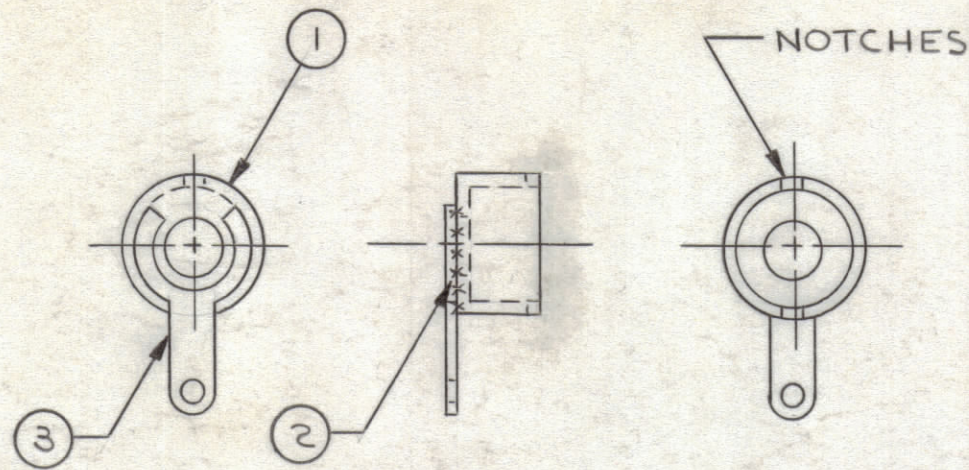
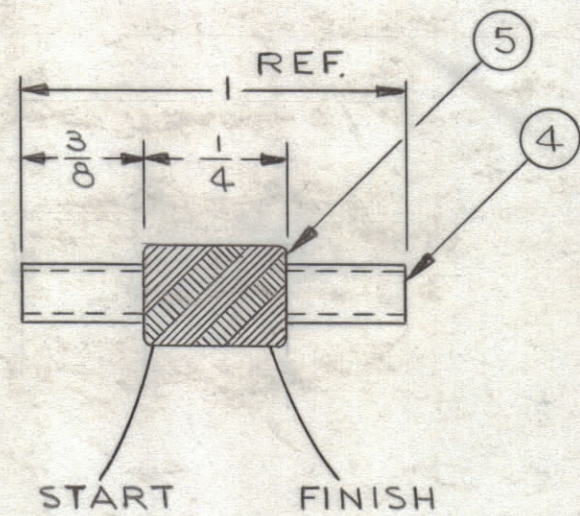


STEP : 1



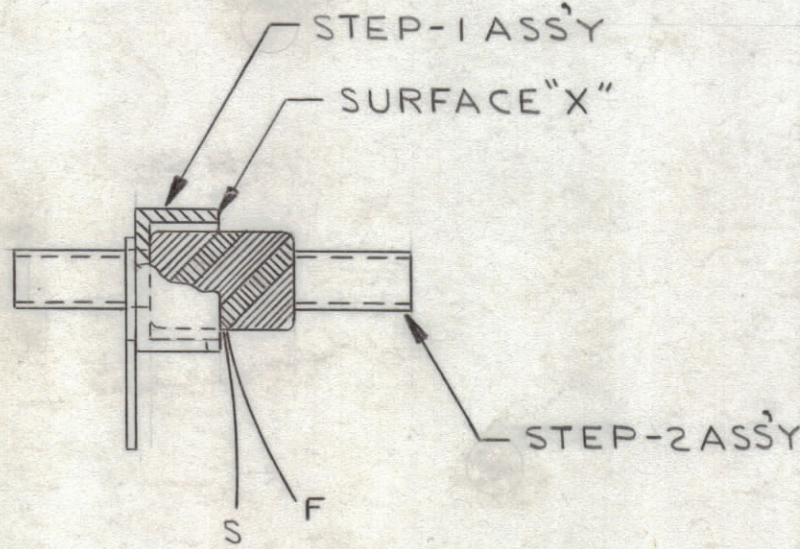
- 1- CEMENT ITEM ③ TO ITEM ① WITH ITEM ②. NOTCHES ON ITEM ① TO BE LOCATED IN POSITION SHOWN.
- 2- ALLOW ITEM ② TO DRY FIRMLY.

