

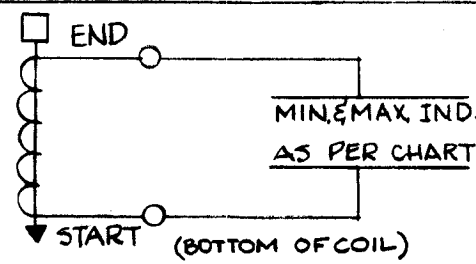
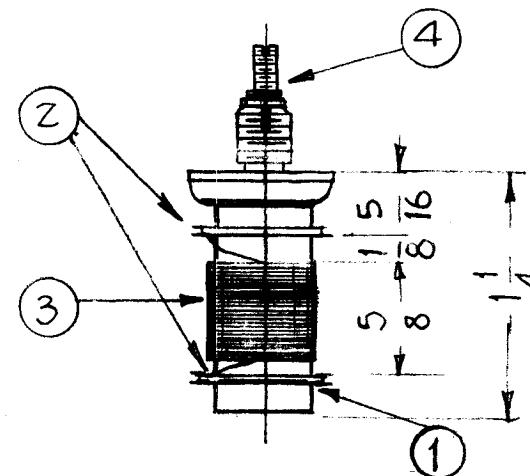
PROCEDURE

- 1~ SECURE TERMINALS (ITEM 2) TO COIL FORM WITH INSULEX (ITEM 5).
- 2~ CLOSE WIND A SINGLE LAYER OF 53 TURNS OF ITEM 3, ON COIL FORM.
- 3~ STAKE WIRE ENDS TO COIL FORM WITH 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 BOSNTON Q METER MODEL 160A or EQUIV.)

MAX. IND.- must be less than 55 μ h
 MIN. IND.- must be more than 25 μ h
 Q at 2.5 mc must be more than 75
 OPERATING FREQ. - 510 Kc.

REQ. PER UNIT	USED ON			A-1910	A
	MODEL	ASS'Y. NO.	DATE		
1	CLL-1		6-2-60		



X	6	BS-100	SOLDER SOFT	
X	5	GL-104-2	INSULEX, U85	
1	4	CI-109-21	COIL SLUG	
X	3	WI-107-15	WIRE	
2	2	TE-146-2	TERMINAL RING	
1	1	CF-129	COIL FORM	

A	ADD QTY'S & IT'S CALLOUT	11/15/66	17261	RME			
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES		SCALE:					
DEC. DIM. \pm		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES					
FRAC. DIM. \pm							
ANGULAR DIM. \pm							

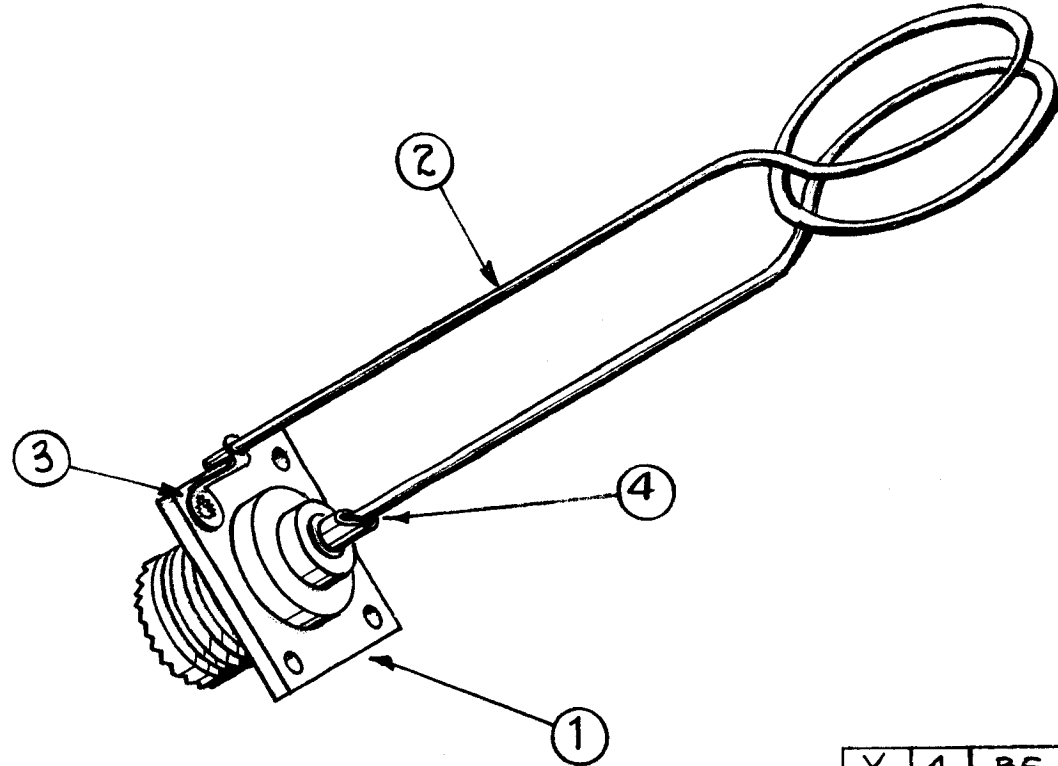
REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK CL-235 ASSEMBLY				
STOCK SIZE				
MATERIAL				
TYPE & TEMPER		HEAT TREAT. SPEC.		
FINISH & SPEC. NO.		ELEC. DES. APP		MECH. DES. APP
		P.A.		A-1910
				A

REQ. PER. UNIT	USED ON			A 1911	A
	MODEL	ASSY. NO.	DATE		
	GPT-40K	AX-209	6-9-60		

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THE TECHNICAL MATERIEL CORPORATION
MAMARONECK, NEW YORK



X	4	BS 100	Solders, Soft
1	3	TE 104-1	Lugs, Ground
1	2	CL 183	Coils, RF, Probe
1	1	SO 239A	Connector

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A		IT.1 WAS SO239A	3-1-67	17874	RME	<i>[Signature]</i>	<i>[Signature]</i>
TOLERANCES			SCALE:				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. ±							
ANGULAR DIM. ±							

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL			AJ-101 ASSEMBLY (RF CONNECTOR PROBE)	
TYPE & TEMPER		HEATTREAT. SPEC.	DRAWN	CHECKED
FINISH & S.P.		ELEC. DES. APP.	MECH. DES. APP.	
			<i>[Signature]</i>	<i>[Signature]</i>
			FINAL APPROVAL	
			A 1911	A

REQ. PER. UNIT	USED ON			A-1917	A
	MODEL	ASSY. N.	DATE		
1	GPT-40K	AR-116	11-1-60		

CLOSE WIND 14 TURNS OF
ITEM 2 (WIRE) ON ITEM 1 (CORE).

