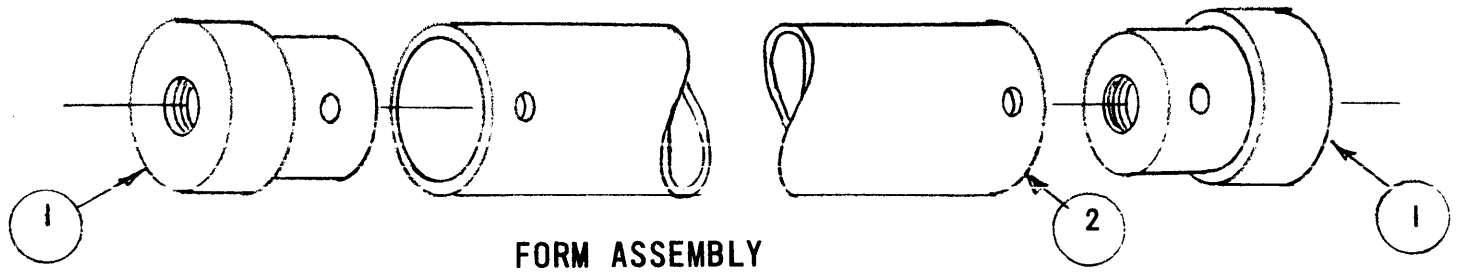
COIL, RF, FIXED

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL424	A

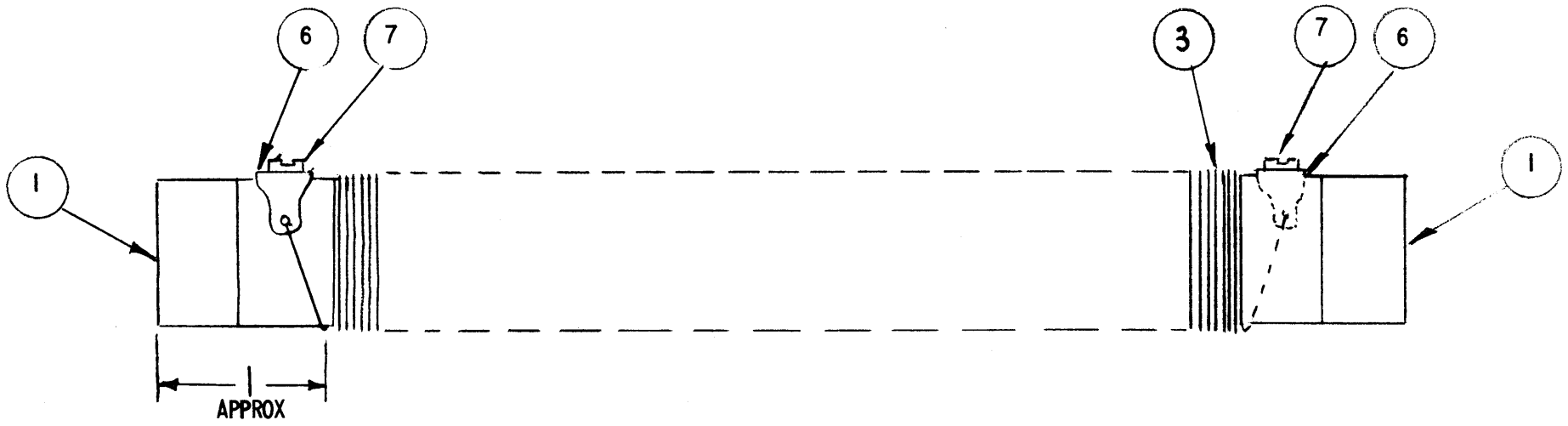
SCALE — SHEET OF

FCI-10-170 (10-66)

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXPERIMENTAL RELEASE	10/30/67		C.V.		
	X_1	UPDATED, ADDED CHART	3/21/68		C.V.		
	Ø	ORIG. RELEASE FOR PROD	4.15.68		R.G.		



FORM ASSEMBLY



FULL ASSEMBLY

TMC P/N	ITEM 2	APPROX TURNS	L	Q	FREQ
CL426-1	CF127-10.750	205	90uH ±5%	140 OR GREATER	2.5Mc
CL426-2	CF127-16.375	330	155uH ±10%	150 OR GREATER	10Mc

PROCEDURE

1. ASSEMBLE END INSERTS (ITEM 1) INTO COIL FORM AS SHOWN.
   ASSEMBLE SCREWS AND LUGS AS SHOWN.
2. SEE CHART 1 FOR AMOUNT OF TURNS TO BE WOUND ON ITEM 2.
   START WINDING APPROX. 1" FROM END. STAKE WIRE ENDS TO FORM.
3. SOLDER WIRE ENDS TO LUGS. (ITEM 6)
4. COAT WINDING WITH INSULEX (ITEM 5)
5. BAKE FOR 1 HOUR AT 200°F.
6. ALLOW UNIT TO COOL
7. TEST UNIT

NOTE:
1. IT IS NECESSARY TO TEST ONLY ONE COIL PER BATCH OF 10.
   ALL OTHERS WILL BE CHECKED MECHANICALLY ONLY.
2. USE 6" LEADS FOR TEST, WITH ALIGATOR CUPS ON ENDS.

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
4	7	SCBP0632BN4	SCREW, MACHINE	
2	6	TE104-2	TERM, LUG LKG	
X	5	GL104-2	INSG VARN, ELEC	
X	4	BS100	SOLDER, TIN ALLOY	
X	3	W1125-2	WIRE ELEC MAG H CER	
1	2	SEE CHART 1	COIL, FORM	
2	1	PM557	INSERT, COIL FORM	

F. BUDETTI — LIST OF MATERIAL

2	BCT-10KA	
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE A: S401-451

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

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

MATERIAL

FINISH

FINAL APPROVAL		DATE 4/15/68
MECH. DES.		DATE 4-15-68
ELECT. DES.		DATE 4/15/68
CHECKED		DATE 4-15-68
DRAWN	J.W.	DATE 11-6-67

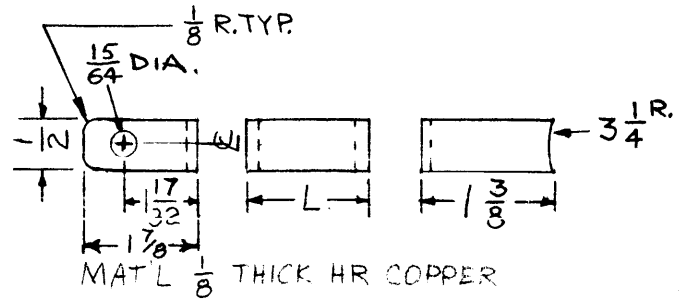
THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL, DECOUPLING, PLATE

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL 426	Ø

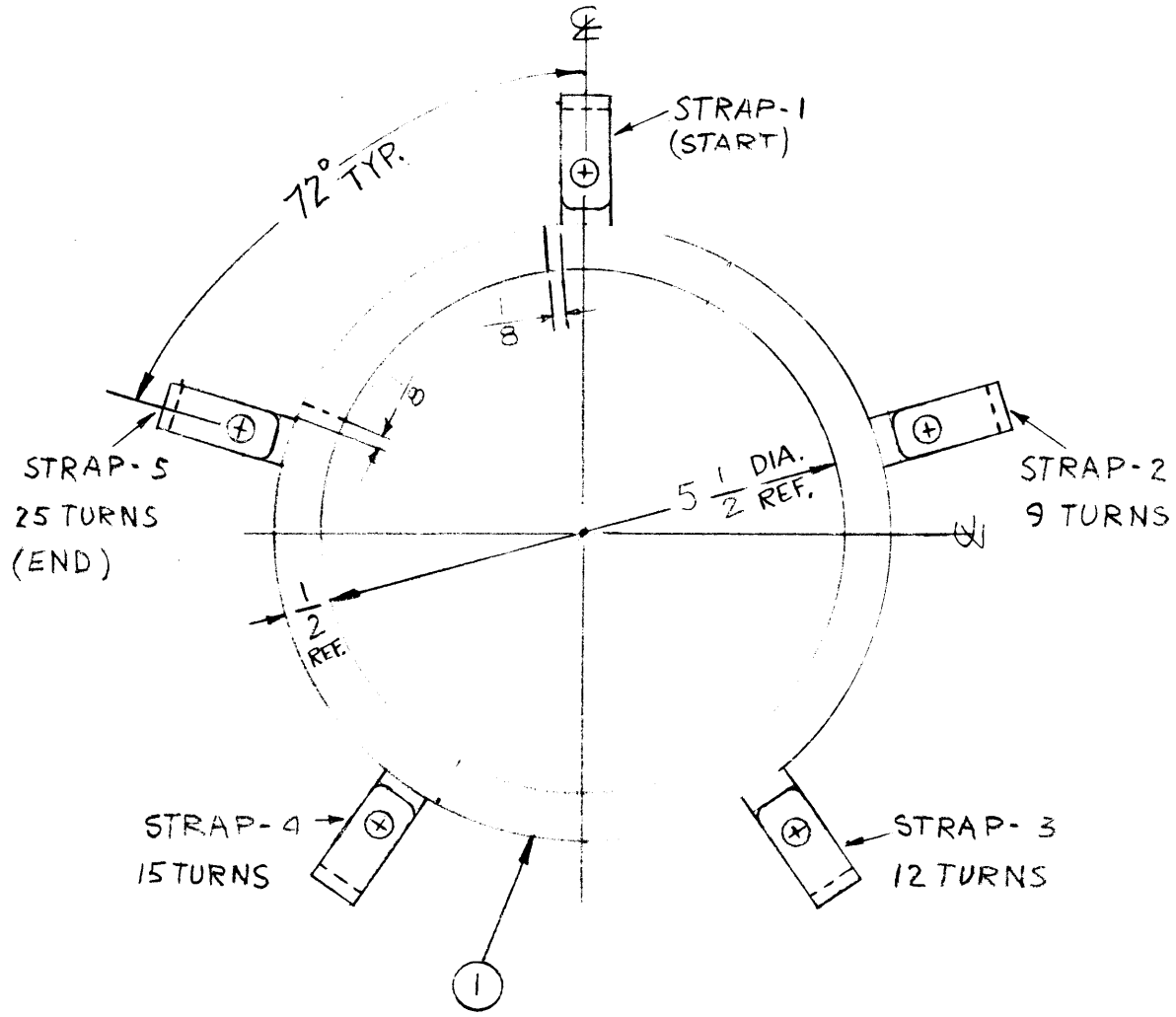
SCALE | SHEET OF

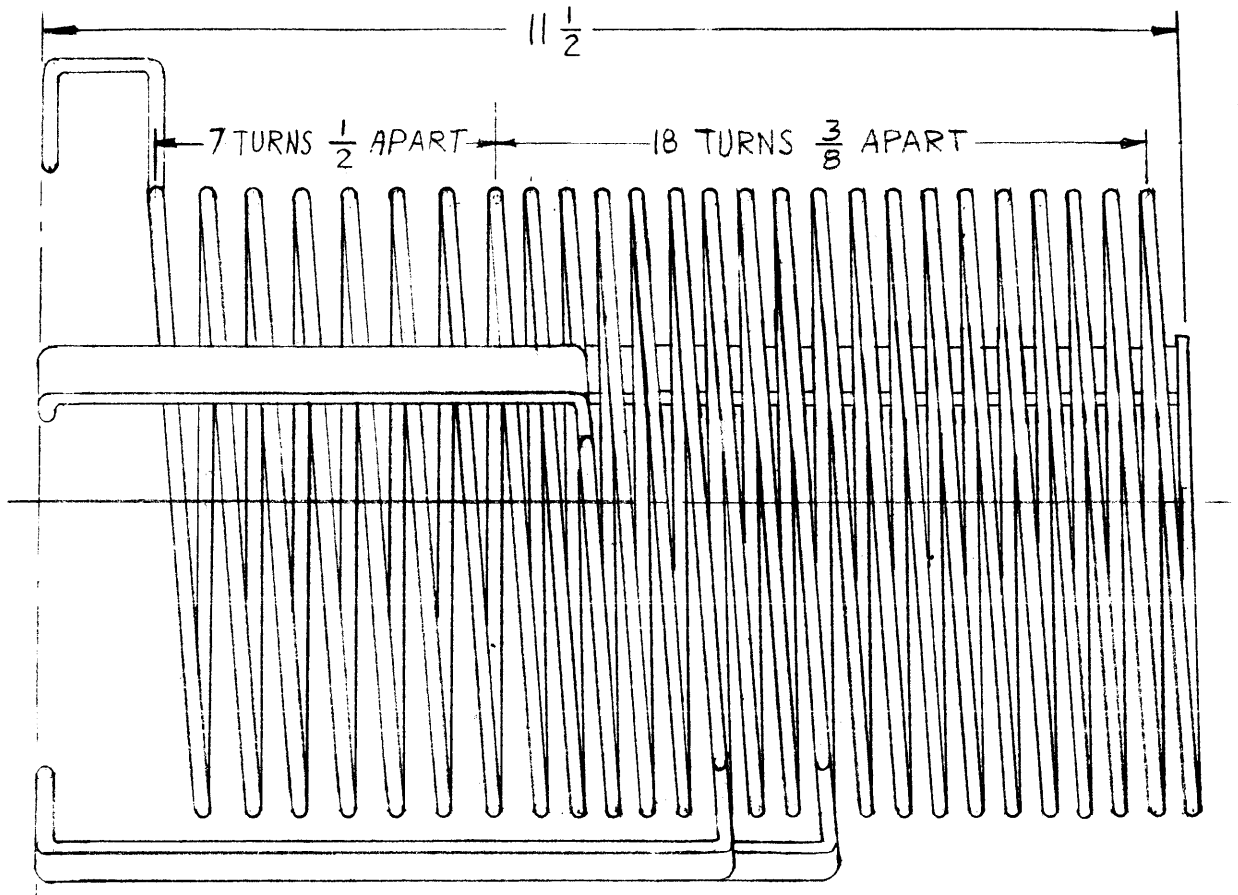
FCI-10-170 (10-66)



TMC P/N	STRAPS				
	1	2	3	4	5
CL427	1-1/4	5 3/8	6-5/8	7-7/8	11-1/2
CL427-2	1-1/4	OMIT	OMIT	OMIT	11-1/2

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP. RELEASE	9-25-67		H.G.		
	B	ORIG. RELEASE FOR PILOT	5-16-68	B	PG		
	A	CHG. DIM. FR 1/4 TO 1/2 REF.	3/30/71	20304	GE	GE	
	B	CHG. HOLE LOC. DIM. ON STRAP	6-22-71	20389	RF		
	C	ADDED TABLE	4/28/72	20640	GE	EG	EG





NOTE:
SILVER SOLDER ALL STRAPS WITH IT.2
ROUND ALL CORNERS & EDGES

X	2	BS101	BRZG ALLY, SILVER	
1	1	CL133-4-25 CW	COIL, RF, FXD	
REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.

F. BUDETTI — LIST OF MATERIAL

1	MFTR-10KE5	BMA482
1	BCT-10KA	AS133
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE A: 5401-451

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

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

MATERIAL: SEE DWG

FINISH: S135 NICKEL PLATE BRIGHT

FINAL APPROVAL		DATE 5-10-68
MECH. DES.	AVC	DATE 5-10-68
ELECT. DES.		DATE 5-10-68
CHECKED		DATE 5-10-68
DRAWN	H.G.	DATE 9-25-67

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

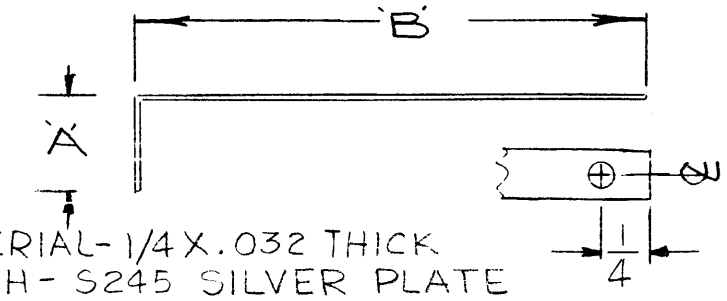
COIL, RF

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL427	C

SCALE 1:2 — SHEET OF

FCI-10-170 (10-66)

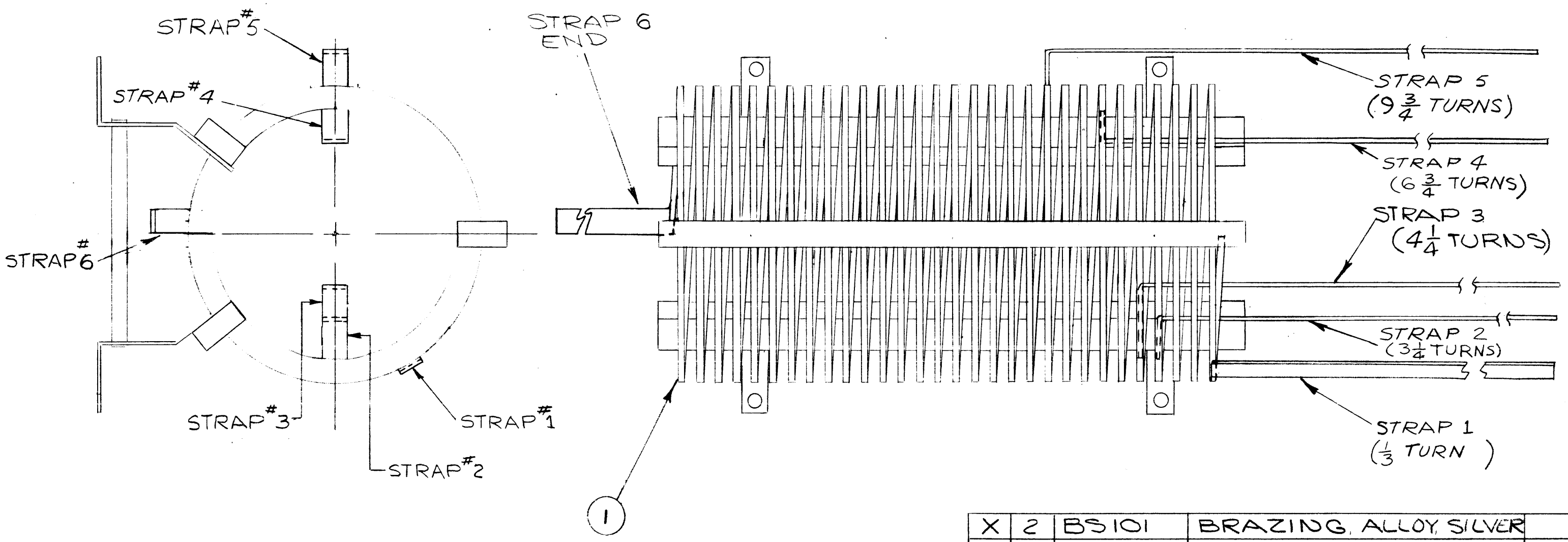
STRAP	"A" DIM	"B" DIM	HOLE
1	—	4"	—
2	3/8"	5"	—
3	3/8"	6"	—
4	3/4"	6"	—
5	3/8"	7"	—
6	3/8"	6"	11/64



MATERIAL - 1/4 X .032 THICK
FINISH - S245 SILVER PLATE
S423 SILVER KOTE

REVISIONS

ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP RELEASE	11-13-67				
	X1	ADDED STRAP 1	1-24-67				
	X2	ADDED STRAP 4	2.15.68				
	Ø	ORIG RELEASE FOR PROD	5-24-66		R.G.		



