

STANDARD DRAWING

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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

CL-100 D

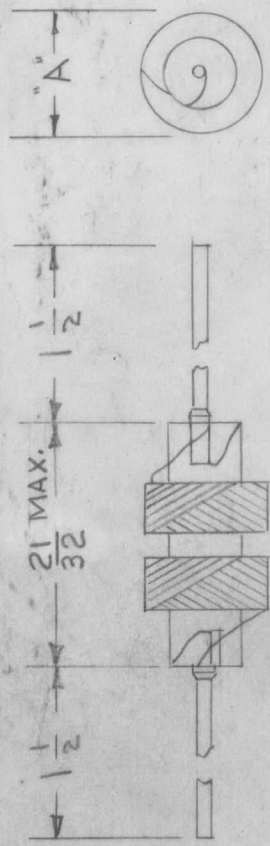
USED ON

MODEL PROJECT NO. ASSY. NO. DATE

TMC NO	MFG. PART NO.	TOTAL PI	INDUCTANCE	CURRENT		APPROX. RESIST. OHMS	DIMENSION	WIRE
				RATED MA.	MAX. MA.			
CL-100-1	R-33-1	SEE NOTE 1	1 ± 10%	850	1000	.06	.221	26 EN
CL-100-2	R-33-10	2	10 ± 10%	75	100	1.0	1/4	36 ESN
CL-100-3	R-33-50	2	50 ± 10%	75	100	A.0	5/16	36 ESN
CL-100-4	R-33-100	2	100 ± 10%	75	100	5.5	5/16	36 ESN
CL-100-5	R-33-750	2	750 ± 10%	75	100	16.0	.442	36 ESN
CL-100-6	TMC SPECIAL	2	10 ± 30%	525	650	1330 MAX.	3/8	28 DN

NOTES: 1. PT. 1 IS SINGLE LAYER COIL.
 2. MAX. CURRENT TO BE USED ONLY WHEN COIL IS IN FREE SPACE.
 3. PIGTAILS - #21 AWG TINNED COPPER WIRE.
 4. FORM - MOLDED BAKELITE
 5. FINISH - FUNGUS RESISTANT VARNISH.

DIMENSIONS FOR REF. ONLY.



PT. NOS. 3 & 4 SHOWN (DOUBLE SIZE)

ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
D	1	MFG. DWG. NO. DELETED. CHART & PICT. CLARIFIED. MFRS CODE ADDED	8-19-63	9785	AK.	JAY	QMB
C	1	NATIONAL PART # CLARIFIED	8-10-62	7021	SS	JAY	QMB
B	1	CL-100-5, IND. WAS TGS	5/28/56	2	JAY	JAY	AJJ
A	1	PH WAS M.H.	1/24/54	1	16	JAY	GT-9

TOLERANCES

DEC. DIM. ±
 FRAC. DIM. ±
 OTHERS ANGULAR DIM. ±

SCALE S-401-122
 DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.

REQ. ITEM	ITEM	PART NO.	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
			CHOKES, R.F.	
			STOCK SIZE	
			MATERIAL	
			WEIGHT PER PC.	
			TYPE & TEMPER	
			DRAWN	
			ELEC. DES. APP.	
			CHECKED	
			FINAL APPROVAL	

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

CL-101 C

USED ON

PROJECT NO.

ASSY. NO.

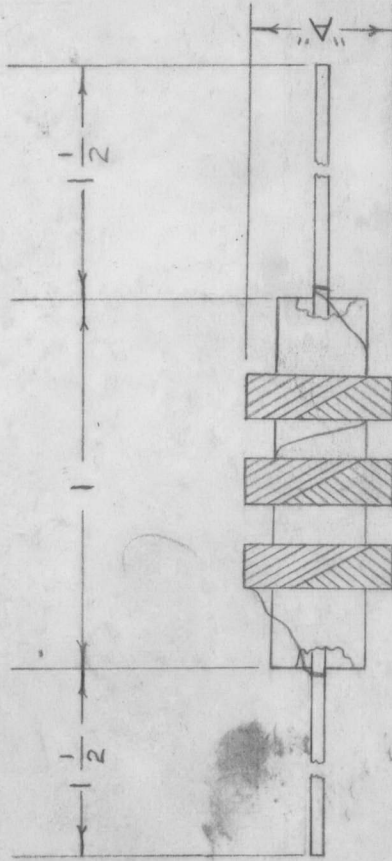
MODEL

DATE

T.M.C. NO.	NATIONAL PART NO.	TOTAL INDUCTANCE	CURRENT RATING FOR 20°C RISE	APPROX. RESIST. OHMS	SELF RES. FREQ. MC ±10%	WIRE A.W.G.	DIMENSION "A"
CL 101-1	R-50-0.5	3 mch. ±10%	150	15 ±	5.5	#36 ESN	13/32
CL 101-2	R-50-1	3	135	23 ±	4.1	#36 ESN	15/32
CL 101-3	R-50-2.5	4	125	40 ±	2.7	#36 ESN	1/2
CL 101-4	R-50-10	3	115	30 ±	1.3	#36 ESN	17/32

NOTES: 1. CL 101-4 HAS IRON CORE,
2. ALL OTHERS MOLDED BAKELITE CORE
3. PIGTAILS #20 TINNED COPPER WIRE.
4. FINISH-FUNGUS RESISTANT VARNISH.

DIMENSIONS FOR REFERENCE ONLY.



S401-358 PT.# R50

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
—	—	THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
—	—	CHOKES, R.F.	
—	—	STOCK SIZE	
—	—	WEIGHT PER PC.	
—	—	MATERIAL	
—	—	TYPE & TEMPER	
—	—	HEAT TREAT. SPEC.	
—	—	FINISH & SPEC. NO.	

ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS CHECKER	ENG. APP.
C	UPDATED FOR CLARIFICATION	3-8-66	15915	H.A.	
B	NATIONAL PART # CLARIFIED	8-10-62	7021	G.S.	
A	NATIONAL PART # CLARIFIED	4-1-57	1	G.C.	

TOLERANCES

DEC. DIM. ±
FRAC. DIM. ±
ANGULAR DIM. ±

DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.

SCALE

FINAL APPROVAL

CL-101 C

CL-10A

STANDARD DRAWING

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

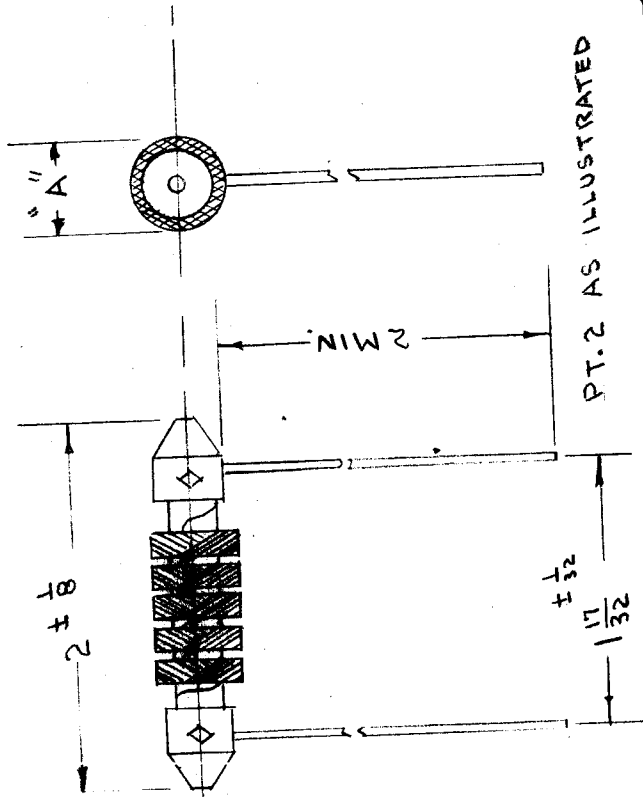
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

USED ON
PROJECT NO. _____
MODEL _____
ASSY. NO. _____

TMC NO.	NATIONAL PART NO.	TOTAL INDUCT. MH.	CURRENT		APPROX. RESIST. OHMS	DIMENSION "A"	WIRE AWG	MFG. DWG NO.
			RATED MA.	MAX. MA.				
CL-10A-1	R-100-2.5	4	100	125	44 ± 15%	1/2 ± 1/16	36 ESN SA 44-B	SA 2608
CL-10A-2	R-100-5	5	50	75	90 ± 15%	15/32 ± 1/32	38 ESN SA 2608	SA 2606
CL-10A-3	R-100-10	5	50	75	130 ± 15%	9/16 ± 1/32	38 ESN SA 2606	

NOTE:
1. PIGTAILS #21AWG TINNED COPPER WIRE.
2. FORM - CERAMIC
3. FINISH - FUNGUS RESISTANT VARNISH
4. MOLDED LEAD ENDS.

DIMENSIONS FOR REF. ONLY.



REF.: NATIONAL CO. INC. TYPE R-100

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
		CHOKES, R.F.	
		STOCK SIZE	
		MATERIAL	
		TYPE & TEMPER	
		HEAT TREAT. SPEC.	
		FINISH & SPEC. NO.	
		WEIGHT PER PC.	
		DRAWN	
		CHECKED	
		ELEC. DES. APP.	
		MECH. DES. APP.	
		FINAL APPROVAL	

3	CL-10A-3 OHMS WAS 150 ± 15%	DATE	CN. NO.	DRAFTS CHECKER	ENG. APP.
2	CL-10A-2 OHMS WAS 100 ± 15%	8-14-42	7022	G.S.	J.R. 16
1	NATIONAL PART NO. CLARIFIED				
ISSUE ITEM		CHANGED FROM		SCALE FULL	
TOLERANCES					
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.					
ALL OTHERS	DEC. DIM. ±	FRAC. DIM. ±	ANGULAR DIM. ±		

CL-10A

CL-105-5

STANDARD DRAWING

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USED ON PROJECT NO. MODEL ASSY. NO.

T.M.C. NO.	MANUFACTURE PART NO.	INDUCTANCE ±10%	SELF RES FREQ. MC ±10%	APPROX DC RES OHMS	CURRENT RATING FOR 20°C MA	"D" MAX.	"L" MAX.	WIRE MFR. A.W.G.	MFR. CODE	COLOR CODE
CL-105-1	R-60-2	2.0 UH	160.	.06	1500	5/16	1 1/8	*26ESN	A	RED
CL-105-2	R-60-4	4.0 UH	110.0	.15	700	5/16	1 1/8	*26ESN	A	BLUE
CL-105-3	R-60-2.8	2.8 UH	40	.11	1500	5/16	7/8		B	GRN
CL-105-4	4622	10.0 KHY	33	.17	1000	5/16	7/8		B	WHT
CL-105-5	4624	15.0 MHY								

NOTE: 1. PIGTAILS #20 A.W.G. TINNED

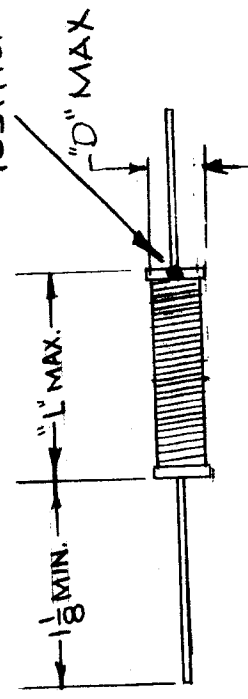
2. COPPER WIRE.

3. FORM-MOLDED MICA FILLED PHENOL-FORMALDEHYDE BELOW 10MH. IRON CORE FORM FOR 10MH AND ABOVE.

3. FINISH - FUNGUS RESISTANT VARNISH.

COLOR CODE (SEE CHART)

POSITION OPTIONAL



STANDARD DRAWING

REQ. ITEM	PART NO.	DESCRIPTION
	ff	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK
STOCK SIZE	ff	CHOKE, RF
MATERIAL	ff	
WEIGHT PER PC.	ff	
TYPE & TEMPER	ff	
HEAT TREAT. SPEC.	ff	
FINISH & SPEC. NO.	ff	

ISSUE ITEM	DATE	CHANGED FROM	SCALE	DRAGS CHECKER	ENG. APP.
5	5/14/67	18456	A=5401-358D	EFM	5401-7
TOLERANCES					
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.					
DEC. DIM. ±					
FRAC. DIM. ± 1/64					
OTHERS AN ULAR DIM. ±					

DRAWN: *[Signature]*
ELEC. DES. APP. *[Signature]*
MECH. DES. *[Signature]*
CHECKED: *[Signature]*
DATE: 10/10/57

CL-105

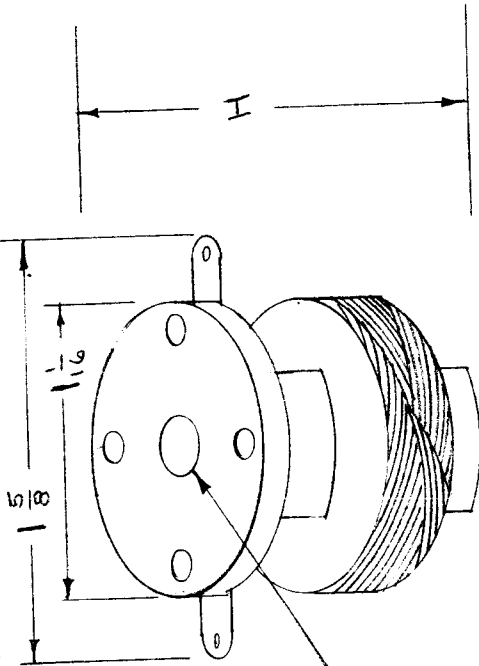
G

STANDARD DRAWING

CL-109

USED ON

MODEL	PROJECT NO.	ASSY. NO.	DATE



DIMENSIONS FOR REF. ONLY.
REF: BUD RADIO INC.

