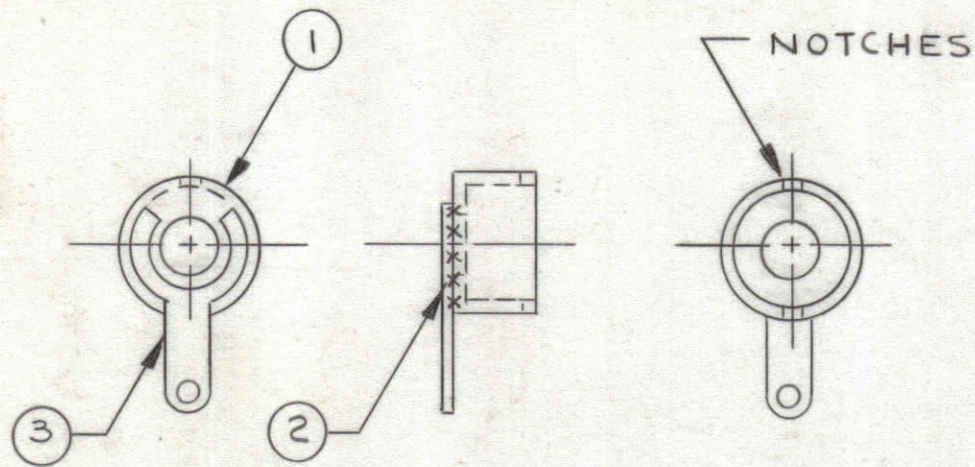
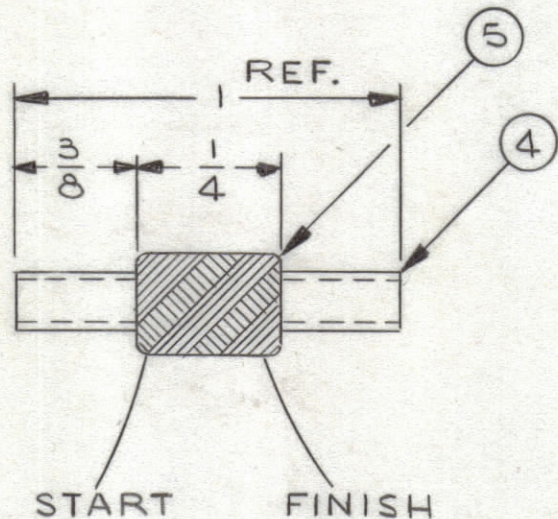


STEP: 1



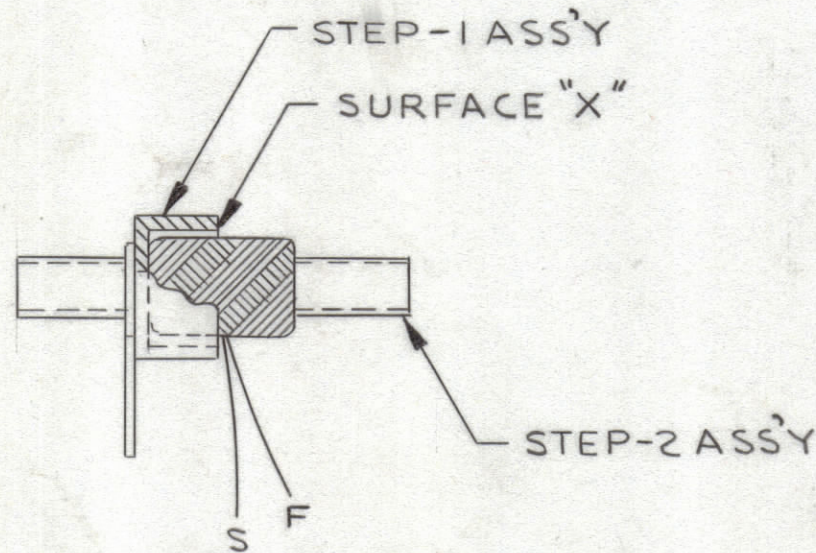
1- CEMENT TERMINAL LUG ITEM ③ TO CUP CORE ITEM ① WITH CEMENT ITEM ②. NOTCHES ON ITEM ① TO BE LOCATED IN POSITION SHOWN.
2- ALLOW ITEM ② TO DRY FIRMLY.

STEP: 2



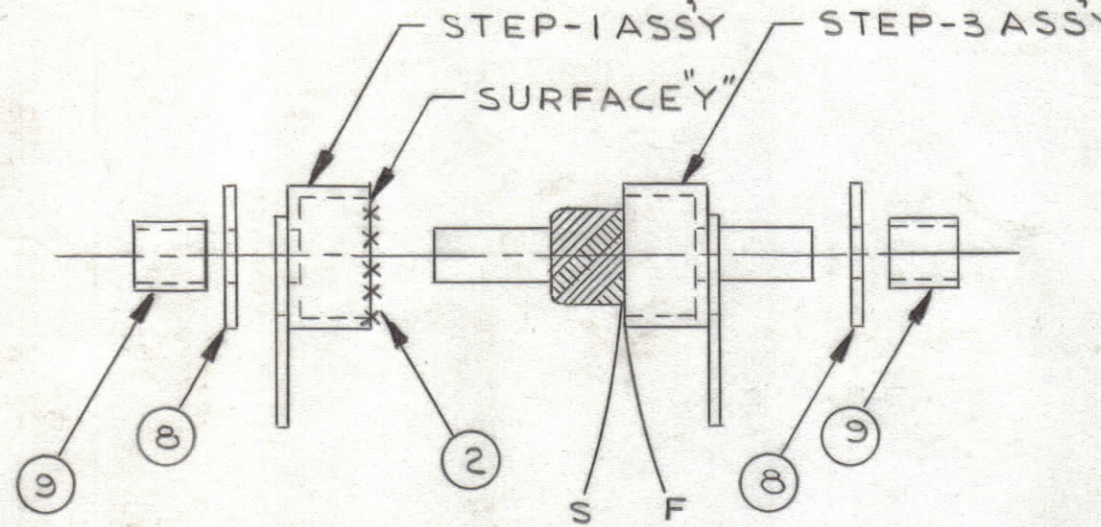
1- WIND 170 TURNS OF WIRE ITEM ⑤ ON COIL FORM ITEM ④ AS SHOWN.
2- STAKE START & FINISH OF WINDING WITH DUCO CEMENT ITEM ⑥.
3- TRIM LEADS TO APPROX. 1" INCH IN LENGTH.
4- CHECK PER STEP-6B.