X	2	BS101	BRAZING, ALLOY, SILVER	
1	1	CL118-22	COIL, RF, FIXED	
REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.

F. BUDETTI — LIST OF MATERIAL

NOTES:
SOLDER STRAPS TO COIL AS SHOWN USING ITEM 2

1	LPA-2	
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE A	S401-451

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

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

MATERIAL

FINISH

FINAL APPROVAL		DATE 5-29-68
MECH. DES.		DATE
ELECT. DES.	E.V.	DATE 5/29
CHECKED		DATE 5-29-68
DRAWN	Machinery	DATE 11-13-67

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

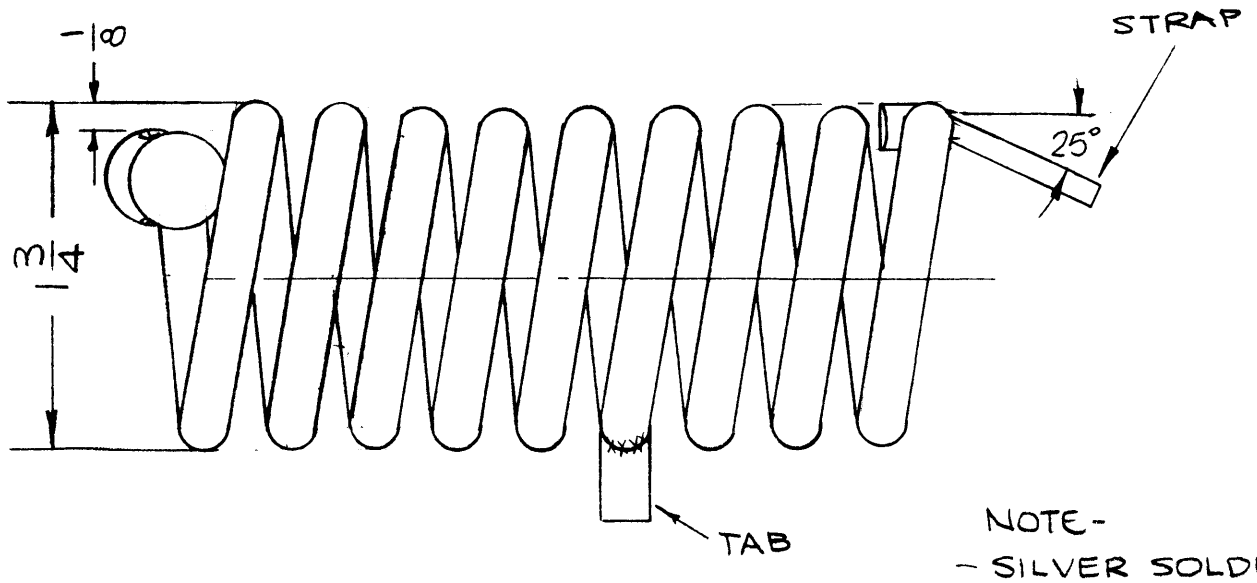
COIL, RF, FIXED

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL428	Ø

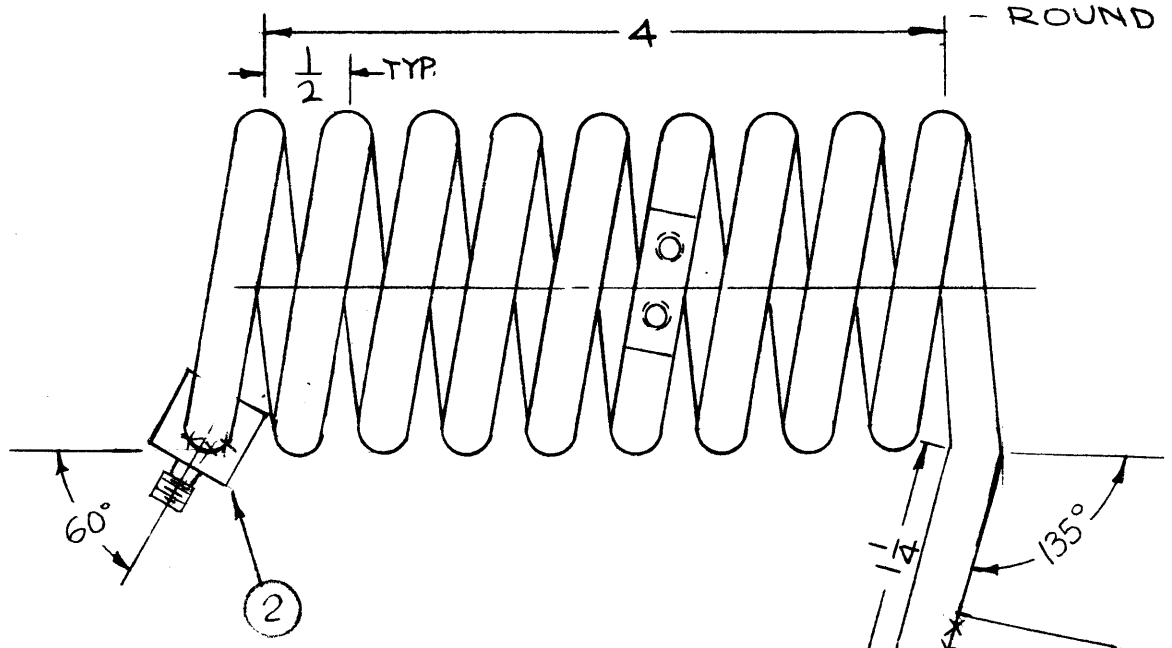
SCALE 1:1 — SHEET — OF

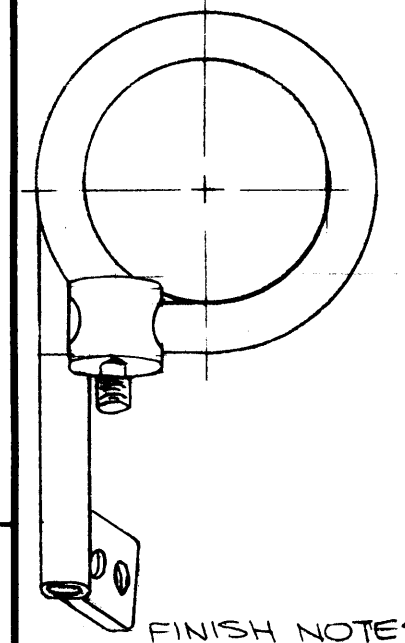
FCI-10-170 (10-66)

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP. RELEASE	11-9-67				
	X1	135° WAS 120, STRAP & TAB REV.	12-18-67				
	Ø	ORIG. RELEASE FOR PROD	2/6/68	Ø	C.V.		



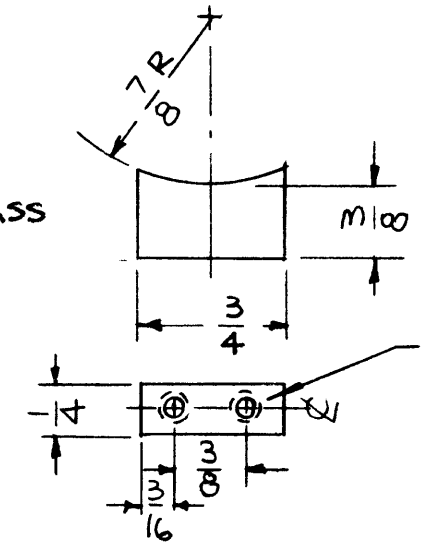
NOTE-
- SILVER SOLDER PARTS AS SHOWN.
- ROUND ALL EDGES.





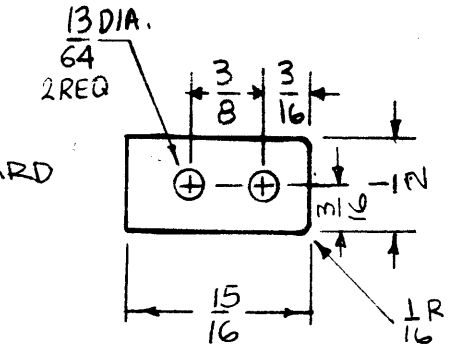
FINISH NOTES:
1-SAND BLASTED
2-COPPER FLASHED
3-S245 SILVER PLATED
4-.000025 RHODIUM FLASH
5- BREAK ALL CORNERS

MATERIAL:
1/2 HARD BRASS



TAB DETAIL

MATERIAL:
1/8 HALF HARD COPPER.



STRAP DETAIL

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
1	2	PM561	MTG STUD, COIL	
X	1	BS101	BRAZING ALLOY, SILVER	

LIST OF MATERIAL

QTY / UNIT	1
MODEL USED ON	TLAA-2.5K
ASS'Y NO.	
APPLICATION	
CODE A	5401-451

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

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

MATERIAL
5/16 O.D. COPPER TUBING

FINISH
SEE NOTES

FINAL APPROVAL	F. BUDETTI	DATE 2/6/68
MECH. DES.		DATE 12/27/67
ELECT. DES.		DATE
CHECKED		DATE 2-6-68
DRAWN		DATE 11-9-67

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL, RF

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL429	Ø

SCALE — SHEET OF

Inductance ±10%	Q min	Test frequency	Self-resonant frequency, min	DC resistance maximum	Rated DC current[2]	Incremental current
uh		mc	mc	Ohms	ma	ma
0.10	50	25	250	.025	2900	2900
.12	51	25	250	.034	2800	2800
.15	51	25	250	.037	2750	2750
.18	50	25	250	.047	2200	2200
.22	49	25	250	.067	1700	1700
.27	47	25	250	.11	1500	1500
.33	46	25	250	.13	1300	1300
.39	44	25	250	.18	1100	1100
.47	44	25	235	.25	1000	1000
.56	43	25	210	.33	900	900
.68	42	25	190	.45	750	750
.82	40	25	180	.59	600	600
1.00	47	25	140	.07	1900	1900
1.20	46	7.9	130	.093	1600	1600
1.50	45	7.9	115	.12	1300	1300
1.80	43	7.9	105	.14	1200	1200
2.20	45	7.9	100	.19	1100	1100
2.70	46	7.9	92	.28	950	950
3.30	44	7.9	85	.35	800	800
3.90	44	7.9	75	.40	750	750
4.70	44	7.9	70	.55	650	650
5.60	47	7.9	65	.72	550	550
6.80	50	7.9	55	1.02	500	500
8.20	50	7.9	50	1.32	475	475
10.0	49	7.9	46	1.62	450	450
12.0	55	2.5	44	2.00	400	400
15.0	44	2.5	49	.80	620	250
18.0	45	2.5	45	.89	610	235
22.0	46	2.5	41	.96	600	220
27.0	49	2.5	38	1.19	500	200
33.0	45	2.5	34	1.37	490	190
39.0	53	2.5	29	1.93	410	180
47.0	52	2.5	27	2.11	400	175
56.0	49	2.5	25	2.23	380	160
68.0	51	2.5	21	2.70	370	150
82.0	45	2.5	10.5	2.44	360	140
100.0	52	2.5	10.0	3.12	325	120
120.0	57	.79	9.7	3.60	290	95
150.0	56	.7	8.5	4.10	275	90
180.0	60	.79	8.0	4.40	260	85
220.0	58	.79	7.5	5.00	250	80
270.0	60	.79	7.0	5.80	240	70
330.0	54	.79	6.5	6.40	225	65
390.0	67	.79	6.2	7.40	200	60
470.0	60	.79	5.7	9.50	180	58
560.0	60	.79	4.7	10.5	174	55
680.0	60	.79	4.5	11.8	168	50
820.0	57	.79	4.2	13.0	152	45
1,000.0	65	.79	3.8	17.5	135	40
1,200.0	45	.25	1.5	22.1	115	35
1,500.0	49	.25	1.2	26.5	110	33
1,800.0	47	.25	1.0	29.9	105	30
2,200.0	50	.25	.97	33.8	99	27
2,700.0	47	.25	.92	47.3	83	25
3,300.0	43	.25	.84	53.0	80	22
3,900.0	43	.25	.80	73.8	67	20
4,700.0	44	.25	.74	81.6	63	19
5,600.0	45	.25	.73	98.9	56	17
6,800.0	43	.25	.66	111.0	54	16
8,200.0	42	.25	.54	119.0	52	15
10,000.0	39	.25	.47	137.0	49	14
12,000.0	31	.079	.33	143.0	46	13
15,000.0	31	.079	.29	157.0	45	12
18,000.0	31	.079	.28	175.0	41	10
22,000.0	27	.079	.25	274.0	33	9
27,000.0	27	.079	.21	308.0	31	8
33,000.0	27	.079	.19	343.0	30	7.5
39,000.0	27	.079	.17	376.0	27	6.0
47,000.0	23	.079	.16	473.0	26	5.5
56,000.0	23	.079	.14	512.0	25	5.0
68,000.0	23	.079	.13	580.0	24	4.0
82,000.0	21	.079	.12	618.0	23	3.5
100,000.0	18	.079	.11	678.0	22	3.0

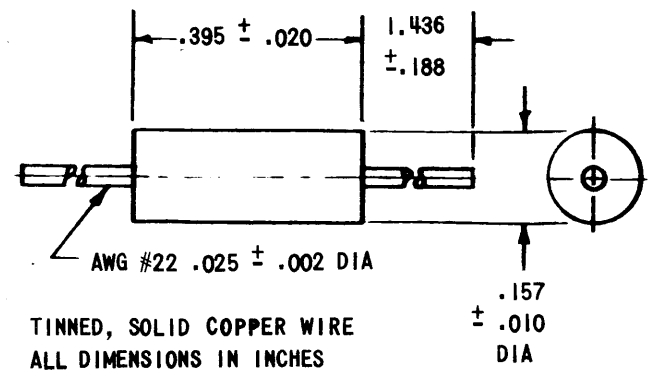
MOISTURE, VIBRATION, AND SHOCK RESISTANCE:

MEETS REQUIREMENTS OF MIL-C-15305C, GRADE 1, CLASS B. HIGH FREQUENCY 10 CPS TO 2000 CPS @15G ±10% MAXIMUM FOR 12 LOGARITHMIC SWINGS EACH OF 20 MINUTE DURATION REPEATED FOR EACH OF THREE MUTUALLY PERPENDICULAR PLANES.

NOTE:

MANUFACTURED PER MS90537

MFR (TMC CODE NO.): S401-134



TINNED, SOLID COPPER WIRE
ALL DIMENSIONS IN INCHES

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXPERIMENTAL RELEASE	5/2/68		C.V.		
	Ø	ORIG. RELEASE FOR PROD	10/24/68	Ø	R.G.		

SPECIFICATIONS

MAXIMUM OPERATING TEMP: 125°C
TEMPERATURE RISE: 35°C
AMBIENT TEMPERATURE: 90°C
TERMINAL PULL: 5 POUNDS
DIELECTRIC WITHSTANDING VOLTAGE: 700 VOLTS RMS (SEA LEVEL)
ALTITUDE (BAROMETRIC PRESSURE): 70,000 FEET
COUPLING: 3% MAX
OPERATING TEMP: -55° TO 125°C
WEIGHT: .750 GRAMS OR LESS
TEST VOLTAGE AT 70,000 FEET: 180 VOLTS RMS

TMC PART NUMBER WILL BE IN THE FOLLOWING FORMAT:

CL 433 - 10 4

- CL 433 - BASIC P/N
- 10 - SIGNIFICANT FIGURES
- 4 - LAST DIGIT DENOTES NUMBER OF ZEROS
- INDUCTANCE IN(uH) (SEE CHART)

EXAMPLES:

104 = 100,000 uH
332 = 3,300 uH
681 = 680 uH
150 = 15.0 uH
8R2 = 8.20 uH
R27 = 0.27 uH

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.