TEST —

R(DC) - .07 ohms ± 5%

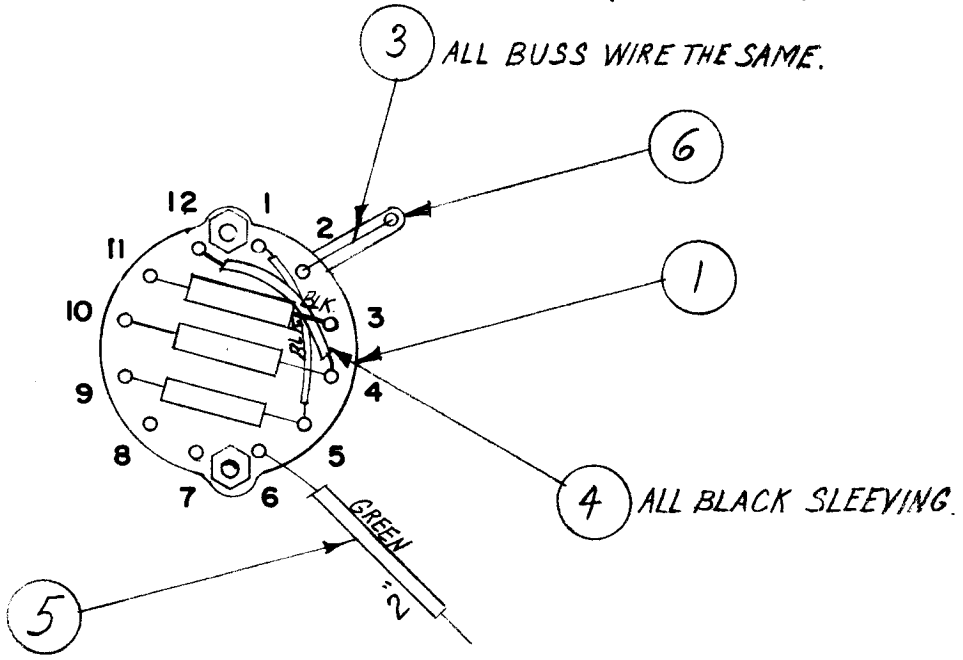
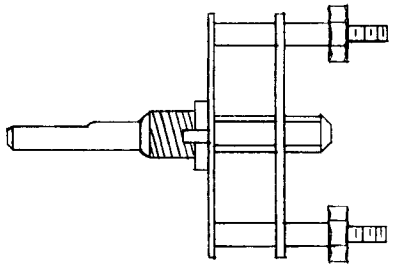


X	3	BS-100	SOLDER, SOFT		
X	2	WI-122-29	WIRE, ENAMEL, SIZE 29		
1	1	CI-114	CORE, POWDERED IRON		
REQ.	ITEM	PART NO.	DESCRIPTION		SYMBOL
			THE TECHNICAL MATERIEL CORP.		
			MAMARONECK, NEW YORK		
			AR-128 ASSEMBLY		
			SHUNT		
			DRAWN		2B
			CHECKED		
			ELEC. DES. APP		A-1917
			MECH. DES. APP		A
			FINISH & SPEC. NO.		

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	2	TEST DATA REVISED	2-1-62	6271	LL	DD	DD
	1	14 TURNS WAS 34 TURNS					
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. ±							