STEP : 2



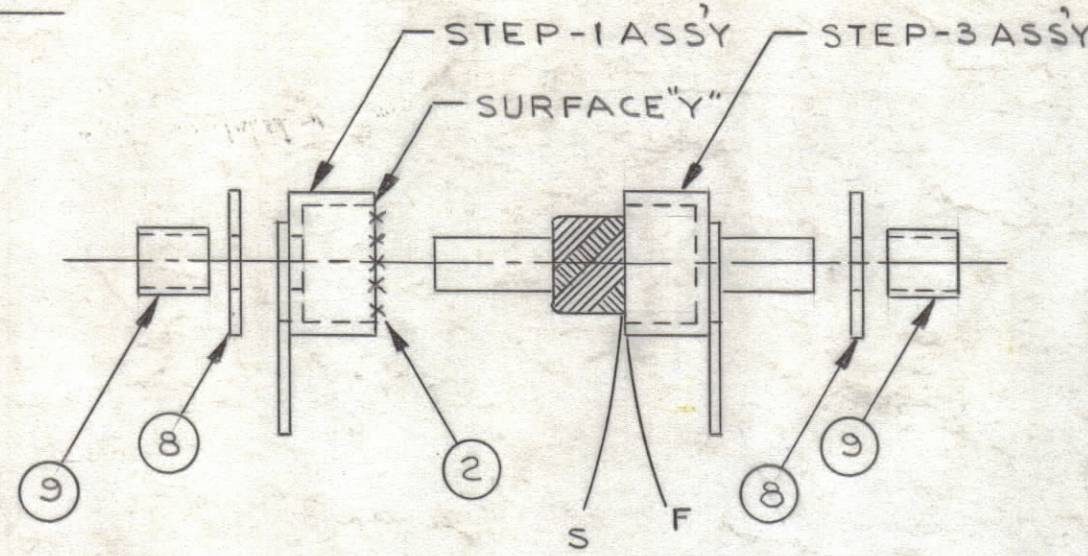
- 1- WIND 71 TURNS OF ITEM ⑤ ON ITEM ④ AS SHOWN.
- 2- STAKE START & FINISH OF WINDING WITH DUCO CEMENT ITEM ⑥.
- 3- TRIM LEADS TO APPROX. 1 INCH IN LENGTH.
- 4- CHECK PER STEP-6B

STEP : 3



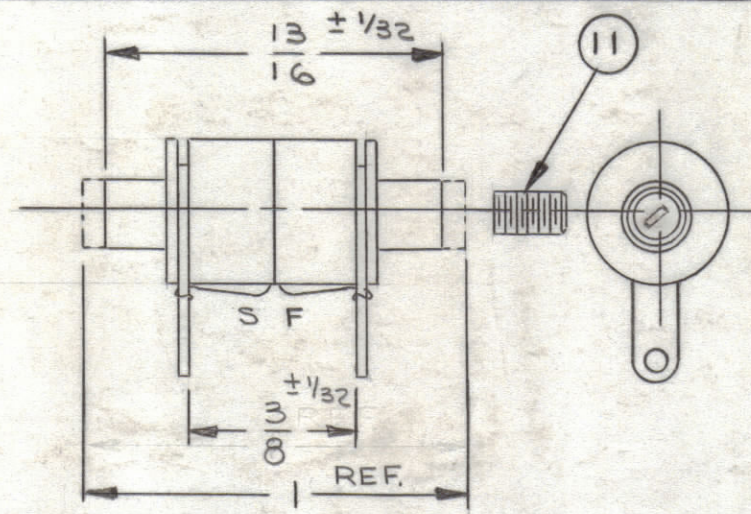
- 1- COAT STEP-2 ASSY WITH Q-DOPE ITEM ⑦ ON OUTSIDE OF WINDING, & PLACE INSIDE STEP-1 ASSY. TAKE CARE TO KEEP SURFACE "X" FREE OF ITEM ⑦.
- 2- STEP-2 START & FINISH LEADS TO BE LOCATED NEAR BOTTOM NOTCH OF STEP-1 ASSY.
- 3- BAKE FOR 20 MINUTES AT 150°F.