LIST OF MATERIAL

QTY / UNIT	MODEL USED ON	ASS'Y NO.
	HFSR-4	

APPLICATION

CODE

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

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

MATERIAL

FINISH

FINAL APPROVAL		DATE
MECH. DES.		DATE
ELECT. DES.		DATE 10/24/68
CHECKED		DATE 10/21/68
DRAWN	C.V.	DATE

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COILS, RADIO FREQUENCY, MOLDED
SUBMINIATURE, SHIELDED, MAGNETIC

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL 433	Ø

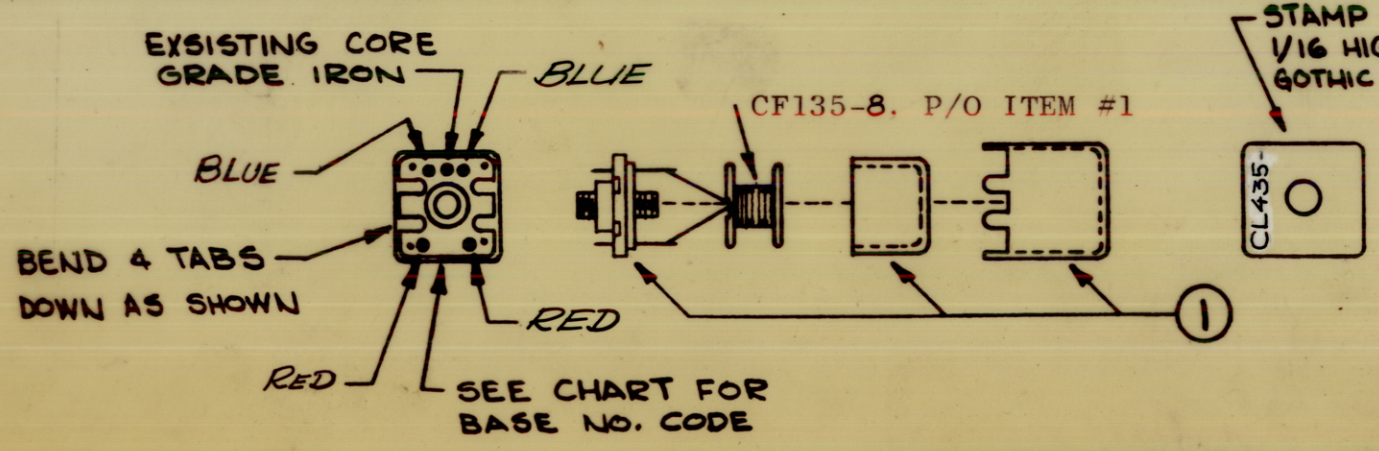
SCALE | SHEET OF

FCI-10-170 (10-66)

TMC P/N	*NO OF TURNS	"Q" TEST FREQ.	"Q" MIN	EXT CAR. Q METER	ITEM 3	LOAD RESISTOR	INDUCTANCE "Q" METER
CL435-1	130	790Kc	75		WI104-12/43SNQS	18K	150µ W/SLUGFLUSH
CL435-2	25	7.9Kc	50		Wi104-3/41-SNQS	82K	6µ W/SLUG FLUSH

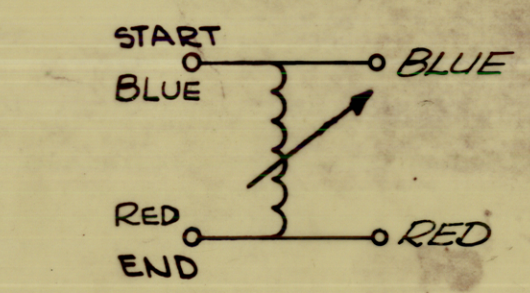
WINDING PROCEDURE

1- WIND * TURNS OF ITEM 3 ON ITEM 1, STAKE WITH ITEM 4.
2- BAKE COIL FOR 15 MIN. AT 150°F, REMOVE FROM OVEN AND COAT COIL WITH ITEM #5.
3- COLOR CODE TERMINALS ON BASE AS SHOWN.
4- STRIP AND TIN LEADS TO WITHIN 1/4" OF COIL.
5- PLACE BOBBIN OVER SLUG ON BASE, TAKING CARE TO POSITION NOTCHES ON RAISED PART OF BASE.
6- SOLDER ALL LEADS TO PROPER COLOR-CODED TERMINALS ON BASE.
7- ASSEMBLE AS PER ASSEMBLY DRAWING, PLACE IN CASE; BEND THE 4 TABS DOWN IN THE NOTCHES.
8- DO NOT CUT OFF THE TWO LONG TABS.
9- CODE THE BASE, AS PER CHART.
10- STAMP TMC PART NO. AS SHOWN ABOVE.
11- TEST INDUCTANCE, AND Q AS SHOWN ABOVE.(WITH SLUG FLUSH)
12- BAKE COMPLETED ASSEMBLY FOR ONE HOUR AT 212°F.
13- REMOVE COMPLETED ASSEMBLE FROM OVEN AND ALLOW TO COOL TO ROOM TEMPERATURE.
14- REPEAT STEP NO. 11.
15- DELETED.
16- DELETED
17- TEST COIL WITH "Q" METER 260A. WITH LOAD RESISTOR ACROSS SECONDARY
18- SET THE TEST FREQUENCY AS SHOWN ABOVE. AND SET THE (MULTIPLY "Q" X) TO 1.
19- TUNE THE INDUCTANCE DIAL. TO REACH THE MAX. READING ON THE "Q" METER.

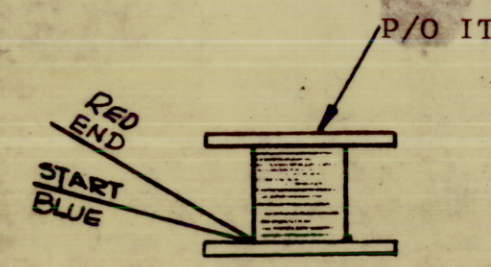


NOTES

REVISIONS						
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X	EXPER. RELEASE	10-24-68		HZ		
Ø	ORIG. RELEASE FOR PROD.	10/28/68	Ø	R.G.		
A	COMPL. REVISED	1/2/69	19175	LH.		FB
B	CHG TMC STAMP CL435 WAS CL374	3/12/69	19339	GE		



SCHEMATIC DIAGRAM



WIRING DETAIL

X	6	BS-100	SOLDER, SOFT	
X	5	GL-130	ADHESIVE, Q-DOPE	
X	4	GL-103	ADHESIVE, N-CEL	
X	3	SEE CHART	WIRE, ELECTRICAL,	
—	—	—	—	
1	1	CI-136-2	CORE, ADJUSTABLE TUNING	
REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL

POSE

LIST OF MATERIAL

1	MTR-1	PC 471	
Q'T'Y./UNIT	MODEL USED ON	ASS'Y. NO.	
SCALE	CODE		

MATERIAL —

FINISH —

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

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

THE TECHNICAL MATERIEL CORP.
MAMARONECK. NEW YORK

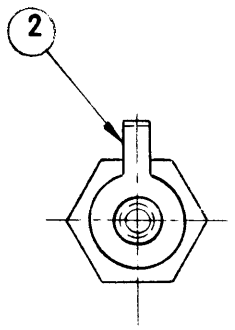
TITLE: COIL, RF, ADJ.

DRAWN	HZ	DATE	10 24 68	FINAL APPROVAL	DATE
CHECKED		DATE	10/23/68		
ELECT. DES.		DATE	10/28/68	CL435	B
MECH. DES.		DATE		SHEET	REV. LTR.

TMC FORM 100 REPROVEL NO. 440H 10197

TMC P/N	NO OF TURNS	WIRE	"A"	FORM	INDUCTANCE ±10%	CORE	* CAPACITOR	FIG
CL438-1	100	W1141-29	1-5/16"	CF138	60uh	C1109-12	CM15B301J	A
-2	100	W1141-29	1-5/16"	CF138	40uh	NONE	CM15B301J	A
-3	75	W1141-29	1"	CF138	30uh	NONE	CM15B101J	A
-4	48 TAP AT 28	W1123-25	1-3/16"	CF138	10uh 6.5/4.5	NONE		B
-5	11	W1123-14	1-3/16"	CF138	0.8uh	NONE		A
-6	11	W1123-14	1-3/16"	5/8	0.8uh	AIR		C

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP. RELEASE	3/31/69		KH		
	Ø	ORIG RELEASE FOR PROD	7/1/69	Ø	CV		



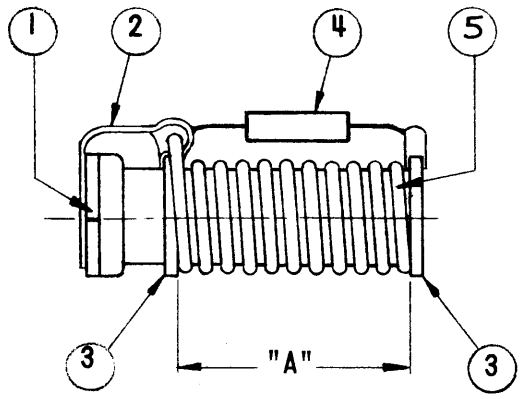


FIGURE A

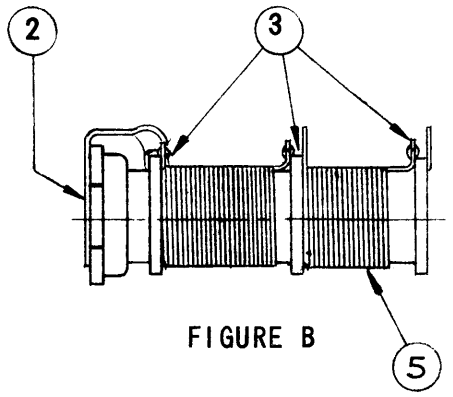


FIGURE B

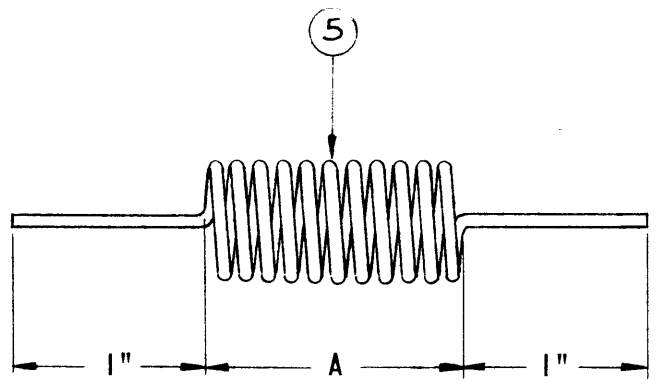


FIGURE C

MFG ASSEMBLY INSTRUCTIONS

1. PLACE ITEM 3 ON ITEM 1 AT LOCATION "A" AS SHOWN.
2. WIND ITEM 5 ON ITEM 1 AS SHOWN AND SOLDER TO ITEM 3 ALONG WITH ITEM 2 AND ITEM 4 ACCORDING TO CHART.
3. CUT OFF THREADED PORTION OF ITEM 6, COAT WITH ITEM 7, AND POSITION IN CENTER OF COIL. (CL438-1 ONLY).
4. COAT COIL WITH ITEM 8 AND BAKE IN OVEN 1/2 HOUR AT 215°F
5. TEST FOR INDUCTANCE ON Q METER AS SHOWN ON CHART.

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
	8	GL104-2	INSULATING, VARNISH, ELEC	
	7	GL103	ADHESIVE, NITRO CELLULOSE BASE	
	6	C1109-12	CORE, TUNING	
	5	WIRE		
	4	CAPACITOR *		
	3	TE146-1	COLLAR & LUG	
	2	TE111-1	LUG, SOLDER	
	1	CF138	FORM, COIL	

LIST OF MATERIAL

QTY / UNIT	MODEL USED ON	ASS'Y NO.
	MTR( )-150	

APPLICATION

CODE

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

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

MATERIAL

FINISH

FINAL APPROVAL		DATE 7/17/69
MECH. DES.		DATE
ELECT. DES.		DATE 7/15/69
CHECKED		DATE 4-1-69
DRAWN	R. Hill	DATE 3/31/69

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

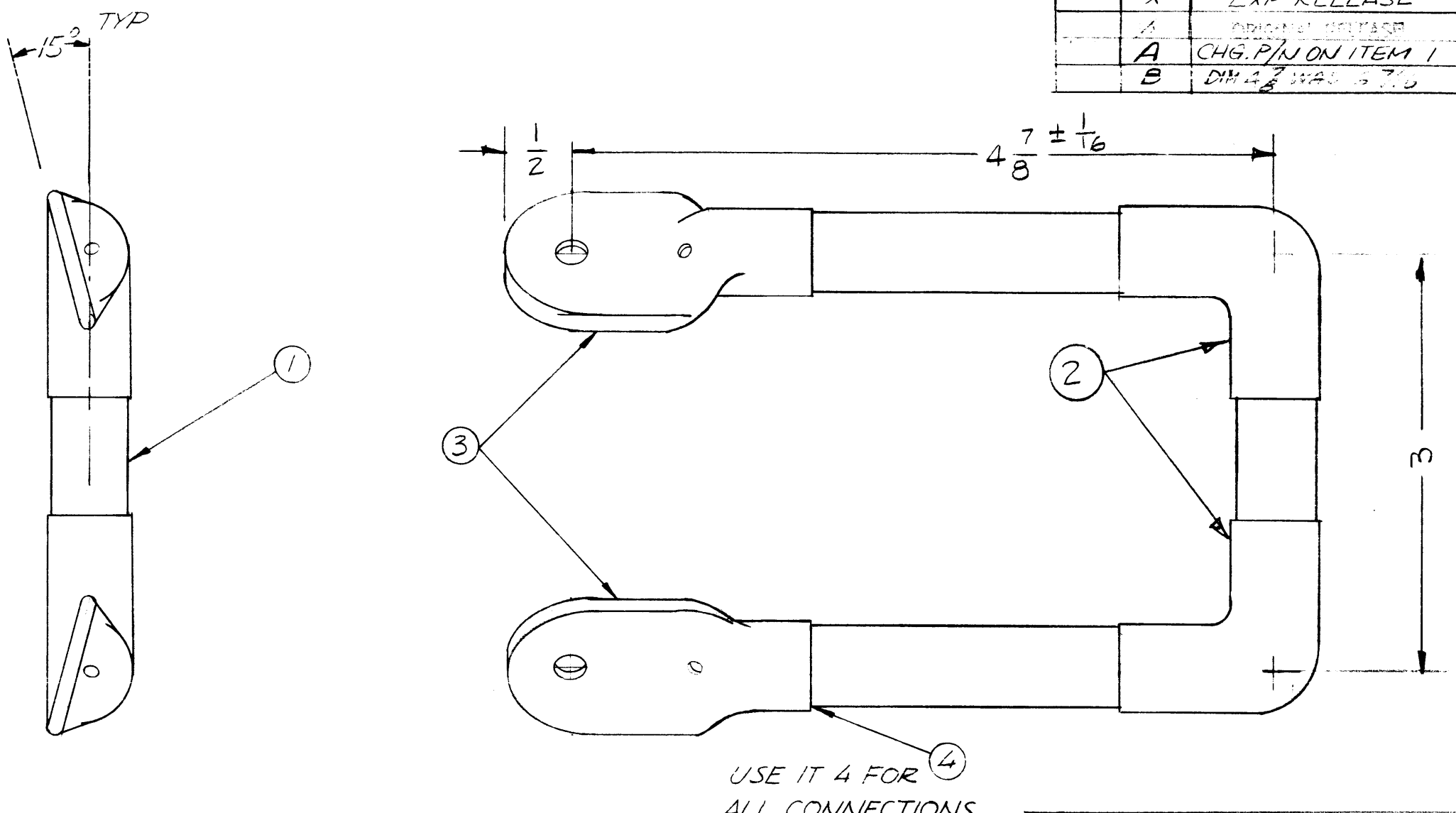
COIL, RF, FIXED

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL 438	Ø

SCALE 1:1 SHEET OF

FCI-10-170 (10-66)

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP RELEASE	9-16-69		GE		
	A	CHG. P/N ON ITEM 1	3-24-70	20563	GE	EJ	EJ
	B	DIM A 7/8 WAS 7/8	2-25-71	21693	GDL		



REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
X	4	BS 101	SOLDER, SILVER	
2	3	TE 178-3	LUG	
2	2	P0324	ELBOW PIPING 1/2 COPPER	
X	1	TU-104-8	TUBING HARD TEMPER	

F. BUDETTI — LIST OF MATERIAL

1	PALA10K	AX5084
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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

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

MATERIAL

FINISH S245 SILVERPLATE

FINAL APPROVAL		DATE 1-70
MECH. DES.	ALP.	DATE 1-70
ELECT. DES.		DATE
CHECKED		DATE
DRAWN	G EVANGELIST	DATE 9.16.69

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

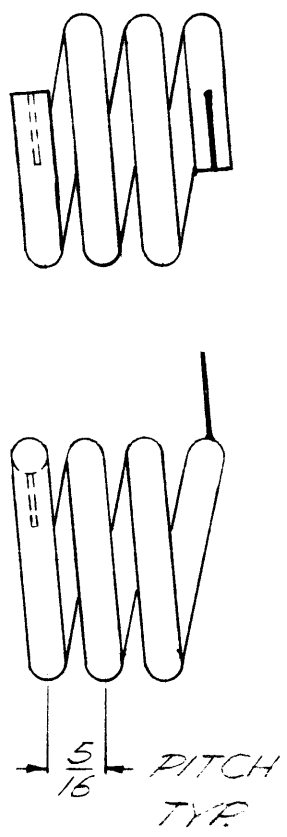
COIL, R.F., HIGH FRE.

