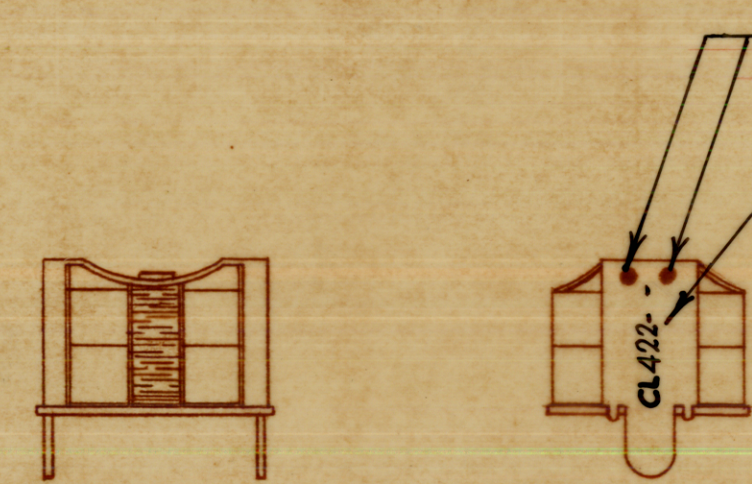


TMC PART NO.	SYMBOL	NO. OF TURNS	TEST FREQUENCY						DISTR. CAP.	COLOR CODE	BAND	REQ.
			L1 ± 1%									
			L1	F	L			Q				
			SET	MIN	MAX							
CL422-1	L1	97	100KC	1.610mH	1.48	1.625	200	1.492	13pF	—	OSC	1
CL422-2	L2	99	100KC	1.60mH	1.548	1.706	200	1.508	13pF	—	OSC	1
CL422-3	L3	82	100KC	1.19mH	1.050	1.162	200	1.238	13pF	—	OSC	1

REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
X		EXP. RELEASE	10-10-67	-	HCC	[Signature]
Ø		ORIG. RELEASE FOR PROD.	1-8-68	Ø	R.G.	[Signature]
A		L1, L2, L3 WAS L4, L5, L6	3/1/68	18807	[Signature]	EEM

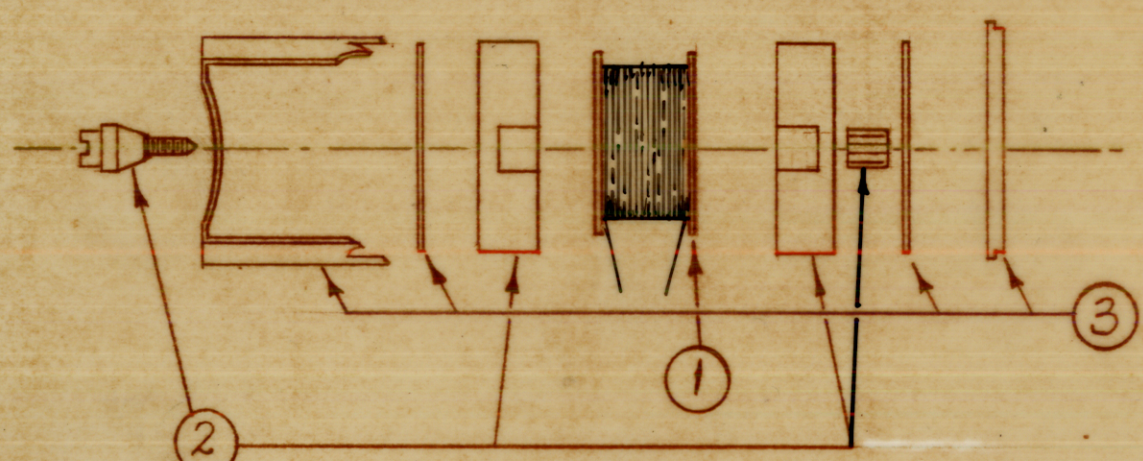


COLOR CODE (SEE CHART & NOTE *)

MARK TMC PART NO. 3/32 HIGH GOTHIC W/LATEST REV. LETTER. (SEE NOTE *)

* NOTE: MARK EACH UNIT WITH CORRESPONDING DASH NO. AND COLOR CODE.