STEP: 3



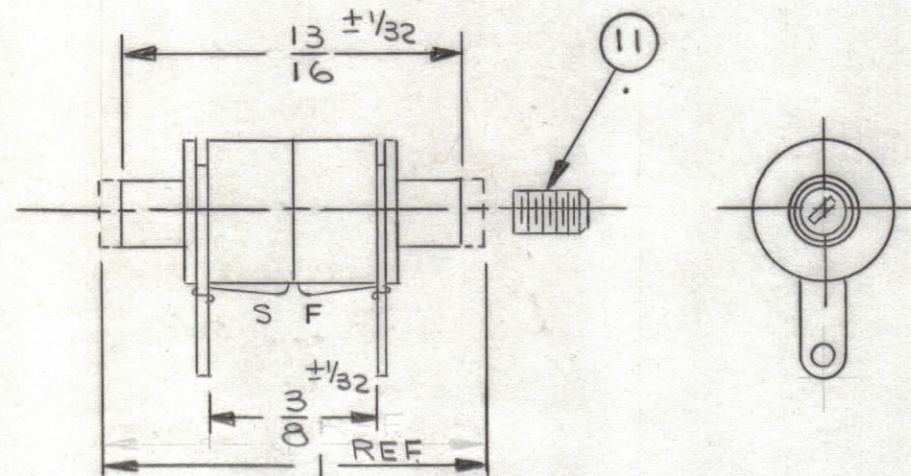
1- COAT STEP-2 ASSY WITH Q-DOPE ITEM ⑦ ON OUTSIDE OF WINDING, & PLACE INSIDE STEP-1 ASSY. TAKE CARE TO KEEP SURFACE "X" FREE OF ITEM ⑦.
2- STEP-2 ASSY START & FINISH LEADS TO BE LOCATED NEAR BOTTOM NOTCH OF STEP-1 ASSY.
3- BAKE FOR 20 MINUTES AT 150°F.

STEP: 4



1- COAT STEP-1 ASSY SURFACE "Y" WITH CEMENT ITEM ②.
2- LINE UP TERMINAL LUGS ON STEP-1 & 3 ASSEMBLIES & IMMEDIATELY JOIN BOTH ASSEMBLIES TOGETHER.
3- CEMENT FIBER WASHERS ITEM ⑧ FLUSH AGAINST TERMINAL LUGS ON STEP-1 ASSY WITH ITEM ②.
4- CEMENT COIL FORM ITEM ⑨ OVER COIL FORM ITEM ④ FLUSH AGAINST ITEM ⑧ WITH ITEM ②.

STEP: 5



1- SOLDER START & FINISH LEADS TO TERMINAL LUGS WITH SOLDER, ITEM ⑩ AS SHOWN.
2- REMOVE, USING RAZOR BLADE APPROX. 3/32" FROM EACH END OF COIL FORM ITEM ④.
3- CLEAN INSIDE THREADS OF ITEM ④ WITH NO. 8-32 NC-2 TAP.
4- THREAD ITEM ⑪ THREAD CORE IN PLACE.

STEP: 6

A- MACHINE SETUP FOR WINDING, SHOWN IN CHART BELOW.

CAM.	GEARS	
	FRONT	REAR
.250	DR=88	DR=81
	DN=44	DN=83

B- CHECK COIL AS PER CHART BELOW.

TURNS	FREQ.	-L-	-Q-	-R-
170	790 KC	.158mh ± 3%	30 ± 10%	6.0-6.2

REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD
#	Q	ORIGINAL RELEASE FOR PRODUCTION	7-27-64	Q	GDL	

PRIMARY TURNS	INDUCTANCE	"Q"	D.C. RESISTANCE	FREQUENCY
170	.158mh ± 3%	30	6.0-6.2	790 KC

A 3359

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
1	11	CI 121-2	CORE, THREADED, FERRITE	
X	10	BS 100	SOLDER, SOFT	
2	9	CF 130-1	FORM, COIL	
2	8	WA 109-51	WASHER, FIBER	
X	7	GL-130	CEMENT, "Q" DOPE	
X	6	GL-103	DUCO CEMENT	
X	5	WI 141-36-9	WIRE, MAGNET, ELECTRICAL	
1	4	CF 132-1.00-M-0832	FORM, COIL	
2	3	TE-201	TERMINAL, LUG	
X	2	GL 129	CEMENT,	
2	1	CI 134-Q1-B	CORE, CUP	

M. GELLMAN LIST OF MATERIAL			
MATERIAL		THE TECHNICAL MATERIEL CORP.	
FINISH		MAMARONECK, NEW YORK	
		CL-328 ASSEMBLY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN	DATE
		J. LESHINSKI	10/2/63
		CHECKED	DATE
			7-27-64
		ELECT. DES.	DATE
		MECH. DES.	DATE

NOTES

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DECIMALS	FRACTIONS	TOLERANCES	ANGLES
X ± .05	± 1/64		± 0° 30'
XX ± .01			
XXX ± .005			

A-3359