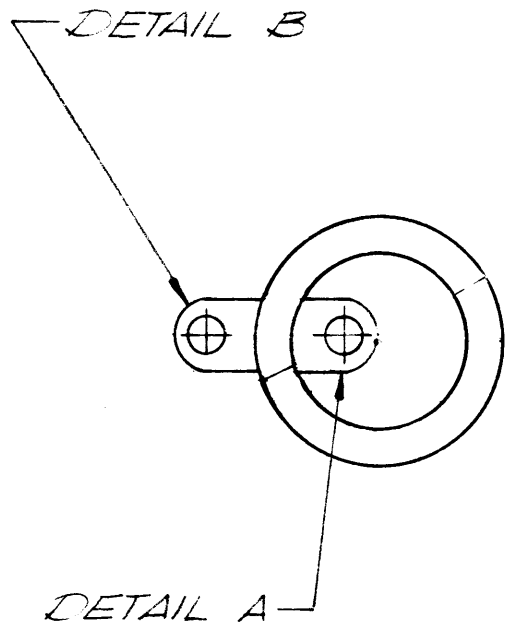
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL-441	B

SCALE NTS — SHEET OF

FCI-10-170 (10-66)

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP RELEASE	11-12-69		GE		
	Ø	ORIGINAL RELEASE FOR PR	1/14/70		GE		





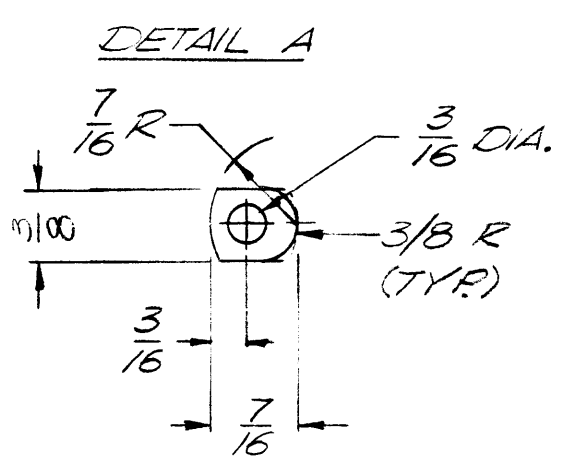
SPECIFICATIONS

COIL TO BE 3 TURNS OF 3/16 COPPER TUBING.

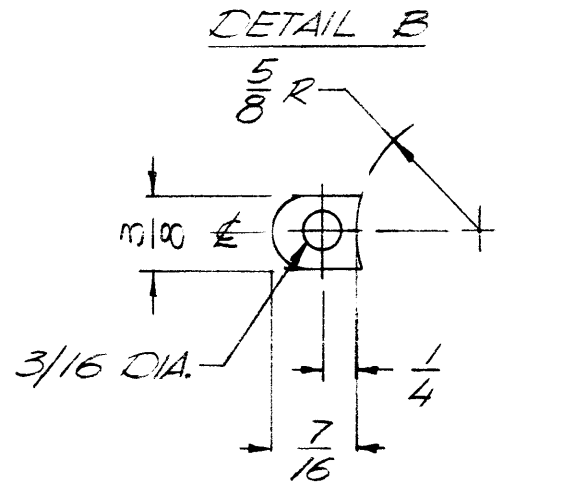
USE ITEM 1 TO ATTACH STRAPS TO COIL

FINISH: S245 SIL PLATE, SIL KOTE S423

O.D. 1 1/4 I.D. 7/8



.030 H.R. COPPER



.030 H.R. COPPER

X	1	BS 101	SOLDER SILVER	
REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.

F. BUDETTI — LIST OF MATERIAL

1	PALA-10K	AX5080
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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

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

MATERIAL SEE NOTES

FINISH SEE NOTES

FINAL APPROVAL		DATE 12-2-70
MECH. DES. ALP		DATE 12-2-70
ELECT. DES.		DATE
CHECKED		DATE
DRAWN EVANGELIST		DATE 11-12-69

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL INDUCTANCE

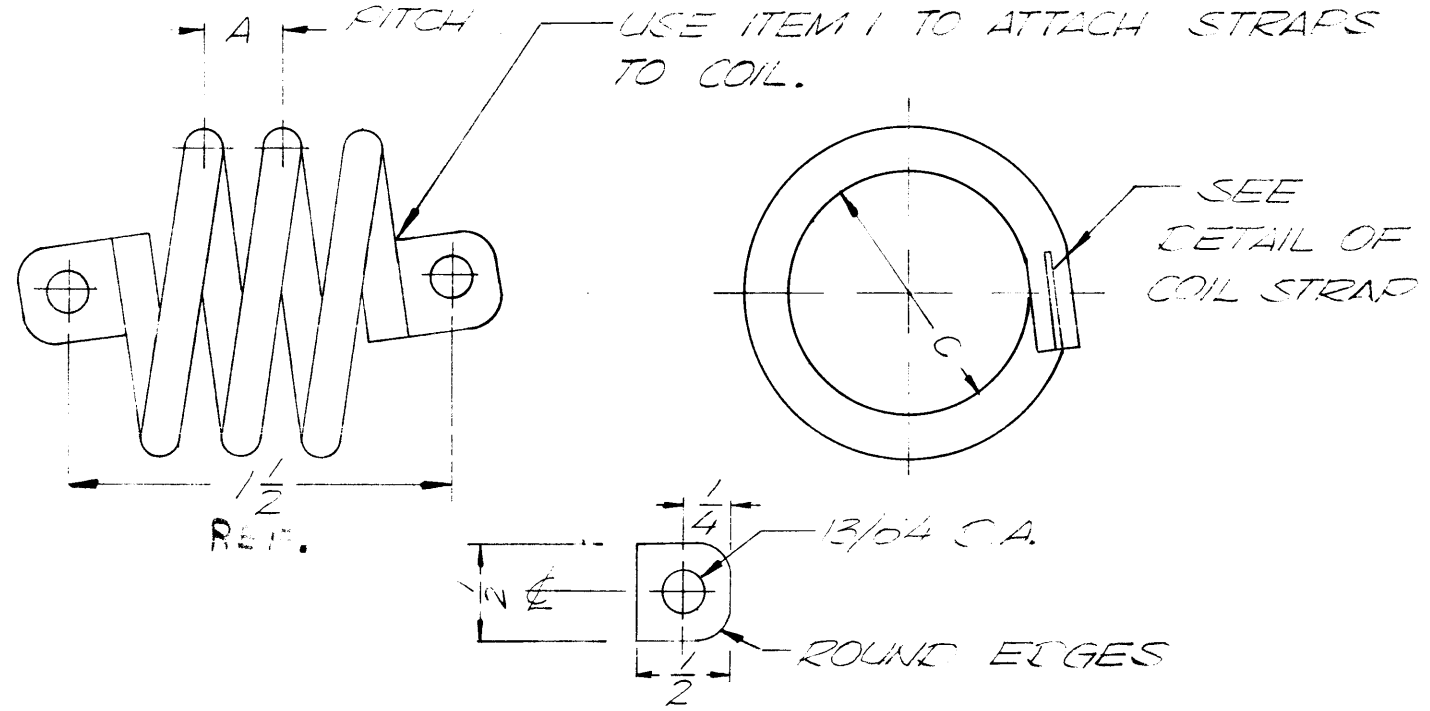
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL448	Ø

SCALE 1:1 — SHEET OF

FCI-10-170 (10-66)

TMC PART NO.	A (PITCH)	C(I.D.)	TURNS	FINISH	MATERIEL
CL 449-1	27/64	15/16	2	S 245	TU100-3
CL 449-2	27/64	1 3/8	2	S 245	TU100-3
CL 449-3	9/32	1 3/8	3	S 245	TU100-3

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP RELEASE	5/27/70		GE		
	Ø	ORIG RELEASE FOR PROD	6/1/70		CV		
	A	ADD NOTE - SOFT COPPER	4672	20585	GE	ES	ES



STRAP - SOFT COPPER .030 THK.

PART NO.	INDUCTANCE SEE NOTE
-1	.11 - .13 uh
-2	.14 - .16 uh
-3	.27 - .29 uh

NOTE: VALUE OF COIL MUST BE MAINTAINED AT JUST PITCH TO ACCOMPLISH.

X	1	ES 101	SOLDER, SILVER	
REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.

LIST OF MATERIAL

	AF 110	
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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

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

MATERIAL AS NOTED

FINISH AS NOTED

FINAL APPROVAL		DATE 5/27/70
MECH. DES.		DATE
ELECT. DES.		DATE 5/26/70
CHECKED		DATE 5/26/70
DRAWN	EVANGELOT	DATE 5/27/70

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

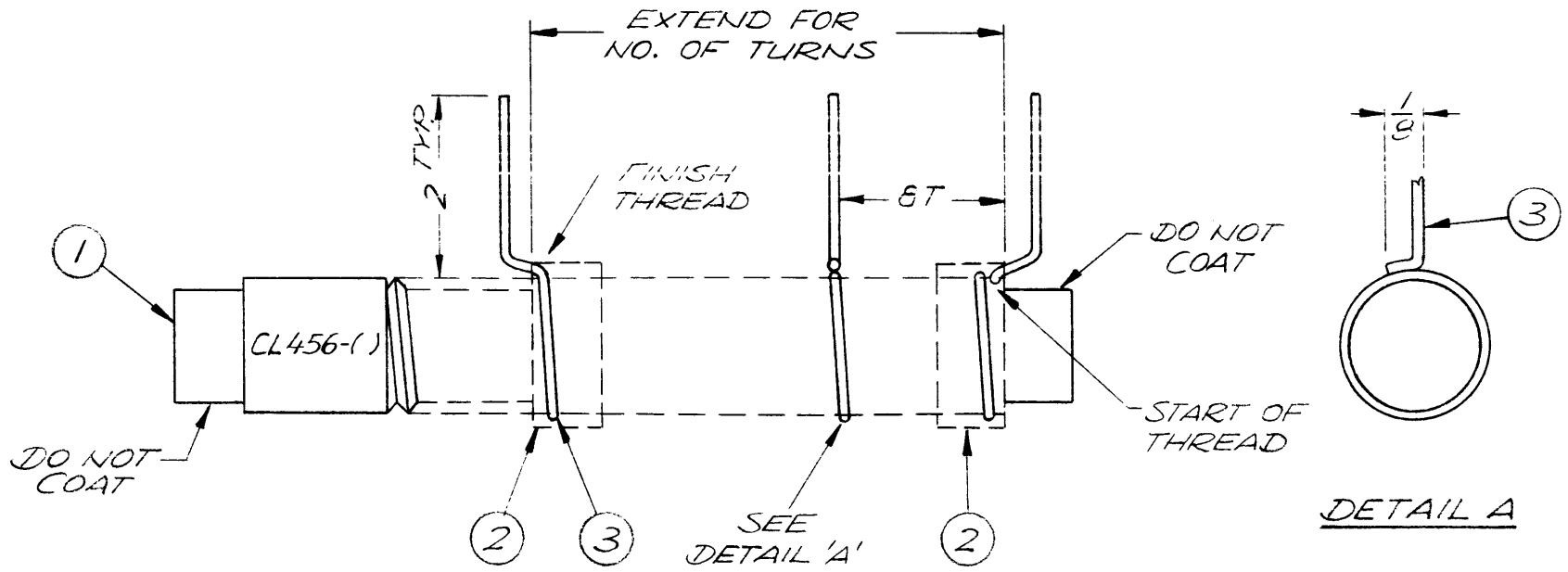
COIL, RF

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL 449	A

SCALE NTS | SHEET OF

FCI-10-170 (10-66)

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X1	REDRAWN WITH CHANG.	10/6/69		KH.	MD	
	Ø	ORIG RELEASE FOR PROD	4/3/70		CV		



PROCEDURE

1. ASSEMBLE COIL FROM ITEM 1 ON A .250 MANDREL CAPABLE OF HOLDING COIL FORM SECURE AND UNDAMAGED AGAINST WINDING TENSION OF 2.5 TO 3.0 INCH-POUNDS AS MEASURED ACROSS MANDREL WITH INCH-POUNDS SCALE.

2. 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.

3. 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.

4. 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
CL456-1	CF141-4	42	L1, L2, L3
CL456-2	CF141-3	30	L4, L5, L6
CL456-3	CF141-2	18	L7, L8, L9
* CL456-4	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	1	SEE CHART	COIL FORM THREADED	

LIST OF MATERIAL

POSE

QTY / UNIT	MODEL USED ON	ASS'Y NO.
3	HERR-4	AX5005

APPLICATION

CODE

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

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

MATERIAL

FINISH

FINAL APPROVAL		DATE 4-3-70
MECH. DES.		DATE
ELECT. DES.	[illegible]	DATE 4-2-70
CHECKED	[illegible]	DATE 10/17/69
DRAWN	[illegible]	DATE 10/6/69

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

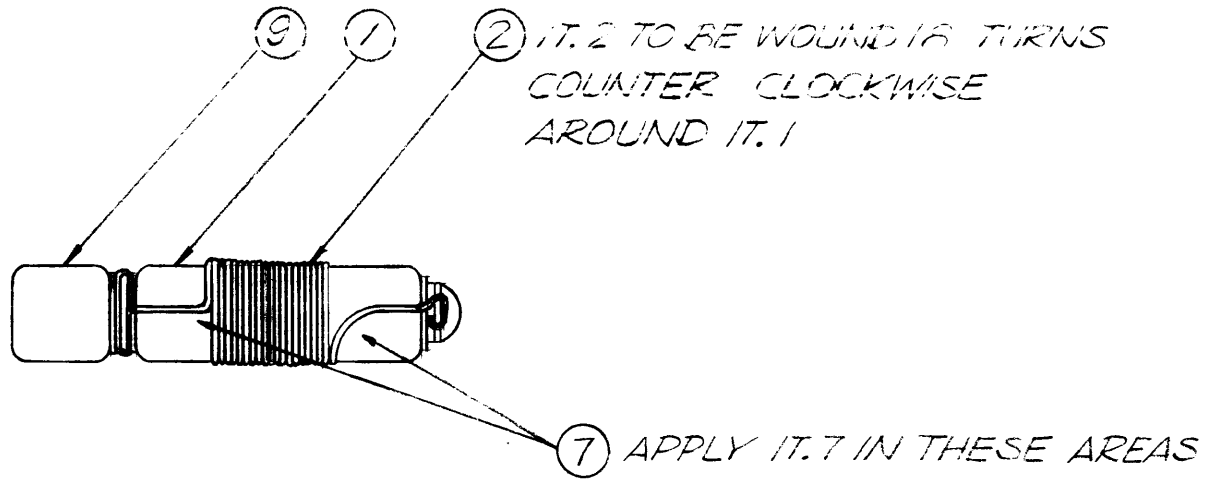
COIL, RF, TUNER

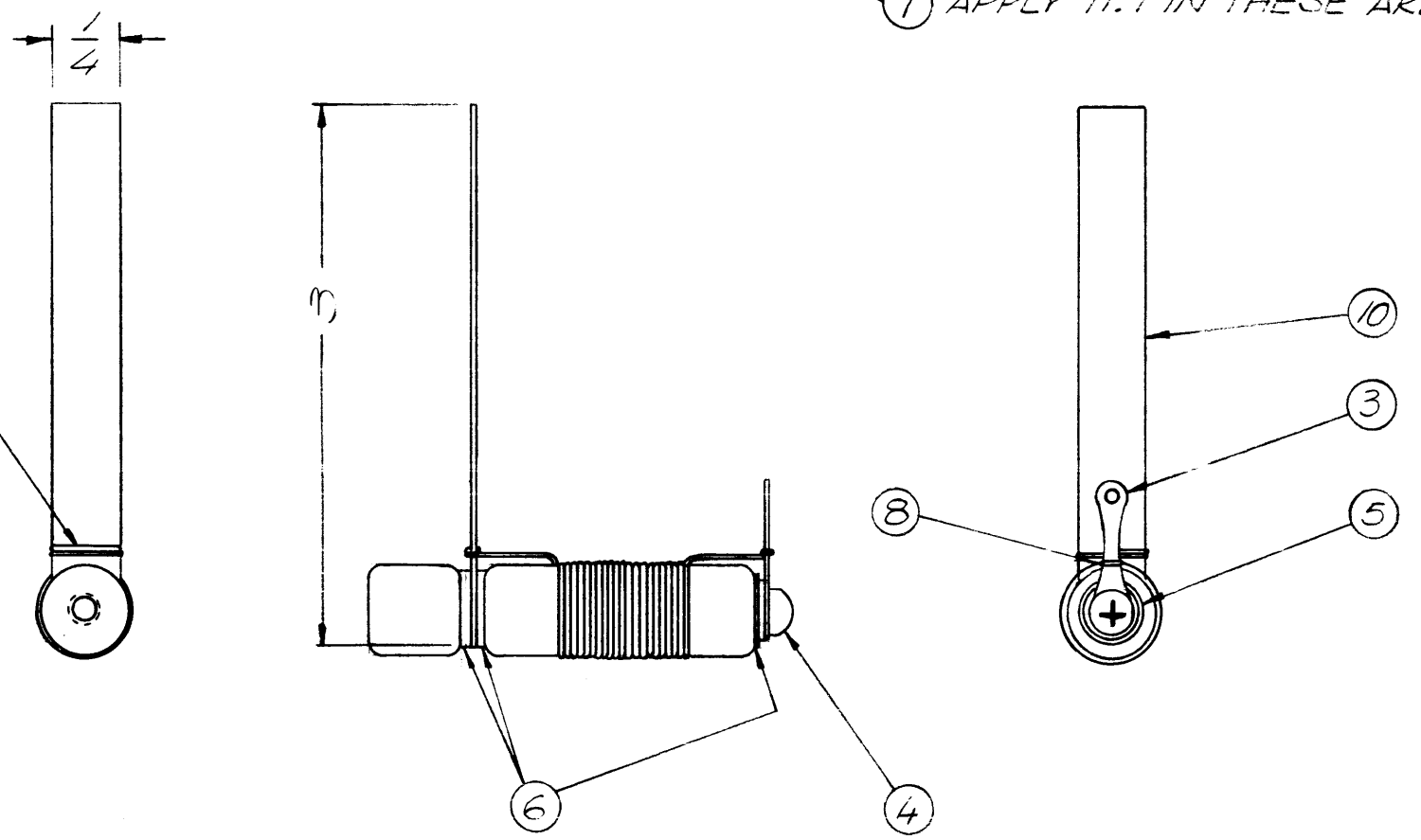
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL 456	Ø

SCALE | SHEET OF

FCI-10-170 (10-66)

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP RELEASE	10/2/69		GE		
	Ø	ORIGINAL RELEASE	2/6/70		GE		
	A	CHG. IT. 10 P/N	6/20/70	19904	GE		FB
	B	CHG. NO. OF TURNS	11/11/70	20069	GE		





REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
1	10	MS 203-3-3.000	LEAD CONNECTING	
1	9	NS3W02-04	INSULATOR STANDOFF	
X	8	BS 100	SOLDER, SOFT	
X	7	GL 105	EPOXY	
3	6	WA 109-45	FIBER WASHER	
1	5	FW 08 HBN	FLAT WASHER	
1	4	SCBP0832BNT	SCREW	
1	3	TE 104-3	SOLDER LUG	
X	2	W1123-22	WIRE ELEC	
1	1	NS3W02-12	INSULATOR STANDOFF	

F. BUDETTI — LIST OF MATERIAL

	HFLA 10K	AX 5113
1	PALA 10K	AX 5080
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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

MATERIAL

FINISH

FINAL APPROV.		DATE 1-70
MECH. DES.	ALP	DATE 1-70
ELECT. DES.	RT	DATE 1-70
CHECKED	T.T	DATE
DRAWN	EVANGELIST	DATE 10-29-69

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

INDUCTOR, FIXED, ASSY.

