

STAMP TMC PART NO.
3/32 HIGH BLACK GOTHIC
AS SHOWN WITH LATEST
REVISION LETTER

	PRIMARY	SECONDARY	TERTIARY
R	3.5 Ω	2.0 Ω	2.0 Ω
*L	26-27.5 mhy	3.2-3.8 mhy	3.2-3.8 mhy
*Q	51-57	7.57	7.57 ± 5%
*F	1KC	1KC	1KC

* MEASURED WITH GR BRIDGE TYPE 1650-A OR
EQUIVALENT. TUNING SLUG ITEM #9 REMOVED.

NOTES:

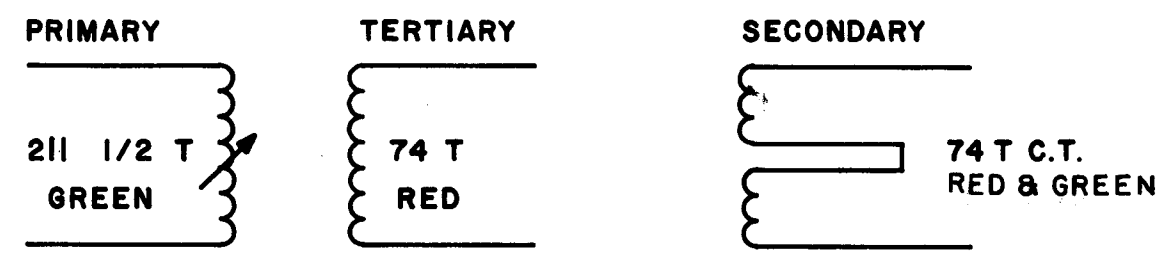
- 1~ SOLENOID WIND PRIMARY 211 1/2 TURNS OF ITEM*2 ON ITEM*6. STAKE WITH ITEM*4.
- 2~ WIND TERTIARY 74 TURNS OF ITEM*11 & STAKE ENDS WITH ITEM*4.
- 3~ BIFILAR WIND SECONDARY 37 TURNS OF ITEMS#11&2. STAKE ENDS WITH ITEM*4. TWIST START OF ONE WINDING WITH FINISH OF OTHER WINDING (SEE PICTORIAL.)
- 4~ COLOR CODE ALL START LEADS WITH WHITE DOT AND BAKE FOR 30 MINUTES AT 150°F. REMOVE FROM OVEN & COAT COIL WITH ITEM #3.
- 5~ COAT CORE SURFACE (ITEM #1) WITH ITEM #5.
- 6~ ASSEMBLE AS SHOWN IMMEDIATELY.
- 7~ STRIP & TIN LEADS (MINIMUM LENGTH OF 2 INCHES)
- 8~ CHECK R, L & Q OF WINDINGS.
- 9~ CHECK FOR CONTINUITY BETWEEN WINDINGS.
- 10~ INSERT ITEM #3 INTO BASE OF CORE TO SEAL BOBBIN.

NOTES

1	VLR-1	AX 425
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE DO NOT SCALE	CODE A	
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A 3177 B

REVISIONS						
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X1	CHART UPDATED; ARROW ADDED TO PRIMARY SCH.	12/18/63	1			
O	ORIGINAL RELEASE FOR PRODUCTION	5-11-64	0	A.M.		
A	IT. 2 WAS WT-141-32-5 ON CHART *Q SEC. WAS 75.7 ON CHART *Q TERTIARY WAS 75.7	8.8.64	12034	ASB	MP	
B	IT. 10 WAS WI141-32-9, NOTE (10 ADDED, 3 & 4 REV.) SEC. WAS NAT.	8.24.67	18469	H.G.		EFM



SCHEMATIC

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	11	WI-141-32-2	WIRE, ELECTRICAL, MAGNET INSUL.	
	10	DELETED		
1	9	CI-133	CORE, TUNING	
2	8	WA-140-1	WASHER, NON-METALLIC	
1	7	CU-148-1	RETAINER, CUP CORE	
1	6	CF-135-4	FORM, COIL	
X	5	GL-129	ADHESIVE, QUICK SETTING	
X	4	GL-103	DUCCO	
X	3	GL-130	CEMENT, Q DOPE	
X	2	WI-141-30-5	WIRE, ELECTRICAL, MAGNET INSUL.	
1	1	CI-132	CORE, CUP	

M. GELLMAN LIST OF MATERIAL				
MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH	TITLE TT-199 ASSEMBLY			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN G. J. [Signature]	DATE 6-3-63	FINAL APPROVAL KOC	
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	TOLERANCES	DATE 5-7-64	DATE	
FRACTIONS ± 1/64 ANGLES ± 0° 30'		DATE	DATE	
		A 3177		B
		SHEET		REV. LTR.