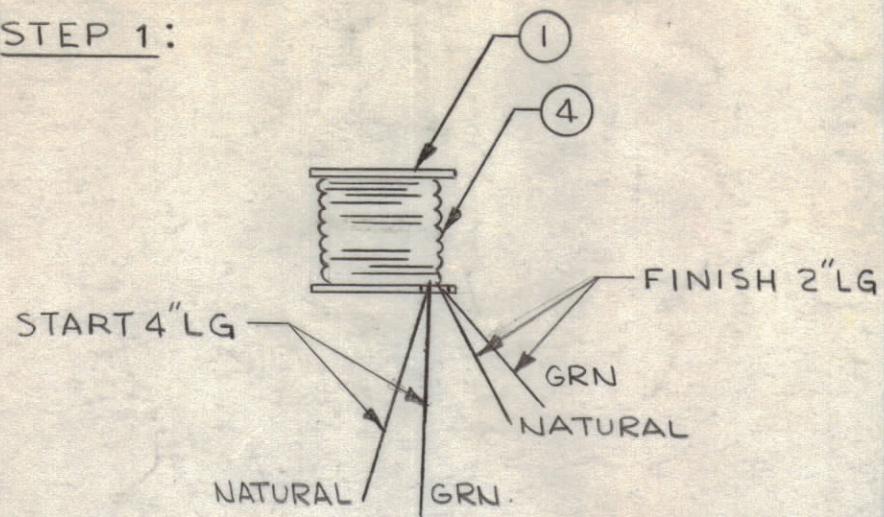
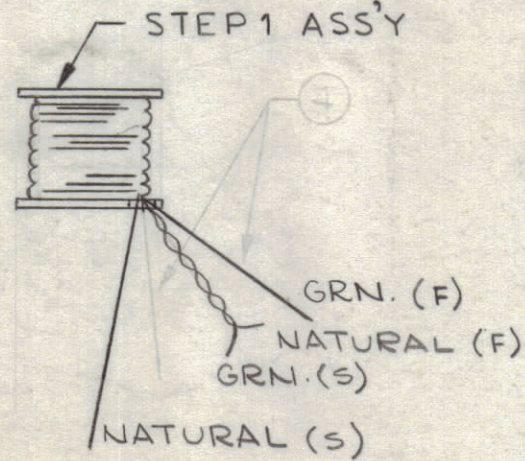


STEP 1:



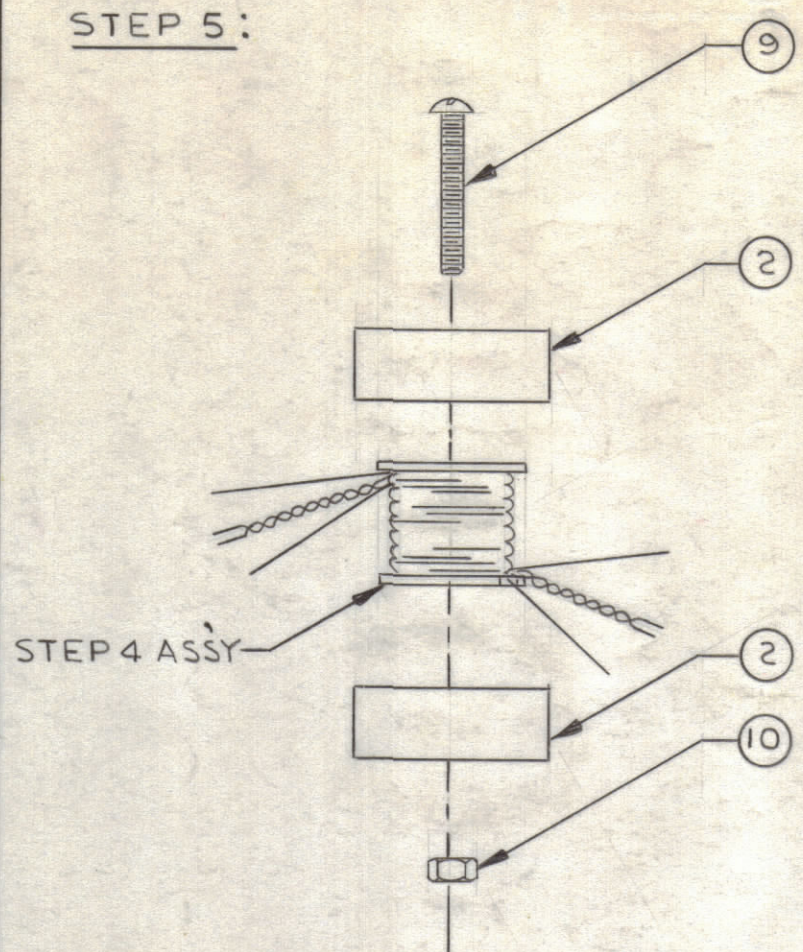
1-WIND 250 TURNS OF MAGNET WIRE ITEMS 4 & 5 ON BOBBIN, ITEM 1  
2-STAKE WITH DUCO CEMENT, ITEM 7.