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL 459	B

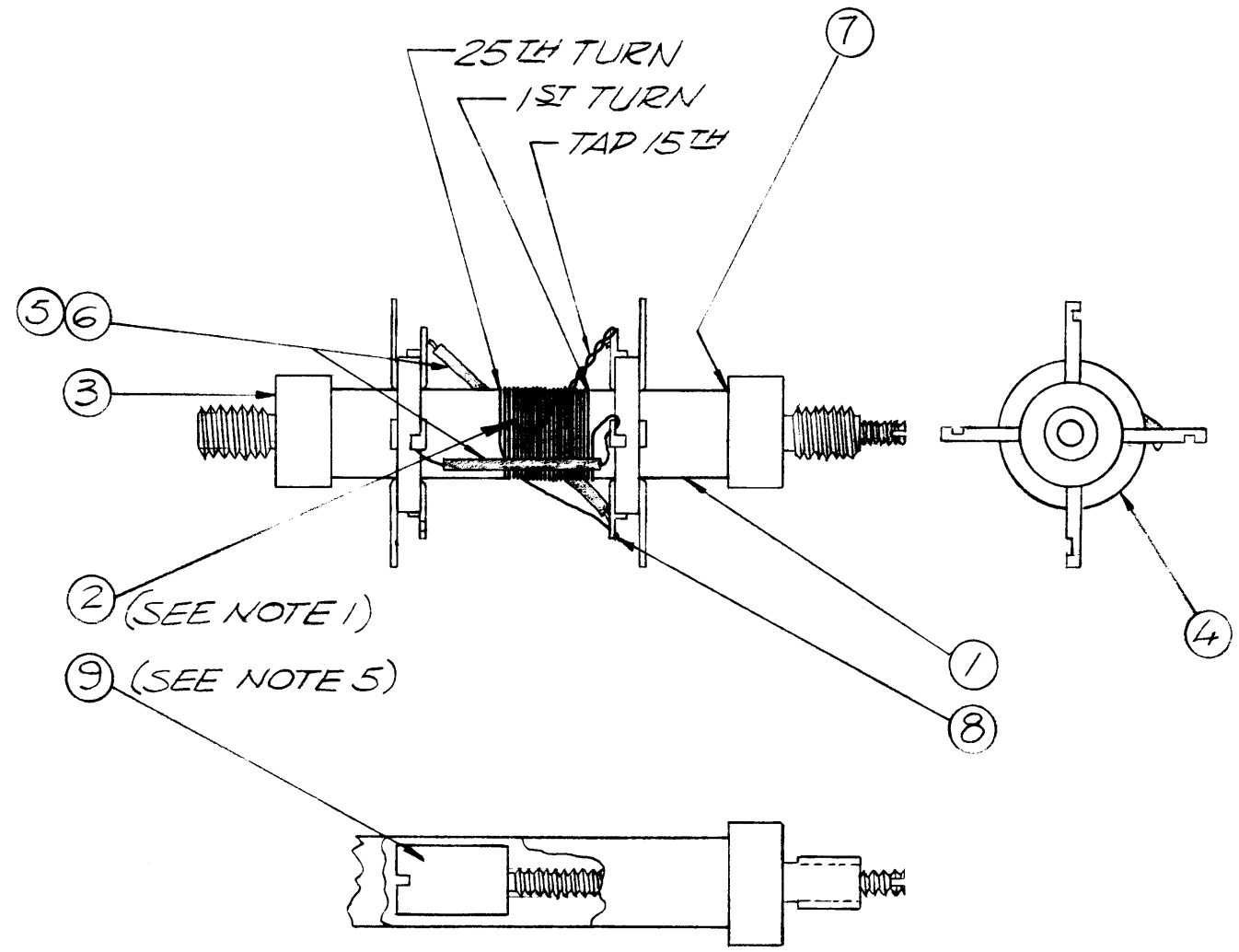
SCALE — SHEET OF

170 (10-66)

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP RELEASE	10 29 69		GE		
	Ø	ORIGINAL RELEASE	2-16-70		GE		
	A	IT. 1 CHG FRM CF122 TO CF122-137	4-21-70	19816	GE		FB
	B	ACC 2ND JUMPER	5/20/70	19903	GE		FB
	C	CHG P/N IT. 4	12/7/70	20141	GE		

~NOTES~

1. WIND ITEM 2, 25 TURNS CLOCKWISE AROUND ITEM 1 AND TAP AT 15 TURNS.
2. FASTEN ITEM 3 TO ITEM 1 WITH ITEM 7.
3. FASTEN ITEM 4 TO ITEM 1 WITH ITEM 7.
4. USE ITEM 8 TO FASTEN WIRE CONNECTIONS.
5. INSERT ITEM 9 FROM END THAT HAS 15 WIRED TURNS (PICTURE RIGHT SIDE)



REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
1	9	CI-116-18	CORE TUNING	
X	8	BS 100	SOLDER, SOFT	
X	7	GL 130	DUCO CEMENT	
X	6	PX 104-2	SLEEVING INS.	
X	5	WL 100-8	BUSS WIRE	
2	4	TE 181-4	COLLAR RING	
2	3	SM 140-2	BUSHING COIL FORM	
X	2	WI 123-30	WIRE ELECTRICAL	
1	1	CF122-1.37	COIL FORM	

LIST OF MATERIAL

QTY / UNIT	MODEL USED ON	ASS'Y NO.
	HFLA-10K	AX 5113
	PALA 10K	AX 5080

APPLICATION

CODE

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

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

MATERIAL

FINISH

FINAL APPROVAL		DATE 3/22/70
MECH. DES.		DATE
ELECT. DES.	T.T.	DATE 3/2/70
CHECKED		DATE
DRAWN	EVANGELIST	DATE 10 30 69

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

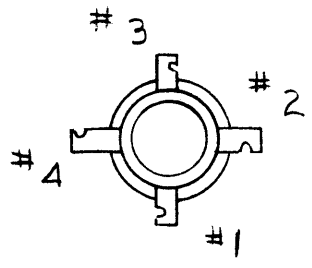
COIL, RF, ADJ.

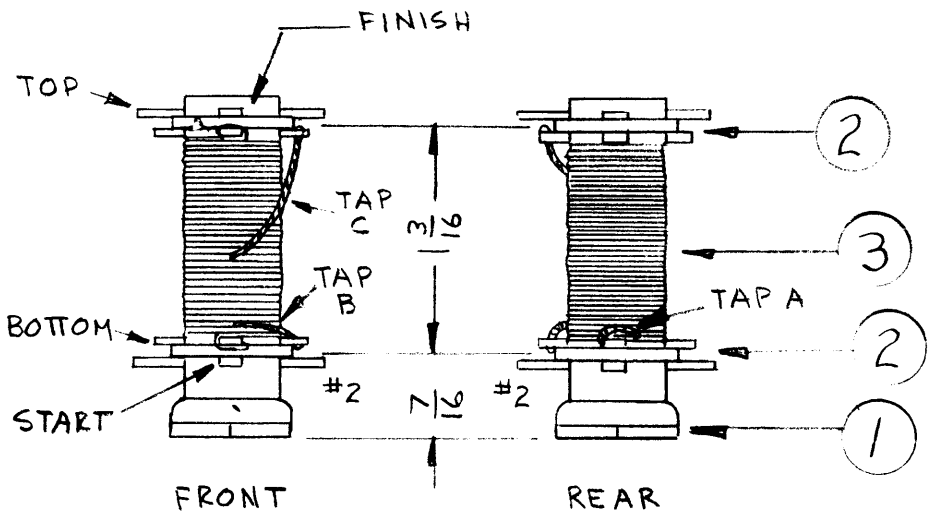
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL 460	C

SCALE 2:1 SHEET OF

FCI-10-170 (10-68)

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	Ø	ORIGINAL RELEASE	11/30/70		Q		



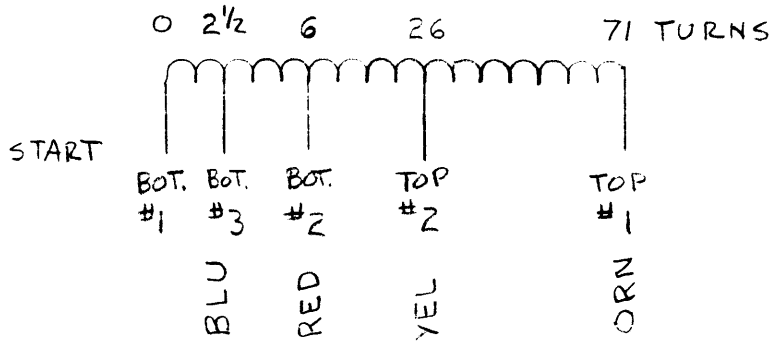


SINGLE LAYER CLOSE WOUND.
WIND COUNTER-CLOCKWISE.
USE IT. 4 AFTER FINISHING.

START AT BOTTOM # 1
TOTAL TURNS - 71
TAP A - 2½ TURNS,* TERMINATE AT BOTTOM # 3
TAP B - 6 TURNS * TERMINATE AT BOTTOM # 2.
TAP C - 26 TURNS.* TERMINATE AT TOP # 2
FINISH AT TOP # 1.

* TURNS FROM START

71 TURNS	25μh ± 5%	Q - 90 ± 5%	TEST FREQ.	2.5 MHz.
26 TURNS	7μh ± 5%	Q - 60 ± 5%	TEST FREQ.	7.9 MHz.



REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
	5	BS100	SOLDER, TIN ALLOY	
	4	GL104-2	UBE, INSULEX	
	3	WI141-28	WIRE, ELEC, MAG	
2	2	TE146-4	TERM LUG, COLLAR	
1	1	CF114-3	FORM, COIL	

LIST OF MATERIAL

QTY / UNIT	2
MODEL USED ON	AX5126
ASS'Y NO.	
APPLICATION	
CODE	

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

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

MATERIAL

FINISH

FINAL APPROVAL		DATE 28 Oct 70
MECH. DES.		DATE 28 Oct 70
ELECT. DES.		DATE
CHECKED		DATE
DRAWN		DATE 28 Oct 70

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

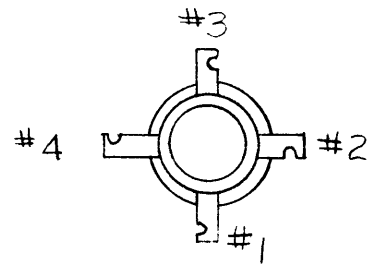
COIL, RF

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL464	

SCALE | SHEET OF

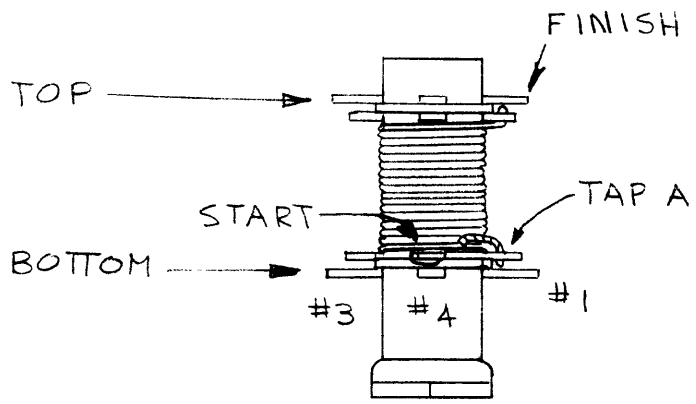
10-170 (10-66)

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	Ø	[illegible] RELEASE	11/30/70		Q		

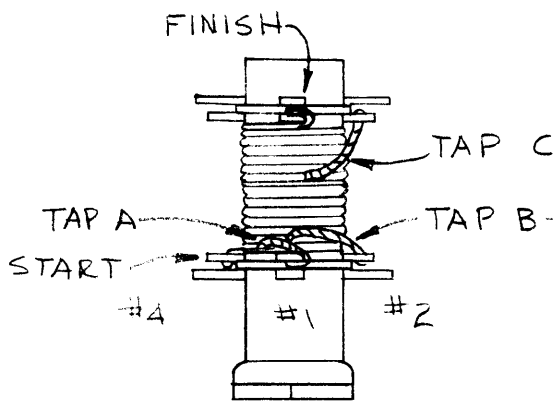


SINGLE LAYER - CLOSE WOUND
WIND COUNTER-CLOCKWISE.
USE IT. 4 AFTER FINISHING.

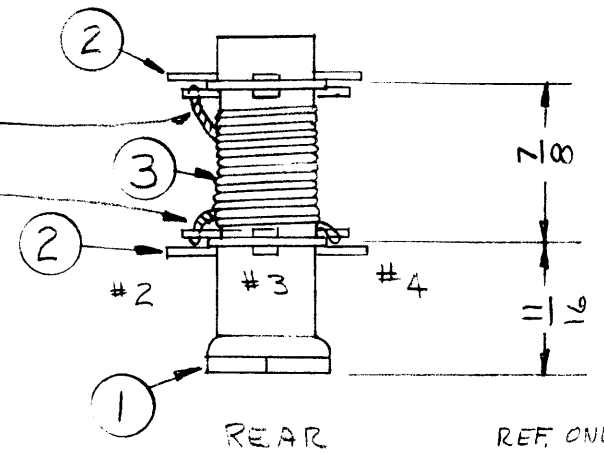
START AT BOTTOM #4.
TOTAL TURNS - 21 1/4
TAP A - BETWEEN 1 & 1 1/4 TURNS *
TERMINATE AT BOTTOM #1.
TAP B - 2 1/4 TURNS * TERMINATE AT BOTTOM #2
TAP C - 9 1/4 TURNS * TERMINATE AT TOP #2
FINISH - 21 1/4 TURNS * TERMINATE AT TOP #1
* TURNS FROM START



LEFT

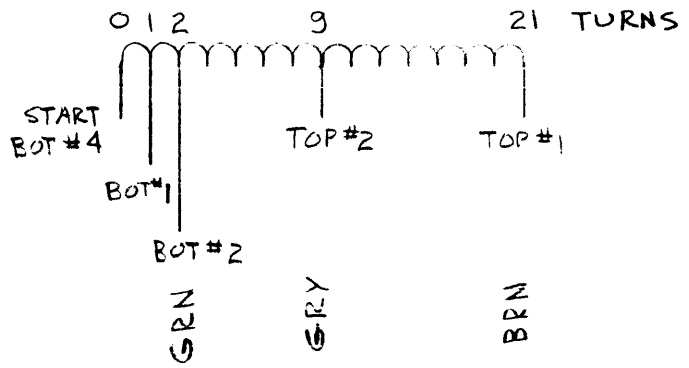


FRONT



REAR

21 TURNS	2.85μh ±5%	Q = 100 ±5%	FREQ 7.9MHz		
REF ONLY 9 TURNS	0.85μh	Q = 40	FREQ 7.9MHz		



REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
	5	BS100	SOLDER, TIN ALLOY	
	4	GL104-2	USE INSULEX	
	3	WI141-20	WIRE, ELEC, MAG	
2	2	TE146-4	TERM LUG, COLLAR	
1	1	CF114-3	FORM, COIL	

