



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.

2	BCT-10KA	
QTY / UNIT	MODEL USED ON	ASS'Y NO.
APPLICATION		
	CODE A	S401-451
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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	FRACTIONS 1/64 ANGLES 0° - 30°
MATERIAL	
FINISH	

REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
	X	EXPERIMENTAL RELEASE	10/30/67		C.V.	<i>[Signature]</i>
	X <sub>1</sub>	UPDATED, ADDED CHART	3/21/68		C.V.	<i>[Signature]</i>
	Ø	ORIG. RELEASE FOR PROD	4/5/68		R.G.	

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

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			
FINAL APPROVAL <i>[Signature]</i> MECH. DES.		DATE 4/15/68	<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK, NEW YORK		
ELECT. DES. CHECKED <i>[Signature]</i>		DATE 4/15/68	<b>COIL, DECOUPLING, PLATE</b>		
DRAWN J.W.		DATE 11-6-67	SIZE B	CODE IDENT. NO. 82679	DWG NO. CL 426
			SCALE	SHEET	OF