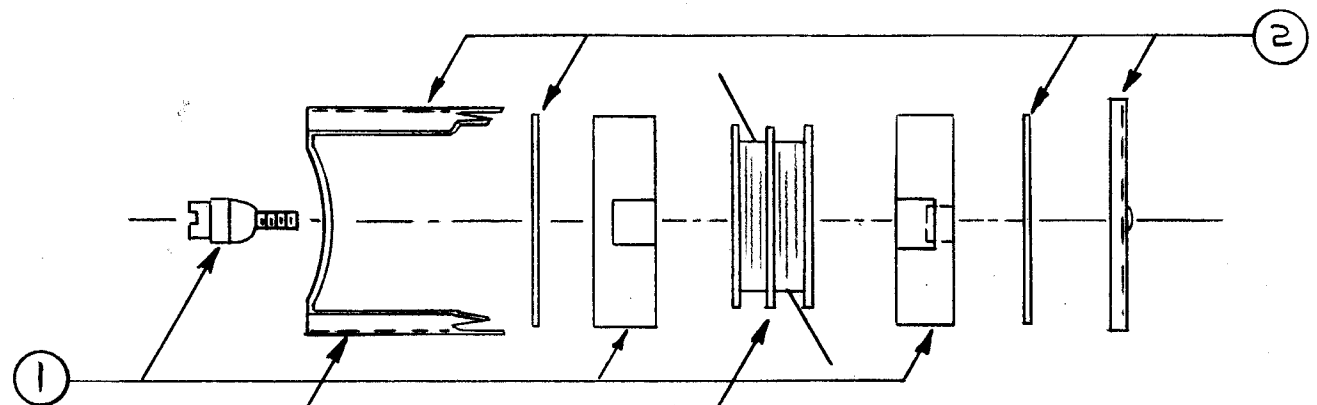


"Q" TEST FREQ.	"Q" MIN.	TEST FREQ.	INDUCTANCE
250 KC	300	790 KC	803 μ h \pm 5%



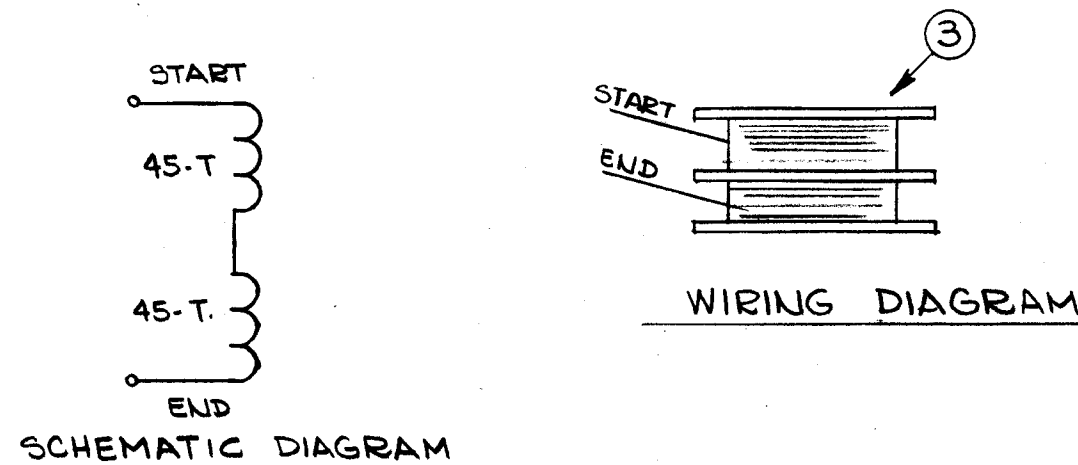
STAMP TMC PART NO. (CL 348) 3/32.
HIGH BLACK GOTHIC AS SHOWN.
W/LATEST REV. LETTER.

WINDING PROCEDURE

- 1- WIND 90 TURNS OF ITEM 6 ON ITEM 3, STAKE WITH ITEM 5.
- 2- ITEM 3 IS A SPLIT BOBBIN, SPLIT THE TURNS ON BOTH SIDES.
- 3- KEEP ALL LEADS 3" LONG.
- 4- STRIP AND TIN ALL LEADS TO WITHIN 2" 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 WITH ITEM 4.
- 7- PLACE ITEM 3 INSIDE OF ITEM 1 AND ASSEMBLE AS PER ASSEMBLY DRAWING.
- 8- BEND THE 4 SMALL TABS DOWN.
- 9- STAMP TMC PART NO. AS SHOWN.
- 10- TEST INDUCTANCE AND "Q" AS SHOWN ABOVE.
- 11- BAKE COMPLETED ASSEMBLY FOR 1 HOUR AT 212°F.
- 12- REMOVE COMPLETED ASSEMBLY FROM OVEN AND ALLOW TO COOL TO ROOM TEMPERATURE.
- 13- REPEAT STEP 10.
- 14- TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE AS SHOWN ABOVE.
- 15- TEST COIL WITH "Q" METER TYPE 260A.
- 16- SET THE TEST FREQ. AS SHOWN ABOVE, AND SET THE (MULTIPLY "Q" BY) TO 2.

A 3994

REVISIONS						
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X	EXPER. RELEASE	12-8-64	X	Plan		
X	A3994 WAS A3944	12-23-64	X	W		
Ø	ORIGINAL RELEASE FOR PRODUCTION	5/24/65	-A	BS		
A	IT 6 WAS WI104-7/41, IT 3 WAS CF135-10, TMC P/N. CL 348 ADDED	8-16-65	14682	WV	JCP	MM



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	7	BS100	SOLDER, TIN ALLOY	
X	6	WI104-7415195	WIRE, ELECTRICAL, SNPQS	
X	5	GL103	ADHESIVE-N-CEL	
X	4	GL130	ADHESIVE-Q-DOPE	
1	3	CF135-11	FORM, COIL, 3 FLANGE	
1	2	CU158-2	RETAINER	
1	1	CI137-5	CORE, ADJUSTABLE, TUNING	

O. POSE LIST OF MATERIAL

MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH	TITLE CL348 ASSY			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN <i>G. Lucas</i>	DATE 12-8-64	FINAL APPROVAL <i>W. May</i>
		CHECKED <i>W. May</i>	DATE 5/24/65	DATE 5/5/65
DECIMALS .X \pm .05 .XX \pm .01 .XXX \pm .005		FRACTIONS \pm 1/64 ANGLES \pm 0° 30'		A3994
TOLERANCES		ELECT. DES. <i>W. May</i>	DATE	REV. LTR. A
		MECH. DES.	DATE	SHEET

NOTES

1	LFRA-1	
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE <i>1/2"</i>	CODE A	
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