

TMC NO.	ITEM NO. 3 (WIRE)	TOTAL NO. OF TURNS	INDUCTANCE (μhy)		TEST FREQ. (MCS)	Q at TEST FREQ. MUST BE MORE THAN	COLOR CODE	QUAN. PER UNIT	SCHEMATIC SYMBOL	OPER. FREQ. (MCS)
			MIN. MUST BE LESS THAN	MAX. MUST BE MORE THAN						
CL-135-1	WI-104-54IDSQS	40	28	39	2.5	50	Black	1	L	2-4
CL-135-2	WI-107-15	22	4.5	7.2	7.9	80	Brown	1	L	4-8
CL-135-3	WI-107-5	12	1.4	1.8	7.9	80	Red	1	L	8-16

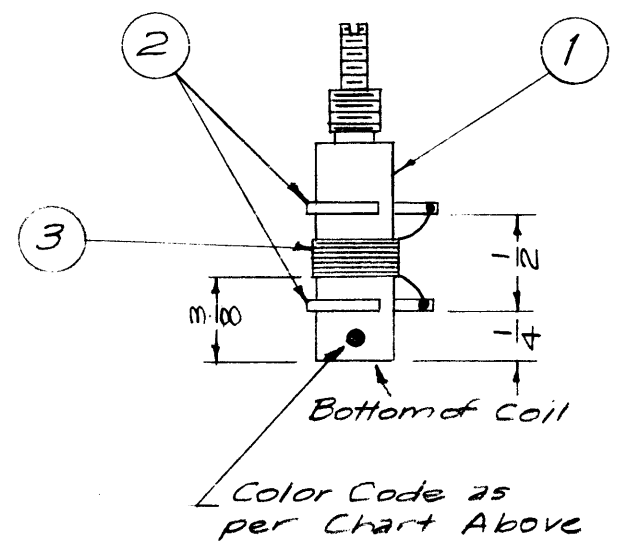
CL-135

WINDING MACHINE DATA

CL-135-1 will use a .125 Cam, 49 Cam Gear, and 95 Driver.  
 CL-135-2 & 3 will be close wound, single layer.

PROCEDURE

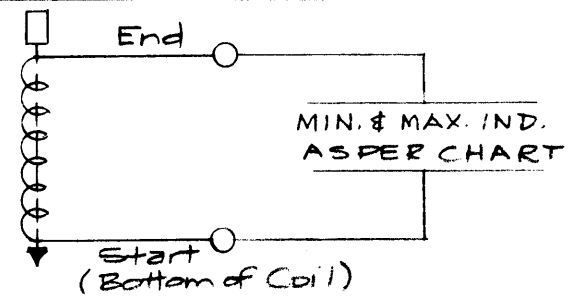
1. Secure terminals (item 2) to coil form with Insulex (item 5).
  2. Wind required number of turns of item 3 (wire) on coil form as per chart above.
  3. Stake wire ends to coil form with Q-Max (item 4).
  4. Solder coil leads to terminals.
  5. Bake for 1/2 hour at 210°F.
  6. Paint coil with Insulex (item 5).
  7. Test unit as per chart and schematic with core. Minimum & Maximum Inductance accomplished by adjusting tuning slug.
- (Use Boonton Q Meter Model 160A or Equiv)



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 MAMARONECK, NEW YORK



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 6	B5-100	Solder, Soft	
X 5	GL-104-2	Insulex, U-85	
X 4	GL-102	Cement, Q-Max	
X 3	See chart	Wire	
2	TE-153-2	Terminal, Ring Type	
1	CF-107-2N	Coil Form	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	1	3/8 to start of winding was 7/16	5/24/58	1	16		<i>[Signature]</i>

TOLERANCES: \_\_\_\_\_ SCALE: \_\_\_\_\_

DEC. DIM. ±  
 FRAC. DIM. ±  
 ANGULAR DIM. ±

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

Deleted from RFA-1 8-19-58 Use TF-186

CHART	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
RFA-1	PAL-350			5-22-58

USED ON

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
COIL, RF, TUNED			
MATERIAL			
TYPE & TEMPER		HEAT TREAT. SPEC.	FINAL APPROVAL
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.

6/22/58 *[Signature]* *[Signature]* *[Signature]*

CL-135 A