

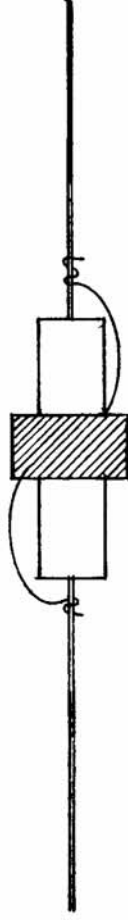
REQ. PER UNIT	USED ON	DATE	A-1872	A
3	MODEL	ASST. NO.		
	CMO	4-15-60		

WINDING MACHINE DATA

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

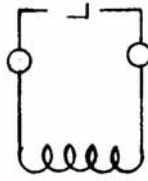
WINDING PROCEDURE

1. WIND 45 TURNS OF ITEM 2.
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 160A OR EQUIVALENT)



TEST DATA

L = 32 μH ± 5 μH
 Q = 60 OR GREATER
 F = 2.5. MC.



REQ. 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	
STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL		CL-228 ASS'Y (COIL, RF, FIXED, 32 UHY)	
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		CL-228 ASS'Y	FINAL APPROVAL

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A 1	On test data 5μH rms. 1 μH	6-1-61	4984	EW	RCB	
TOLERANCES						
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±						
SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES						