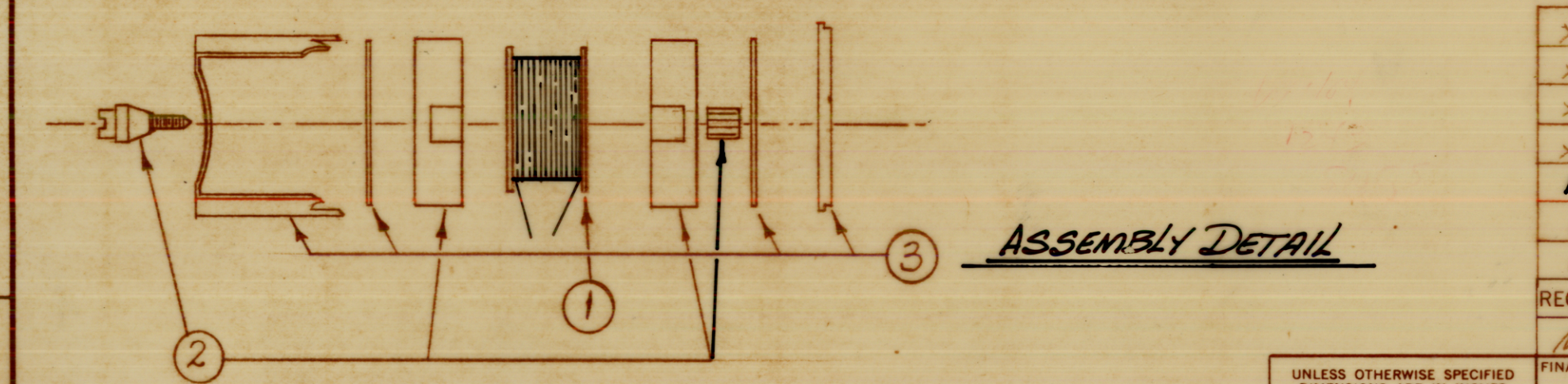
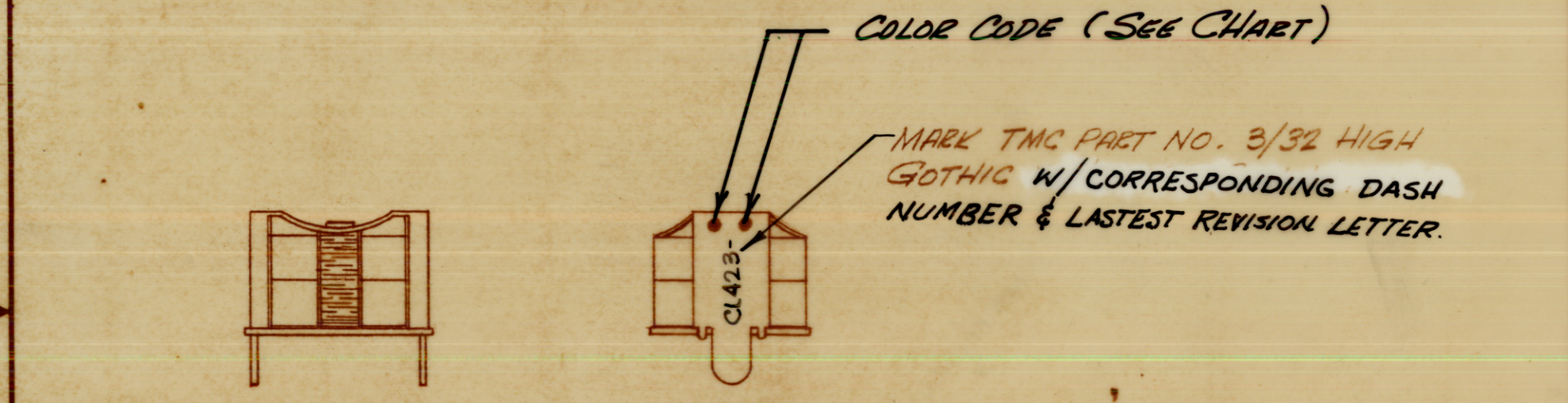


TMC PART NO.	SYMBOL	NO. OF. TURNS	TEST FREQUENCY						DISTR. CAP.	COLOR CODE	BAND	REQ.
			L1 ± 1%									
			L1	F	L		Q	R				
				SET	MIN	MAX						

REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
X		EXP. RELEASE	10-10-67		HCB	
Ø		ORIG. RELEASE FOR PROD	1-8-68	Ø	R.G.	
A		L4 WAS L7	3-11-68	18807	CAF	EPM

CL423-1	L4	110	100KC	Ø31µH	797	879.5	200	1.2	13pF	—	OSC	1
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- 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.



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	WT104-1243-SNGS	WIRE, ELEC, LITZ	
1	3	CU158-2	RETAINER, CUP CORE	
1	2	CI137-12	CORE, ADJ TUNING (RED)	
1	1	CF195-17	FORM, COIL (BOBBIN TYPE)	

MARTINENGO LIST OF MATERIAL

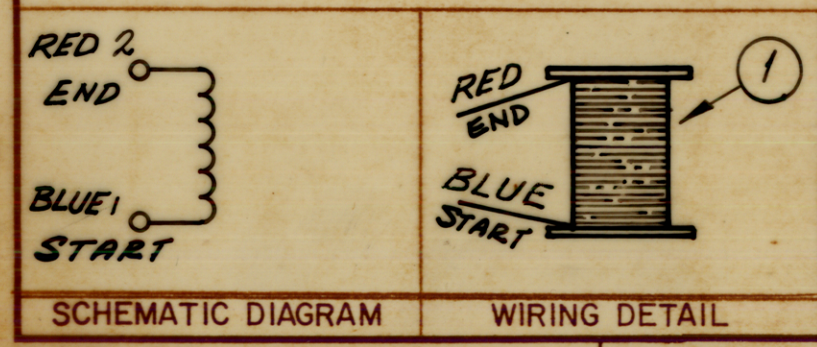
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES

FINAL APPROVAL	SFM	DATE	1-3-69
MECH. DES.	CAF	DATE	1-5-68
ELECT. DES.	CAF	DATE	
CHECKED	CAF	DATE	1-5-68
DRAWN	H. AUSTIN	DATE	10-10-67

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

COIL, RF, FIXED

SIZE	B	CODE IDENT. NO.	82679	DWG NO.	CL423	ISSUE	A
SCALE	—		SHEET		OF		



1	VLRC-1	ASS'Y NO.	
QTY / UNIT	MODEL USED ON	APPLICATION	
	CODE	5401-451	
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DECIMALS	FRACTIONS
.X ± .05	1/64
.XX ± .01	TOLS. ANGLES
.XXX ± .005	0° - 30'
MATERIAL	
FINISH	