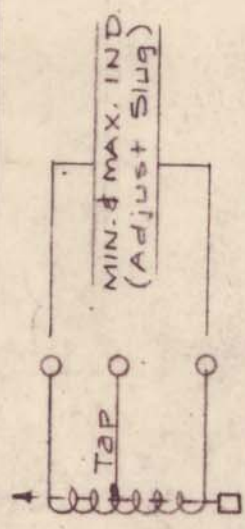


PROCEDURE

1. Slip two terminal rings (item 2) on form (item 1) as shown. (marked "A" & "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 9 turns of wire (item 4) on outer form. Bring out tap at 7-1/2 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 Equiv.



ASSY #	L-MAX	L-MIN	Q	TEST FREQ	CORE	COLOR	PART #	OPER. RANGE
A1611-1	>1.3µh	<1.1µh	>130	7.9 MC	CI109-19	RED	CL146	8-16 MC
A1611-2	>2µh	<1.3µh	>80	7.9 MC	CI03D7B5	GREEN	CL146-2	6.3-12.3 MC

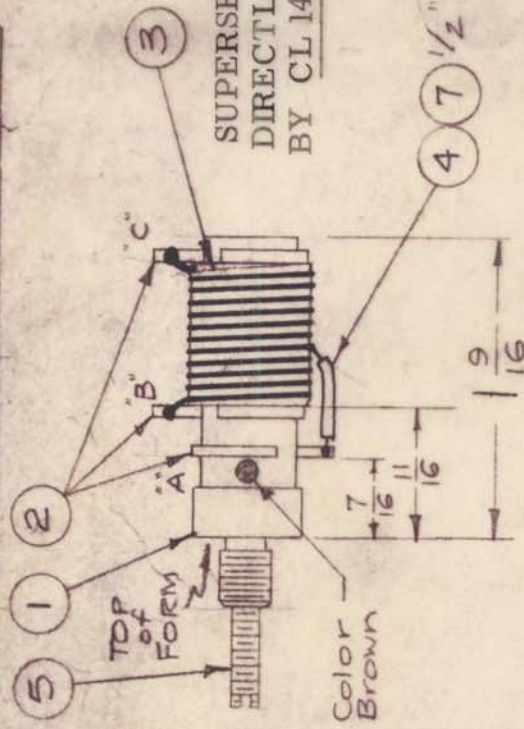
ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
E	Replaced by CL146	6/11/59	20332	00		
D	EL. SPECS REV. CHART ADD. IT. 5 WAS CI-109-19, RED	6.12.64	11553	10B	@	AB
C	MIN. MAX. IND. ADDED	8-14-62	7066	9.5	AB	AB
B	ITEMS 6, 7, 8, 9	6/27/59	1123	10	AB	AB
A	Test Q was 150	4/1/59		J.C.B.	AB	AB

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

SCALE: FULL

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

USED ON
 ASS'Y. NO. GPT-10K
 DATE 12-19-58
 MODEL RFB-1
 PALIK
 RFD-1
 RFC-1
 10-22-60
 11-22-60



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 8	BS-100	Solder, Soft	
1/2"	PX-100-1-.042	Insulation, Sleeving (Size 18)	BK.
X 7	GL-104-2	Insulex, UBS	
X 1	SEE CHART	Core, Tuning,	
X 4	WL-100-5	Wire, Buss (size 18)	
1	CF-125-3P0.75	Coil Form, Grooved	
3	TE-153-3	Terminal, Ring Type	
1	CF-119-1.562	Coil Form, w/ Bushing	

THE TECHNICAL MATERIEL CORP.
 MAMARONECK, NEW YORK

RF COIL ASSY, TUNED
 (CL-146)

16/17/19/58
 DRAWN ATB
 CHECKED [Signature]
 FINAL APPROVAL OMB

A-1611
 E