BUDETTI — LIST OF MATERIAL

2	AX5126	
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION — CODE

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

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

MATERIAL

FINAL APPROVAL		DATE 30NOV70
MECH. DES.		DATE 30NOV70
ELECT. DES.		DATE 30NOV70
CHECKED		DATE
DRAWN		DATE 30NOV70

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

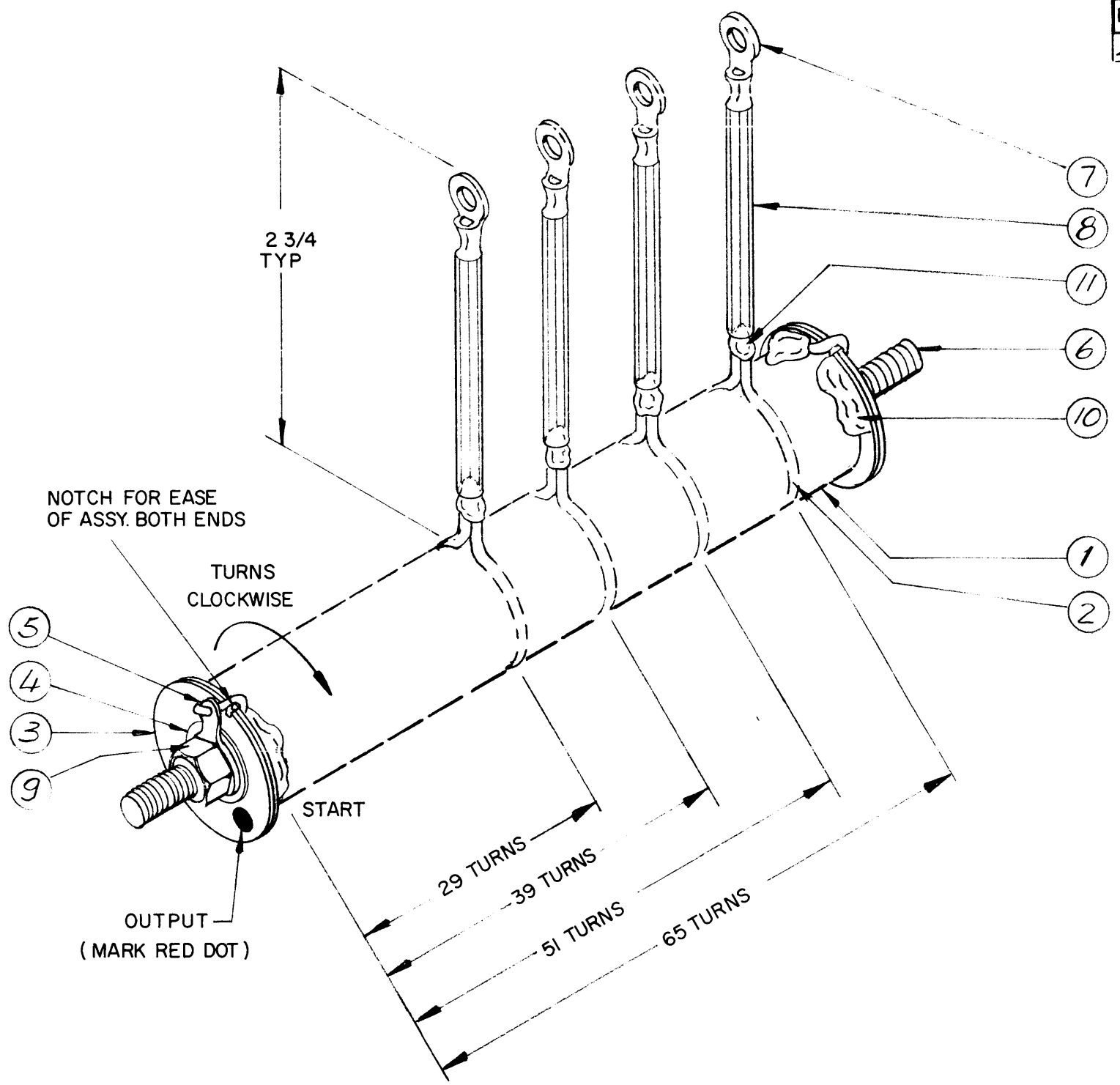
COIL RF

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL465	C

SCALE — SHEET 1

FCI-10-170 (10-66)

REVISIONS							
E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
20909	GE	EJ		B	REVISE COMPLETELY & REDRAWN	10/25/72	EJ



76 TURNS MIN.

WINDING - CLOCKWISE TURNS CLOSE WOUND

FABRICATION

1. ASSEMBLE ITEMS 1, 3, 4, 5, 6, & 9
2. WIND FULL LENGTH AND TAP AS SHOWN AT 29, 39, 51, & 65 TURNS.
3. STAKE ENDS WITH EPOXY & SOLDER TO LUGS
4. FABRICATE TAPS BY INSERTING LEADS APPROX. 2 3/4" LONG, STRIP ENDS, COVER WITH TEFLON & SOLDER ON LUGS.

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
X	11	BS100	SOLDER TIN ALLOY	
X	10	GL125	CEMENT EPOXY	
2	9	NTH2520BN14	NUT, HEX	
X	8	PX370-10-7	INS. SLVG. TEF.	
4	7	TE141-1	TERM LUG	
2	6	SM2520BN1.250	ROD THD.	
2	5	TE104-5	TERM. LUG.	
2	4	FW25HBN	WASHER, FLAT	
4	3	WA110-2	WASHER, FIBER	
X	2	W1139-2	WIRE	
1	1	NS3W0440	INS. STANDOFF	

F.B. LIST OF MATERIAL

1	TLAM-1K	AS147
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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

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

MATERIAL

FINISH

FINAL APPROVAL	BN	DATE 14JAN71
MECH. DES.	BN	DATE 14JAN71
ELECT. DES.	BN	DATE 14JAN71
CHECKED		DATE
DRAWN	BN	DATE 12JAN71

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL, LOAD

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL467	C

SCALE | SHEET OF

FCI-10-170 (10-66)

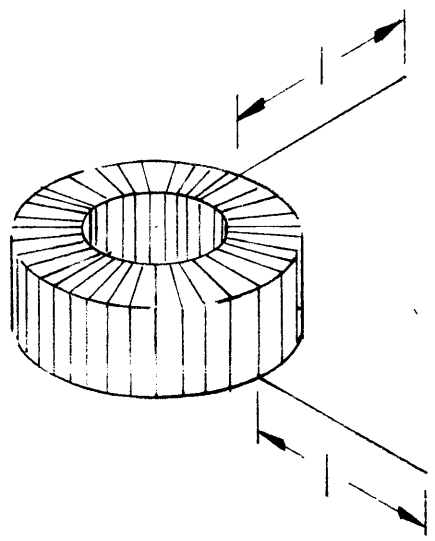
TMC P/N	INDUCTANCE	APPROX NO. OF TURNS	SYMBOL
CL 469-1	45 MH ± 2%	530	L5
CL 469-2	53 MH ± 2%	540	L6
CL 469-3	60 MH ± 2%	565	L4

REVISIONS

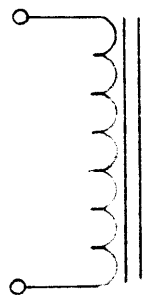
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT
	ø	ORIG RELEASE FOR PROD	6/30/71		CV

NOTES

INDUCTANCE TO BE MEASURED AT 1KC USING 1/4 % BRIDGE.
QUAN: 2
TYPE: WIRE LEAD (PRI. 1" LONG TINNED)



— SCHEMATIC —



QTY / UNIT	MODEL USED ON	ASS'Y NO.
	MMX(A)-2A	A-4884

APPLICATION

CODE

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

MATERIAL

FINISH

FINAL APPROVAL		DATE 6/30/71
MECH. DES.		DATE
ELECT. DES.		DATE 6/30/71
CHECKED		DATE
DRAWN	GE	DATE 6/11/71

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
1	2	C1-103-8	COIL, FORM	
X	1	W1 141-30	WIRE ELECTRICAL	

LIST OF MATERIAL

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL AUDIO, FIXED

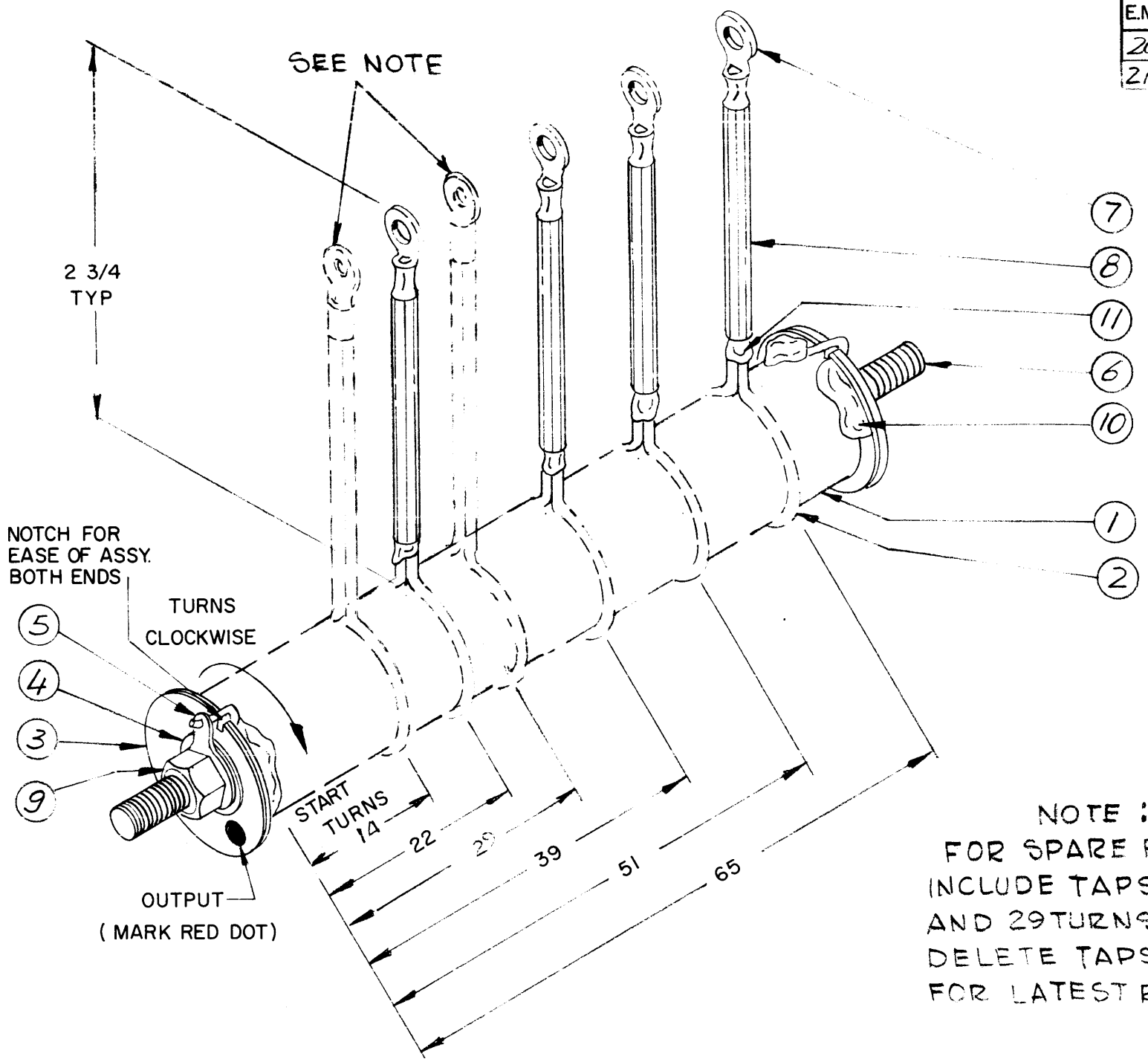
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL 469	

SCALE

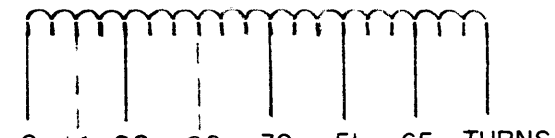
SHEET OF

FCI-10-170 (10-66)

REVISIONS							
E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
20909	GE			A	REVISED & REDRAWN	10/25/72	
21652	G.D.L.			B	NOTE ADDED	6-17-73	



NOTE :
FOR SPARE PARTS
INCLUDE TAPS 14 TURNS,
AND 29 TURNS.
DELETE TAPS AS SHOWN
FOR LATEST REVISED UNITS.



76 TURNS MIN.

WINDING - CLOCKWISE TURNS CLOSE WOUND

FABRICATION

1. ASSEMBLE ITEMS 1, 3, 4, 5, 6, & 9
2. WIND FULL LENGTH AND TAP AS SHOWN AT 14, 22, 29, 39, 51 AND 65 TURNS
3. STAKE ENDS WITH EPOXY & SOLDER TO LUGS
4. FABRICATE TAPS BY INSERTING LEADS APPROX. 2 3/4" LONG, STRIP ENDS, COVER WITH TEFLON & SOLDER TO LUGS.

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
X	11	BS100	SOLDER TIN ALLOY	
X	10	GL125	CEMENT EPOXY	
2	9	NTH2520BN114	NUT, HEX	
X	8	PX370-10-7	INS. SLVG. TEF.	
6	7	TE141-1	TERM LUG	
2	6	SM2520BN1.250	ROD THD.	
2	5	TE104-5	TERM LUG.	
2	4	FW25HBN	WASHER FLAT	
4	3	WA110-2	WASHER FIBER	
X	2	WI139-2	WIRE	
1	1	NS3W0440	INS. STANDOFF	

F.B.

LIST OF MATERIAL

QTY / UNIT	MODEL USED ON	ASS'Y NO.
1	TLAA-1K	AS160

APPLICATION

CODE

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

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

MATERIAL

FINISH

FINAL APPROVAL		DATE
MECH. DES.	BN	DATE 12JUL71
ELECT. DES.	BN	DATE 12JUL71
CHECKED		DATE
DRAWN	GE	DATE 7-13-71

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL, LOAD

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL472	B

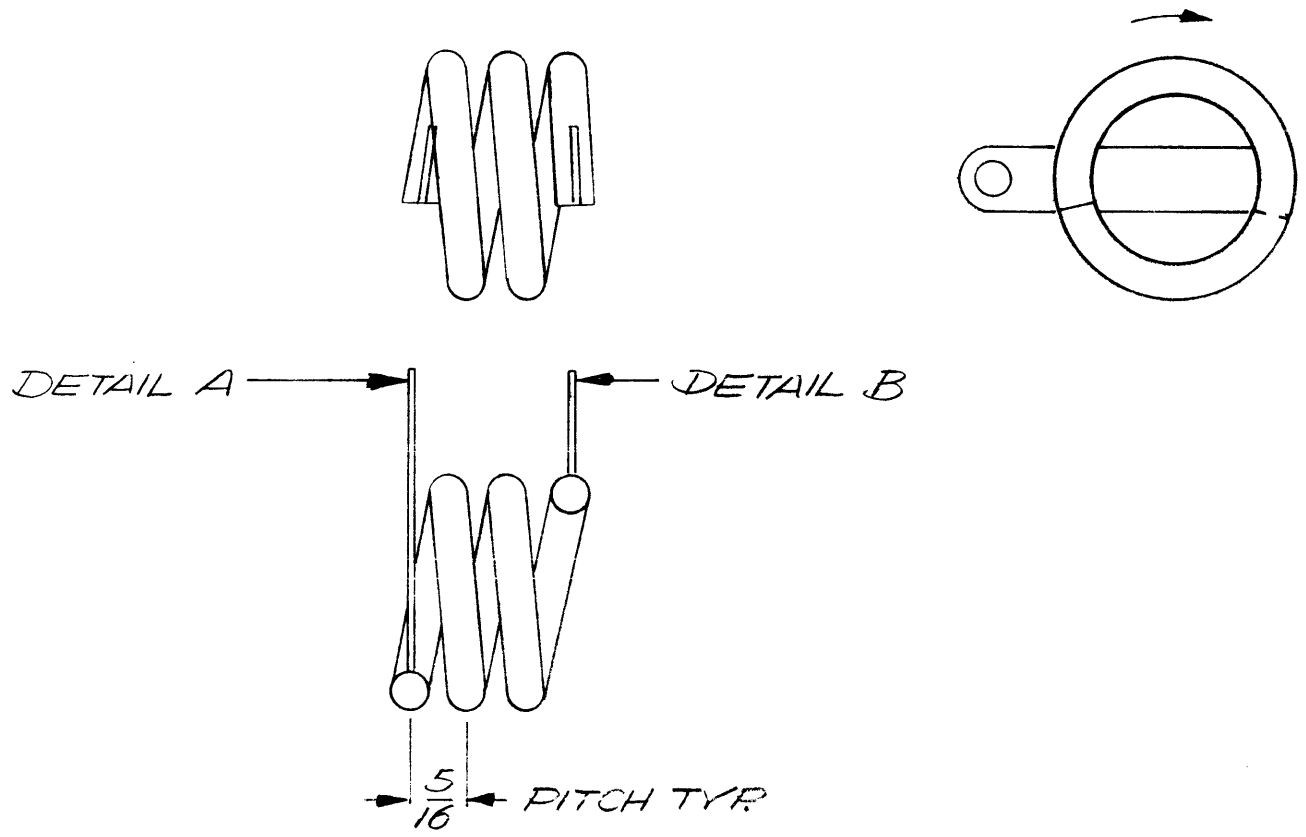
SCALE | SHEET OF

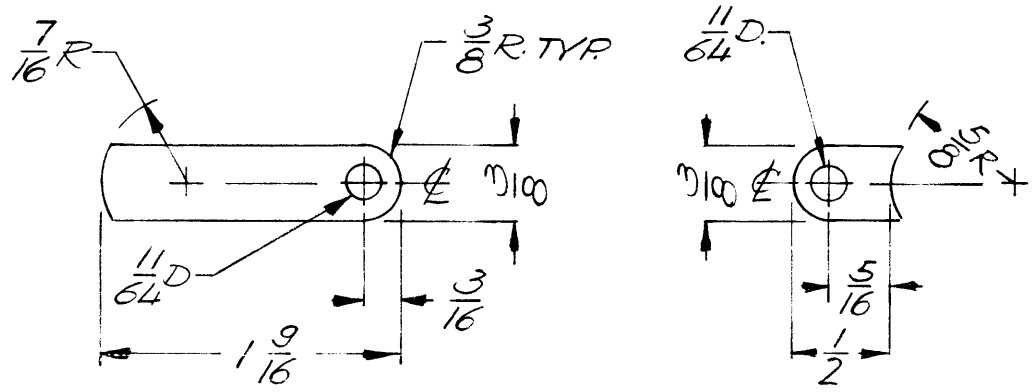
FCI-10-170 (10-66)

REVISIONS							
E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
	GE	S.R.		Ø	ORIGINAL RELEASE FOR PRODUCTION	5/9/72	

SPECIFICATIONS

COIL TO BE 2 1/2 TURNS OF 3/16 COPPER TUBING
USE ITEM 1 TO ATTACH STRAPS TO COIL
FINISH: S245 SIL. PLATE, SIL KOTE S423
O.D.-1-1/4 I.D.-7/8





MATL: .030 H.R. COPPER DETAILS A & B

DETAIL A DETAIL B

X	1	BS101	SOLDER, SILVER	
REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.

