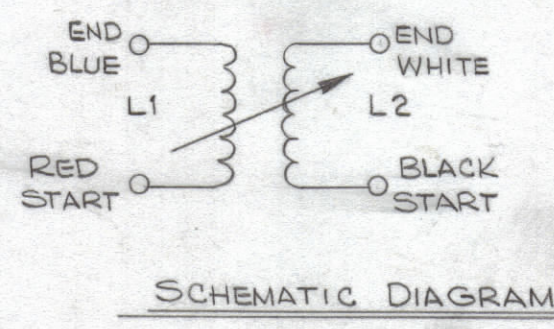
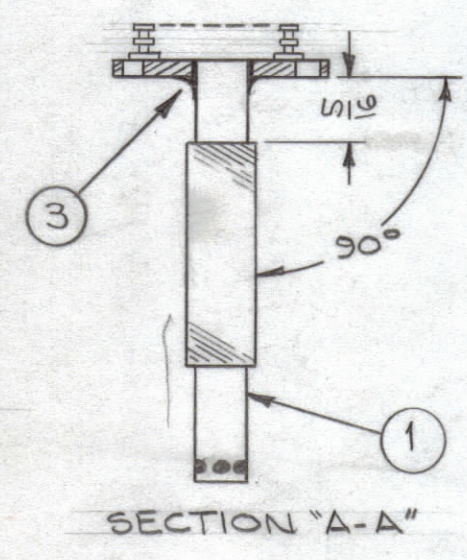
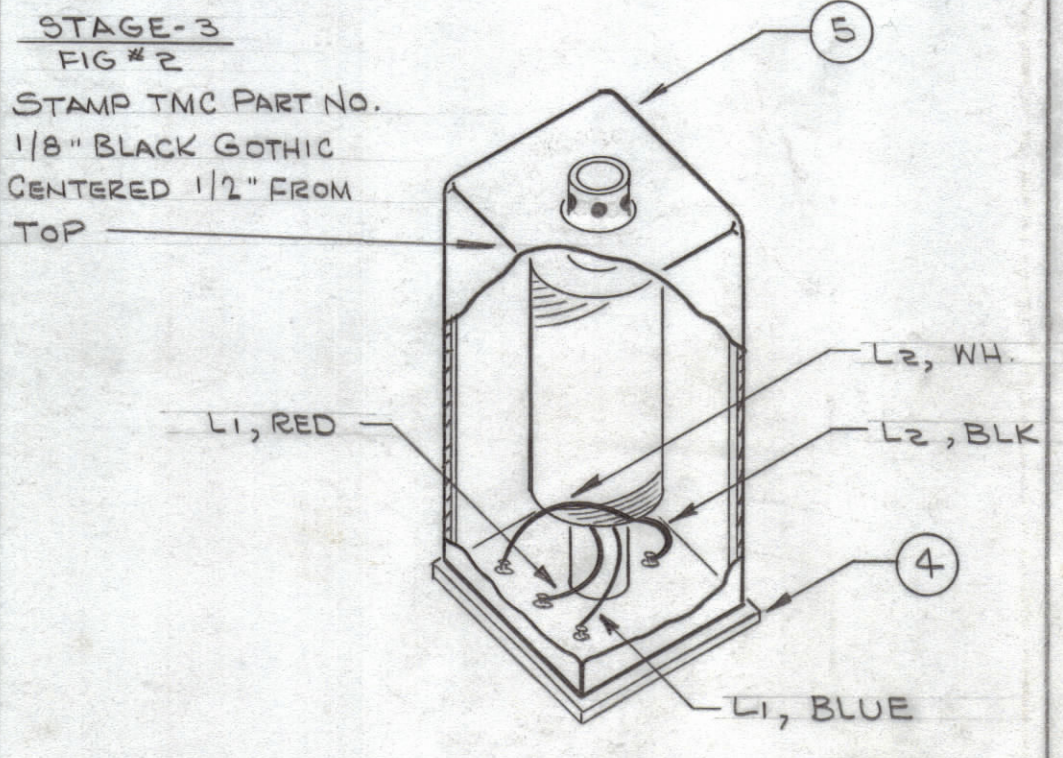