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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TMC NO.	CAT. NO.	IND. M.H.	D.C. RES. Ω	CURRENT MA	H
CL-109-1	CH-1212	2.5	28	125	1 1/16
CL-109-2	CH-1213	3.4	36	125	1 1/16
CL-109-3	CH-1214	5.5	46	125	1 1/16
CL-109-4	CH-1215	8.	60	125	1 1/16
CL-109-5	CH-1216	10.	65	125	1 1/16
CL-109-6	CH-1217	16.	84	125	1 1/16
CL-109-7	CH-1218	30.	190	100	15/16
CL-109-8	CH-1219	60.	279	90	15/16
CL-109-9	CH-1220	80.	332	80	15/16

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		CHOKES, RF	
		LATTICE WOUND	
		CDD. 1/13/53	MECH. DES. APP. <i>PPR</i>
		DRAWN	ELEC. DES. APP. <i>PPR</i>
		CHECKED <i>MAD</i>	FINAL APPROVAL <i>PPR</i>
		1/15/53	CL-109

ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES						
SCALE						
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.						
ALL OTHERS	DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±					

CL-110 A

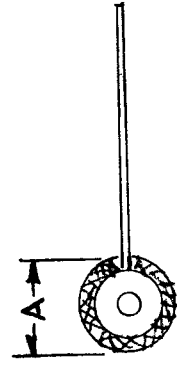
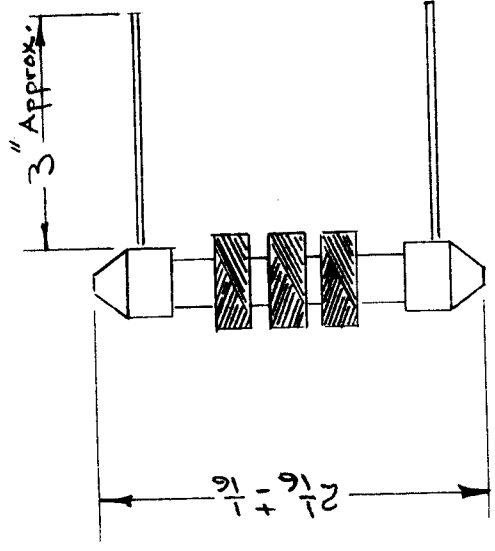
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TMC NO.	CAT. NO.	INDUCTANCE MH	CURRENT		APPROX. RES. OHMS
			RATED MA.	MAX. MA.	
CL-110-1	R-300-0.5	0.5 ± 10%	250	300	7 ± 10%
CL-110-2	R-300-1	1.0 ± 20%	250	300	11 ± 15%
CL-110-3	R-300-2.5	2.5 ± 10%	250	300	17 ± 10%
CL-110-4	R-300-5	5 ± 10%	250	300	24 ± 10%

USED ON
 MODEL PROJECT NO. ASSY. NO. DATE



- NOTE:**
1. PIGTAILS # 19 A.W.G. TINNED COPPER WIRE.
 2. FORM-CERAMIC.
 3. FINISH-FUNGUS RESISTANT VARNISH.

Ref: National Co., Inc. B-300

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		CHOKE, R.F.	
		STOCK SIZE	
		MATERIAL	
		WEIGHT PER PC.	
		TYPE & TEMPER	
		HEAT TREAT. SPEC.	
		FINISH & SPEC. NO.	

MECH. DES. APP. _____
 ELEC. DES. APP. _____
 DRAWN: J.A.G.
 CHECKED: J.A.G. 5/28/53
 FINAL APPROVAL: _____

ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS CHECKER	ENG. APP.
A	CATALOG CHART CLARIFIED	8-14-62	7022	G.S.	J.A.G.
	CHART CLARIFIED				
TOLERANCES					
DEC. DIM. ±					
FRAC. DIM. ±					
OTHERS ANGULAR DIM. ±					
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.					

CL-110

A

CL-112

USED ON

PROJECT NO.

ASSY. NO.

DATE

10/26/53

MODEL

RAPC

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

Ref: TR McSoley Sm L-2 (RAPC)

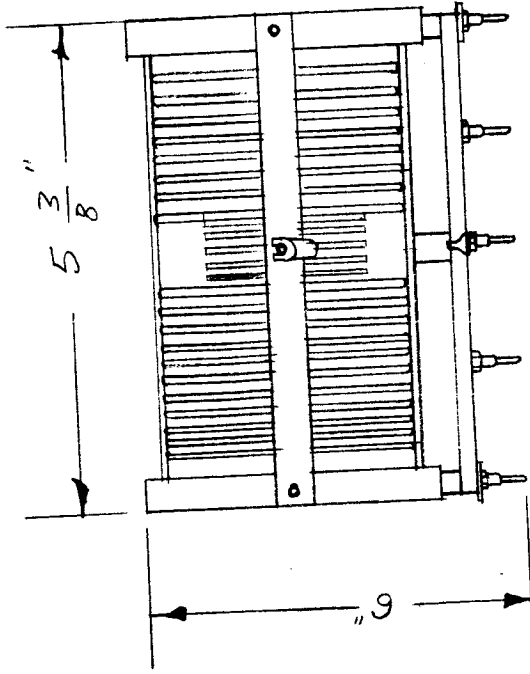
REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		COIL, PEN RECORDERS	
	STOCK SIZE		
	MATERIAL	WEIGHT PER PC.	
	TYPE & TEMPER	DRAWN	ELEC. DES. APP. MECH. DES. APP.
	HEAT TREAT. SPEC.	CHECKED	FINAL APPROVAL
	FINISH & SPEC. NO.		CL-112

ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS CHECKER	ENG. APP.
SCALE					
TOLERANCES					
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.					
ALL DEC. DIM. ±					
OTHERS FRAC. DIM. ±					

CL-113

USED ON

MODEL	PROJECT NO.	ASSY. NO.	DATE
BC-610G			11/16/53



DIM. FOR REF. ONLY.

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TMC NO.	SIG. C. NO.	MALICRAFTER NO.	FREQ. RANGE
CL-113-1	C-387-D	51C706	2.0-3.5
CL-113-2	C-388-C	51C707	3.5-4.5
CL-113-3	C-389-C	51C708	4.5-5.7
CL-113-4	C-390-C	51C709	5.7-8.0
CL-113-5	C-447-B	51C710	8.0-11.0
CL-113-6	C-448-B	51C711	11.0-14.0
CL-113-7	C-449-B	51C712	14.0-18.0

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
STOCK SIZE		COIL UNIT, SWINGING LINK	
MATERIAL			
TYPE & TEMPER			
HEAT TREAT. SPEC.			
FINISH & SPEC. NO.			

16 11-16-53	ARB	MECH. DES. APP.
DRAWN	ARB	ELEC. DES. APP.
CHECKED	ARB	FINAL APPROVAL
		CL-113

ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS CHECKER	ENG. APP.
SCALE					
TOLERANCES					
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.					
ALL DEC. DIM. ±					
OTHERS FRAC. DIM. ±					
ANGULAR DIM. ±					

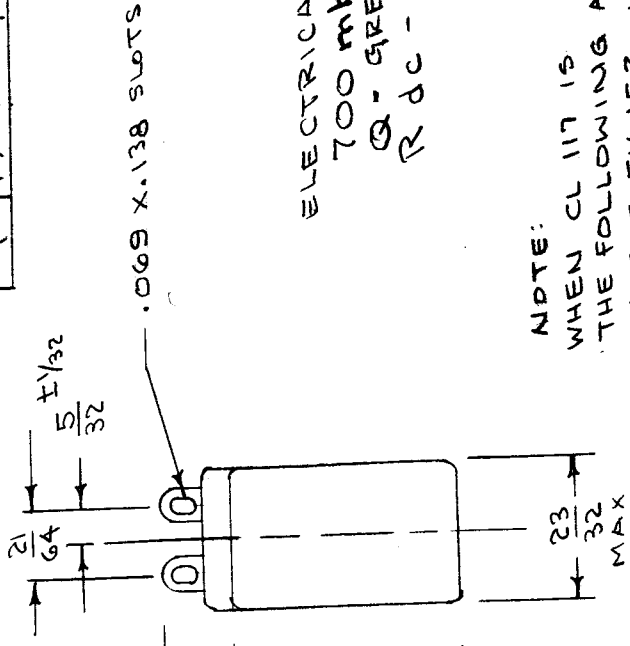
CL 117 F

USED ON			
REQ. PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.
1	GPR	297	
1	FX-152		

DATE
5-18-55
3-14-57

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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ELECTRICAL SPECS.
700 MH ± 5%
Q - GREATER THAN 40 AT 1,000 CPS
R DC - 69Ω ± 20

NOTE:
WHEN CL 117 IS NOT PURCHASED,
THE FOLLOWING APPLIES:
1. FOR FX 152, USE A 1530
2. FOR GPR, USE A 1482

ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
F	CLERICAL CHANGE	4/15/55	4	28	WCB	
E	COMMUNICATION ACC. DELETED	10-2-61	5660	LL	WCB	W
D	CODE ADDED 5401-102	11-8-60	3431	MA		
C	RDC WAS 85-95Ω	1/19/58	3	W	WCB	W
B	NOTE CHANGED TO INCLUDE NEW A-1530 PRE-FX-152	1/4/57	2	WCB	WCB	W
A	RDC WAS 60-70Ω	6/17/55	1	WCB	WCB	W

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
		COIL, 1200Ω PEAKING	
		STOCK SIZE	
		MATERIAL	
		WEIGHT PER PC.	
		TYPE & TEMPER	
		HEAT TREAT. SPEC.	
		FINISH & SPEC. NO.	

SCALE 540-102(76-0079-87)

TOLERANCES

DEC. DIM. ±
FRAC. DIM. ±
OTHERS ANGULAR DIM. ±

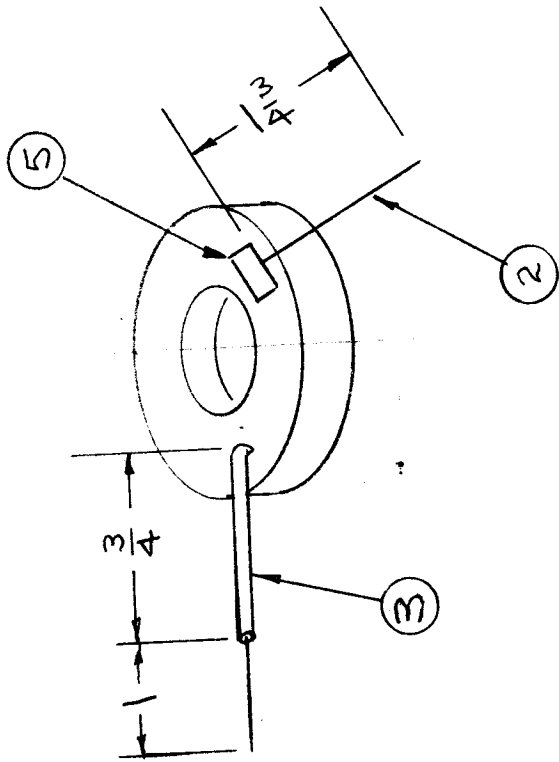
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.

DRAWN: WCB
CHECKED: WCB
ELEC. DES. APP. WCB
MECH. DES. APP. WCB

G.T.O. FINAL APPROVAL

CL 117 F

REQ. PER UNIT	1 EACH	MODEL	FX-151	USED ON ASSY. NO.	A-1375	DATE	2/29/57	CL-126
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TMC NO.	INDUCTANCE mh.	Q GREATER THAN	ITEM 2 WIRE	APPROX. CORE TURNS	APPROX. LOAD TURNS
CL-126-1	14.2-14.4	15	WI-123-30	670	30
CL-126-2	41.5-41.7	15	WI-123-32	1140	50
CL-126-3	14.7-14.9	15	WI-123-30	680	30
CL-126-4	28.3-28.5	15	WI-123-32	940	42
CL-126-5	28.0-28.3	15	WI-123-30	920	40
CL-126-6	28.0-28.5	15	WI-123-37	2600	110

WINDING PROCEDURE

NOTE: Coils to be wound in accordance with TMC Spec. S-337

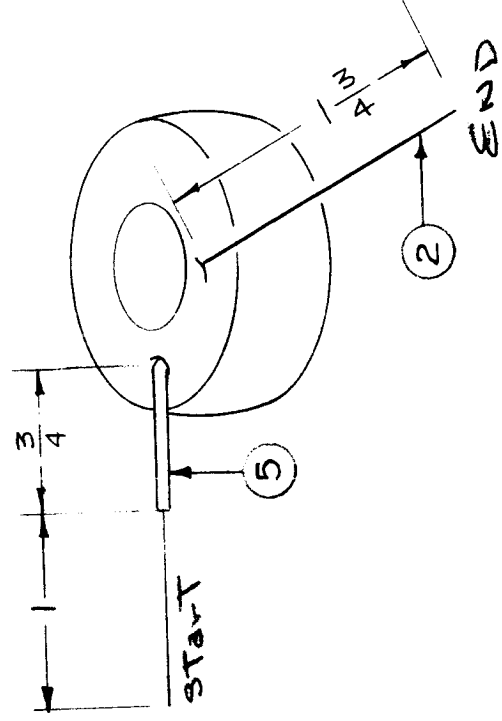
1. Wind all coils as per chart above.
2. Measure inductance, using inductance bridge (General Radio Model 650-A). Remove necessary turns until the inductance complies with above chart.
3. Bake for 1/2 hour at 215° F.
4. Submerge Hot Coil in GL-110.
5. Tape end of coil as shown.

