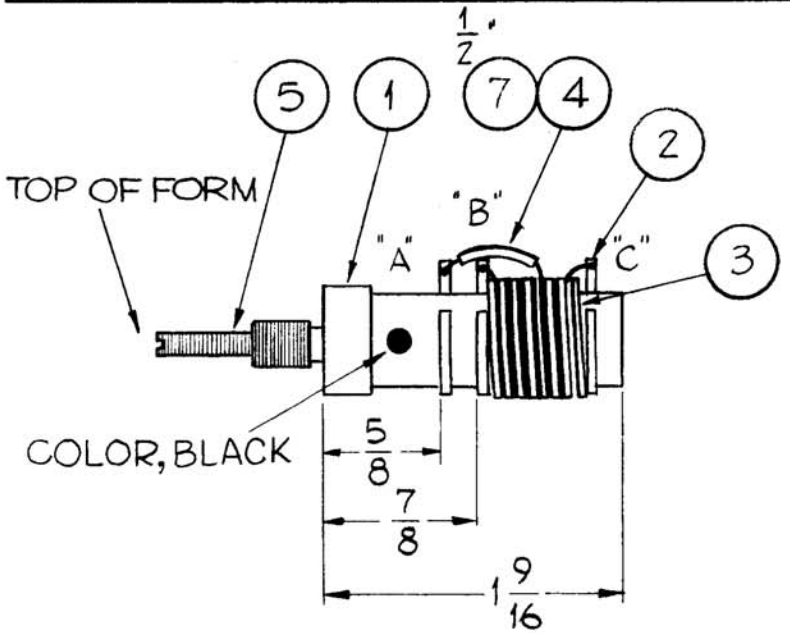
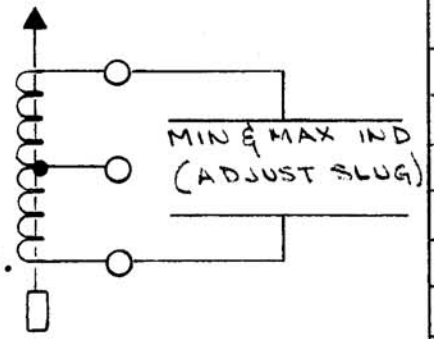
REQ. PER UNIT	USED ON MODEL	ASS'Y. NO.	DATE		
1	RFD-1	PAL-1K, SBT-1K	10-25-60	A-2005	B

PROCEDURE

1. Slip two terminal rings (item on form (item 1) as shown. (Marked "A" and "B").
2. Force fit outer form (item 3) onto inner form (item 1) and cement with Insulex (item 6).
3. Slip terminal ring marked "C" on inner form.
4. Cement all rings to inner form.
5. Wind 5 turns of wire (item 4) on outer form. Bring out tap at 3-1/4 turns from top. Slip Sleeving (item 7) over tap. Solder all wire ends to proper terminals.
6. Paint winding with Insulex.
7. Bake for 1/2 hour at 250° F.
8. Insert core (item 5).
9. Test as shown below. Use Boonton Q - Meter Model 160A or Equivalent.



Minimum inductance must be less than - .50 uhy, ± 5 %
Maximum inductance must be more than - .65 uhy, ± 5 %
Q at 25 Mc must be more than - 130.
Test frequency - 25 Mc.
Operating frequency - 16-22Mc.



REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	8	BS-100	Solder, Soft	
1/2"	7	PX-100-1-.042	Insulation, Sleeving (Size 18)	Blk
X	6	GL-104-2	Insulex, U85	
1	5	CI-109-19	Core, Tuning, Red	
X	4	WL-100-5	Wire, Buss (Size 18)	
1	3	CF-125-3P0.50	Coil, Form, Grooved	
3	2	TE-153-3	Terminal, Ring Type	
1	1	CF-119-1.562	Coil Form, W/Bushing	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B	2	.50uhy ±5% WAS .55 uhy	11-27-63	10431			
	1	.65uhy ±5% WAS .85uhy					
A	2	MIN. INDUCTANCE .55 ADDED.	11-23-60	3569			
	1	MAX. INDUCTANCE .85 ADDED					

TOLERANCES
DEC. DIM. ±
FRAC. DIM. ± 1/64
ANGULAR DIM. ±

SCALE: FULL, Do Not Scale

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

STOCK SIZE
MATERIAL
TYPE & TEMPER | HEAT TREAT. SPEC.
FINISH & PEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

CL-259 ASS'Y
(LZ24) COIL, R.F. TUNED, 16-22MC

DRAWN: J.C. Biele
CHECKED
FINAL APPROVAL
ELEC. DES. APP. | MECH. DES. APP.

A-2005 B

FORM 108-A