REQ. PER UNIT	USED ON		
	MODEL	ASSY. NO.	DATE
1	DVM-2		7-26-60
1	DVM-4		2-8-62

A-1936 A

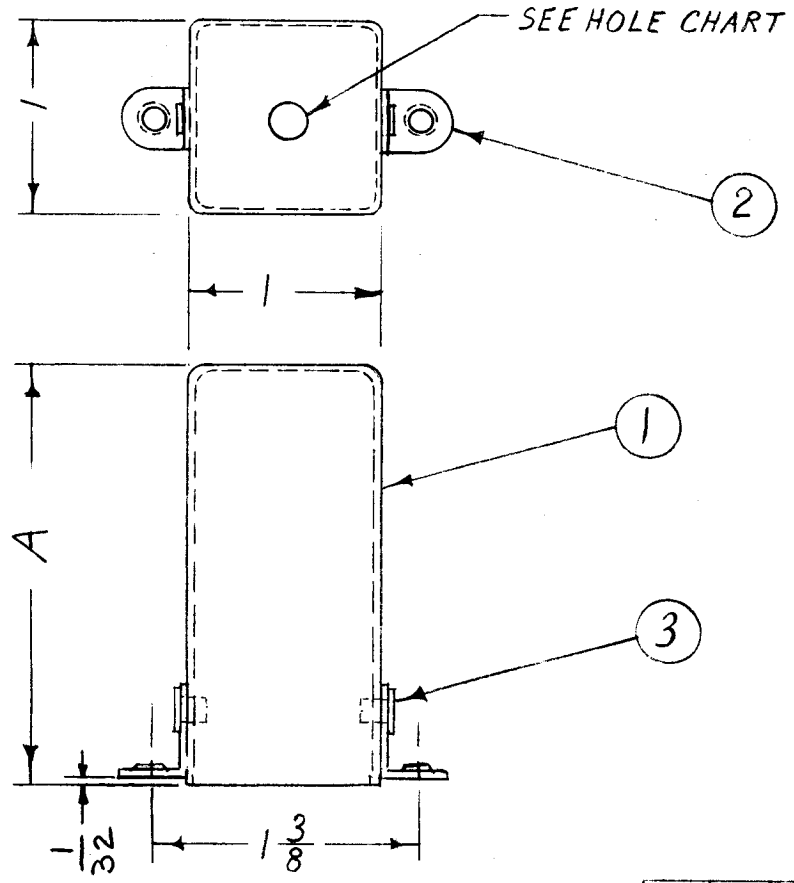


1	6	TE-111-2	LUG, SOLDER	
2"	5	PX-104-4-.034	SLEEVING, INSULATED	GRN.
	4	PX-104-1-.034	SLEEVING, INSULATED	BLK.
	3	WL-100-7	WIRE, BUSS-BAR	
3	2	RC206F821K	RESISTOR, FIXED COMPOSITION	R172, R173, R174
1	1	SW-275	SWITCH, ROTARY	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A	1	ITEMS 4 & 5 WERE PX-100	11-1-60	3333			
TOLERANCES			SCALE:				
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK SWITCH, ASSEMBLY S-101				
STOCK SIZE				
MATERIAL				
TYPE & TEMPER		HEAT TREAT. SPEC.		
FINISH & SPEC. NO.		ELEC. DES. APP		MECH. DES. APP
		DRAWN		CHECKED
		FINAL APPROVAL		
		A-1936		A

REQ. PER. UNIT	USED ON			A 1950	B
	MODEL	ASSY. NO.	DATE		
	CHG-1		8-25-60		



TMC PART NO.	ITEM	"A" HEIGHT	HOLE
A-1950-1	FP-182-1	2 1/8	3/16
A-1950-2	FP-182-2	1 3/16	1/4
A-1950-3	FP-182-3	2 1/8	1/4
A-1950-4	FP-182-4	1 3/16	3/16

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MAMARONECK, NEW YORK

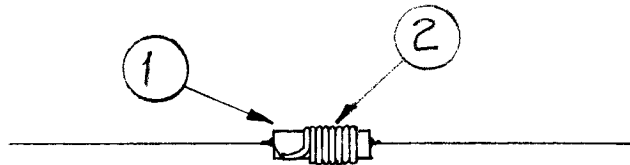
2	3	EY-100-1	EYELET, FLAT FLANGE	
2	2	TE-167	LUG, ANGLE THREADED (6-3)	
1	1	SEE CHART	CAN	
REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
STOCK SIZE			THE TECHNICAL MATERIEL CORP.	
MATERIAL			MAMARONECK, NEW YORK	
			CAN ASSEMBLY	
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP	MECH. DES. APP	

B	1/32 WAS 1/16	2-10-62	21919	GDL			
A	4 LUGS RE LOCATED	3-23-66	15999	AKH			
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE: FULL				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.				
FRAC. DIM. ± 1/64			REMOVE ALL BURRS AND SHARP EDGES				
ANGULAR DIM. ±							

REQ. PER. UNIT	USED ON		
	MODEL	ASSY. NO.	DATE
2	CHG-1	MF/RF	9-20-60
2	CHG-2	MF/RF	

A-1972 A

- SPECIFICATIONS -



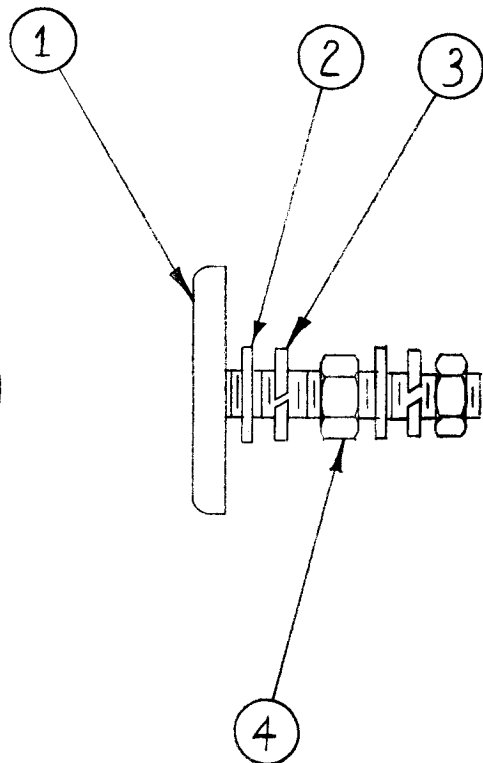
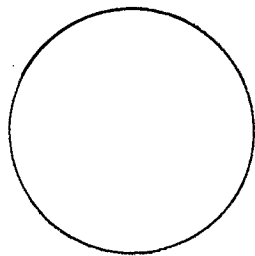
$L = .9 \text{ uhy} \pm .05 \text{ uhy}$