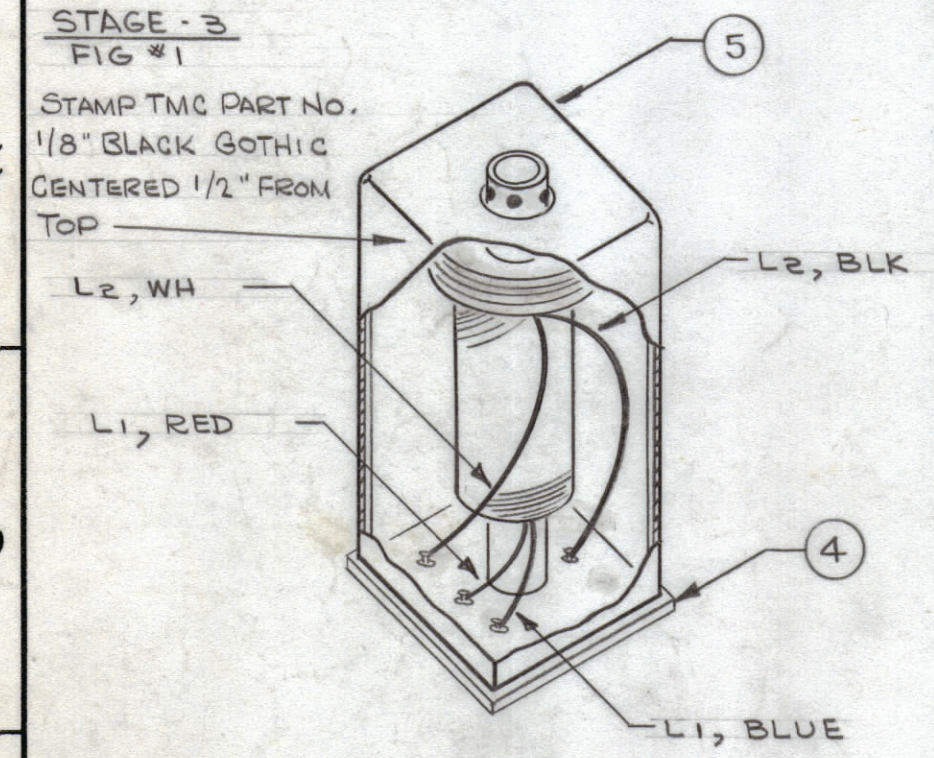
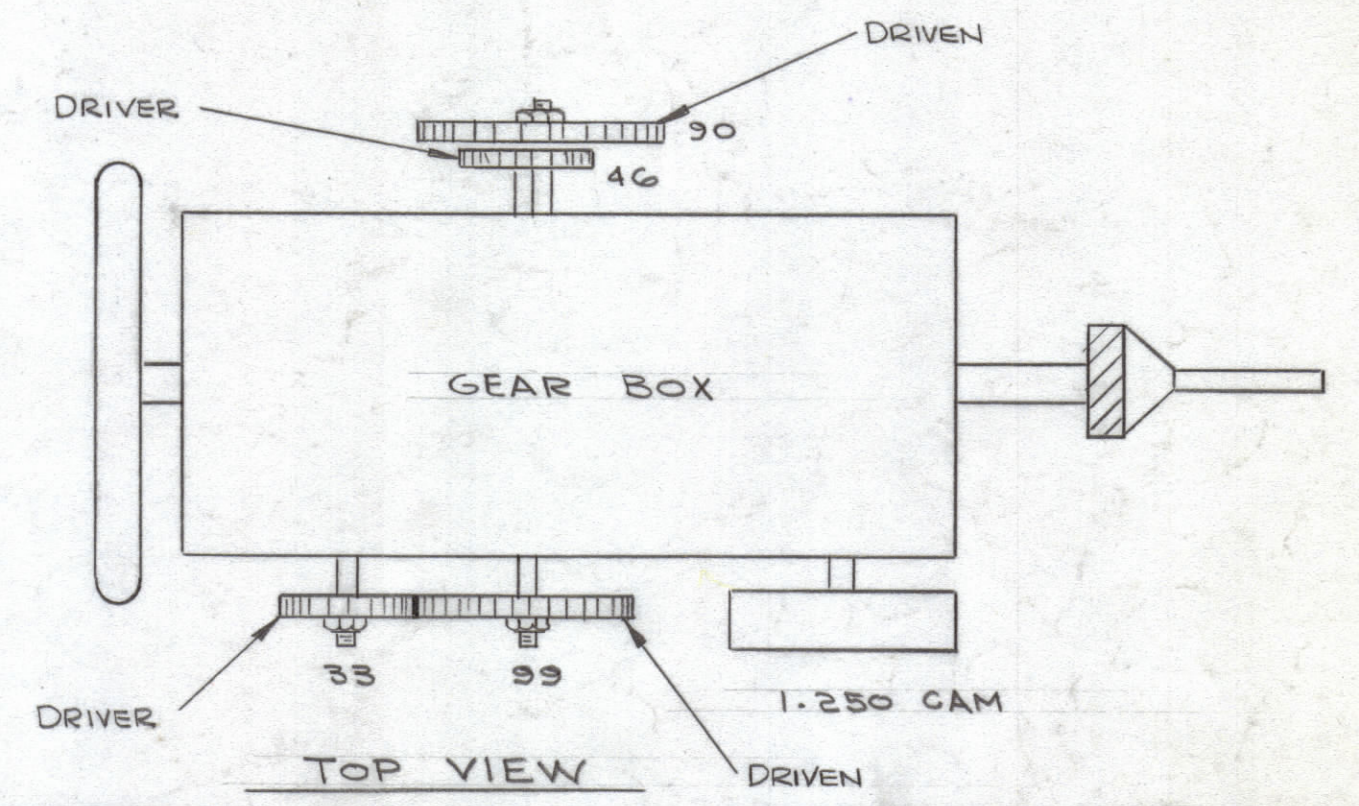
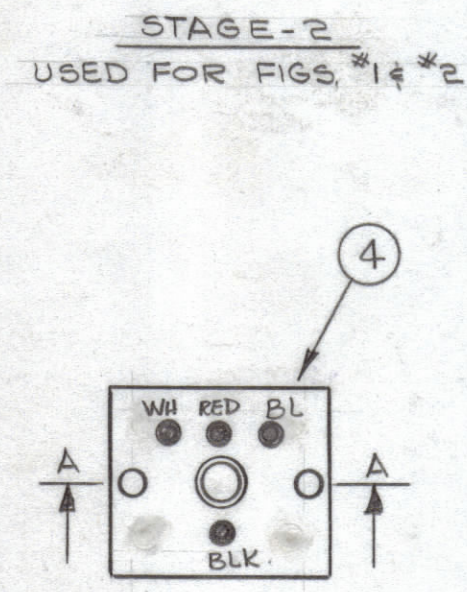
