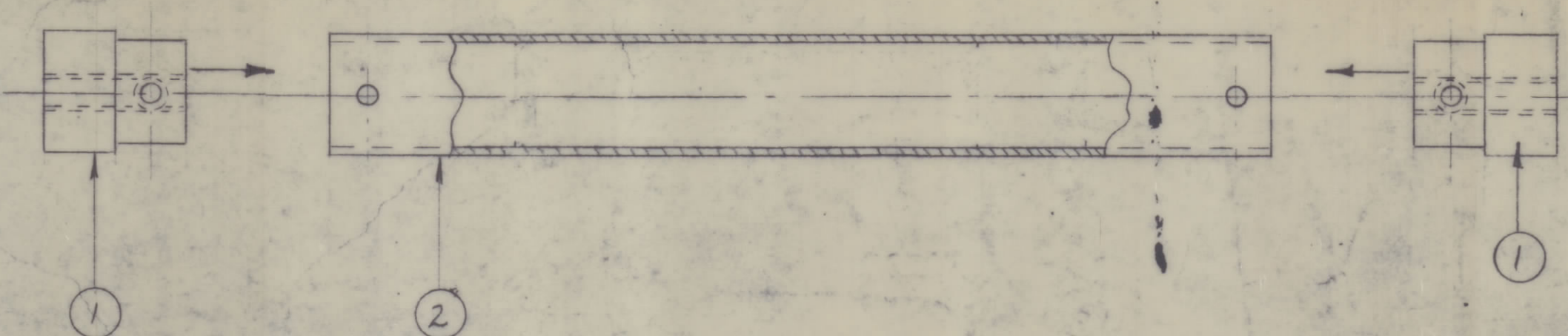


IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

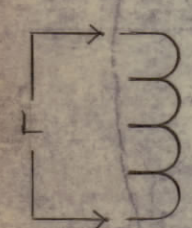
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES.

THE TECHNICAL MATERIEL CORPORATION claims the right to make and use all improvements in the information herein. This drawing is loaned to you for your use only and is not to be used to manufacture any other product without the permission of THE TECHNICAL MATERIEL CORPORATION. THE TECHNICAL MATERIEL CORPORATION is not responsible for any assistance and is subject to recall at any time.