F.B. LIST OF MATERIAL

1	HFTM-1K	AS-147
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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

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

MATERIAL AS NOTED

FINISH AS NOTED

FINAL APPROVAL	GB	DATE 5/8/72
MECH. DES.		DATE
ELECT. DES.		DATE
CHECKED		DATE
DRAWN	GE	DATE 4-27-72

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

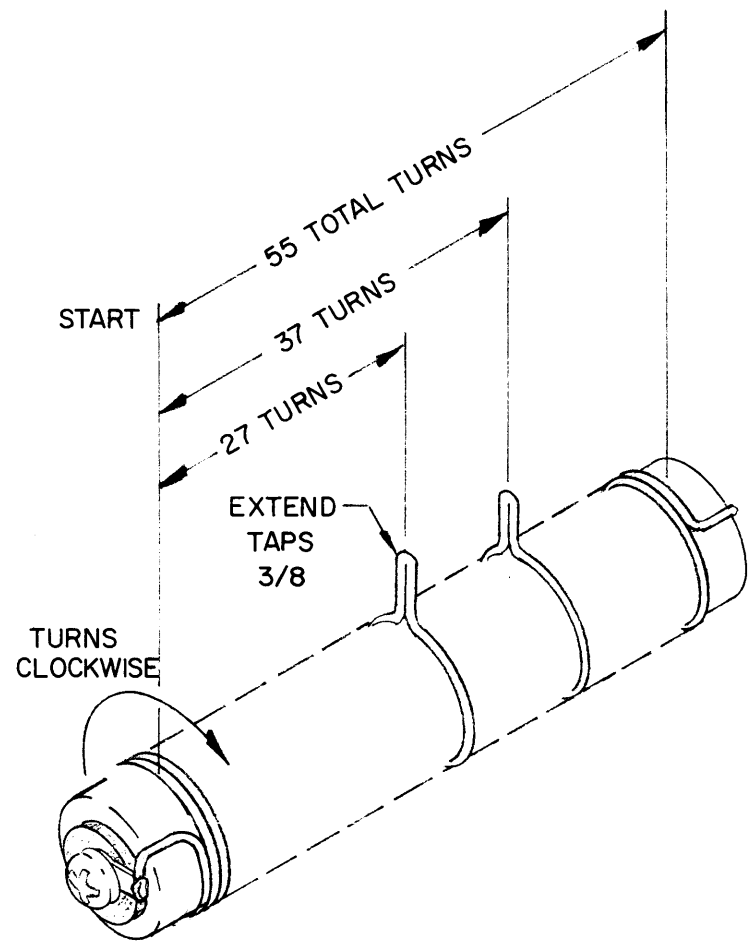
COIL INDUCTANCE

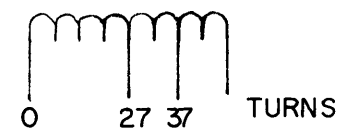
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL474	Ø

SCALE N.T.S SHEET OF

(10-66)

REVISIONS							
E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
	EJ			Ø	ORIGINAL RELEASE FOR PRODUCTION	10-26-72	





WINDING - CLOCKWISE TURNS CLOSE WOUND FABRICATION.

1. WIND FULL LENGTH AND TAP AS SHOWN AT 27 AND 37 TURNS.
2. SOLDER ENDS OF ITEM 4 TO ITEM 5.

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
X	6	BS100	SOLDER TIN ALLOY	
2	5	TE116-3	TERMINAL LUG	
X	4	W1123-16	WIRE ELEC.	
2	3		WASHER FIBER	
2	2		SCREW MACHINE	
1	1	NS3W0328	INS. STANDOFF	

F.B.

LIST OF MATERIAL

QTY / UNIT	MODEL USED ON	ASS'Y NO.
1	ATU350	

APPLICATION

CODE

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

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

MATERIAL

FINISH

FINAL APPROVAL	BB	DATE 10/26/72
MECH. DES.		DATE
ELECT. DES.		DATE 10
CHECKED		DATE
DRAWN GE		DATE 10/6/70

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL LOAD

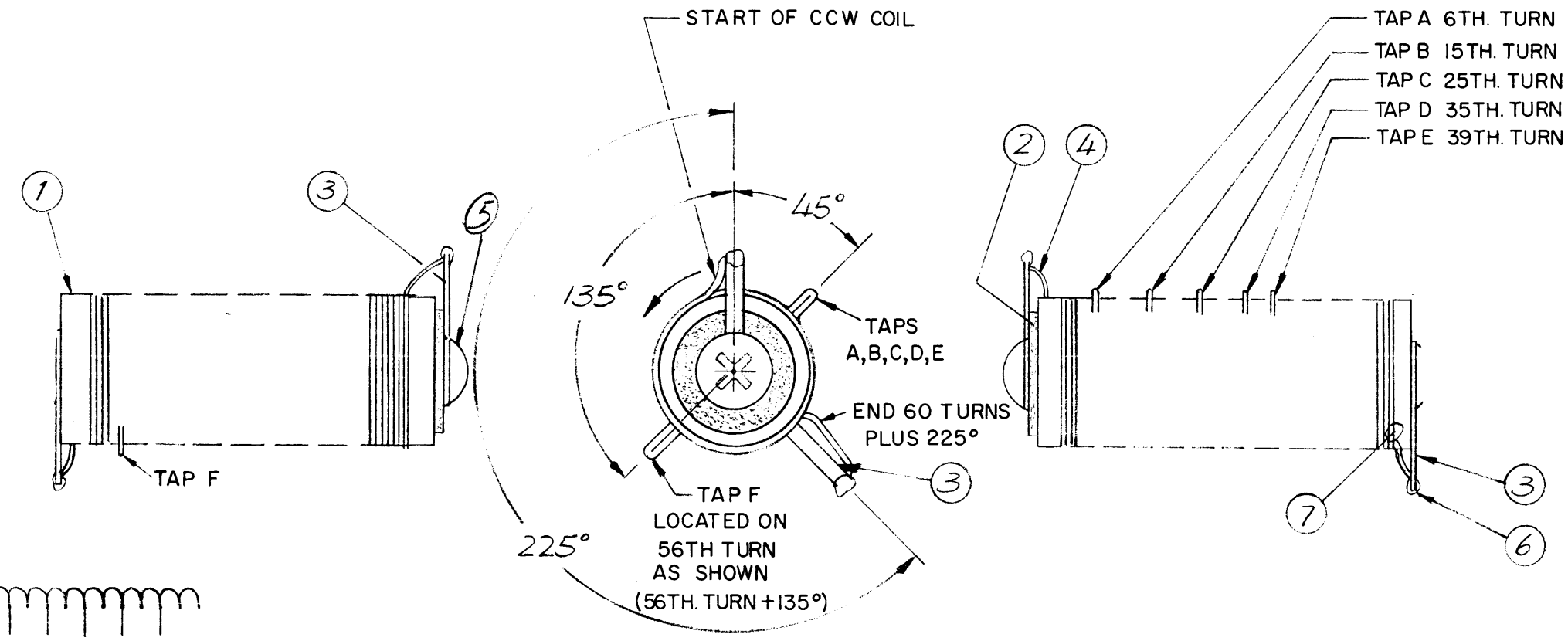
SIZE	CODE IDENT. NO.	DWG NO.	ISSU.
B	82679	CL477	

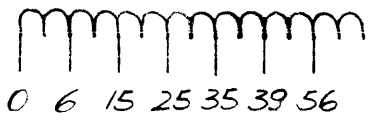
SCALE 1:1 SHEET OF

FCI-10-170 (10-66)

REVISIONS							
E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
	EJ			Ø	ORIGINAL RELEASE [illegible]	10/20/72	

A, B, C, D & E TAPS LOCATED ON TURNS AS SHOWN





WINDING - COUNTER CLOCKWISE CLOSE WOUND
FABRICATION - WIND FULL LENGTH AND TAP AT TURNS DESIGNATED. SOLDER ENDS OF COIL TO ITEM 3 WITH ITEM 6.

NOTE: 1. POSITION ITEMS 3 AS SHOWN.
2. EXTEND LENGTH OF TAPS 1/4"
3. SECURE WIRE TO FORM WITH EPOXY (ENDS)

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
X	7	GL 125	CEMENT EPOXY	
X	6	BS 100	SOLDER TIN ALLOY	
1	5	SCBP2520BN5	SCREW, MACHINE	
X	4	W1123-20	WIRE	
2	3	TE111-1	TERMINAL LUG	
1	2	WA109-55	WASHER, FIBER	
1	1	NS3W0420	INS. STANDOFF	

F.B. LIST OF MATERIAL

QTY / UNIT	MODEL USED ON	ASS'Y NO.
1	TMA 350	

APPLICATION

CODE

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

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

MATERIAL

FINISH

FINAL APPROVAL	BB	DATE 10/17
MECH. DES.		DATE
ELECT. DES.		DATE
CHECKED		DATE
DRAWN	GE	DATE 10/18/72

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

LOADING COIL

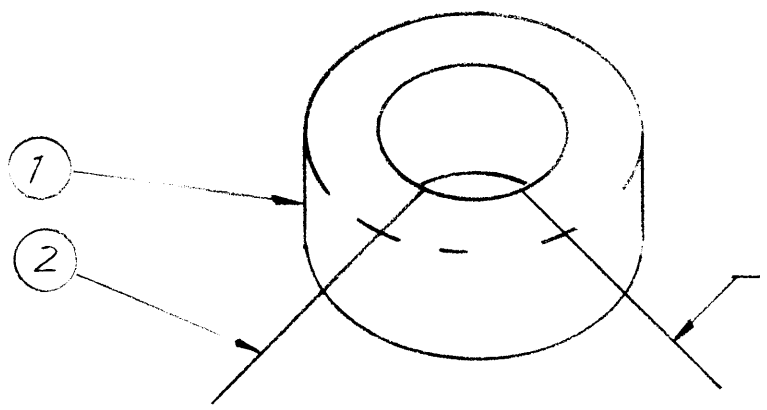
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL478	Ø

SCALE | SHEET OF

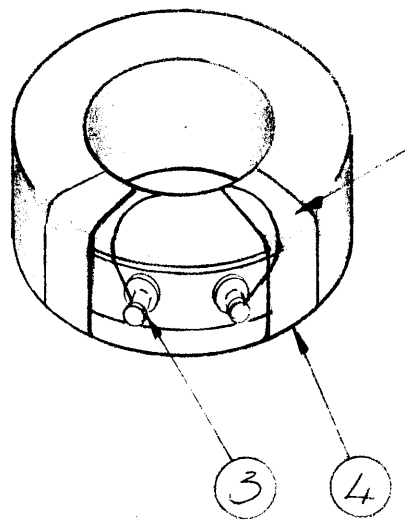
(10-66)

COIL NO	WIRESIZE	TURNS	QMTR. TEST FREQ	L mhy	REQ
CL-481	WI-141-24-9	400	1KHz	28 ± 10%	3

REVISIONS							
E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		CL		Ø	ORIGINAL RELEASE FOR PROD.	1/26/73	



LEADS TO BE SANDED CLEAN & TINNED WITH ITEM 5.



ATTACH ITEM 3 TO ITEM 1 WITH ITEM 4 THEN WRAP ALL OF ITEM 1 WITH ITEM 4

—— NOTES ——

1. REFER TO TMC SPEC. S-1311.
2. AFTER MATCHING COIL WITH CAPACITOR ASSEMBLE AS SHOWN.
3. STOCK FINISHED INDUCTOR AND CAPACITOR TOGETHER.

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
1	7	CN127-A-1R0	CAP. POLYCARBONATE	
X	6	GL-110	COMPOUND, POTTING	
X	5	BS100	SOLDER TIN ALLOY	
X	4	TA108-2	TAPE THERMOSETTING	
1	3	A-450	TERM. STRIP ASSY.	
X	2	WI-141-24-9	WIRE ELEC.	
1	1	C1103-19	CORE	

LIST OF MATERIAL

POSE

RSU-1

QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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

MATERIAL

FINISH

FINAL APPROVAL		DATE
MECH. DES.		DATE
ELECT. DES.	[illegible]	DATE 1/17/73
CHECKED		DATE
DRAWN	GE	DATE 1-17-73

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

TOROID ASSY.

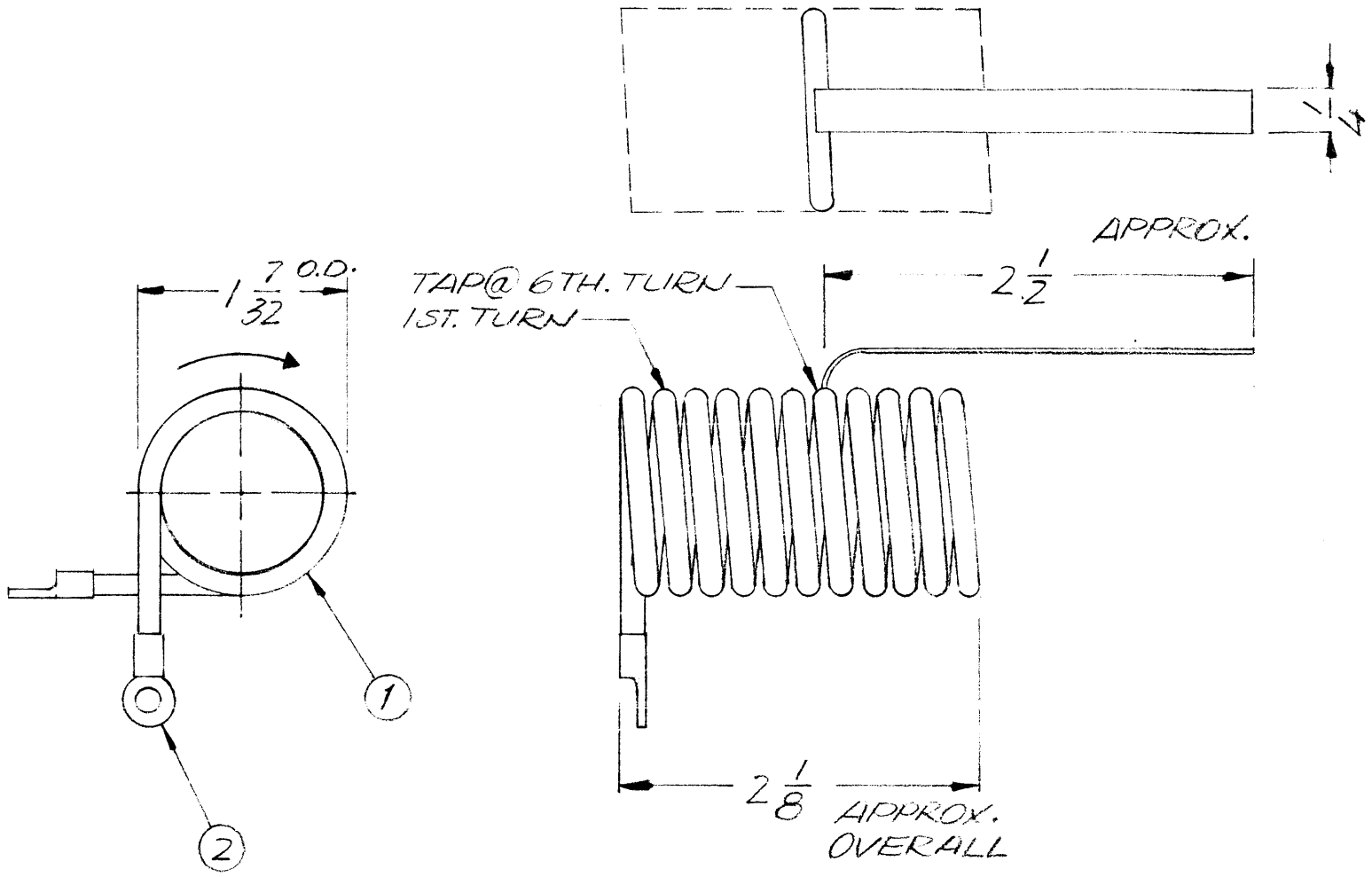
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL481	1

SCALE | SHEET OF

FCI-10-170 (10-6)

PX 370

REVISIONS							
E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
	CL			Ø	ORIGINAL RELEASE FOR PROD.	1/9/73	



SPECIFICATIONS

1. 11 COMPLETE TURNS CLOCKWISE
2. TAP @ 6TH. TURN AS SHOWN.
3. FABRICATE TAP AS SHOWN USE .032 COPPER.
4. COVER TAP WITH ITEM 4.
5. USING ITEM 3 ATTACH ITS. 2 & TAP TO COIL

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
X	4	PX 370-2	INSULATION	
X	3	BS100	SOLDER TIN ALLOY	
2	2	TE141	TERMINAL, LUG	
X	1	WI-100-1	WIRE	

F. BUDETTI — LIST OF MATERIAL

QTY / UNIT	MODEL USED ON	ASS'Y NO.
1	TM1A 350	

APPLICATION

CODE

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

MATERIAL

FINISH

FINAL APPROVAL	OB	DATE 1/9/73
MECH. DES.	SR	DATE 1/9/73
ELECT. DES.		DATE
CHECKED		DATE
DRAWN	GE	DATE 1/9/73

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

HF TANK COIL

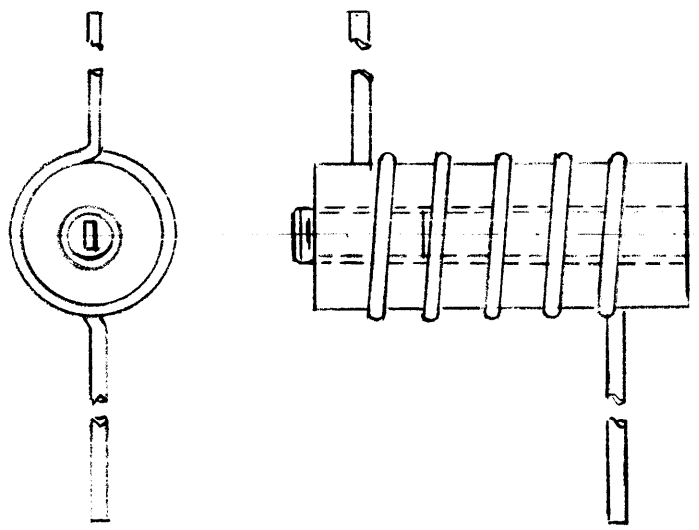
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL 403	Ø