X 6	PK-104-1-022	Insulation Sleevling	BLK
X 5	TA-102-2	Tape, Paper	
X 4	GL-110	Impregnating Wax	
X 3	LWC 2.8(7)UD	WIRE-HOOKUP #28	BLK
X 2	See Chart	Wire, Magnet	
1 1	CI-103-34	Core, Molybdenum Permalloy Powder	

THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	REACTOR, TOROIDAL	FX-151	FINAL APPROVAL
DESCRIPTION	DRAWN	CHECKED	
PART NO.	MATERIAL	HEAT TREAT. SPEC.	FINISH & SPEC. NO.
STOCK SIZE	TYPE & TEMPER	ELEC. DES. APP.	MECH. DES. APP.
ISSUE	ITEM	CHANGED FROM	DATE
DATE	CH. NO.	DRAFTS	CHECKER
SCALE:	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES		

2 Coil Winding Note Added 7/26/57
 1 ITEM 6 ADDED 5/18/57
 2 Winding Data on 5-6 CL-126
 1 ITEM 3 WAS PX-104-2-022
 CL-126-6 WAS 230-245 mH
 CL-126-6 WAS 230-275
 ASSY No. Added 3/14/57

REQ. UNIT	USED ON
1 Each	MODEL
	FX-153
	ASSY. NO.
	A-1407
	DATE
	3-27-57



TMC NO.	INDUCTANCE mh.	Q GREATER THAN	ITEM 2 WIRE	APPROX. LOAD TURNS
CL-128-1	18.4	15	WI-123-31	47
CL-128-2	13.3	15	WI-123-30	30
CL-128-3	16.9	15	WI-123-30	35
CL-128-4	13.3	15	WI-123-30	30
CL-128-5	14.0	15	WI-123-30	31
CL-128-6	13.3	15	WI-123-30	30
CL-128-7	14.0	15	WI-123-30	31
CL-128-8	18.4	15	WI-123-31	33

WINDING PROCEDURE

1. Wind all coils to inductance required, in accordance with TMC Specification S-337
2. Winding machine changes:
 - a. Remove top rubber tired wheel and replace with solid brass wheel.
 - b. Back off turns counter contact finger.
 - c. Connect ground end of impedance bridge to base of winding machine.
 - d. Connect hot end of impedance bridge to start lead on t roid.
3. Wind toroid in a back and forth motion checking induct. as it is being wound.
4. Bake for 1/2 hour at 215° F.
5. Submerge hot coil in GL-110.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 5	LWC28(7)UO	Wire Hook-up #28	HLK.
X 4	GL-110	Impregnating Wax	
X 3	PX-104-1-022	Insulation, Sleeving, Black	
X 2	See chart	Wire, Magnet	
1 1	CI-103-34	Core, Molybdenum Permalloy Powder	
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK REACTOR, TOROIDAL (FX-153)			
TYPE & TEMPER HEAT TREAT. SPEC. DRAWN MATERIAL STOCK SIZE FINISH & SPEC. NO.			
63-27-57 A. J. J. CHECKED FINAL APPROVAL CL-128 A			

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A 2	Note 1. Extended	7-26-57	1	sc.	W.P.	A.J.J.
1	Item 5 Added					

SCALE: 1/4"

TOLERANCES

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.

REMOVE ALL BURRS AND SHARP EDGES

DEC. DIM. ±

FRAC. DIM. ±

ANGULAR DIM. ±

CL-130 A

USED ON
 REQ. PER UNIT: 1
 MODEL: MSR-3
 SYMBOL NO.: L3
 DATE: 4-10-58

COIL MACHINE DATA

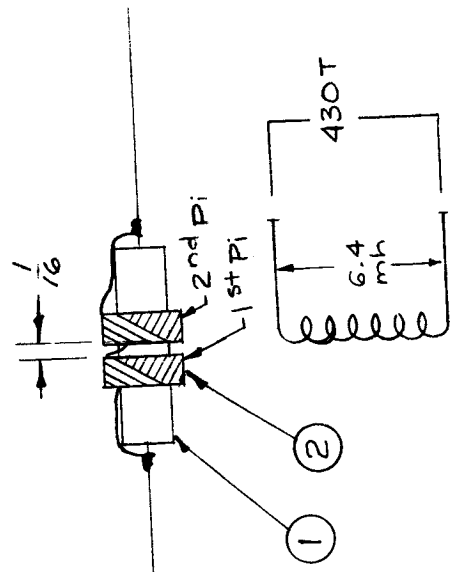
Driver Gear - 100
 Cam Gear - 104
 Cam - .156

WINDING DATA

1. Start 1st Pi 5/16" from end of core.
2. Wind on 215 turns. To form 1st Pi.
3. End 2nd Pi at approx. 430 Turns.
4. Add or Subtract Turns to meet inductance
5. Stake ends with GL-103 (item 4).
6. Strip coil leads and wrap and solder to core leads.
7. Bake for 1/2 hour. at 215 degrees F.
8. Saturate coil with GL-104-2 and air dry. for 10 min.
9. Bake for 2 hours at 215 degrees F.
10. Test as below.

TEST DATA: Use Boonton "Q" Meter or equivalent

Inductance - 6.4 (6.1 - 6.7) millihenries.
 Q _____ 50 or greater.
 Freq. _____ 250 KC



X	5	BS-100	Solder, Soft
X	4	GL-103	Cement, Duco
X	3	GL-104-2	Insullex, U85
X	2	WI-120-15	Wire, Magnet, No. 34 DSC
1	1	CI-111-1	Core, Fixed, Ferrite

REG. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
COIL, RF, 6.4 MH			
STOCK SIZE		DRAWN: 6/4/10/58	
MATERIAL		CHECKED: [Signature]	
TYPE & TEMPER		HEAT TREAT. SPEC.	
FINISH & SPEC. NO.		ELEC. DES. APP. MECH. DES. APP.	
CL-130		FINAL APPROVAL: [Signature]	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A		WIND. DATA 334 UPDATED Q WAS 50	11/20/67	18615	Leaf	[Signature]	OP

SCALE:

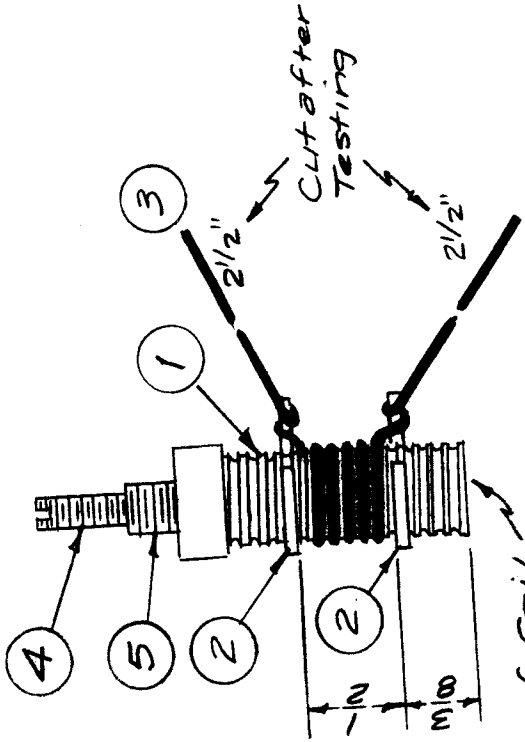
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

DEC. DIM. ±
 FRAC. DIM. ±
 ANGULAR DIM. ±

CL-136 A

REQ. PER UNIT	USED ON	DATE
1	RFA-1	5/22/58
MODEL	ASBY. NO.	
L208		

- PROCEDURE**
- Secure Terminals (item 2) and bushing (item 5) to coil form (item 1) with insulex (item 7). Do not allow insulex to form on terminal tips.
 - Bake for 2 hours at 250° F.
 - Wind 5 turns of wire (item 3) on coil form starting from bottom in a CCW direction.
 - Twist and solder wire ends to terminals as shown, leaving 2 1/2" of wire extending from terminals for testing purposes. (Cut these leads after testing, flush with term.)
 - Coat Winding with Insulex (item 7).
 - Bake unit for 2 hours at 250° F.
 - Test unit as per below. (Use Bonton "Q" Meter Model 160A or equivalent).
 - Cut 1 ads indicated after testing.

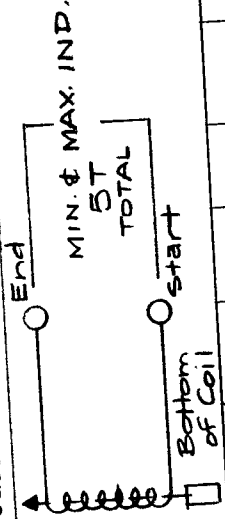


Bottom of Coil

TEST DATA (With Core)

INDUCTANCE - MINIMUM must be less than .36 uhy.
 MAXIMUM must be more than .48 uhy.

Minimum & Maximum "L" accomplished by adjusting core.
 Test Frequency - 25 Mc.
 Q at 25 Mc - Greater than 130.



ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A 1	ITEM 4 WAS CI-109-B	5/24/58	1	6	WJP	AKL

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. ±
 ANGULAR DIM. ±

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 7	BS-100	SOLDER, SOFT	
X 6	GL-104-2	INSULEX, U-85	
1 5	SM-142	BUSHING, COIL FORM	
1 4	CI-109-19	CORE, TUNING	
X 3	WL-100-4	WIRE, BUSS #16	
2 2	TE-153-3	TERMINAL, RING TYPE	
1 1	CF-124-1-43	COIL FORM, THREADED	

THE TECHNICAL MATERIEL CORP.
 MAMARONECK, NEW YORK

COIL, RF, TUNED, 16-32 Mc.

L208

A. J. J. J.

FINAL APPROVAL

16 9/22/58

CHECKED

DRAWN

CL-136 A

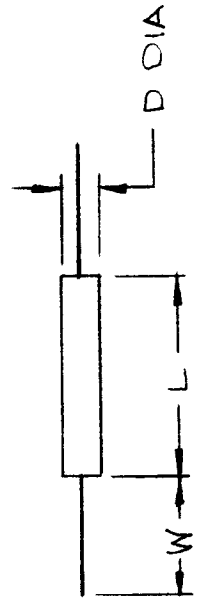
ELEC. DES. APP. MECH. DES. APP.

STANDARD DRAWING

TMC PT/No	MFGR No	INDUCTANCE IN OHMS ± 10%	MIN Q AT FREQ	F ₀ (MHZ) MIN	CD MAX UUF	RATED MA	RDC MAX	CORE MAT'L	WIRE SIZE (MIN)	DIMENSIONS	
										D	L
CL140-1	SA-2500-I	2500 AT 250KHZ	80 AT 250KHZ	1.8	3.3	110	290 OHMS	IRON	22AWG	.390	.640 .360
CL140-2	SB-150-I	150	70	9	2.000	400	3.7				
CL140-3	SB-270-I	270	70	6.5	2.2	300	5.2				
CL140-4	SA-1000-I	1000	70	3.1	2.6	185	14.2				
CL140-5	SB-560-I	560	70	4.5	2.6	220	9.8				
CL140-6	SB-220-I	220	70	7	2.2	350	4.6				
CL140-7	SB-470-I	470	65	4.6	2.6	230	7.1				
CL140-8	SA-820-I	820	75	3.3	2.6	195	12.5				
CL140-9	SA-680-I	680 AT 790KHZ	75 AT 790KHZ	3.5	2.6	210	11.2 OHMS	(IRON)	22AWG	.390	.640 .360

USED ON	DATE
MODEL	ASSY. NO.
REQ. PER UNIT	

CL140 L



SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
L	REDEAWN & REVISED	11/28/66	17326	WVW	QFB	QF
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES						
DECIMALS	TOLERANCES	SCALE				
.X ±	FRACTIONS ± 1/64	CODE				
.XX ±	ANGLES ± 0° 30'	S401-122				
.XXX ±						

THE TECHNICAL MATERIAL CORP.
MANHATTAN, NEW YORK

COIL, R.F.
MOLDED

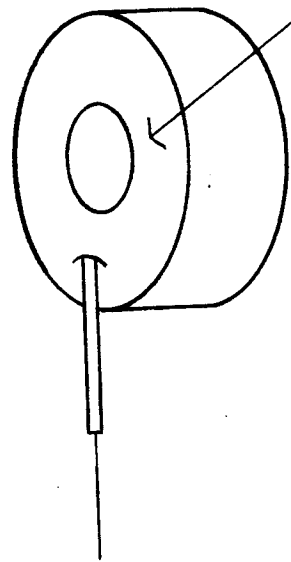
TRIAL UNIT	MODEL	ASSY. N.	DATE
1	A-1591		11-11-58
			CL-141

WINDING MACHINE DATA
(Boesch Winding Machine)

1. Approximate Load Length - 65 Feet

WINDING PROCEDURE

1. Wind coil to 33.2 millihenries, in accordance with TMC Specification S-337.
2. After proper inductance has been reached and checked, (use Inductance Bridge - General Radio Model 650-A), bake coil for 1/2 hour at 215°F.
3. Submerge hot coil in GL-110 (item 3).
4. Resonate coil in accordance with TMC Specification S-400.



