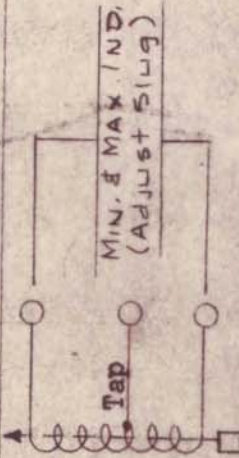


PROCEDURE

1. Slip two terminal rings (item 2) 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 6 turns of wire (item 4) on outer form. Bring out tap at 4 1/2 turns from top. Slip Sleaving (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 -.60 uhy.
 Maximum inductance must be more than -.78 uhy.
 Q at 25 Mc must be more than - 140
 Test frequency - 25 Mc.
 Operating frequency - 16-20 Mc.

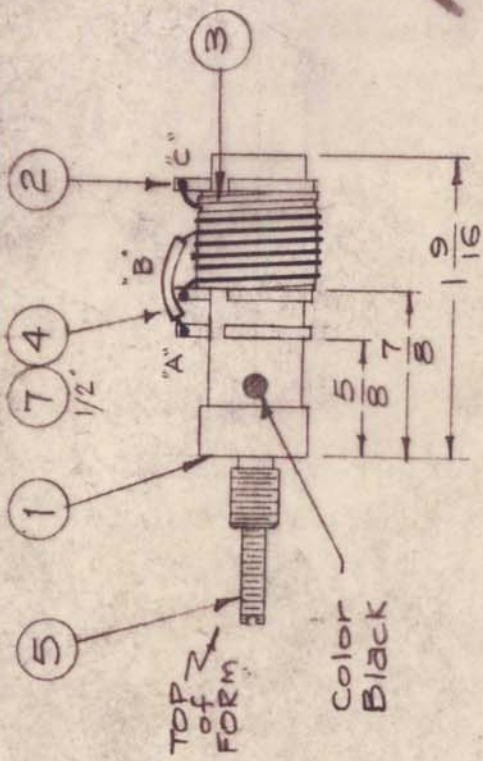
ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
E	Replaced by CL147	6/1/51	20332	AW		
D	MIN & MAX INDUCTANCE ADDED Q SPEC WAS 130	8-14-62	7066	JS.	Hde	W
C	ITEM 5 WAS CI-116-10	6/23/59	1124	Hde	Hde	Hde
B	TEST Q WAS 145	4/1/59		J.C.B.	Hde	Hde
A	Winding & wiring changed .60 uhy was .71 .78 uhy was 1.0 1.95 was 1.30	1/5/59	643	AW	Hde	Hde

SCALE: FULL

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

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

REQ. PER UNIT	MODEL	USED ON ASSY. NO.	DATE
1	RFB-1 RFC-1	GPT-10K	12-19-58
			11-22-60



SUPERSEDED
 DIRECTLY REPLACED
 BY CL147

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 8	BS-100	Solder, Soft	
1/2"	PX-100-1-042	Insulation, Sleaving (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	

THE TECHNICAL MATERIEL CORP.
 MAMARONECK, NEW YORK

RF COIL ASSY, TUNED
 16-20 MC (CL-147)

16^{12/19/58} Hde
 DRAWN
 CHECKED
 ELEC. DES. APP. MECH. DES. APP.

FINISH & SPEC. NO.
 A-1612

FINAL APPROVAL
 OMB

A-1612