SCALE — SHEET OF

FCI-10-170 (10-66)

REVISIONS							
E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
				X1	CL484-3 NO LONGER USED	1-7-75	
	G.D.L.			Ø	ORIGINAL RELEASE FOR PRODUCTION	1-27-77	
21532				A	REMOVE WINDING REFERENCE FROM CL484-1	4-11-77	

CL484-1	CL484-2	CL484-3
MECHAICAL SPECIFICATIONS:	MECHANICAL SPECIFICATIONS:	MECHANICAL SPECIFICATIONS:
5 1/2 TURNS.	6 1/2 TURNS	4 1/2 TURNS
ELECTRICAL SPECIFICATIONS: (FLUSH CORE)	ELECTRICAL SPECIFICATIONS: (FLUSH CORE)	ELECTRICAL SPECIFICATIONS: FLUSH CORE)
INDCT .23 uh	INDUCT .24 uh	INDUCT. .17
Q. 150	Q 150	Q. 130
FREQ. 25.0 MHz	FREQ 25.0 MHz	FREQ. 25 0 MHz



SCHEMATIC DIAGRAM

SEE CHART FOR
ELECTRICAL SPECIFICATIONS

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
F. BUDETTI			LIST OF MATERIAL	

	GRR110	
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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

MATERIAL

FINISH

FINAL APPROVAL	GDB	DATE 1/31/77
MECH. DES.		DATE
ELECT. DES.		DATE
CHECKED		DATE
DRAWN	GDL	DATE 3-5-74

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

HFO COIL ASS'Y

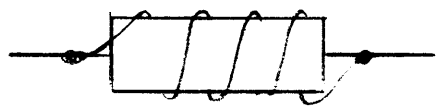
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL484	A

SCALE | SHEET OF

FCI-10-170 (10-66)

TMC PART NO	TYPE WIRE	APPROX NO. OF TURNS	COIL FORM	USED ON	SYMB. REF.
CL486-1	W141-24-2	3	RC20GF183J	GPR 110	L1, L2
CL486-2	WL100-8	6 1/2	RC20GF104J	GPR 110	L2
CL486-3	WL100-8	4 1/2T	RC20GF104J	GPR 110	L9
CL486-4	WL100-8	3 1/2T	RC20GF104J	GPR 110	L6
CL486-5	WL100-8	5 1/2T	RC20GF104J	GPR 110	L4

E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	REVISIONS DESCRIPTION	DATE	APPROVED
				X	EXP RELEASE		
	G.D.L			X1	ELEC. SPEC. [illegible] OF CHART ADDED	1-7-75	
	G.D.L			Ø	ORIGINAL RELEASE FOR PRODUCTION	1-25-77	*



USE FOR
SPARE PARTS ONLY

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
X	2	GL162	ADHESIVE - Q-MAX	
X	1	BS100	SOLDER, TIN ALLOY	

LIST OF MATERIAL

QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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

MATERIAL

FINISH

FINAL APPROVAL	[illegible]	DATE 1/26/77
MECH. DES.		DATE
ELECT. DES.		DATE
CHECKED		DATE
DRAWN	G. Ledoux	DATE 3-21-74

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL HF, IF

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL486-	Ø

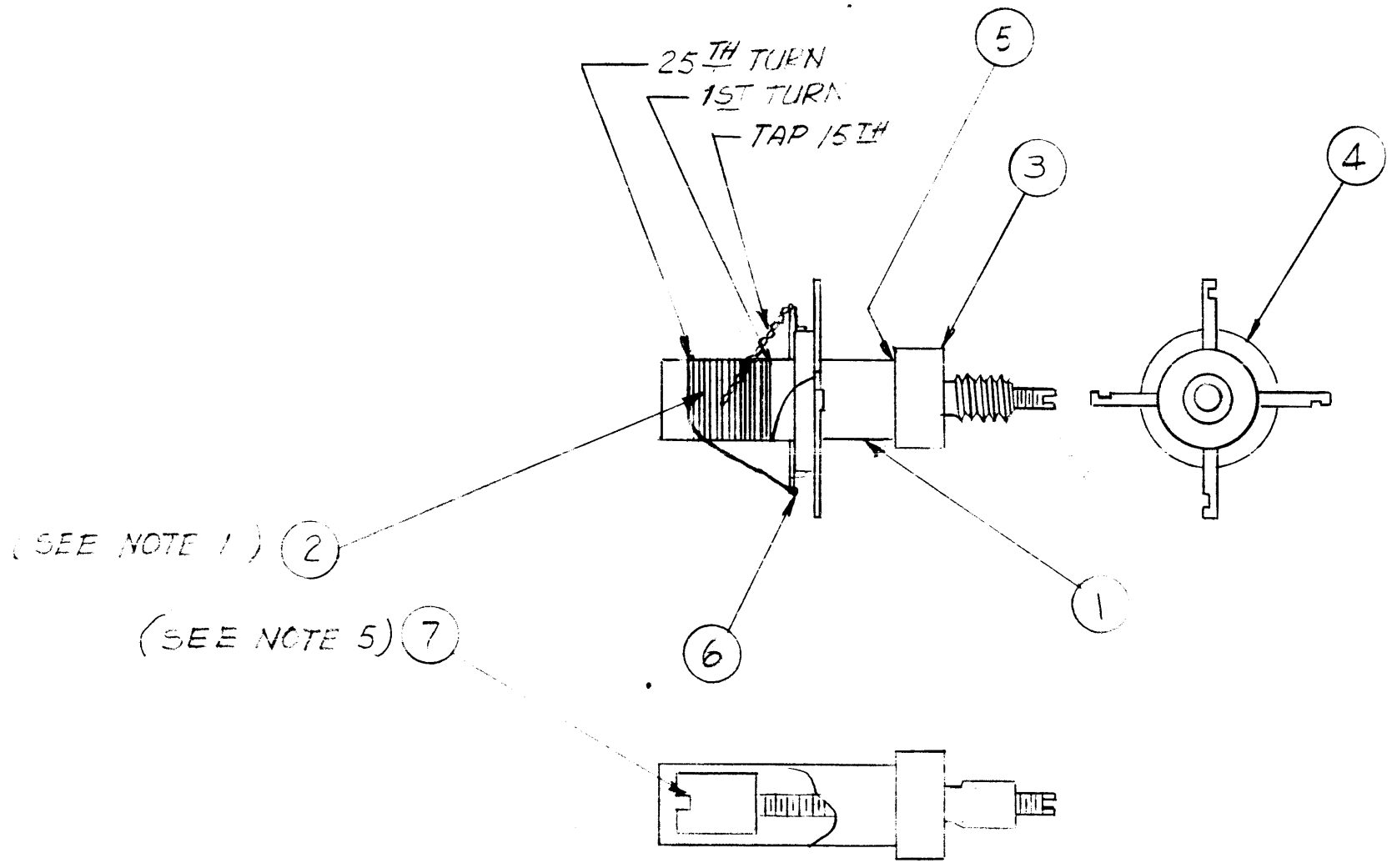
SCALE | SHEET OF

FCI-10-170 (10-66)

REVISIONS							
E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
	9-21-74			X	EXP RELEASE		
	D.L.			Ø	[illegible]	1-2-25	

NOTES—

1. WIND ITEM 2 25 TURNS CLOCKWISE AROUND ITEM 1 AND TAP AT 15 TURNS
2. FASTEN ITEM 3 TO ITEM 1 WITH ITEM 7
3. FASTEN ITEM 4 TO ITEM 1 WITH ITEM 7
4. USE ITEM 8 TO FASTEN WIRE CONNECTIONS
5. INSERT ITEM 9 FROM END THAT HAS 15 WIRED TURNS (PICTURE RIGHT SIDE)



REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
1	7	C1-115-18	CORE TUNING	
X	6	BS100	SOLDER, SOFT	
X	5	GL130	DUCO CEMENT	
1	4	TE181-4	COLLAR RING	
1	3	[illegible]	BUSHING COIL FORM	
X	2	W1123-30	WIRE ELECTRICAL	
1	1	CF122-1"	COIL FORM	

LIST OF MATERIAL

1	[illegible]	
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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

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

MATERIAL

FINISH

FINAL APPROVAL		DATE 12/31/74
MECH. DES.	F. IANNUZZI	DATE 12-31-74
ELECT. DES.		DATE
CHECKED		DATE
DRAWN	[illegible]	DATE

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL, RF ADJ

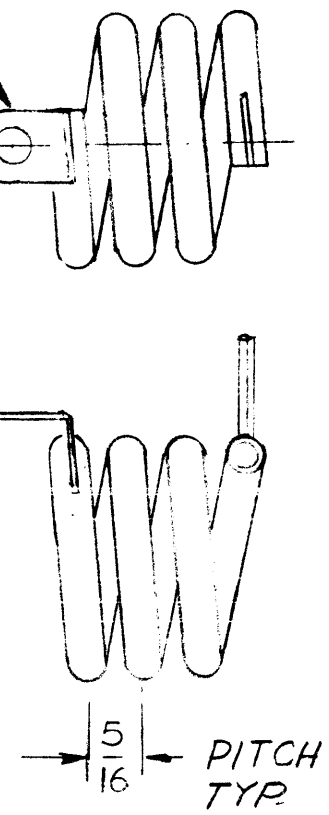
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL 488	Ø

SCALE 2:1 SHEET OF

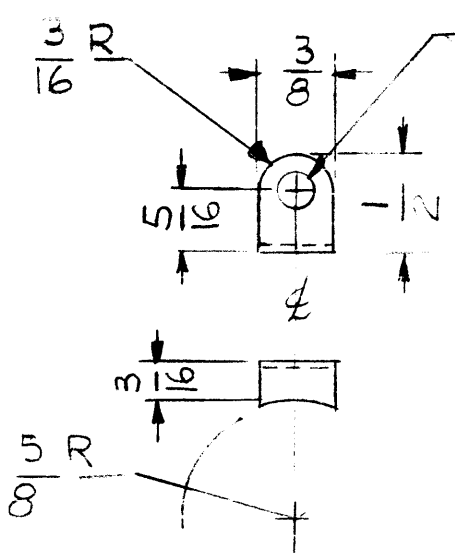
REVISIONS							
E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
	G.O.L			X	EXP. RELEASE		
—	CL	JrB		Ø		8/76	*

DETAIL "A"

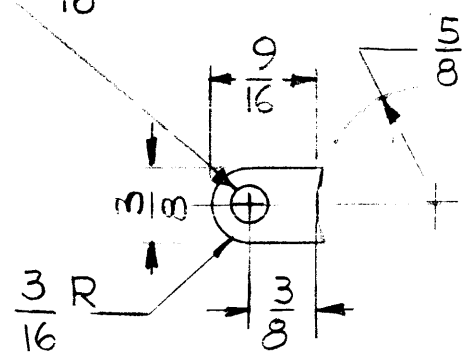
DETAIL "B"



5/16 PITCH TYP.



DETAIL "A"
.030 H.R. COPPER



DETAIL "B"
.030 H.R. COPPER

SPECIFICATIONS :

COIL TO BE 3 TURNS OF 3/16 COPPER TUBING.
USE ITEM 1 TO ATTACH STRAPS TO COIL.
FINISH: S245 SIL PLATE, SIL KOTE S423
O.D. 1 1/4 I.D. 7/8

X	1	BS101	SOLDER SILVER	
REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM

LIST OF MATERIAL

2	TLAA-IK	AS15
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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

MATERIAL SEE NOTES

FINISH SEE NOTES

FINAL APPROVAL *		DATE 9-20-76
MECH. DES.		DATE
ELECT. DES.		DATE
CHECKED		DATE
DRAWN	G.O.L	DATE 1-7-76

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL INDUCTANCE

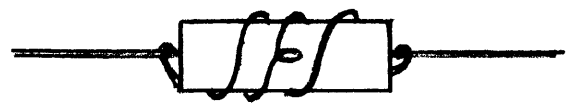
SIZE	CODE IDENT. NO.	DWG NO.	IS
B	82679	CL 493	

SCALE 1:1 SHEET OF

-10-170 (10-66)

TMC P/NO	COIL FORM	TYPE WIRE	NO. TURNS	REQ'D
CL496-1	RC07GF822J	WL-100-7	3	2
CL496-2	RC07GF104J	WL-100-7	2	1

REVISIONS							
E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED



CL496-2

CL496-1

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.

LIST OF MATERIAL

	GPR-110	
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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

MATERIAL

FINISH

FINAL APPROVAL		DATE
MECH. DES.		DATE
ELECT. DES.		DATE
CHECKED		DATE
DRAWN	G.D.L	DATE

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

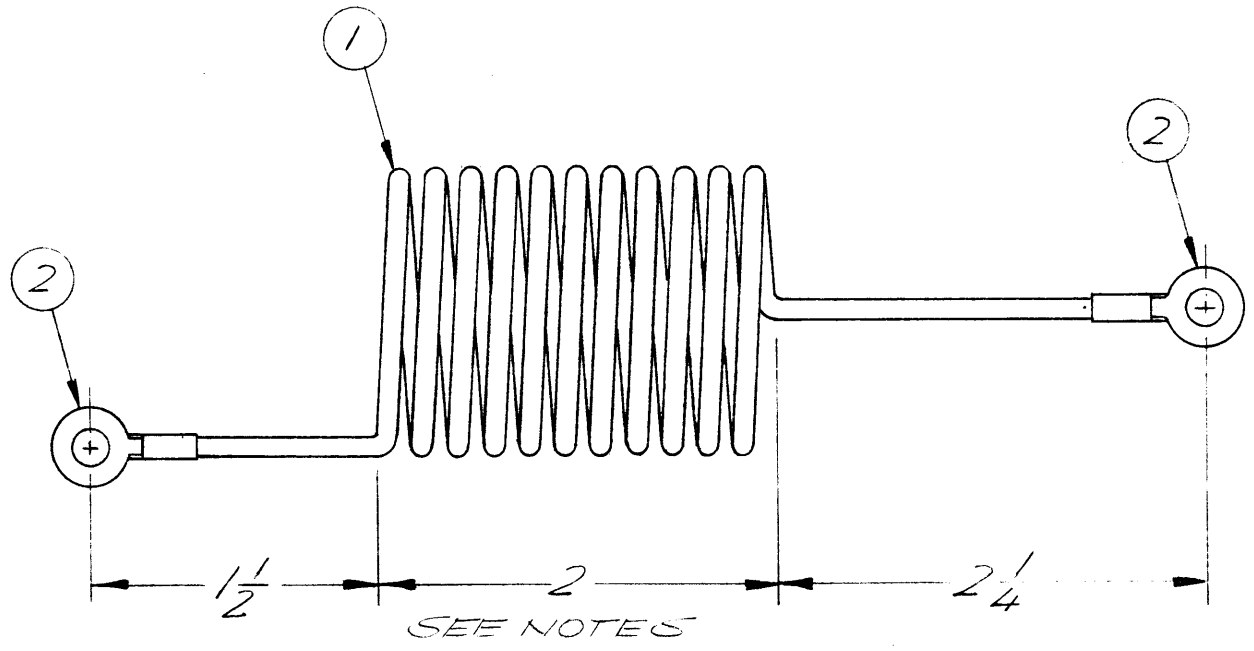
COIL, RF

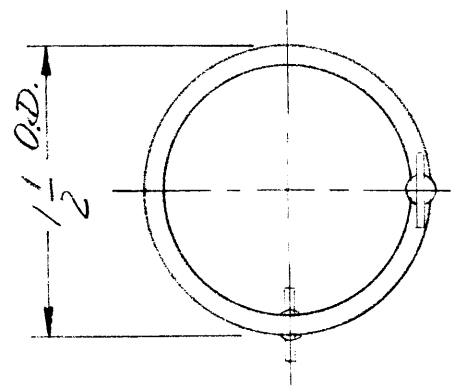
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL496-	

SCALE —— SHEET OF

FCI-10-170 (10-66)

REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP. RELEASE	9/16/69		LH		
	Ø	ORIGINAL RELEASE	11/21/69		Ø		
	A	SPECS. WERE 4.3 μh ± 10%	11-20-72	20959	GE	G	G





NOTES:
1. 10 3/4 TURNS, CLOSE WOUND.
2. EXPAND TO 2 INCHES AFTER WINDING
3. CRIMP AND SOLDER ALL LUGS.

SPECIFICATIONS:
2.5 μh ±20 %

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
X	3	BS 100	SOLDER, TIN ALLOY	
2	2	TF 141-1	TERMINAL LUG	
X	1	WI 123-10	WIRE ELECT. MAGNET	

LIST OF MATERIAL

2	SPT 3K/VHF	
QTY / UNIT	MODEL USED ON	ASS'Y NO.

APPLICATION

CODE

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

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

MATERIAL —#—

FINISH —#—

FINAL APPROVAL		DATE 11/24/69
MECH. DES.		DATE 9-23-69
ELECT. DES.		DATE
CHECKED		DATE 9/22/69
DRAWN		DATE 9/16/69

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL RF, FIXED
(LOW BAND, P.A.)

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL 8002	A

SCALE 1:1 SHEET OF

FCI-10-170 (10-66)