

WINDING MACHINE DATA

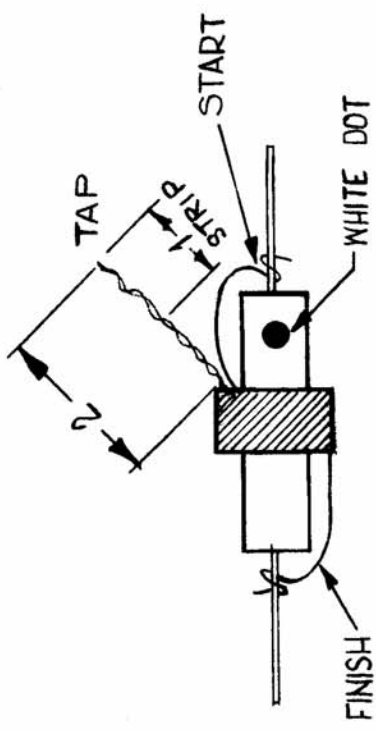
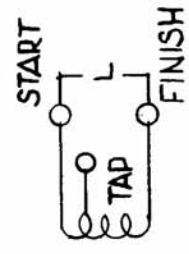
DRIVER GEAR - 68  
 CAM GEAR - 104  
 CAM - .187

WINDING PROCEDURE

1. WIND 63 TURNS AND BRING OUT 2" TAP; THEN WIND 127 ADDITIONAL TURNS.
2. STAKE LEADS OF WINDING TO CORE BODY WITH ITEM 3
3. BAKE DRY AT 100°C
4. SOLDER COIL LEADS TO CORE LEADS AS SHOWN.
5. COAT WINDING WITH ITEM 4
6. BAKE DRY AT 100°C
7. TEST AS BELOW. (USE BOONTON Q-METER 160 A OR EQUIV.)
- 8 - PAINT WHITE DOT ON START SIDE OF COIL  
 SEE ILLUSTRATION AT RIGHT FOR LOCATION OF DOT.

TEST DATA

L = 500 μH ± 5%  
 Q = 90 OR GREATER  
 F = 790 KC



REQ. PART UNIT	USED ON
3	ASSY. NO.
	DATE
	4-15-60
	MODEL
	CMO
	A 1871
	D

REG. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 5	BS-100	SOLDER, SOFT	
X 4	GL-102	Q-MAX	
X 3	GL-103	CEMENT	
X 2	WI-106-17	WIRE #36 DSB	
1	CI-114	CORE FIXED W/LEADS	

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
CL 227 ASSY (COIL, RF, FIXED, 500 UHY)	
DRAWN	CHECKED
TYPE & TEMPER	HEAT TREAT. SPEC.
FINISH & SPEC. NO.	ELEC. DES. APP. MECH. DES. APP.
	A 1871
	D

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
D 1	CLERICAL CHANGE	11-17-64				
C 1	TEST DATA L ± 5% WAS 100%	5-3-61	4797			
B 1	STEP 8 ADDED, SCHEM. CLAIMED	4-28-61	4728			
A 1	1" STRIP ADDED TO TAP	4-7-61	4580			

SCALE:

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

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