INDUCTANCE - 33.2 MILLIHENRIES
Q MUST BE 15 OR GREATER AT 1KC

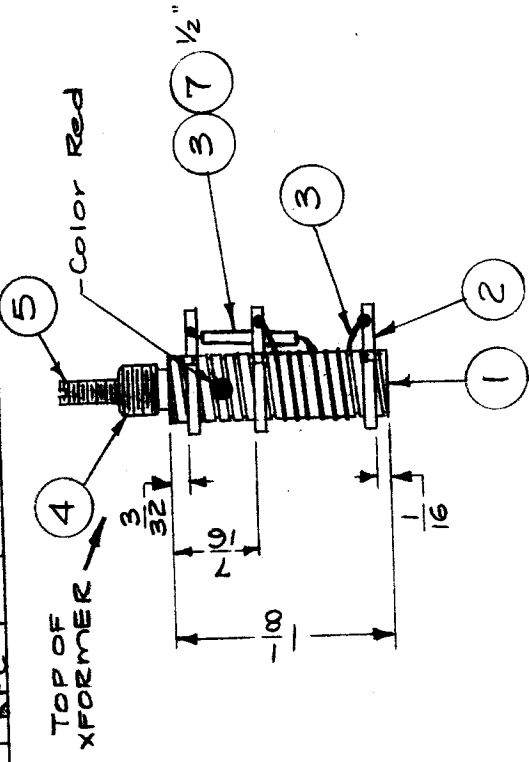
REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 5	IAC28(7)00	Cable, Hook-Up	BLACK
X 4	PX-104-1-.022	Insulation, Sleeving	OR S-337
X 3	GL-110	Wax, Impregnating	
X 2	WI-123-98	Wire, Magnet	
1 1	CI-103-34	Core	
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		REACTOR, TOROIDAL	
		33.2 MH	
		J.C. BIELE	ORBS
		DRAWN	ORBS
		CHECKED	ORBS
		TYPE & TEMPER	MECH. DES. APP.
		HEAT TREAT. SPEC.	CL-141
		FINISH & SPEC. NO.	A

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	EN. APP.
A 1	ITEM(2) WAS WI-123-33	8-1-63	9684	AK	JCB	W. Ball

SCALE:	
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REM VE ALL BURRS AND SHARP EDGES	

CL 144 A

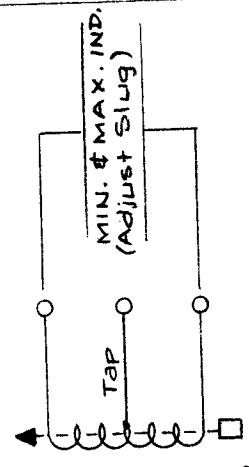
REQ. PART UNIT	MODEL	ASSY. NO.	DATE
	REF-1	APT-13K	12-19-58
	REC-		11-22-60



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 8	BS-100	Solder, Soft	
1/2"	PX-100-1-034	Insulation, Sleeving (Size 20)	BK.
X 6	GL-104-2	Insulex, UBS	
1	CI-109-10	Core, Tuning, BLUE	#
#	Deleted		#
X 3	WL-100-6	Wire, Buss (Size 22)	
3	TE-153-2	Terminal, Ring Type	
1	CF-128-1	Coil Form, Grooved	

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
REF COIL ASSY, TUNED	
20-2 MC	(CL-144)
16 12/19/58	AWL
AWB	ONS
TYPE & TEMPER	HEAT TREAT. SPEC.
FINISH & SPEC. NO.	FINAL APPROV.
	CL 144 A

- PROCEDURE -**
- Force Fit Bushing (item 4) into form (item 1).
 - Secure terminals (item 2) to form with Insulex (item 6).
 - Wind 6 Turns of wire (item 3) on form. Bring out tap at 3 turns from top. Slip Sleeving (item 7) over tap. Solder wire ends to proper terminals.
 - Paint winding with Insulex.
 - Bake for 1/2 hour at 250° F.
 - Insert Core (item 5).
 - Test as shown Below. Use Boonton Q-Meter Model 160A or Equiv.

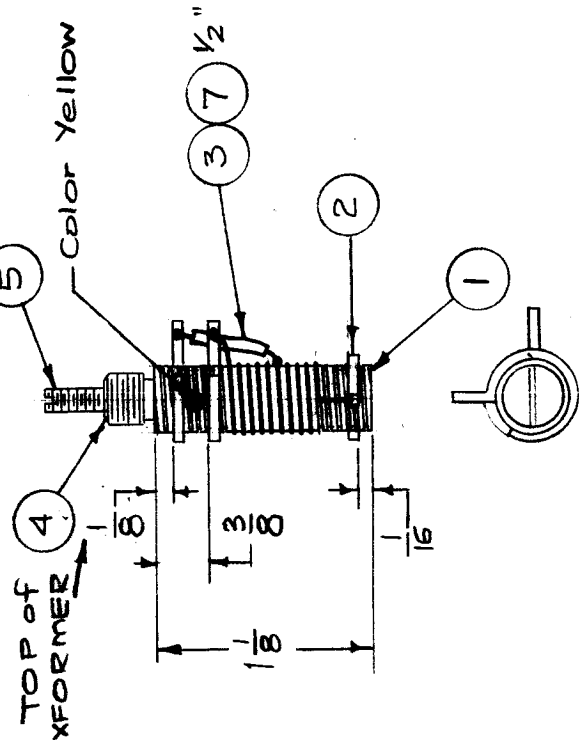


MIN. IND. MUST BE LESS THAN .32 μhy.
 MAX. IND. MUST BE MORE THAN .40 μhy
 Q AT TEST FREQ. MUST BE MORE THAN 135
 TEST FREQ. 25 MC
 OPERATING FREQ. 20-28 MC

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	Redrawn	9/1/51	20332			RED
SCALE: FULL						
TOLERANCES MAXIMUM ALL WABLET LERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTI N. REMOVE ALL BURRS AND SHARP EDGES						
DEC. DIM. ±						
FRAC. DIM. ±						
ANGULAR DIM. ±						

CL 145 E

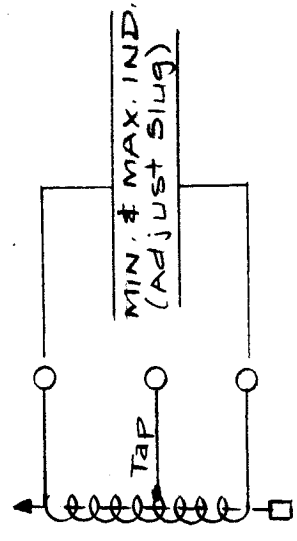
REQ. PER UNIT	1
MODEL	RFB-1
ASBY. NO.	GPT10K
DATE	11-22-60



REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 8	BS-100	Solder, Soft	
1/2"	PX-100-1-034	Insulation, Sleeving (Size 20)	BIK.
X 6	GL-104-2	Insulex, U-85	
1	CI109-2	Core, Tuning, Red	
#	4 Deleted		#
X 3	WL-100-6	Wire, Buss (Size 20)	
3	TE-153-2	Terminal, Ring Type	
1	CF-128-2	Coil Form, Grooved	

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
CL-145 ASSY	
(RF COIL TUNED) (16-20 MC)	
DATE	16/12/19/58
DRAWN	APB
CHECKED	APB
APPROVED	APB
FINAL APPROVAL	CL 145 E

- PROCEDURE -**
- Force Fit Bushing (item 4) into form (item 1)
 - Secure terminals (item 2) to form with Insulex (item 6).
 - Wind 9 1/2 Turns of wire (item 3) on form. Bring out tap at 5 turns from top. Slip Sleeve (item 7) over tap. Solder wire ends to proper terminals.
 - Paint Winding with Insulex.
 - Bake for 1/2 hour at 250°F.
 - Insert Core (item 5).
 - Test as shown Below. Use Boonton Q-Meter Model 160A or Equiv.

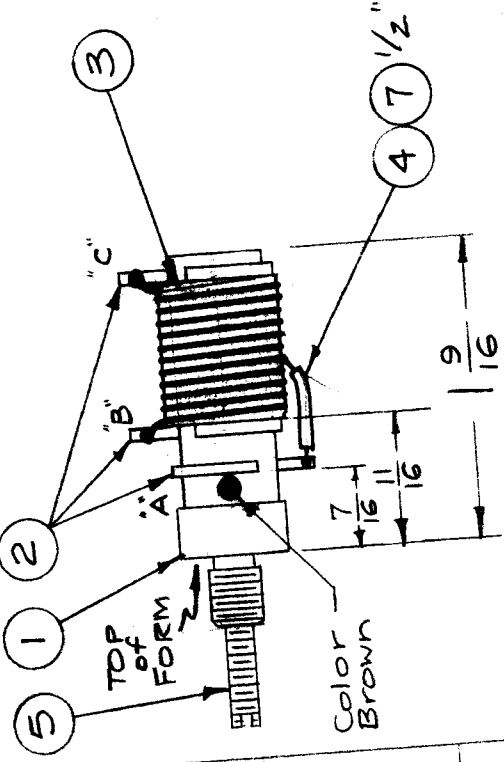


MIN. IND. MUST BE LESS THAN - .51 μhy
 MAX. IND. MUST BE MORE THAN - .86 μhy
 Q AT 25 MC MUST BE MORE THAN - 150
 TEST FREQ. - 25 MC
 OPERATING FREQ. - 16-20 MC

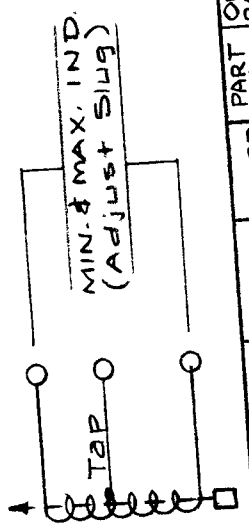
ISSUE ITEM	CHANGED FR M	DATE	CH. N.	DRAFTS	CHECKER	ENG. APP.
E	Redrawn	04/71	20332	CW		Red
SCALE: FULL						
TOLERANCES MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES						
DEC. DIM. ±						
FRAG. DIM. ±						
ANGULAR DIM. ±						

CL146 E

REQ. PER UNIT	MODEL	ASSY. NO.	DATE
1	RFD-1	6PT-10K	12-19-58
1	RFC-1	PALIK	10-22-60
			11-22-60



- PROCEDURE**
- Slip two terminal rings (item 2) on form (item 1) as shown. (marked "A" & "B").
 - Force fit outer form (item 3) onto inner form (item 1) and cement with Insulex (item 6).
 - Slip terminal ring marked "c" on inner form.
 - Cement all rings to inner form.
 - Wind 9 turns of wire (item 4) on outer form. Bring out tap at 7-1/2 turns from top. Slip sleeving (item 7) over tap. Solder all wire ends to proper terminals.
 - Paint winding with Insulex.
 - Bake for 1/2 hour at 250°F.
 - Insert core (item 5).
 - Test as shown below. Use Boonton Q-Meter Model 160A or Equiv.



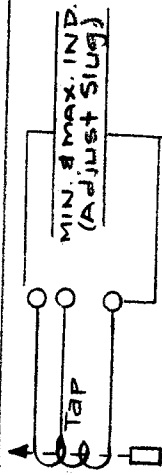
ASSY #	L-MAX	L-MIN	Q	TEST FREQ	CORE	COLOR	PART #	OPER. RANGE
A1611-1	>1.3µh	<1.1µh	>130	7.9 MC	GI109-19	RED	CL146	8-16 MC
A1611-2	>2µh	<1.5µh	>80	7.9 MC	GI037B5	GREEN	CL146-2	6.3-12.3

ISSUE ITEM	CHANGED FR M	DATE	CH. NO.	DRAFTS	CHECKER	EN . APP.
E	REDRAGON	6/1/71	20330	CU		P.E.D.
T LERANCES						
SCALE: FULL						
MAXIMUM ALL WABLET LERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REM VE ALL BURRS AND SHARP EDGES						
DEC. DIM. ±	FRAC. DIM. ± 1/64					
ANGULAR DIM. ±						

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 8	BS-100	Solder, Soft	BK.
1/2"	7 PX-100-1-.042	Insulation, Sleeving (Size 18)	
X 6	GL-104-2	Insulex, UBS	
1	5 SEE CHART	Core, Tuning,	
X 4	WL-100-5	Wire, Buss (Size 18)	
1	3 CF-125-3P0.75	Coil Form, Grooved	
3	2 TE-153-3	Terminal, Ring Type	
1	1 CF-119-1.562	Coil Form, w/ Bushing	
		THE TECHNICAL MATERIEL CORP.	
		MAMARONECK, NEW YORK	
		RF COIL ASSY, TUNED (CL-146)	
		MATERIAL	
		DATE	
		DRAWN	
		TYPE & TEMPER	
		HEAT TREAT. SPEC.	
		FINISH & SPEC. NO.	
		FINAL APPROVAL	

PROCEDURE

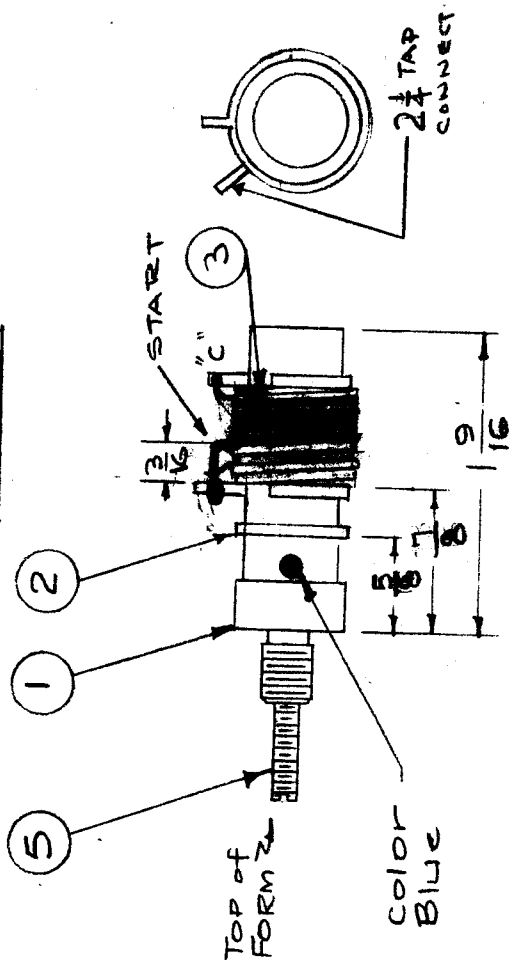
1. Slip two terminal rings (item 2) on form (item 1) as shown (Marked "A" and "B").
2. Force fit outer form (item 3) onto inner form (item 1) and cement with Insulex (item 6).
3. Slip terminal ring marked "C" on inner form.
4. Cement all rings to inner form.
5. Wind 4 turns of wire (item 4) on outer form. Bring out tap at 2 1/4 turns from top. Slip Sleeve (item 7) over tap. Solder all wire ends to proper terminals.
6. Paint Winding with Insulex.
7. Bake for 1/2 hour at 250°F.
8. Insert Core (item 5).
9. Test as shown below. Use Beantown Q - Meter Model 160A or Equivalent.