STEP 2:



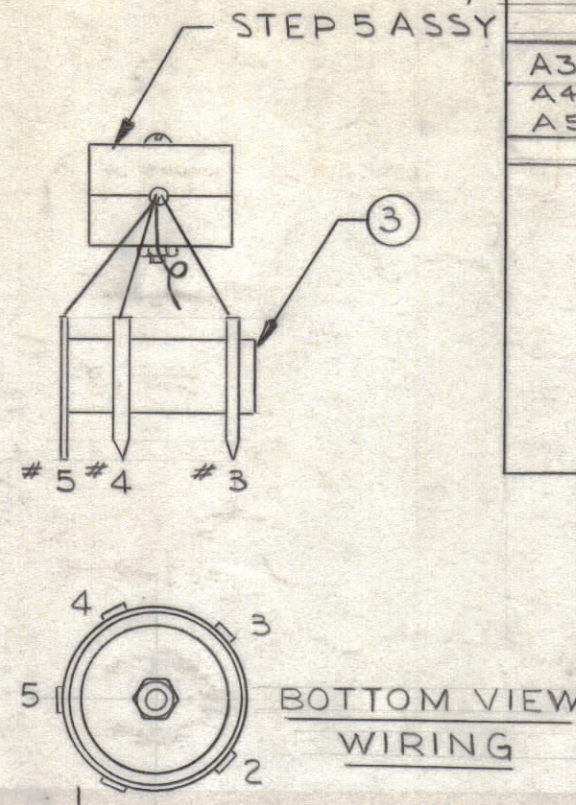
1- TWIST TOGETHER THE NATURAL (F) TO GRN (S) TO MAKE CENTER TAP.  
2- TWIST TOGETHER THE RED OF 2" LG TO GREEN OF 4" LG.

STEP 5:



1- ASSEMBLE AS SHOWN  
2- CAUTION: CARE SHOULD BE TAKEN TIGHTENING ITEM 9 SO AS NOT TO CRACK ITEM 2. HAND TIGHT WILL BE MAXIMUM ALLOWANCE.

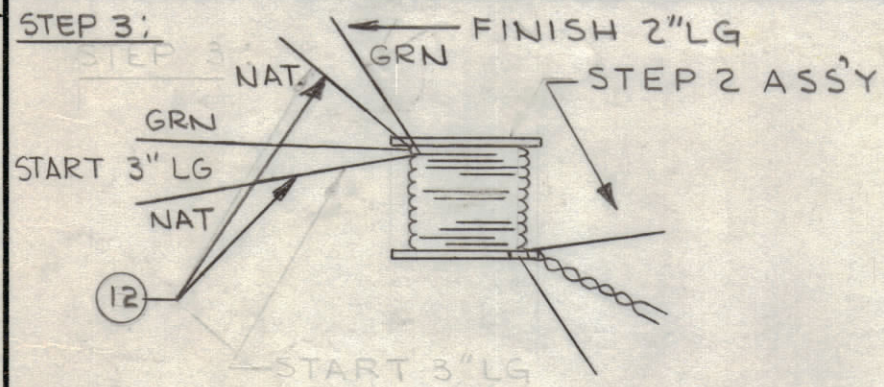
STEP 6:



~ WIRE TERMINATION ~  
I- STEP 2: (A) TWISTED PAIR (NAT-GRN) GO TO PIN #1.  
(B) GRN. WIRE TO PIN #5.  
(C) NAT. WIRE TO PIN #2.  
II- STEP 4: (A) NAT. WIRE TO PIN #3.  
(B) GRN WIRE TO PIN #4.  
(C) TWISTED PAIR (NAT-GRN) SOLDERED TOGETHER AND GLUED TO SIDE OF ITEM #3  
III- THE NUT MUST BE FLUSH WITH BOTTOM OF ITEM #3.

