

THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.		REQ. PER UNIT	MODEL	USED ON	DATE	CL 291	C
		2	HFR-1		4-10-62		

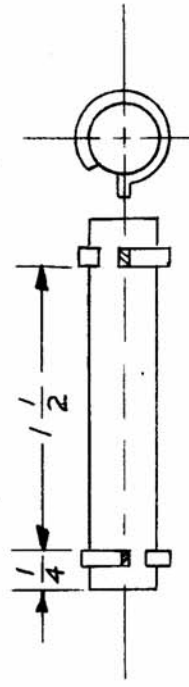
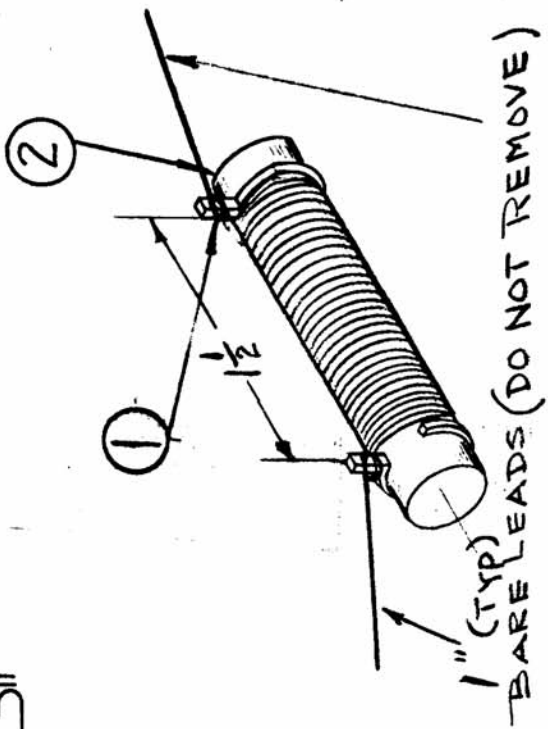
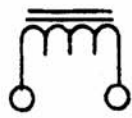
CORE & TERMINAL RING ASSEMBLY:

1. Assemble Terminal Rings (Item 1) to Ferramic Core (Item 2), Maintaining 1-1/2" Between Rings, as Shown.
2. Apply GL-104-2 (Item 3) Around Terminal Rings (Item 1).
3. Bake for One-Half Hour at 215°F.

WINDING DATA:

1. Starting Close to Terminal Ring as Shown, Solenoid Wind 53 Turns of WI-123-22 (Item 4) Onto Core Sub-Assembly, Leaving Approximately 1" Bare Lead Lengths. (Do Not Remove.)
2. Stake Leads to Terminal Rings with BS-100 (Item 5).
3. Check Inductance.
4. Saturate Coil Assembly with GL-104-2 (Item 3).
5. Bake for One-Half Hour at 215°F.

SCHEMATIC



TOP VIEW - NOTE
POSITION OF LUGS

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 5	BS-100	SOLDER, SOFT	
X 4	WI-123-22	WIRE, ELECTRICAL, MAGNET, SZ22	
X 3	GL-104-2	INSULATING VARNISH, ELECTRICAL	
1	CI-112Q1-2R0F	CORE, FINED, ROD	
2	TE-153-2	TERMINAL, LUG, RING	
		GELLMAN DESCRIPTION	
		STOCK SIZE	
		MATERIAL	
		TYPE & TEMPER	
		HEATTREAT. SPEC.	
		FINISH & SPEC. NO.	

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

CL-291 ASSEMBLY

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENGR. APP.
C	REDRAWN & UPDATED	9/18/61	20215	CV	CV	CV
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON FRAC. ± 1/64 DEC. ± .005 ANGLES ± 1/20						
SCALE:					MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES	
DRAWN			CHECKED		FINAL APPROVAL	
ELEC. DES. APP.			MECH. DES. APP.		CL 291	