Minimum Inductance must be less than .36 uhy.
 Maximum Inductance must be more than .45 uhy.
 Q at 2.5 Mc must be more than 140
 Test frequency 25 Mc.
 Operating frequency - 20-28 Mc.

CL 148 F

UNIT	MODEL	ASST. NO.	DATE
1	RFC-1	CL 148	12-22-58
			1-22-60

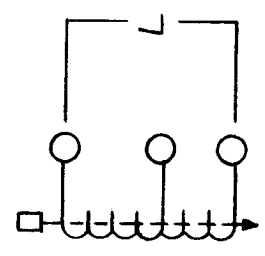
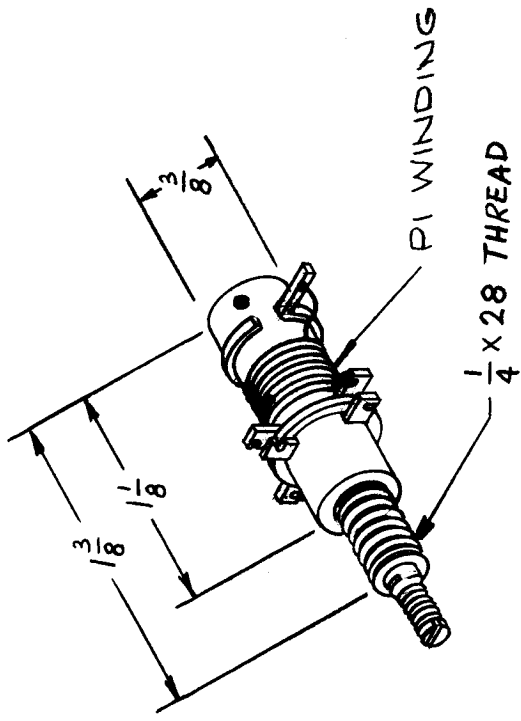


REQ. ITEM	PART NO.	DESCRIPTION	SYMB L
X 8	BS-100	Solder, Soft	
1/2"	PX-100-1-.053	Insulation, Sleeve (Size 16)	BLK
X 6	GL-104-2	Insulex, U85	
1 5	CI-109-19	Core, Tuning, Red	
X 4	WL-100-5	Wire, Buss (Size 18)	
1 3	CF-125-3P0.50	Coil Form, Grooved	
3 3	TE-153-3	Terminal, Ring Type	
1 1	CF-119-1.562	Coil Form, w/Bushing	

STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL		RF COIL ASSY, TUNED	
TYPE & TEMPER		20-2 MC	
HEAT TREAT. SPEC.		K 1/2 2/58	
FINISH & SPEC. NO.		DRAWN: ATB, CHECKED: JNS, APPROVED: OMB	
ENG. APP.		FINAL APPROVAL: CL 148 F	

ISSUE ITEM	CHANGED FR M	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
F 3	REDRAWN	6/1/61	20382	OLL	JEB	
SCALE: 1/32						
TOLERANCES						
DEC. DIM. ±						
FRAC. DIM. ±						
ANGULAR DIM. ±						
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES						

REQ. PER UNIT	USED ON	CL-149	A
	MODEL	RFA-1	
	ASS'Y. N.		
	DATE		



ELECTRICAL SPECIFICATIONS

Operating Frequency Range 2-4 mcs.
 L - minimum less than 28 uhy
 L - maximum greater than 39 uhy
 Q - greater than 50
 F - 2.5 mcs

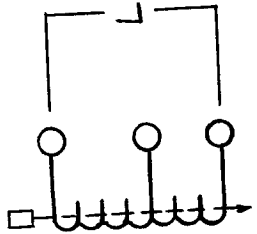
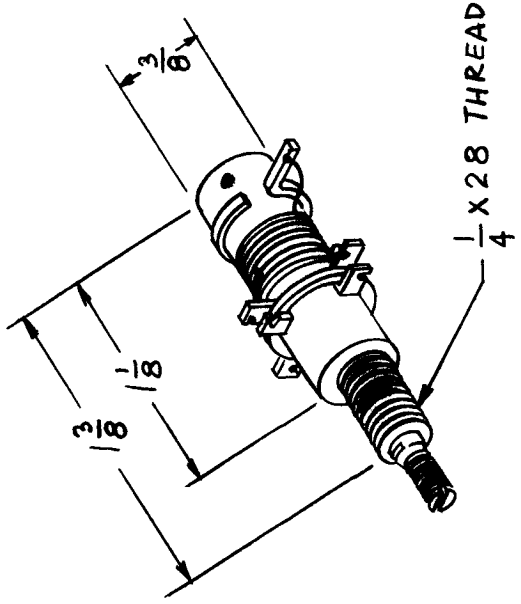
MECHANICAL SPECIFICATIONS

Phenolic coil form
 Powdered iron tuning slug
 Stud mounted 1/4-28 threads
 40 turns
 #541 lits wire
 Color Code - Black

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		COIL, RF, TUNED, 2-4 mc	
		MJT 1-7-59	
		DRAWN	
		CHECKED	
		FINAL APPROVAL	
		CL-149	A
A		COIL FORM WAS SER PI WINDING ADD PIC	
ISSUE ITEM	CH. NO.	DATE	SCALE:
	17380	12.6.66	NPL 2A-1614-1
	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES			
DEC. DIM. ±			
FRAC. DIM. ±			
ANGULAR DIM. ±			
FINISH & SPEC. NO.			
ELEC. DES. APP. MECH. DES. APP.			

CL-151 A

REQ. PER UNIT	M DEL	USED ON	DATE
1	RFA-1	ASSY. NO.	



ELECTRICAL SPECIFICATIONS

Operating Frequency range 8-16 mcs.
 L - minimum less than 1.4 uhy
 L - maximum greater than 1.8 uhy
 Q - greater than 80
 F - 7.9 mcs

MECHANICAL SPECIFICATIONS

PAENOLIC coil form
 Powdered iron tuning slug
 Stud mounted 1/4-28 threads
 12 turns
 #24 magnet wire
 Color Code - Red

SYMBOL	DESCRIPTION	
	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
	COIL, RF, TUNED, 8-16 MC	
MJT	1-7-59	DATE
	DRAWN	CHECKED
	APP	APP
	FINAL APPR VAL	CL-151 A
REG. ITEM	PART NO.	STOCK SIZE
		MATERIAL
		HEAT TREAT. SPEC.
		FINISH & SPEC. NO.
ISSUE ITEM	CHANGED FROM	TOLERANCES
A	COIL FORM WAS CER	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES
	DATE 12-6-66	SCALE: NPL
	CH. NO. 17380	CHECKER ENG. APP. J/S
	DRAFTS	2A-1614-3

WINDING MACHINE DATA

2 Loads Required
 6" Load Ring
 Load #1 - Approx. 250 Turns
 Load #2 - Approx. 235 Turns

WINDING (in accordance WITH TMC SPEC. S-337)

1. Wind 3600 turns from Load 1 onto core. Splice Load #2 wire to Load #1 wire.
2. Wind 2600 turns from Load 2 onto core. (Total turns, 6200).
3. Bake for 1/2 hour at 2150 F.
4. Submerge hot coil in GL-110 (item 3).
5. Test and resonate as per spec. S-417

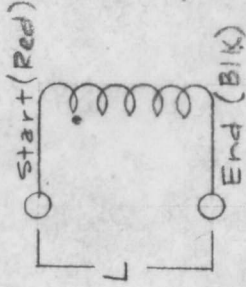
See S337 for Use of These Items

L = 4.8 Hy (Approx.)

Q = 150 or greater

DC Res. - 360 Ω or Greater

Fr = 1 Kc



ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	COMPLETE REVISION	6-4-71	20369	RJ	W	Red

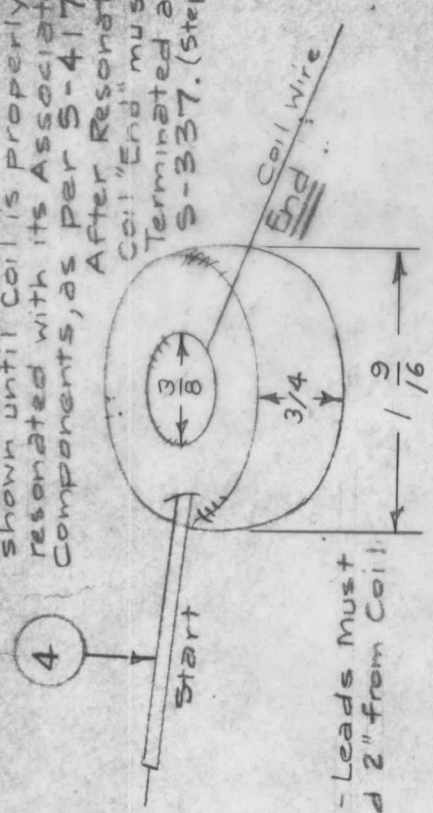
TOLERANCES

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

REQ. PER UNIT	1
MODEL	FX-156
ASSY. NO.	2-25-59
DATE	2-25-59
USED ON	CL156
	A

NOTE - "Coil Wire END" must extend as shown until coil is properly resonated with its associated components, as per S-417. After Resonating Proc, coil "End" must be terminated as per S-337. (stepc)



NOTE - Leads must extend 2" from coil

X	8	BS-100	SOLDER, SOFT								
X	7	TA-102-2	TAPE, PAPER								
X	6	FX-104-1-022	SLEEVING								Blk
X	5	IMC28(7)U0	CABLE, INSULATED (End)								Blk
X	4	IMC28(7)U2	CABLE, INSULATED (Start)								Red
X	3	GL-110	COMPOUND, POTTING								
X	2	WI-123-36	WIRE (#36)								
1	1	CI-103-11	CORE								

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		COIL, AF, 935 cps BANDPASS FILTER	
TYPE & TEMPER	HEATTREAT. SPEC.		
		16 ² / ₂₅ /59	
DRAWN	CHECKED		
RWB	APB		
FINISH & SPEC. NO.		CL156	A
ELEC. DES. APP. MECH. DES. APP.			

WINDING MACHINE DATA

Load Turns = 200 (approx.)
6" Load Ring

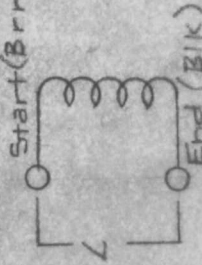
WINDING (in accordance WITH TMC SPEC. S-337)

1. Wind 2500 turns of wire (item 2) onto core (item 1).
2. Bake for 1/2 hour at 215° F.
3. Submerge hot coil in GL-110 (item 3)
4. Test and resonate as per Spec. S-418

F_r = 1 Kc

L = .95 Hy (Approx.)

Q = 150 or greater
DC Res. = 125 Ω or greater



See S337
for use of
these items

COMPLETE REVISION

6-4-71 20369 R2

W. P. S. A

ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	COMPLETE REVISION	6-4-71	20369	R2	W. P. S. A	

SCALE:

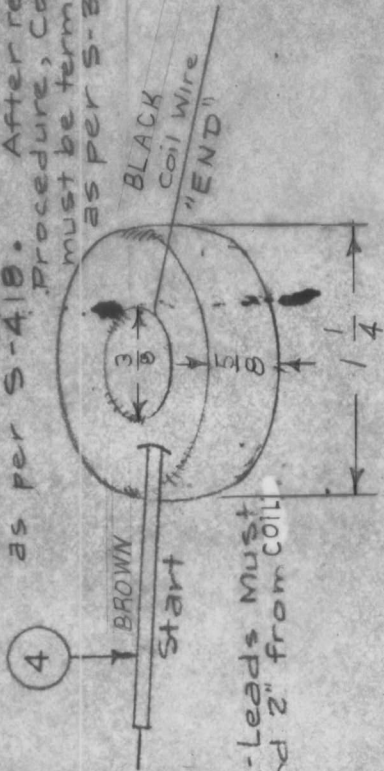
DEC. DIM. ±
FRAC. DIM. ±
ANGULAR DIM. ±

TOLERANCES

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

REQ. PER UNIT	MODEL	ASSY. NO.	DATE
1	FX-157		2-25-59

NOTE: "Coil Wire END" must extend as shown until coil is properly resonated with its associated components, as per S-418. After resonating procedure, coil "END" must be terminated as per S-337. (Steps



NOTE - Leads Must Extend 2" from COIL

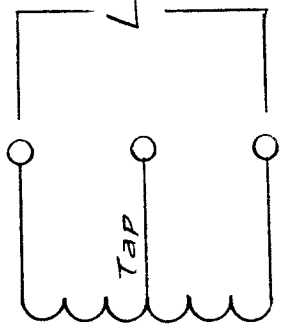
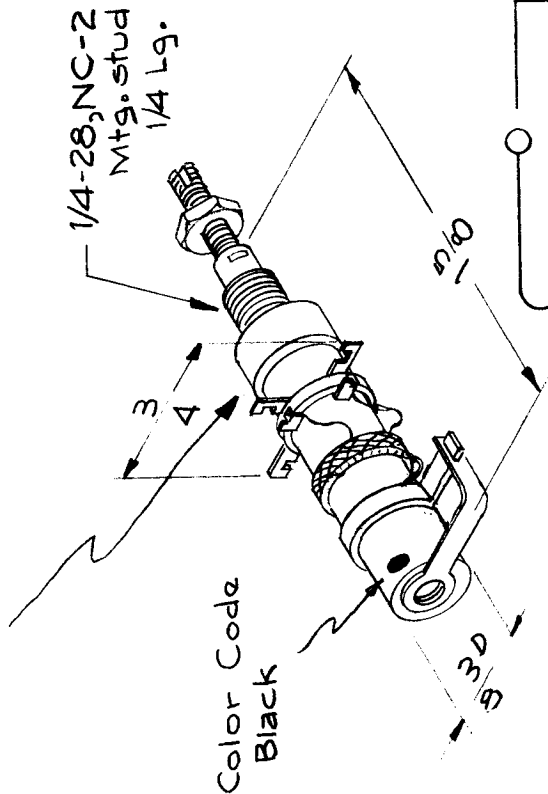
REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 8	BS-100	SOLDER, SOFT	
X 7	TA-102-2	TAPE, PAPER	
X 6	PX-104-1-.022	SLEEVING	BIK
X 5	LWC28(7)U0	CABLE, INSULATED (End)	BIK
X 4	LWC28(7)U1	CABLE, INSULATED (start)	Brn
X 3	GL-110	COMPOUND, POTTING	
X 2	WI-123-36	WIRE (#36)	
1 1	CI-103-8	CORE	

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
COIL, AF, 2805 cps BANDPASS FILTER	

16 ² /25/59	AWC	FINAL APPROVAL
DRAWN	CHECKED	
RWP	AWC	CL157
ELEC. DES. APP.	MECH. DES. APP.	

