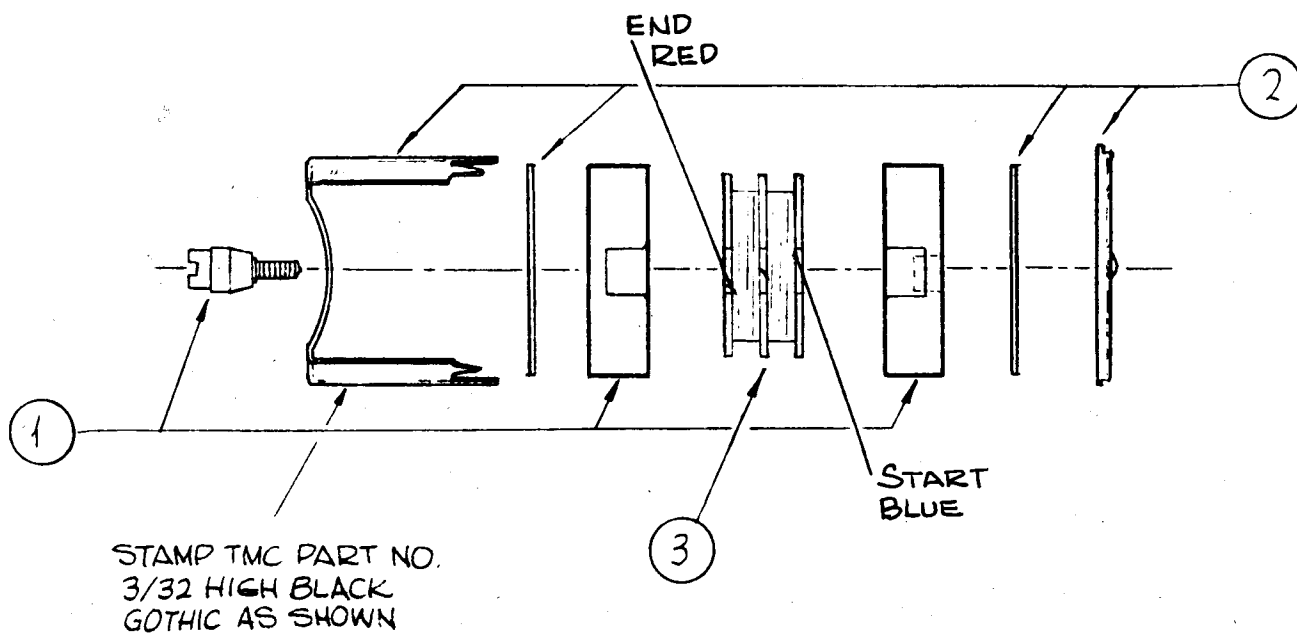


"Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	NUMBER CODE	SYMBOL	INDUCTANCE 10K BRIDGE
200 KCS	140	#	#	#	2.712 mh ±.02mh



WINDING PROCEDURE

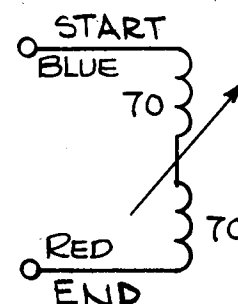
1. WIND 140 TURNS OF ITEM 6 ON ITEM 3, STAKE WITH ITEM 5.
2. ITEM 3 IS A SPLIT BOBBIN, DIVIDE TURNS EVENLY ON BOTH SIDES.
3. KEEP ALL LEADS 1 1/2" LONG.
4. STRIP AND TIN ALL LEADS TO WITHIN 3/4" OF COIL.
5. COLOR CODE ALL LEADS AS SHOWN IN WIRING DETAIL.
6. BAKE COIL FOR 15 MINUTES AT 150° F. REMOVE FROM OVEN AND COAT COIL WITH ITEM 4.
7. PLACE ITEM 3 INSIDE OF ITEM 1 AND ASSEMBLE AS PER ASSEMBLY DRAWING.
8. BEND THE 4 SMALL TABS DOWN, TOWARD CENTER OF COIL.
9. DELETED.
10. STAMP TMC PART NO. AS SHOWN.
11. TEST INDUCTANCE AND "Q" AS SHOWN ABOVE. SET INDUCTANCE FIRST.
12. BAKE COMPLETED ASSEMBLY FOR 1 HOUR AT 212° F.
13. REMOVE COMPLETED ASSEMBLY FROM OVEN AND ALLOW TO COOL TO ROOM TEMPERATURE.
14. REPEAT STEP # 11.
15. TEST COIL WITH 1/4 % 10KC UNIVERSAL BRIDGE (INDUCTANCE ONLY).
16. TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE AS SHOWN ABOVE.
17. TEST COIL WITH "Q" METER TYPE 260A (FOR "Q" ONLY).
18. SET THE TEST FREQUENCY AS SHOWN ABOVE, AND SET THE (MULTIPLY "Q" BY) TO 2.
19. TUNE THE INDUCTANCE DIAL, TO REACH THE MAX. READING ON THE "Q" METER.
20. WAX CORE IN PLACE AFTER SETTING.

NOTES

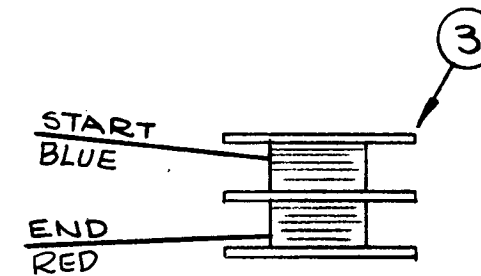
1	VLRB-1	A3681
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	
	A	
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.		

A3918

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPER. RELEASE	3-26-65	X	ALA	
Ø	ORIGINAL RELEASE FOR PRODUCTION	7-7-65	Ø	PL	
A	INDUCTANCE WAS 2.62 mh, WINDING PROCEDURE (20) ADD.	5-21-66	14120	CU	



SCHEMATIC DIAGRAM



WIRING DIAGRAM

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	7	BS100	SOLDER, TIN ALLOY	
X	6	WI-104 - 3/41 SN QS	WIRE, ELECTRICAL, MAGNET LITZ	
X	5	GL103	ADHESIVE-N-CEL	
X	4	GL130	ADHESIVE-Q-DOPE	
1	3	CF135-10	FORM, COIL, 3 FLANGE	
1	2	CU158	RETAINER	
1	1	CI137-8	CORE, ADJUSTABLE, TUNING	

LIST OF MATERIAL

MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH	TITLE AC190 COIL, RF, ADJUSTABLE			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN	DATE	FINAL APPROVAL	DATE
	H. AUSTIN	3-26-65	[Signature]	
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005 FRACTIONS ± 1/64 ANGLES ± 0° 30'	CHECKED	DATE	A3918	A
	[Signature]	3-29-65		
TOLERANCES	ELECT. DES.	DATE	SHEET	REV. LTR.
	JAB			