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THE TECHNICAL MATERIEL CORPORATION
 MAMARONECK, NEW YORK



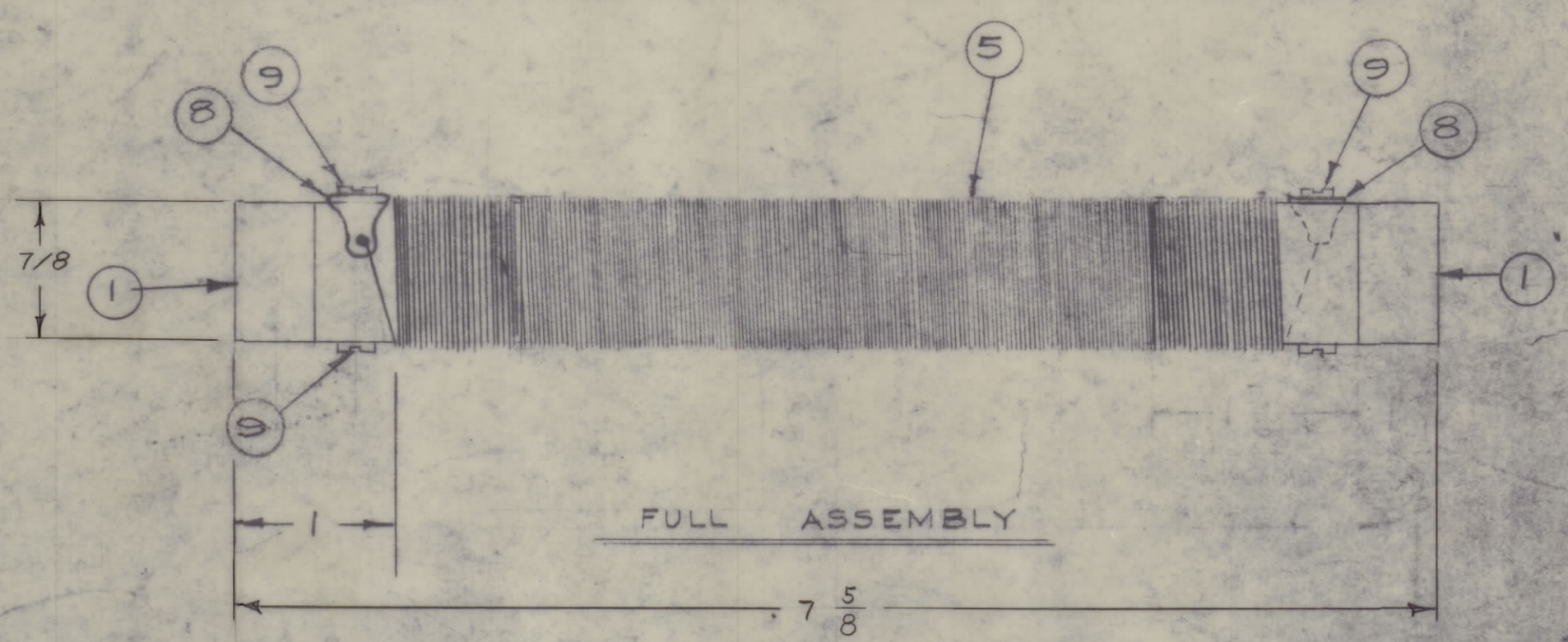
FORM ASS'Y.



PROCEDURE

- 1 - ASSEMBLE "END INSERTS" (ITEM 1) INTO COIL FORM AS SHOWN. ASSEMBLE SCREWS AND LUGS AS SHOWN.
- 2 - WIND APPROX. 118 TURNS OF WIRE (ITEM 5) ON COIL FORM, START WINDING 1" FROM END. STAKE WIRE ENDS TO FORM.
- 3 - SOLDER WIRE ENDS TO LUGS. (ITEM 8)
- 4 - COAT WINDING WITH INSULEX (ITEM 7)
- 5 - BAKE FOR 1 HOUR AT 200° F
- 6 - RECOAT WINDING WITH INSULEX (ITEM 7)
- 7 - BAKE FOR 1 HR. AT 200° F
- 8 - ALLOW UNIT TO COOL.
- 9 - TEST UNIT.

NOTE: IT IS NECESSARY TO TEST ONLY ONE COIL PER BATCH OF 10. ALL OTHERS WILL BE CHECKED MECHANICALLY ONLY.



FULL ASSEMBLY

TEST DATA

L = 45 Microhenries. ±10%
 Q = 130 or Greater
 f = 2.5 mc

CL154 F

X 10	GL-102	CEMENT, Q-MAX
4	9 SCBP0632EM	SCREW MACHINE
2	8 TE-104-2	LUG, SOLDER
X 7	GL-104-2	INSULEX, U85
X 6	BS-100	SOLDER, SOFT
X 5	WI-125-2	WIRE, CEROC # (17)
4		DELETED (WAS CM12-Q-4L)
3		DELETED (WAS TA-10-4)
1	2 CF-127-6.625	COIL FORM
2	1 PM-537	INSERT, COIL FORM

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
STOCK SIZE			
MATERIAL WEIGHT PER PC. (PLATE DECOUPLING COIL)			
TYPE & TEMPER			
HEAT TREAT. SPEC.			
FINISH & SPEC. NO.			

F	REVISED	6-4-71	20369	RZ	G.S.A.		
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

TOLERANCES		SCALE:
ALL OTHERS	DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±	DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.

1	GPT-10K	CL-154		2-2-59
REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
USED ON				

CL154 F