REQ. PER. UNIT	1	MODEL	AX-204	USED ON	CL161
	1	SBE-2	AX-204	ASSY. NO.	A
		SBE-3	AX-204	DATE	12-9-59

Bushing Assy. to be cemented to form upon Assy. of Coil into unit.



ELECTRICAL SPECIFICATIONS

L - 25.5 (23.5-27.5) Microhenries
 Q - 60 or greater
 FREQ. (Test) - 2.5 Mcs
 OPER. FREQ. - 2-4.3 Mcs

MECHANICAL SPECIFICATIONS

TOTAL TURNS - 42
 TAP - 8 turns
 WIRE - WI-104-511DS08
 TUNING SLUG - Powdered Iron
 FORM - Phenolic

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Property of:

THE TECHNICAL MATERIEL CORPORATION
 MAMARONECK, NEW YORK

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		COIL, RF, TUNED, 2-4.3 mcs.	
		MATERIAL	
		STOCK SIZE	
		TYPE & TEMPER	
		HEAT TREAT. SPEC.	
		DRAWN	
		CHECKED	
		FINAL APPROVAL	
		FINISH & SPEC. NO.	
		ELEC. DES. APP.	
		MECH. DES. APP.	

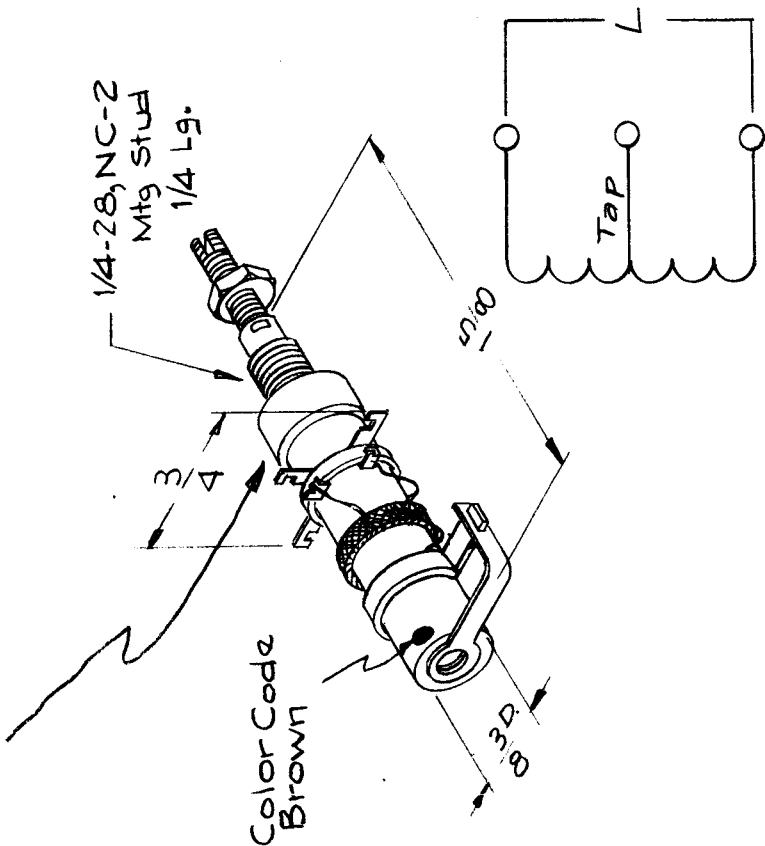
ISSUE ITEM: A 1
 CHANGED FROM: TERM. RING REPOSITIONED
 DATE: 6-17-60
 CH. NO.: 16378
 DRAFTS: [Signature]
 CHECKER: [Signature]
 ENG. APP.: [Signature]
 SCALE: 2A-1451-1

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

CL162 A

REQ. PER UNIT	MODEL	ASST. NO.	DATE
1	SBE1#2		
2	TTC		
1	SBE-3	AX-204	12-9-69

Bushing Assy to be Cemented to form upon Assy of coil into unit.



ELECTRICAL SPECIFICATIONS

L - 25.5(23.5 - 27.5) Microhenries
 Q - 60 or greater
 FREQ. (Test) - 2.5 Mcs
 OPER. FREQ. - 2.4-3 Mcs

MECHANICAL SPECIFICATIONS

TOTAL TURNS - 42
 TAP - 16
 WIRE - WL-104-54LDSQS
 TUNING SLUG - Powdered Iron
 FORM - Phenolic

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		COIL, RF, TUNED, 2-4.3 mc	
		MATERIAL	
		STOCK SIZE	
		HEAT TREAT. SPEC.	
		FINISH & SPEC. NO.	
		TYPE & TEMPER	
		DRAWN	
		CHECKED	
		FINAL APPR VAL	
A	1	TERM RING REPOSITIONED	
		CHANGED FROM	
		DATE	
		CH. NO.	
		DRAFTS	
		CHECKER	
		ENG. APP.	
		SCALE:	2A-1451-2
TOLERANCES			
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES			
DEC. DIM. ±			
FRAG. DIM. ±			
ANGULAR DIM. ±			
		ELEC. DES. APP. MECH. DES. APP.	
		CL162	A

CL163 B

REQ. PER. UNIT	USED ON
3	MODEL
4	ASSY. N.
	DATE
	SBE-3 AX-204
	MF/RF

ELECTRICAL SPECIFICATIONS

L - 3.7(3.4-4.3) Microhenries w/o core
 Q - 90 or greater
 FREQ. (TEST) - 7.9 Mcs
 OPER. FREQ. - 4-8 Mcs

MECHANICAL SPECIFICATIONS

TOTAL TURNS - 20
 TAP - 6 Turns
 WIRE - WI-107-15
 TUNING SLUG -, Powdered Iron
 FORM - Phenolic

NOTICE TO PERSONS RECEIVING THIS DRAWING

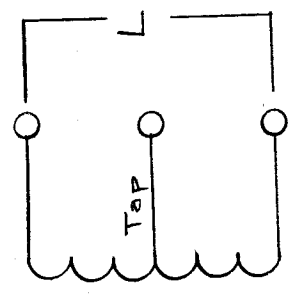
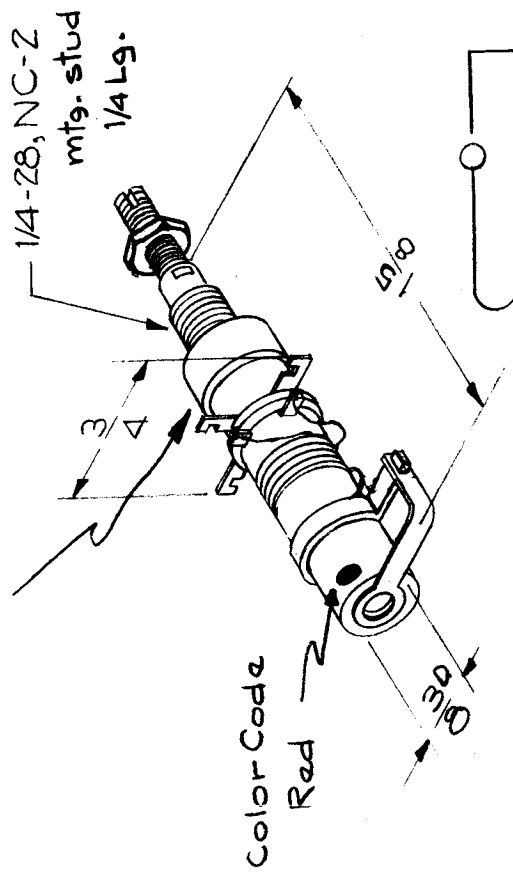
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THE TECHNICAL MATERIEL CORPORATION

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP.	
		MAMARONECK, NEW YORK	
		COIL, RF, TUNED, 4-8 mc	
		MATERIAL	
		TYPE & TEMPER	CHECKED
		HEAT TREAT. SPEC.	DRAWN
		FINISH & SPEC. NO.	ELEC. DES. APP. MECH. DES. APP.
			CL163 B

Bushing Ass'y to be Cemented to form upon Ass'y of coil into unit.



ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
B 1	TERM RING REPOSITIONED	6/17/66	16378			
A 2	TOTAL TURNS WAS 21	12/19/60	3751			
A 1	L-W 35-3.7(3.4-4.3) Microhenries					
TOLERANCES						
SCALE: 2A-1451-B						
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES						
DEC. DIM. ±						
FRAC. DIM. ±						
ANGULAR DIM. ±						

CL 164 A

REQ. PER. UNIT	2
MODEL	SBE-3
ASSY. NO.	AX-204
DATE	

ELECTRICAL SPECIFICATIONS

L - 1.1(1.0-1.2) Microhenries
 Q - 90 or greater
 FREQ. (TEST) - 7.9 Mcs
 OPER. FREQ. - 8-16 Mcs

MECHANICAL SPECIFICATIONS

TOTAL TURNS - 12
 TAP - 6
 WIRE - WI-107-5
 TUNING SLUG - Powdered Iron
 FORM - Phenolic

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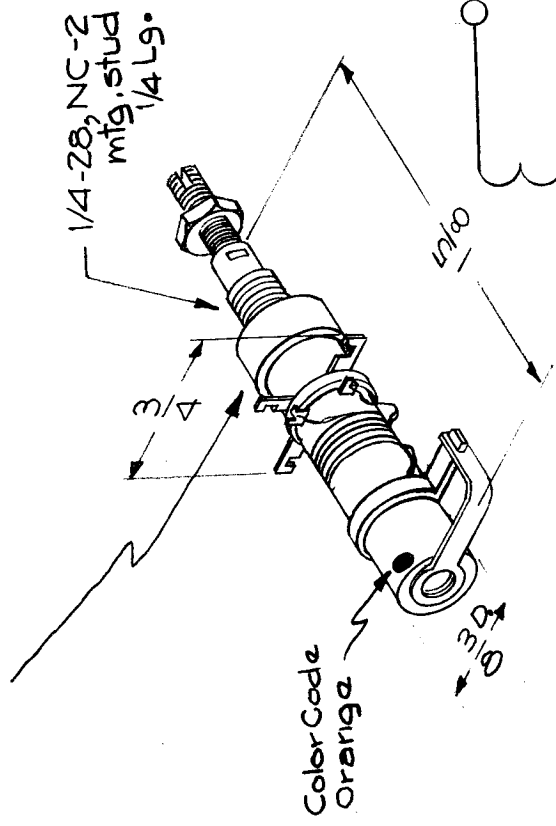
Property of:

THE TECHNICAL MATERIEL CORPORATION

MAMARONECK, NEW YORK

SYMBOL	A
DESCRIPTION	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK
PART NO.	COIL, RF, TUNED, 8-16 MC
STOCK SIZE	
MATERIAL	
TYPE & TEMPER	DR. W. R. 10
HEAT TREAT. SPEC.	
FINISH & SPEC. NO.	CL 164
ELEC. DES. APP.	
MECH. DES. APP.	
FINAL APPROVAL	J. [Signature]

Bushing Assy to be cemented to form upon Assy of Coil into unit.