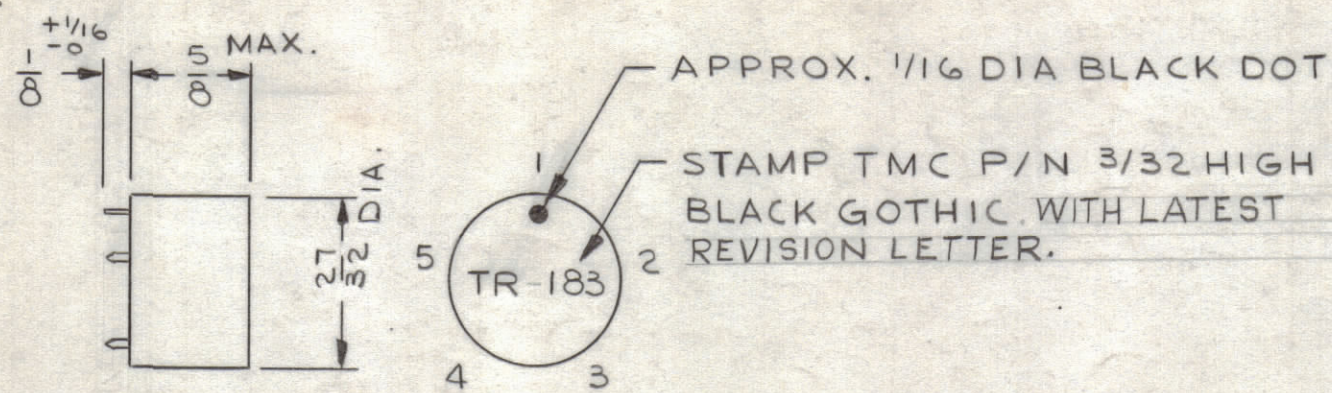
REVISIONS							
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
#	X1	COMPLETELY UPDATED	12/14/63	1	EP	MP	W
	O	ORIGINAL RELEASE FOR PRODUCTION	5/12/64	0	A.M.	@	
A3	A	ON STEP B WINDING CHART, FREQ. COLUMN DELE.					
A4		ON STEP B WIND. CHART 39Ω WAS 38-40, 24Ω W. 23-25	9.24.64	12336	hwb	@	adk
A5		ON STEP B NOTE 2 UPDAT, NOTE "SET GENER..." ADD					
B		STEP B. ±2.5dB WAS 5db	7-7-67	18347	L.A.K.	PPS	E.H.M.

STEP 3:



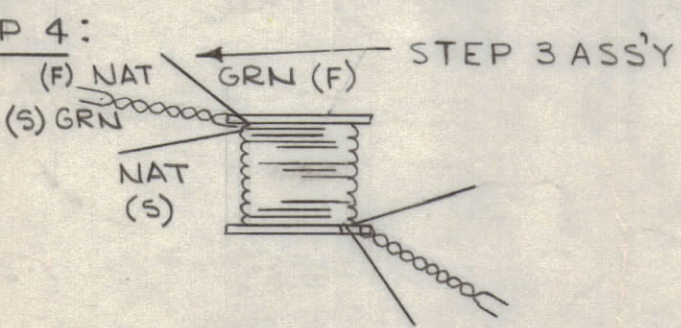
1- WIND 125 TURNS OF MAGNET, WIRE ITEM 12 IN SAME DIRECTION AS 250 TURN WINDING.  
2- STAKE WITH DUCO CEMENT ITEM 7  
3- SEPARATE NATURAL & GREEN WIRES WITH RAZOR BLADE.

