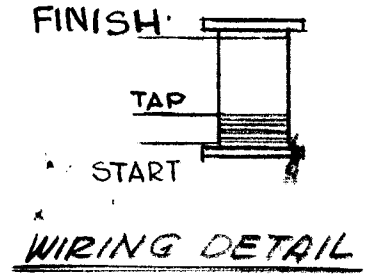
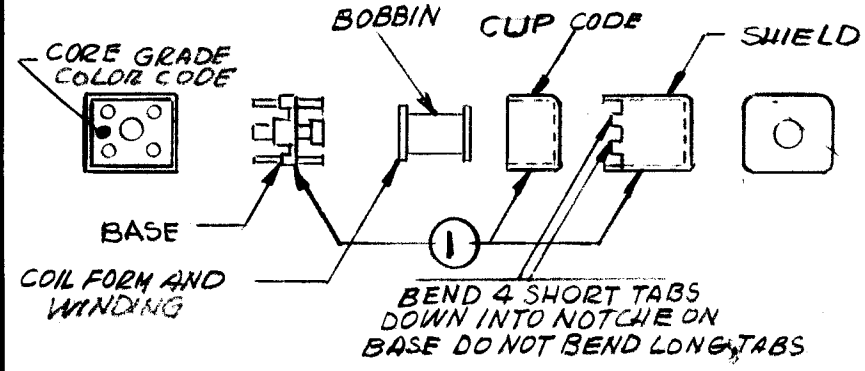
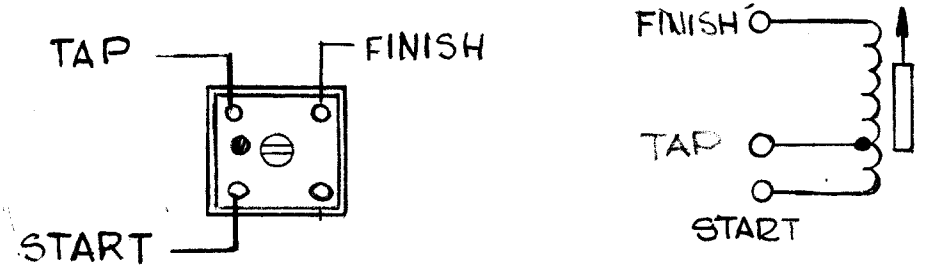


TMC P/NO	WINDING ITEM	TURNS	TAP AT	CORE COLOR	CORE ITEM	INDUCTANCE		REVISIONS							
						Q MHZ	L UHY	E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
TT-317-1	WI104-12/43	55	6	RED	CI136-2	80	25					X1	START & FINISH REVISED	6-16-77	
TT-317-2	WI104-12/43	36	4	RED	CI136-2	80	10					X2	TT137-3 WAS 27T & -4 WAS 9T	7-11-77	
TT-317-3	WI141-32	14	3	RED	CI136-2	80	2.4					Ø	ORIGINAL RELEASE FOR PRODUCTION	2-11-80	FB
TT-317-4	WI141-32	5	1	RED	CI136-2	80	.5								

FABRICATION PROCEDURE

- 1-WIND L1 ON BOBBIN, TAP AT (SEE CHART) AND SECURE WITH GL103.
- 2-BAKE COIL FOR 15 MINUTES @ 150°F. REMOVE FROM OVEN AND COAT WITH GL102 -
- 3- PLACE BOBBIN ON CORE BASE AND ROTATE FOR CORRECT POSITIONING. GLUE BOBBIN TO BASE WITH GL129
- 4- CONNECT LEADS ACCORDING TO SCHEMATIC AND BASE ASSY AND SOLDER-
- 5- SECURE CLIP CORE TO BASE WITH GL129. ASSEMBLE AS SHOWN.
- 6-MARK TMC P/N ON TOP OF CASE AS SHOWN (BLACK GOTHIC). NOTE TMC P/N MUST BE IN ALIGNMENT WITH CORE COLOR CODE. PLACE BLACK DOT ON SIDE OF CAN CORRESPONDING TO BASE COLOR CODE. 9 TEST Q UNLOADED -



REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
X	6	BS100	SOLDER TIN ALLOY	
X	5	GL129	ADHESIVE EASTMAN 910	
X	4	GL102	ADHESIVE Q MAX	
X	3	GL103	ADHESIVE N-CEL	
X	2	SEE CHART	WIRE ELEC.	
1	1	CI136 SEE CHART	CORE ADJ. TUNING	

LIST OF MATERIAL

GPR-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	FINAL APPROVAL	DATE	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK					
DECIMALS: .X ± .05, .XX ± .01, .XXX ± .005	MECH. DES.	DATE				XFMR. RF ADJUSTABLE		
FRACTIONS: 1/64, TOLS. ANGLES: 0°-30'	ELECT. DES.	DATE						
MATERIAL	CHECKED	DATE						
FINISH	DRAWN: GDL	DATE: 6-2-77	SIZE: B	CODE IDENT. NO.: 82679	DWG NO.: TT 317			
			SCALE	SHEET OF				