Color Code Orange

ISSUE ITEM	A 1	TERM RING REPOSITIONED	CHANGED FROM	DATE	6-17-46	CH. NO.	X	DRAFTS	APD	CHECKER	ENG. APP.	SCALE	2A-1451-4
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TOLERANCES
 DEC. DIM. ±
 FRAC. DIM. ±
 ANGULAR DIM. ±

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

REQ. PART. UNIT	M DEL	ASSY. N.	DATE
	SE-3	AX-204	
USED ON			CL 165
			A

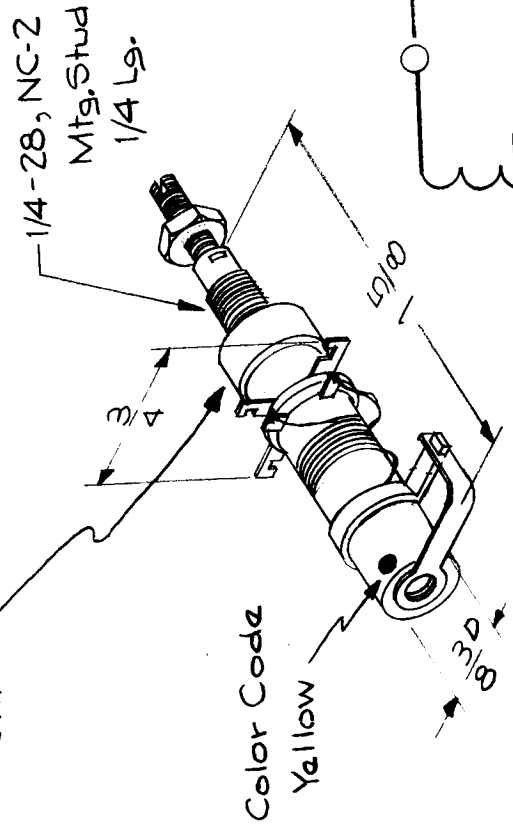
ELECTRICAL SPECIFICATIONS

L - 1.1(1.0-1.2) Microhenries
 Q - 90 or greater
 FREQ. (TEST) - 7.9 Mcs
 OPER. FREQ. - 8-16 Mcs

MECHANICAL SPECIFICATIONS

TOTAL TURNS - 12
 TAP - 3 Turns
 WIRE - WI-107-5
 TUNING SLUG - Powdered Iron
 FORM - Phenolic

Bushing Assy. to be Cemented to form upon Assy. of Coil into Unit.



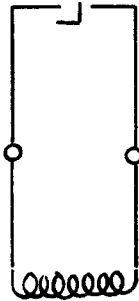
REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		COIL, RF, TUNED, 8-16 mc.	
		<i>88 Mar 16</i>	
		DRAWN	CHECKED
		TYPE & TEMPER	HEAT TREAT. SPEC.
		MATERIAL	
		STOCK SIZE	
		FINISH & SPEC. NO.	ELEC. DES. APP. MECH. DES. APP.
			CL 165
			A
A 1	TERM. RING REPOSITIONED	DATE 6-17-66	CH. NO. 16378
	CHANGED FROM	SCALE: 2A-1451-5	CHECKER ENG. APP.
	TOLERANCES	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES	
	DEC. DIM. ±		
	FRAC. DIM. ±		
	ANGULAR DIM. ±		

ELECTRICAL SPECIFICATIONS

L ~ 25 μhy
 Q ~ GREATER THAN 180
 F ~ 2.5 mc

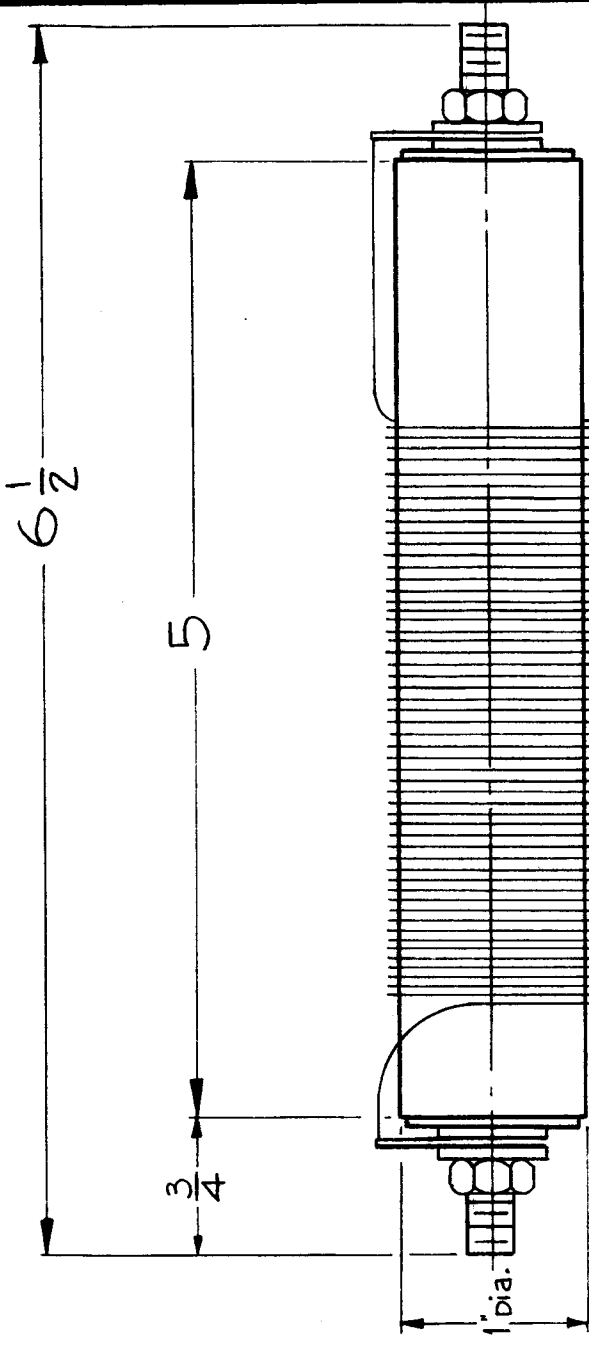
MECHANICAL SPECIFICATIONS

CERAMIC COIL FORM
 58 TURNS NO. 17 CEROC WIRE
 THREADED ROD MOUNTED 1/4-20
 THREADS



REQ. PER. UNIT	USED ON	MODEL	ASSY. NO.	DATE
1		GPT10K	4X-137	4-29-59

CL-167



REQ. ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
									THE TECHNICAL MATERIEL CORP.	
									MAMARONECK, NEW YORK	
									CHOKE, PLATE	
									J.C. BIELE	<i>ans</i>
									DRAWN	FINAL APPROVAL
									6.	CL-167
									ELEC. DES. APP.	
									MECH. DES. APP.	
									FINISH & SPEC. NO.	
									HEAT TREAT. SPEC.	
									STOCK SIZE	
									MATERIAL	

SCALE: ZA-1679

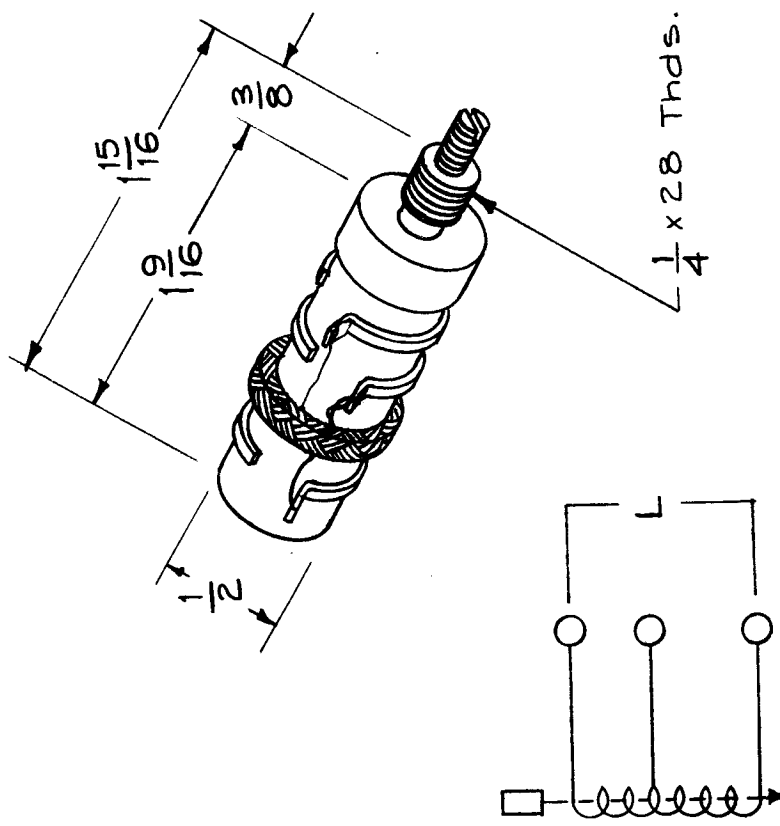
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

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

CL-173 C

REQ. PART UNIT	MODEL	USED ON ASSY. N.	DATE
1	RFC-1		6-25-59
1	RFD-1		6-25-59
1	RFD-2		6-11-64

SPECIFICATIONS			
RANGE	TMC PART NO.	L MIN	G
2-4 MC	CL173-1	> 23.0uh	> 50 2.5 MC
1.75-3.4MC	CL173-2	> 35.0uh	> 55 2.5MC



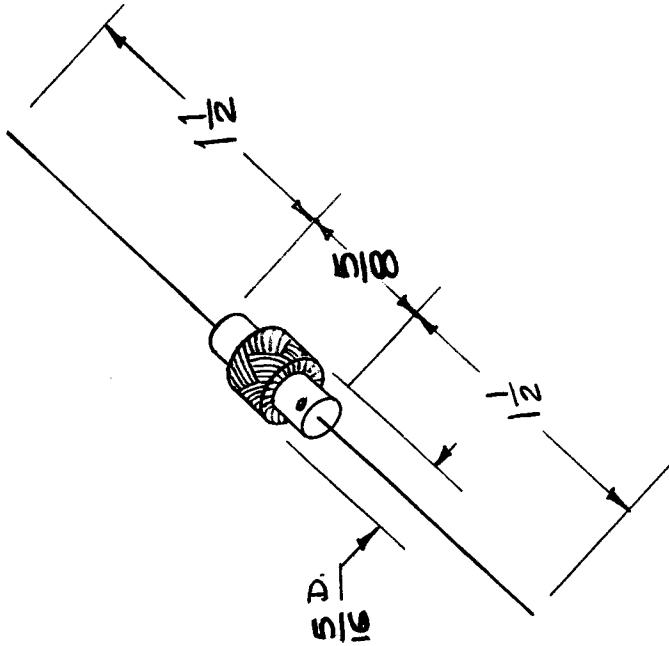
SYMBOL	DESCRIPTION
C	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK
B	COIL, RF, TUNED
A	16/25/59
ISSUE ITEM	CHECKED
CHANGED FROM	DRAWN
TOLERANCES	FINAL APPROVAL
DEC. DIM. ±	CL-173 C
FRAC. DIM. ±	
ANGULAR DIM. ±	

CL-177

USED ON		
REQ. PER. UNIT	M DEL	DATE
1	GPT-10K	9-25-59
2	RFB-1	AX-165
17	RFB-1	11
1	SBE-3	12-2-59
1	RFC-1	11-22-60

ELECTRICAL SPECS.
 L - 128μhy (116-140)
 Q - 100 or Greater
 F (TEST) - 790 KC

MECHANICAL SPECS.
 CORE - Powdered Iron
 Winding - 100 turns of 541 Lutz Wire
 Color Code - Green



REQ. ITEM		PART NO.		DESCRIPTION		SYMBOL	
				THE TECHNICAL MATERIEL CORP.		MAMARONECK, NEW YORK	
				STOCK SIZE		COIL, RF, FIXED, 128μhy.	
				MATERIAL		16 ^{9/16} /59	
				TYPE & TEMPER		DRAWN	
				HEAT TREAT. SPEC.		CHECKED	
				FINISH & SPEC. NO.		FINAL APPROVAL	
				ELEC. DES. APP		CL-177	
				MECH. DES. APP			

SCALE: 1A1045
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

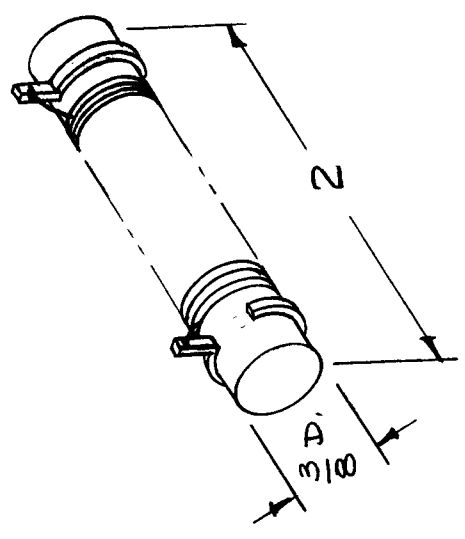
TOLERANCES
 DEC. DIM. ± DIM.
 FRAC. DIM. ± FOR
 ANGULAR DIM. ± REF.