STEP : 4



- 1- COAT STEP-1 ASSY SURFACE "Y" WITH ITEM ②.
- 2- LINE UP LUGS ON STEP-1 & STEP-3 ASSEMBLIES & IMMEDIATELY JOIN BOTH ASSEMBLIES TOGETHER.
- 3- CEMENT ITEM ⑧ FLUSH AGAINST LUGS ON STEP-1 ASSY WITH ITEM ②.
- 4- CEMENT ITEM ⑨ OVER ITEM ④ FLUSH AGAINST ITEM ⑧ WITH ITEM ②.

STEP : 5



- 1- SOLDER START & FINISH LEADS TO LUGS WITH ITEM ⑩ AS SHOWN.
- 2- REMOVE, USING RAZOR BLADE APPROX. 3/32" FROM EACH END OF ITEM ④.
- 3- CLEAN INSIDE THREADS OF ITEM ④ WITH #8-32NG-2 TAP.
- 4- CHECK PER STEP-6B
- 5- THREAD ITEM ⑪ IN PLACE

STEP : 6

A- MACHINE SETUP FOR WINDING, SHOWN IN CHART BELOW.

CAM	GEARS	
	FRONT	REAR
.250	DR = 88	DR = 81
	DN = 44	DN = 83

B- CHECK COIL AS PER CHART BELOW.

TEST SPECIFICATION CHART					
STEPS	TURNS	FREQ.	-L-	-Q-	-R-
STEP 2:4	71	2.5 MC	14.24H ± 10%	50 ± 10%	1.2 - 1.4
STEP 5:4	71	2.5 MC	20.0 ± 10%	GREATER THAN 35	1.2 - 1.4

NOTES

LFSB-1 & LFSB-1		
Q'TY/UNIT	MODEL USED ON	ASSY. NO.
SCALE	CODE	
NONE	A	

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REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
#	0	ORIGINAL RELEASE FOR PRODUCTION	7-27-64		GDL	
A		ON STEP 2 IN IT. 71 WAS 68, ON STEP 5 IT WAS 4, IT. 4 ADDED. ON STEP 6 IN TURN COL 71 WAS 68, STEP 2:4, STEP 3:4 ADDED.	10-15-64	12691	RL	ADP
B		ON B/M: IT. 4 WAS CF132-1.00-M-083 2"	12-7-64	13068	RL	ADP
C		WI 104-541-SCQS WAS -SCP-QS.	5/16/65	14572	H.V.V.	ADP

PRIMARY	INDUCTANCE	Q	DC RESISTANCE	FREQUENCY
68.68	4.24 ± 10%	50	1.2 - 1.4	2 1/2 MC

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
1	11	CI 121-2	CORE, THREADED, FERRITE	
X	10	BS 100	SOLDER, SOFT	
2	9	CF 130-1	FORM, COIL	
2	8	WA 109-51	WASHER, FIBER	
X	7	GL 130	CEMENT, "Q" DOPE	
X	6	GL 103	DUCO CEMENT	
X	5	WI 104-541-SCQS	WIRE, LITZ	
1	4	CF 132-1.000M0832	FORM, COIL	
2	3	TE 201	TERMINAL, LUG	
X	2	GL 129	CEMENT,	
2	1	CI 134-Q1-B	CORE, CUP	

M. GELLMAN LIST OF MATERIAL				
MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH	TITLE CL 327 ASSEMBLY			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN	DATE	FINAL APPROVAL	DATE
	J. LESHINSKI	10/2/63		
	CHECKED	DATE		
		7-17-64		
DECIMALS X ± .05 XX ± .01 XXX ± .005	TOLERANCES	FRACTIONS ± 1/64 ANGLES ± 0° 30'	ELECT. DES.	MECH. DES.
			DATE	DATE
			A 3358	C
			SHEET	REV. LTR.

A 3358 C