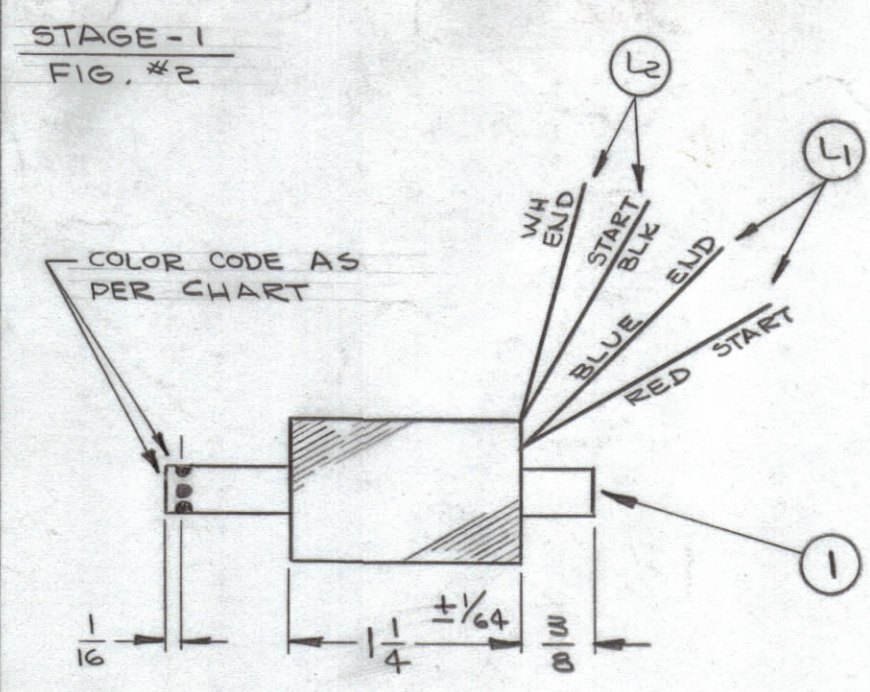
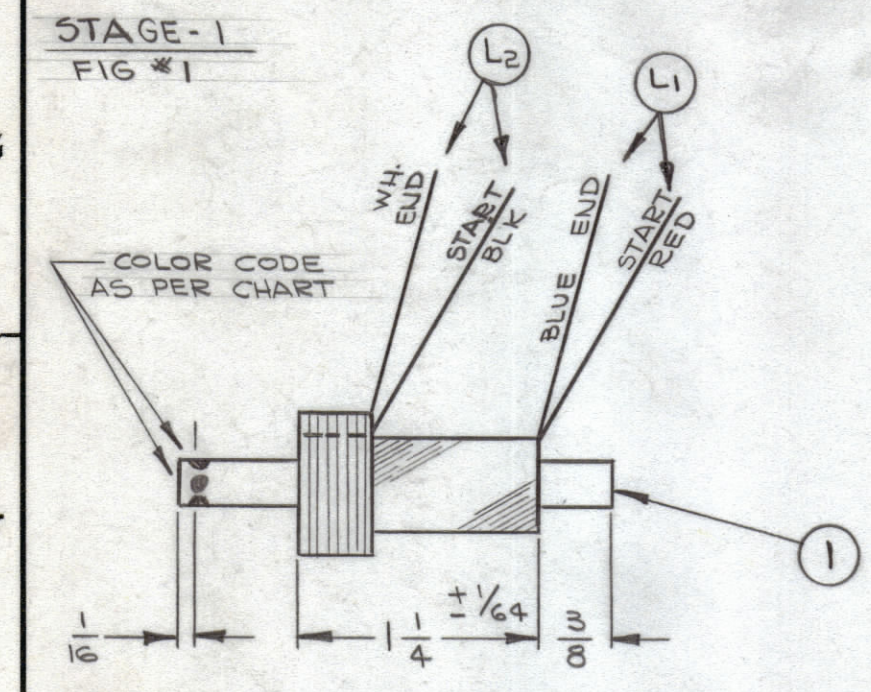


TMC MFG. ASSY. NO.	TMC PART NO.	NUMBER OF TURNS (APPROX)		TEST FREQUENCY L1 ± 2%				TEST FREQUENCY L2 ± 10%				COLOR CODE	BAND	FIGURE	R.F.	REQ.