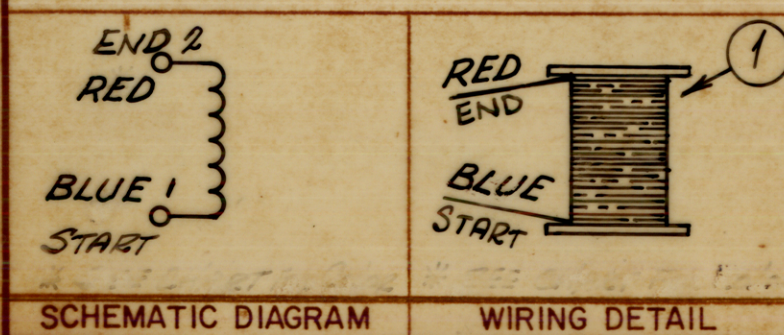
- WINDING PROCEDURE
1. WIND REQ. TURNS (SEE CHART) OF ITEM 4 ON ITEM 1 STAKE WITH ITEM 6.
 2. KEEP ALL LEADS 1-1/2" LONG.
 3. STRIP AND TIN ALL LEADS TO WITHIN 3/4" OF COIL.
 4. COLOR CODE ALL LEADS AS SHOWN IN WIRING DETAIL.
 5. BAKE COIL FOR 15 MINUTES AT 150°F. REMOVE FROM OVEN AND COAT WITH ITEM 5.
 6. ASSEMBLE ITEMS 1, 2, 3 AS PER ASSEMBLY DETAIL SHOWN.
 7. BEND THE 4 SMALL TABS DOWN, TOWARD CENTER OF COIL.
 8. STAMP TMC P/N AS SHOWN. (SEE CHART)
 9. TEST INDUCTANCE AND "Q" AS SHOWN. SET INDUCTANCE FIRST.
 10. BAKE COMPLETE ASSEMBLY FOR 1 HOUR AT 212°F.
 11. REMOVE COMPLETED ASSEMBLY FROM OVEN AND ALLOW TO COOL TO ROOM TEMPERATURE.
 12. REPEAT STEP # 9.
 13. TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE AS SHOWN.
 14. TEST COIL WITH "Q" METER TYPE 260A
 15. WAX CORE IN PLACE AFTER SETTING.



ASSEMBLY DETAIL

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
X	7	BS100	SOLDER, TIN ALLOY	
X	6	GL103	ADHESIVE - N-CEL	
X	5	GL130	ADHESIVE - Q-DOPE	
X	4	WI 104-1141-SNGS	WIRE, ELEC, LITZ	
1	3	CU158-2	RETAINER, CUP CORE	
1	2	CI 137-13	CORE, ADJ TUNING (YELLOW)	
1	1	CF195-17	FORM, COIL (BOBBIN TYPE)	

MARTINENGO LIST OF MATERIAL			
FINAL APPROVAL	[Signature]	DATE	1-8-68
MECH. DES.	[Signature]	DATE	7-5-68
ELECT. DES.	[Signature]	DATE	
CHECKED	[Signature]	DATE	1-5-68
DRAWN	H. AUSTIN	DATE	10-10-67
THE TECHNICAL MATERIEL CORP.	MAMARONECK, NEW YORK		
COIL, RF, FIXED			
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	CL422	A
SCALE	SHEET		OF



QTY / UNIT	MODEL USED ON	ASS'Y NO.
3	VLRC-1	
APPLICATION		
CODE	S401-451	
A		

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	
DECIMALS	FRACTIONS
.X ± .05	1/64
.XX ± .01	TOLS. ANGLES
.XXX ± .005	0° -30'
MATERIAL	
FINISH	