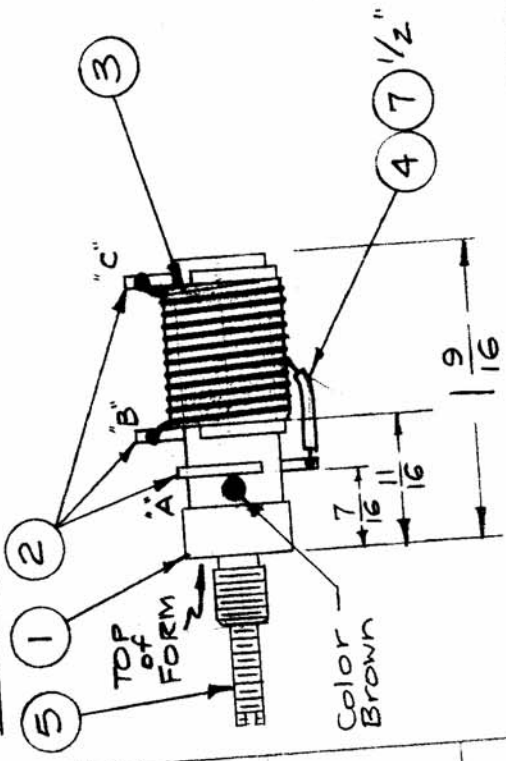
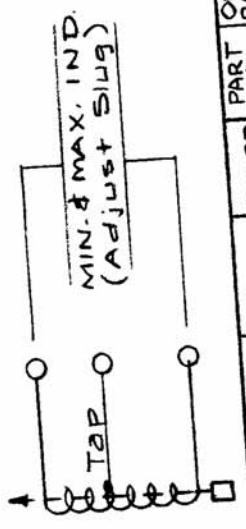


CL146 E

REQ. PER UNIT	1
MODEL	RFD-1
ASBY. NO.	PALIK
DATE	10-22-60
	11-22-60



- PROCEDURE**
- Slip two terminal rings (item 2) on form (item 1) as shown. (marked "A" & "B").
 - Force fit outer form (item 3) onto inner form (item 1) and cement with Insulex "c" on inner form.
 - Slip terminal ring marked "c" on inner form.
 - Cement all rings to inner form.
 - Wind 9 turns of wire (item 4) on outer form. Bring out tap at 7-1/2 turns from top. Slip sleeving (item 7) over tap. Solder all wire ends to proper terminals.
 - Paint winding with Insulex.
 - Bake for 1/2 hour at 250°F.
 - Insert core (item 5).
 - Test as shown below. Use Boonton Q-Meter Model 160A or Equiv.



ASSY #	L-MAX	L-MIN	Q	TEST FREQ	CORE	COLOR	PART #	OPER. RANGE
A1611-1	>1.3μh	<1.1μh	>130	7.9 MC	CI109-19	RED	CL146	8-16 MC
A1611-2	>2μh	<1.5μh	>80	7.9 MC	CI103D7B5	GREEN	CL146-2	6.3-12.3 MC

ISSUE ITEM	REDRAWN	CHANGED FR M	DATE	6/1/71	CH. NO.	20389	DRAFTS	CW	CHECKER	EN . APP.
SCALE: FULL										
T LERANCES										
MAXIMUM ALL WABLET LERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REM VE ALL BURRS AND SHARP EDGES										
DEC. DIM. ±	1/64									
FRAC. DIM. ±	1/64									
ANGULAR DIM. ±										

X	8	BS-100	Solder, Soft
1/2"	7	PX-100-1-.042	Insulation, sleeving (Size 18) BK.
X	6	GL-104-2	Insulex, UBS
1	5	SEE CHART	Core, Tuning,
X	4	WL-100-5	Wire, Buss (Size 18)
1	3	CF-125-3FO.75	Coil Form, Grooved
3	2	TE-153-3	Terminal, Ring Type
1	1	CF-119-1.562	Coil Form, w/Bushing

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		RF COIL ASS'Y, TUNED (CL-146)	
		STOCK SIZE	
		MATERIAL	
		TYPE & TEMPER	
		HEAT TREAT. SPEC.	
		FRESH & SPEC. NO.	
		DATE	6/17/1958
		DRAWN	ATB
		CHECKED	AMB
		FINAL APPROVAL	CL146 E