		L1	L2	F	L	Q	R	F	L	Q	R					
		COIL FORM														
A3731-1	TT207	860	210	10KC	1.550 mh	-	3.10 ±15%	10KC	215mh	+	7.50 ±15%	BLK-RED-RED	1 & 2	2	2 ND	1
A3731-2	TT208	473	100	10KC	377uh	-	1.10 ±15%	10KC	29.5uh	-	2.80 ±15%	ORN	3	2		
A3731-3	TT209	260	50	10KC	101uh	-	5.0 ±15%	10KC	59uh	-	1.10 ±15%	YEL	4	2		
A3731-4	TT210	136	18	10KC	26.2uh	-	2.40 ±15%	10KC	2.4uh	-	4.0 ±15%	BLK-RED-GRN	5	1	2 ND	1

REVISIONS							
ZONE	SYM	DESCRIPTION	DATE	E.M. NO.	DRAFT	CHKD	APPD
#	X1	REDRAWN & REDESIGNED	11-9-64	X1			
#	X2	CHART & PICTORIAL UPDATED	2-23-65	X2			
#	X3	CHART & PICTORIAL UPDATED; ADD. PROCEDURE	3-29-65	X3	HLA		
		ORIGINAL RELEASE FOR PRODUCTION	4-20-65				



- PROCEDURE**
1. Assemble Item 1 to Item 4 using Item 3. BAKE AT 250°F. FOR 1 HOUR.
 2. WIND L1, STARTING 3/8" FROM END OF COIL FORM.
 3. WHEN L1 WINDING IS COMPLETED PULL OUT A LOOP OF WIRE.
 4. START L2 WHERE L1 ENDS, AND IN SAME DIRECTION.
 5. STAKE LEADS TO COIL FORM WITH ITEM 7.
 6. ALL WINDINGS ARE WOUND WITH THE GEAR RATIO SHOWN EXCEPT L2 OF A3731-4.
 7. L2 OF A3731-4 IS CLOSE WOUND BY HAND ON TOP OF L1 AS SHOWN IN FIG. 1 AND IN SAME DIRECTION AS L1.
 8. CUT ALL LEADS TO WITHIN 1" OF BASE OF COIL FORM. STRIP AND TIN TO BASE OF COIL FORM.
 9. COLOR CODE LEADS, TERMINAL BOARD AND COIL FORM AS SHOWN.
 10. TEST INDUCTANCE PER CHART ABOVE PRIOR TO CONNECTING LEADS TO TERMINAL BOARD. USE MARCONI MOD. TF1313 UNIVERSAL BRIDGE (1/4%)
 11. SOLDER LEADS TO RESPECTIVE TERMINALS AND ASSEMBLE AS SHOWN.

- NOTE**
1. USE 265 TO 270 GRAMS TENSION ON WIRE GUIDE. CHECK FREQUENTLY.
 2. TEST IN ACCORDANCE WITH S947.

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	7	GL103	ADHESIVE, N-CEL	
X	6	BS100	SOLDER, TIN ALLOY	
1	5	A3930	CAN	
1	4	A3933-2	TERMINAL BOARD ASSY	
X	3	GL125	EPOXY ADHESIVE, SEALANT	
X	2	WI104-7-41-SNGS	WIRE, ELEC., LITE.	
1	1	CF137-2.218	COIL FORM	

LIST OF MATERIAL			
MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
FINISH	TITLE		
	TRANSFORMER ASSY, 2 ND R.F.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN	DATE	FINAL APPROVAL
	G. Penner	11/10/64	
	Checked	DATE	
		3-29-65	
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	TOLERANCES	FRACTIONS ± 1/64 ANGLES ± 0° 30'	ELECT. DES.
			MECH. DES.
			DATE
			SHEET
			REV. LTR.

VLRB-1		
QTY./UNIT	MODEL USED ON	ASSY. NO.
SCALE	CODE	
NONE	A	
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NOTES

A3731