CL-178 A

USED ON	
REQ. PER UNIT	MODEL
3	REF-1
1	GPT-10K AX-137
	REC-1
	DATE
	9-23-59
	DATE
	11-22-60

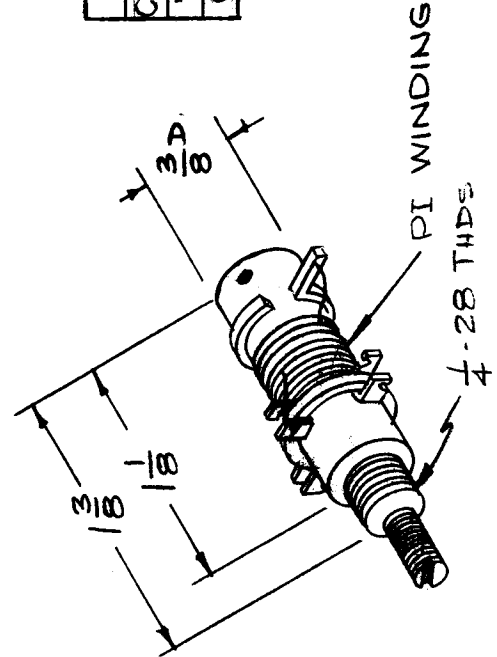
ELECT. SPECS.
 L- 185 μ hy \pm 15 μ hy
 Q- 50 or Greater
 F (Test)- 790 KC

MECH. SPECS.
 Core- Ferrite
 Winding- 60 turns # 26 Magnet Wire



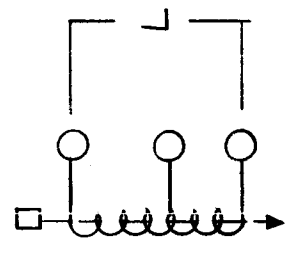
REQ. ITEM		PART NO.		SYMBOL	
				DESCRIPTION	
				THE TECHNICAL MATERIEL CORP.	
				MAMARONECK, NEW YORK	
				COIL, RF, FIXED, 185 μ hy.	
				MATERIAL	
				16 ⁹ /10/59	
				DRAWN	
				CHECKED	
				FINAL APPROVAL	
				CL-178 A	
ISSUE ITEM		CHANGED FROM		ELEC. DES. APP	
A		(TERM RING REPOS. 6.27.66 16465 WHD)		MECH. DES. APP	
		DATE		CHECKER	
		6.27.66		2A1126	
		CH. NO.		ENG. APP.	
		16465		WHD	
		DATE		CHECKER	
		6.27.66		2A1126	
		SCALE:		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES	
		TOLERANCES		FOR	
		DEC. DIM. \pm		REF.	
		FRAC. DIM. \pm			
		ANGULAR DIM. \pm			

REQ. PER UNIT	1	USED ON	CL-181
MODEL	RFD-1	ASSY. NO.	
	RFC-1	DATE	9-23-59
			11-22-60



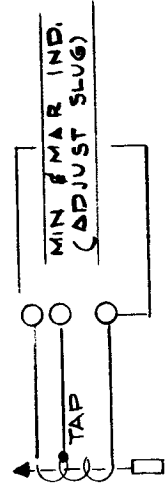
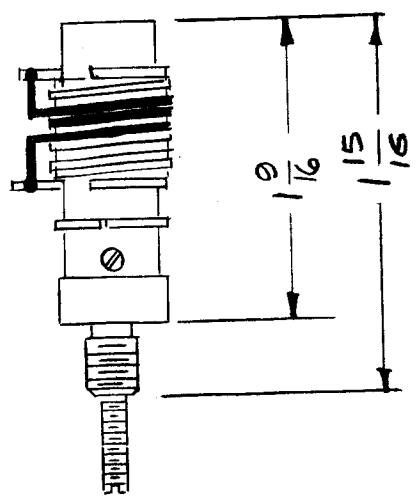
ELECTRICAL SPECS.					
COLOR CODE	TMC PART NO.	L MAX	L MIN	Q	RANGE
YELLOW	CL181-1	>25.1uh	<16.4h	>60	2-4 MC
ORANGE	CL181-2	>36uh	<16.4h	>55	1.75-3.4 MC
					2.5 MC

MECHANICAL SPECS.
 COIL FORM - PHENOLIC
 CORE - POWDERED IRON
 MOUNTING - 1/4-28 THD. STUD.
 WINDING - 33 TURNS #541 LITZ WIRE



REQ. ITEM		DESCRIPTION	SYMBOL
F		PI WINDING ADDED PICT COIL FORM WAS CER Y6L L MIN WAS 15.5UH	
E	4	UPDATED SPECS 2-4 MC DELE. FR TITLE	
ISSUE ITEM	CHANGED FROM		
TOLERANCES			
DEC. DIM. ±	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.		
FRAC. DIM. ±	REMOVE ALL BURRS AND SHARP EDGES		
ANGULAR DIM. ±			
REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP.	
		MAMARONECK, NEW YORK	
		COIL, RFI, TUNED	
		MATERIAL	
		HEAT TREAT. SPEC.	
		CHECKED	
		DRAWN	
		FINISH & SPEC. NO.	
		ELEC. DES. APP. MECH. DES. APP.	
		FINAL APPROVAL	
		CL-181	F

REQ. PER UNIT		USED ON	
1	M DEL	ASSY. NO.	DATE
	RED-1	PAL-1K	B-7-59
		CL-182	



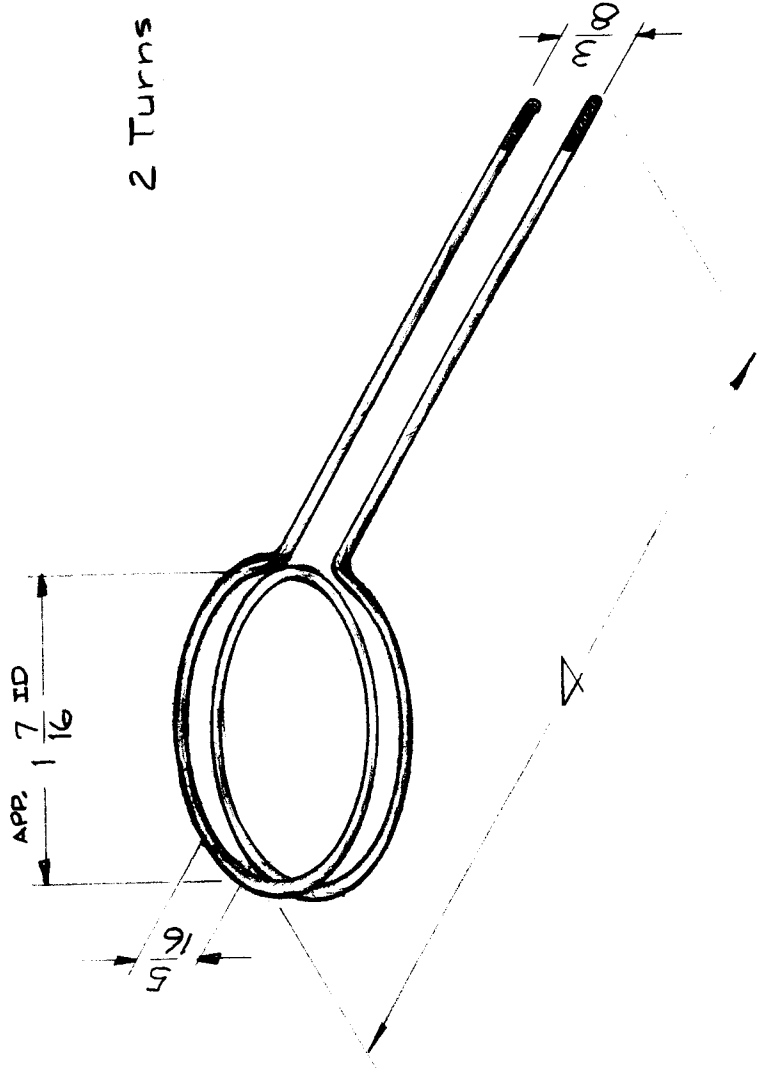
ELECT. SPEC.
 OPER. FREQ. - 22-32 MC
 L - MIN. LESS THAN
 Q - GREATER THAN 120
 F (TEST) - 25 MC
 MECH. SPEC.
 COIL FORM - PHENOLIC
 CORE - POWDERED IRON
 MOUNTING - 1/4-28 STUD
 WINDING - 3 TURNS OF #18 WIRE

REQ. ITEM		PART NO.		SYMBOL	
				DESCRIPTION	
				THE TECHNICAL MATERIEL CORP.	
				MAMARONECK, NEW YORK	
		STOCK SIZE		COIL, RF, TUNED, 22-32 MC	
		MATERIAL			
		TYPE & TEMPER		PI.	
		HEAT TREAT. SPEC.		CHECKED	
		FINISH & SPEC. NO.		DRAWN	
				ELEC. DES. APP. MECH. DES. APP.	
ISSUE ITEM		CHANGED FROM		DATE	
				CH. NO.	
				DRAFTS	
				CHECKER	
				ENG. APP.	
				SCALE: NPL 1A-1740	
				TOLERANCES	
				MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES	
DEC. DIM. ±					
FRAC. DIM. ±					
ANGULAR DIM. ±					

CL-183

REQ. PER. UNIT	MODEL	USED ON ASS'Y. NO.	DATE
1	10K(B)	AX-187	
1	10K	AJ-100	

2 Turns #12 Magnet Wire



NOTICE TO PERSONS RECEIVING THIS DRAWING
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Property of:
 THE TECHNICAL MATERIEL CORPORATION
 MAMARONECK, NEW YORK

REQ. ITEM		PART NO.		SYMBOL	
				DESCRIPTION	
				THE TECHNICAL MATERIEL CORP.	
				MAMARONECK, NEW YORK	
				COIL, R.F., FIXED	
ISSUE ITEM		MATERIAL		DRAWN	
CHANGED FROM		TYPE & TEMPER		CHECKED	
TOLERANCES		HEAT TREAT. SPEC.		ELEC. DES. APP. MECH. DES. APP.	
DATE		SCALE: A 1747		NO. NP/L	
CHECKER		ENG. APP.		FINAL APPROVAL	
DRAFTS		REMOVE ALL BURRS AND SHARP EDGES		CL-183	
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.					
DEC. DIM. ±					
FRAC. DIM ±					
ANGULAR DIM. ±					

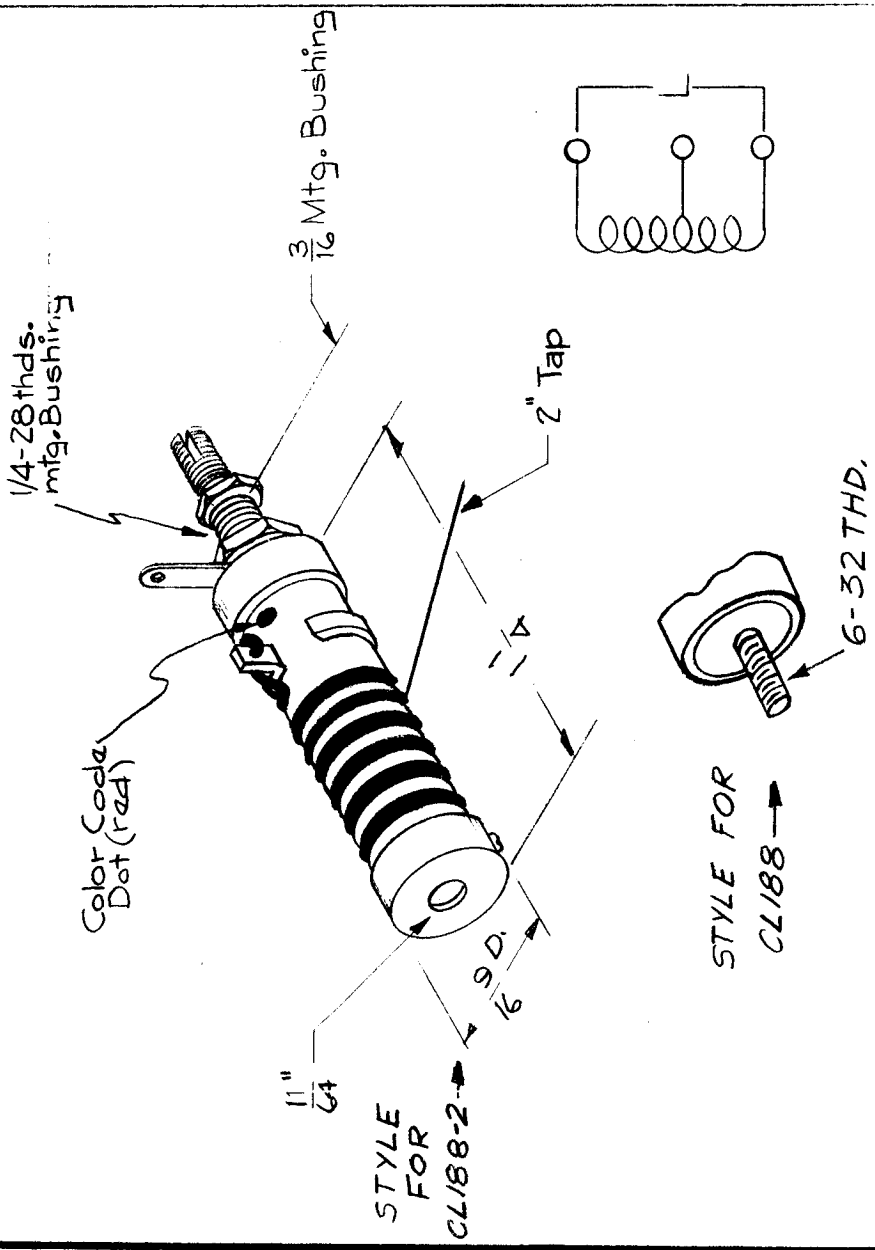
REQ. PER. UNIT	USED ON	CL-188	B
2	MODEL	AX-204	DATE
	ASSY. NO.	SBE-3	

ELECTRICAL SPECIFICATIONS

L - .40 (.39 - .41) Microhenries
 Q - 170 or greater
 FREQ. (Test) - 25 Mcs
 OPER. FREQ. - 16-32 Mcs.

MECHANICAL SPECIFICATIONS

TOTAL TURNS - 6-1/2
 TAP - 4 turns
 WIRE - No. 16 Buss
 TUNING SLUG - Powdered Iron
 FORM - Phenolic



REG. ITEM	PART NO.	DESCRIPTION	SYMBOL
B		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
A		COIL, RF, TUNED, BAND 4	
ISSUE ITEM	CHANGED FROM	MATERIAL	16-32 mc
	DATE	DRAFTS	12/1/51
	CH. NO.	CHECKER	16
	NO	SCALE	2A1519-1
	NPL		
TOLERANCES			
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES			
DEC. DIM. ±			
FRAC. DIM. ±			
ANGULAR DIM. ±			
	TYPE & TEMPER	HEATTREAT. SPEC.	CHECKED
			DRAWN
	FINISH & SPEC. NO.		ELEC. DES. APP. MECH. DES. APP.
			CL-188
			B

