

DATE 10/12/59
SH. 1 OF 2
COMPILED BY

TMC SPECIFICATION NO. S-457

TITLE: MODIFICATION INSTRUCTIONS FOR MODEL XFK

JOB REV. A

APPROVED   MODIFICATION KIT, TMC #144

MATERIAL REQUIRED:

<u>QUAN. REQ.</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>
1	SW-264	Switch, Mode
36 in.	MWC22(7)S6	Shielded wire, Blue
36 in.	MWC22(7)S9	Shielded wire, White
36 in.	CD-101-1-MW	Lacing Cord
1	TE-102-2	Terminal, Stand-Off
1	#30	Drill
1	LD-625	Switch, Position, Plate
1	HB-101-3	1/2 in. Cap. Plug
1	SCBS044OBC3	Screw, Machine 4-40 X 3/16
1	LWE04MRC	Lockwasher, #4
12 in.	WL-100-8	Wire, Buss
6 in.	PX-100-1-.022	Tubing
21 in.	MWC22(7)U Pink	Wire Hook-Up

1. Remove and discard toggle switch S5 mounted on the back of the unit leaving the leads of R6, 100-K and C-16, .01 uf. as long as possible.
2. Cut back the yellow and orange leads as short as possible (these leads will be replaced by shielded leads in the latter steps.).
3. Cut off all connections to S3 (three position switch) mounted on the front panel, leaving all leads emerging from the cable harness as long as possible. Remove and discard this switch.
4. Cut off the yellow lead at terminal #6 of E1 in the back of the unit.
5. Drill a hole with #30. Drill where R6 and C16 meet together.
6. Place new 5 positions switch SW-264 in place of S3 (which has been removed in step 3) their place switch position plate LD-625 on the front panel and over the switch and tighten the whole assembly.
7. Mount stand-off terminal into the hole drilled in step 5.
8. Make one 2 inch pigtail on the blue shielded wire and connect the center conductor to the stand-off (step 7) and ground the pigtail at the nearest ground lug.
9. Lay the blue shielded wire under the R. F. cables and strip the shield and wire at the other end as far as necessary to make connection with the switch mounted in step 6.
10. Make one 2 inch pigtail on the white shielded wire and connect the center conductor to the terminal #6 of E1.
11. Lay the white shielded wire under the R. F. Cable as in step 9.
12. Cut orange wire approximately at R22 which is coming from R8. Pull it out from under a few lacing switches and strip the end to move connection with the switch mounted in step 6.

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SH. 2 OF 2

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TMC SPECIFICATION NO. S

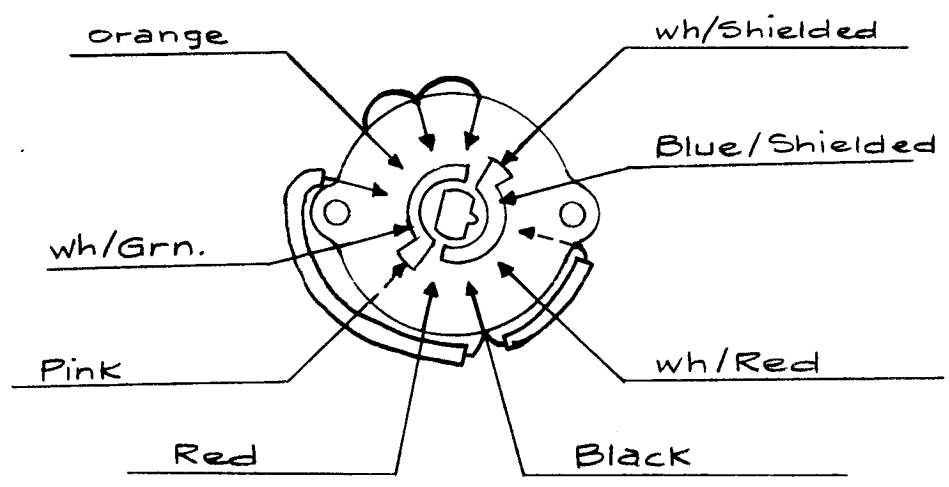
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- 13. Connect pink hook-up wire to (TB3, R23, Red Lead) and bring the other end of the wire to the switch S5 mounted in step 6.
- 14. Lace the three added wires to the cable with the lacing cord.
- 15. Connect all leads and jumpers to the switch as shown below:



- 16. Insert plug into the hole which has been created in step 1 by the removal of S5.

