

| | | |
|---------------|-------|----------------|
| REQ. PER UNIT | MODEL | USED ON |
| | CLL-1 | ASSY. NO. DATE |
| | | 6-1-60 |

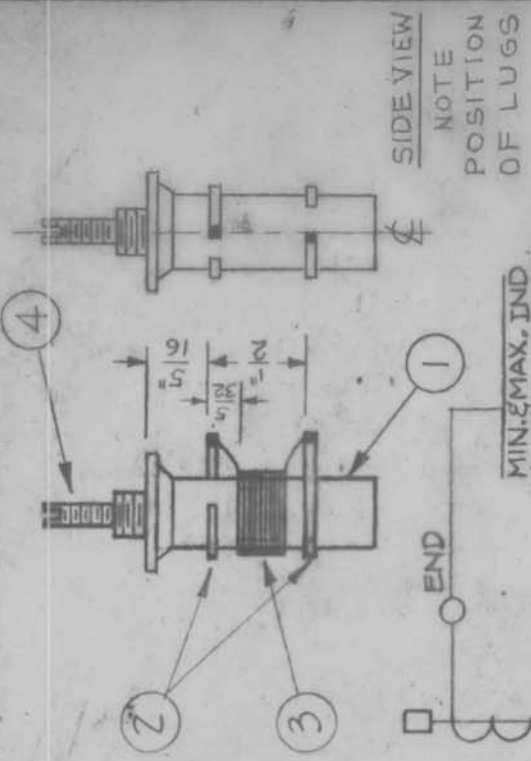
CL234 A

PROCEDURE

- 1~ SECURE TERMINALS (ITEM 2) TO COIL FORM WITH INSULEX (ITEM 5).
- 2~ WIND 14 TURNS OF ITEM 3 (WIRE) ON COIL FORM, SINGLE LAYER, CLOSE WOUND.
- 3~ STAKE WIRE ENDS TO COIL FORM WITH Q-MAX, (ITEM 4).
- 4~ SOLDER LEADS TO TERMINALS.
- 5~ BAKE FOR 1/2 HR. AT 210°F.
- 6~ PAINT COIL WITH INSULEX (ITEM 5).
- 7~ BAKE FOR 1/2 HR. AT 210°F.
- 8~ TEST UNIT AS PER CHART AND SCHEMATIC WITH CORE. MIN. MAX INDUCTANCE, ACCOMPLISHED BY ADJUSTING TUNING SLUG.

(Use Boonton Q Meter Model 160A or Equiv.)

MAX. IND. must be less than 4.5 μ h.
 MIN. IND. must be more than 1.5 μ h.
 Q at 7.9 mc must be more than 40.
 OPERATING FREQ. - 510 KC.



| REQ. ITEM | PART NO. | DESCRIPTION | SYMBOL |
|-----------|-----------|--------------|--------|
| X 6 | BS-100 | SOLDER, SOFT | |
| X 5 | GL-104-Z | INSULEX-U-85 | |
| 1 | CI-109-16 | COIL SLUG | Yellow |
| X 3 | WT-123-Z8 | WIRE | |
| 2 | TE-153-2 | TERMINAL | |
| 1 | CF-114-Z | COIL FORM | |

| | |
|--|-------------------|
| THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK | |
| ASSEMBLY | |
| TYPE & TEMPER. | HEAT TREAT. SPEC. |
| FINISH & SPEC. NO. | |
| DRAWN | CHECKED |
| ELEC. DES. APP. MECH. DES. APP. | |

| | | | | | | | |
|----------------|---------|--------|---------|---|-------|-------|-------|
| REV # | REV # | REV # | REV # | REV # | REV # | REV # | REV # |
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 |
| DATE | CH. NO. | DRAFTS | CHECKER | ENG. APP. | | | |
| 7-20-67 | 18345 | WHO | WHO | WHO | | | |
| TOLERANCES | | | | SCALE: | | | |
| 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. ± | | | | | | | |