$Q^? = 110$

FREQ = 25 Mcs

Solenoid Winding, Close Wound.
WINDING ~ 7-1/2 TURNS (APPROX.)

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL	
								X	2	WI-107-5	DOUBLE SILK COVER WIRE		
								1	1	CI-114	CORE		
								STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
								MATERIAL		CL-241, COIL ASS'Y .9 uhy			
A	2	ON WINDING ADD. (APPROX) ON U/O INF ADDED (2) (CHG-2) (MF/RF)	3.25.64	11097	WTB	@							
TOLERANCES			SCALE:					DRAWN		CHECKED		FINAL APPROVAL	
DEC. DIM. \pm FRAC. DIM. \pm ANGULAR DIM. \pm			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES					TYPE & TEMPER		HEATTREAT. SPEC.		A-1972 A	
								FINISH & SPEC. NO.		ELEC. DES. APP		MECH. DES. APP	



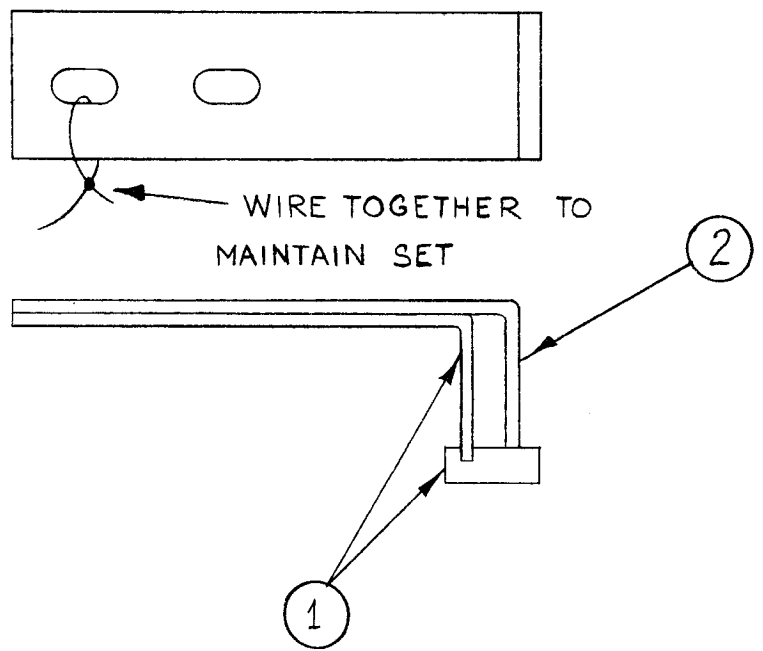
REQ. PER. UNIT	USED ON			A-1986	A
	MODEL	ASS'Y. NO.	DATE		
10	ACU		10-21-60		
5	GPT-40K		4-15-61		

2	4	NTH2520BNI4	HEXAGON NUT	
2	3	LWS25MRN	LOCKWASHER, SPLIT	
2	2	FW25HBN	WASHER, FLAT	
1	1	PM-622-1	CONTACT, SWITCH	

A	1	Items 2, 3, 4 Quan Was 1	10-31-61	5789	EB	RLL	LG	
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	
TOLERANCES			SCALE:					
DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES					

