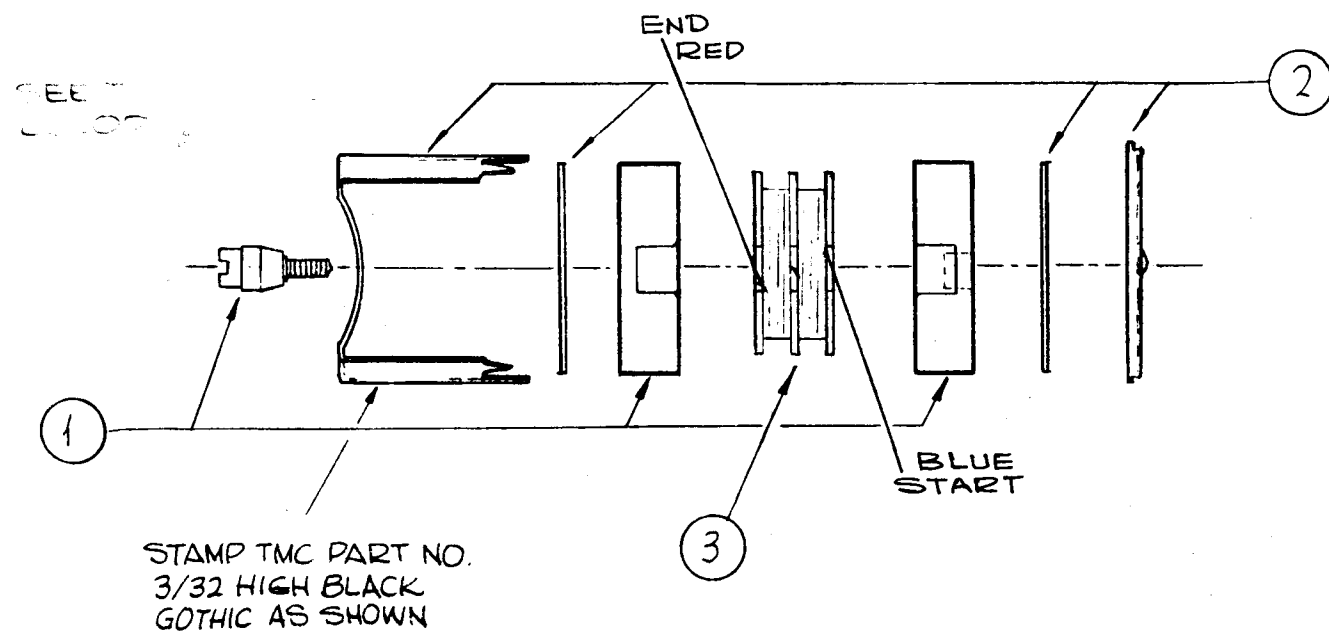


"Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	NUMBER CODE	SYMBOL	INDUCTANCE 10K BRIDGE
200KCS	125	155 pf	"	"	3.17mh ±.5mh



WINDING PROCEDURE

1. WIND 190 TURNS OF ITEM 6 ON ITEM 3, STAKE WITH ITEM 5.
2. ITEM 3 IS A SPLIT BOBBIN, WIND 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. ~~DEBENTED~~ OF THE COIL ON THE SIDE OF CORE.
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.

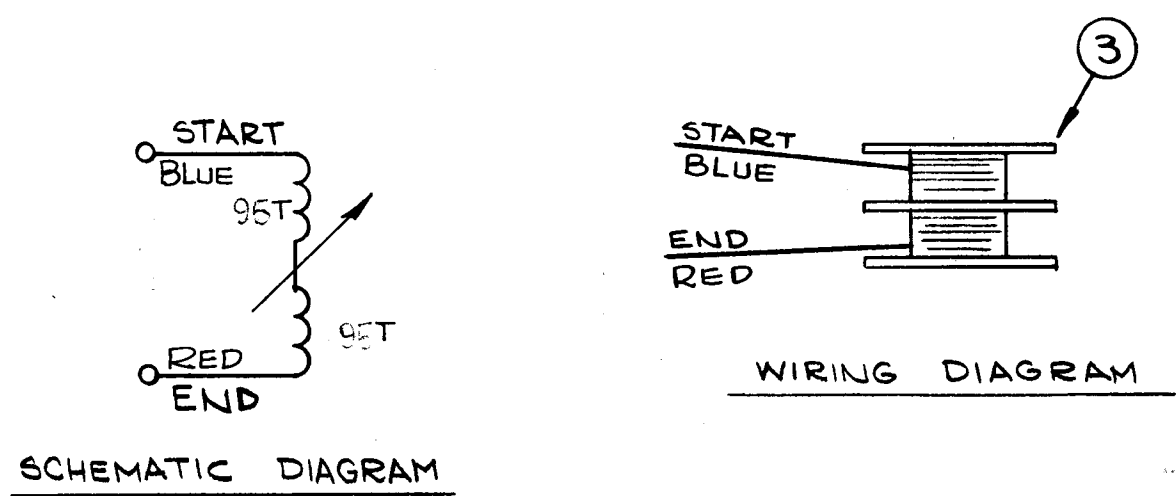
NOTES

1	VLRB-1	A3681
Q'TY./UNIT	MODEL USED ON	ASSY. NO.
SCALE	CODE	
	A	

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A3919

REVISIONS						
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X	EXPER. RELEASE	3-25-65	X	H.A.		
Ø	ORIGINAL RELEASE FOR PRODUCTION	4-7-65	Ø	ØL		
A	INDUCTANCE WAS 3.92 mh, WINDING PRO. 20 ADDED, T" WAS 100	5-21-65	14120	CJR		



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	7	BS100	SOLDER, TIN ALLOY	
X	6	WI-104-3/43 SWQS	WIRE, ELECTRICAL, MAGNET LITZ (SN.)	
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 AC 191 COIL, RF, ADJUSTABLE			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN H. AUSTIN	DATE 3-25-65	FINAL APPROV. <i>[Signature]</i>	DATE
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		CHECKED <i>[Signature]</i>	DATE 3-29-65	A3919	
TOLERANCES		ELECT. DES. HAB	DATE	A	
FRACTIONS ± 1/64 ANGLES ± 0° 30'		MECH. DES.	DATE	SHEET	
				REV. LTR.	