STEP 7:



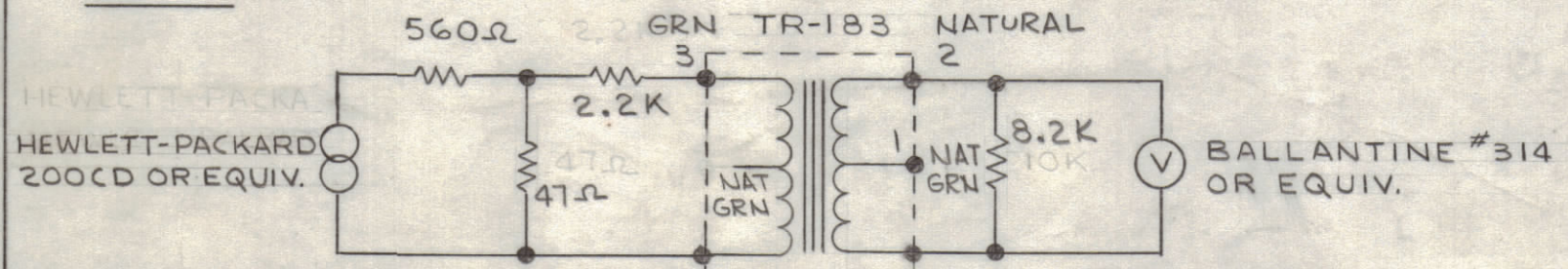
1- ENCAPSULATE STEP 6 ASSY WITH COMPOUND, POTTING, ITEM 8 TO ABOVE DIMENSIONS.

STEP 4:



1- SEPARATE NATURAL & GREEN WIRES WITH RAZOR BLADE.  
1- TWIST TOGETHER THE NATURAL (F) TO GRN (S) TO MAKE CENTER TAP.  
2- BAKE FOR 20 MINUTES AT 150° F.  
3- COAT THOROUGHLY WITH Q DOPE  
4- ITEM 6 IMMEDIATELY AFTER BAKING  
4- PROCESS, ROUGHLY WITH Q DOPE ITEM

STEP 8:



1. CHECK FOR CONTINUITY.  
2. CHECK FREQUENCY RESPONSE AS PER SETUP SHOWN.  
SET GENERATOR TO 5KC AT 0.25 VRMS OUTPUT. NOTE INDICATION ON OUTPUT METER. KEEP OUTPUT OF GENERATOR CONSTANT AT 0.25 VRMS AND SLOWLY RAISE FREQUENCY TO 100KC. OUTPUT METER MUST NOT VARY FROM MAXIMUM INDICATION TO MINIMUM INDICATION MORE THAN 2.5dB OVER THIS FREQUENCY RANGE.

WINDING	R ±5%	FREQ
2-5	39Ω	5dB
3-4	24Ω	5KC TO 100KC

NOTES

NOT TO BE RELEASED W/O AUTHORIZATION  
AUTH BY: \_\_\_\_\_  
DATE: \_\_\_\_\_

A-3217-B

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	12	WI 148-40-95	WIRE, MAGNET	NAT/GRN
-	11	BS 100	SOLDER, SOFT	
1	10	NTH0256BNG	NUT, HEX	
1	9	SCBP0256BNG	SCREW, MACHINE	
-	8	GL 128-4	COMPOUND, POTTING (YEL)	
-	7	GL 103	DUCO, CEMENT	
-	6	GL 130	CEMENT, Q DOPE	
-	5	WI 141-40-55	WIRE, MAGNET	GRN
-	4	WI 141-40-92	WIRE, MAGNET (REDDISH BRN)	NAT.
1	3	TM 124-2	TERMINAL, COLLAR	
2	2	CI-119-TI-D	CORE, CUP	
1	1	CF 135-7	BOBBIN, NYLON	

M. GELLMAN		LIST OF MATERIAL	
MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH		TITLE TR-183 ASSEMBLY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN J. LESHINSKI	DATE 7/11/63
TOLERANCES		CHECKED @	DATE 5-8-64
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	FRACTIONS ± 1/64 ANGLES ± 0° 30'	ELECT. DES. MECH. DES.	FINAL APPROVAL DATE A-3217 B
SCALE NONE		SHEET 1	
MODEL USED ON VLRA-1		ASSY. NO. AX-425	
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.		REV. LTR.	