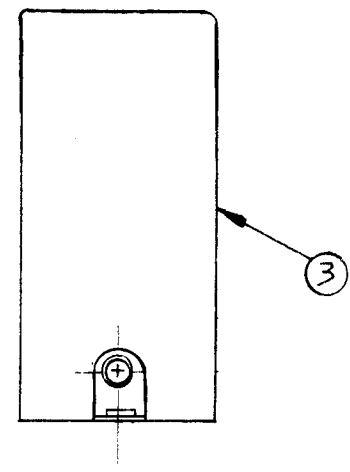
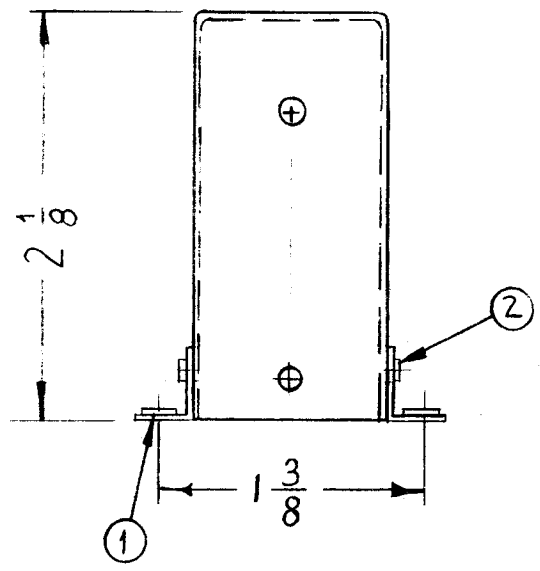
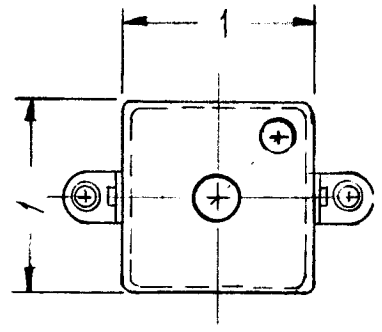
REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK AX-233 ASS'Y (CONTACT ROTARY SWITCH)				
STOCK SIZE				
MATERIAL				
TYPE & TEMPER		HEATTREAT. SPEC.	DRAWN	CHECKED
FINISH & SPEC. NO.		ELEC. DES. APP	MECH. DES. APP	
				A-1986
				A

REQ. PER. UNIT	USED ON			A-1987
	MODEL	ASS'Y. N .	DATE	
8	ACU		10-21-60	
5	GPT-40K		4-15-61	



1	2	MS-1984-2	LEAF, CONTACT												
1	1	A-1819	SHOE CONTACT ASS'Y.												
REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL											
			THE TECHNICAL MATERIEL CORP.												
			MAMARONECK, NEW YORK												
			AX-234 ASS'Y.												
			(CONTACT ASS'Y ROTOR)												
ISSUE		CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.								
TOLERANCES		SCALE:													
DEC. DIM. ±		MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES						TYPE & TEMPER		HEATTREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL		
FRAC. DIM. ±								FINISH & SPEC. NO.		ELEC. DES. APP		MECH. DES. APP			
ANGULAR DIM. ±															

REQ. PER UNIT	USED ON			A-1997	A
	MODEL	ASS'Y. NO.	DATE		
1	CHG-1	MF/RF	10-15-60		



1	3	FP-184	CAN, MACHINING
2	2	EY-100-1	EYELET
2	1	TE-167	LUG, ANGLE THREADED

A	1	REVISED TO CONFORM WITH FP-184 DRAWING	11-21-60	3512	DAW	JCB	
ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES			SCALE: FULL (DO NOT SCALE)				
DEC. DIM. ±			MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES				
FRAC. DIM. ± 1/64							
ANGULAR DIM. ±							

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
.0159			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
STOCK SIZE				
ALUMINUM			CAN ASS'Y.	
MATERIAL			BALANCED MODULATOR	
TYPE & TEMPER		HEAT TREAT. SPEC.	DRAWN	CHECKED
S404 YELL. IRIDITE				
FINISH & SPEC. NO.		ELEC. DES. APP	MECH. DES. APP	
			A-1997	A