

REVISIONS						
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD

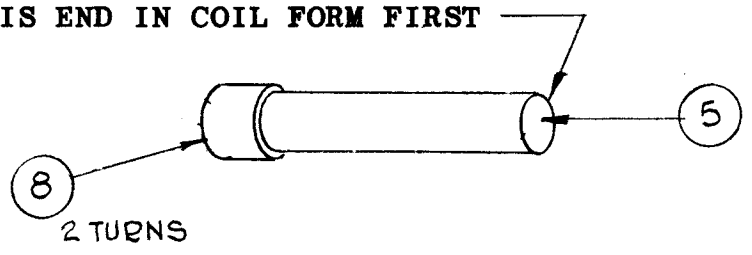
TEST DATA; WITH CORE:  
 L = 180 uh (170-190 uh)  
 Q = 85 OR GREATER  
 F = 790 KC  
 USE BOONTON Q-METER 260A OR EQUIVALENT

**ASSEMBLY PROCEDURE:**

1. POSITION LUGS ON COIL FORM AS SHOWN. SECURE WITH ITEM 6 (U-85).
2. WIND ON 68 CLOSE WOUND TURNS OF ITEM 3 (ALLOW 3/4" STRIPPED LEADS EACH END FOR TEST PURPOSES. REMOVE AFTER TEST).
3. STAKE COIL ENDS WITH ITEM 4.
4. SOLDER LEADS TO LUGS AS SHOWN.
5. COAT THE ENTIRE COIL, COIL FORM AND INNER SURFACE OF THE COIL FORM WITH ITEM 6 (U-85).
6. WIND TWO TURNS OF ITEM 8 (TAPE) ON CORE TO INSURE A SNUG FIT IN COIL FORM (SEE BELOW).
7. COAT ITEM 5 (CORE) WITH ITEM 6 (U-85) THEN INSERT CORE INTO COIL FORM AS SHOWN. CORE MUST FIT FORM SECURELY.
8. BAKE FOR ONE HOUR AT 270° F.
9. TEST (WITH CORE).
10. STAMP COIL FORM AS SHOWN.

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	8	TA-100-2	TAPE, VINYL PLASTIC (1/2" WIDE)	BLACK
X	7	BS-100	SOLDER, SOFT	
X	6	GL-104-2	RESIN, SYNTHETIC (U-85)	
1	5	CI-112Q2R0F	CORE, POWDERED IRON	
X	4	GL-103	CEMENT, DUCO	
X	3	WI-107-11	MAGNET, WIRE, #30 DBC	
2	2	TE-153-3	LUG, RING TYPE	
1	1	CF-119-2.00	COIL, FORM	

INSERT THIS END IN COIL FORM FIRST



2	TTR-10	AX-418
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE A	CODE A	
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R. KOHN				LIST OF MATERIAL	
MATERIAL			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
FINISH			TITLE CL-317 ASSEMBLY COIL, R.F. FIXED		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN G.D.L.	DATE 1-23-63	FINAL APPROVAL BP	
		CHECKED JH	DATE 6-12-63		
		ELECT. DES. RON KOHN	DATE 6-14-63	A-3172	
		MECH. DES.	DATE	SHEET	
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		FRACTIONS ± 1/64 ANGLES ± 0° 30'		REV. LTR.	

**NOTES**