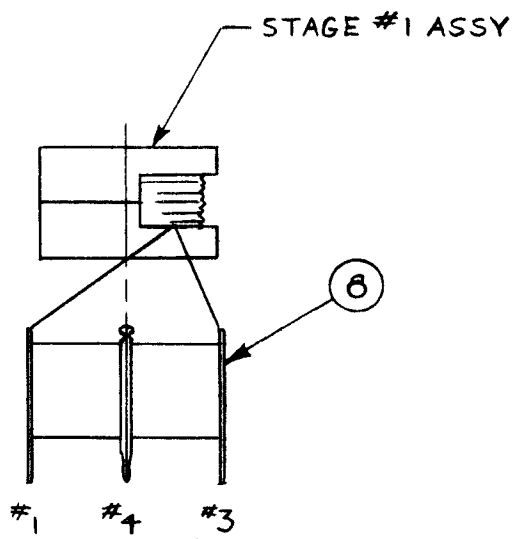
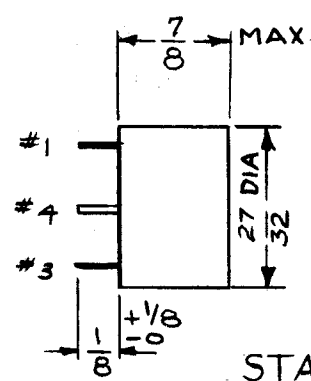


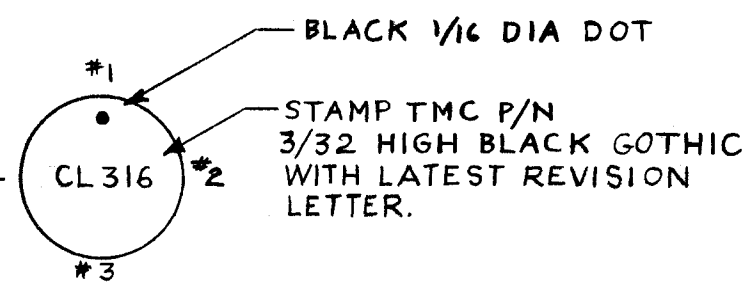
STAGE #1



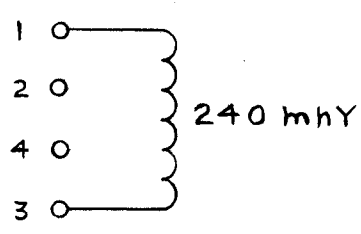
STAGE #2



STAGE #3



R	L	Q AT 1KC
24Ω APPROX	240 mHY	> 10



SCHMATIC

ABOVE READINGS TAKEN WITH GR #1650-A METER OR EQUIV.

1	VLR-1	A3168
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	
	A	

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A33550

REVISIONS						
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X1	DWG # WAS AC-175; COMPLETELY REVISED NOTE: 5; ADDED ITEM 11	12/9/63	1	JL	MP	W
0	ORIGINAL RELEASE FOR PRODUCTION	5-11-64	0	A.M.	@	

NOTES:

- SOLENOID WIND 640 TURNS, ITEM #2 ON ITEM #6 STAKE ENDS WITH ITEM #4.
- BAKE FOR 20 MINUTES AT 200°F REMOVE FROM OVEN & COAT WITH ITEM #5.
- ASSEMBLE AS PER STAGE #1, APPLY ITEM #3 ROTATE CORE TO REACH REQUIRED 'L', LET SET 2 HOURS.
- CHECK L, Q & R. (+10% -0)
- ENCAPSULATE STAGE #2 ASSY BY INSERTING INTO TMC MOLD #JG 107-1 & POTTING WITH ITEM #7.
- CHECK L, Q & R. (±10%)
- STAMP AS PER STAGE #3.

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	11	BS 100	SOLDER, SOFT	
1	10	SCBP0256BN6	SCREW, MACHINE	
1	9	NTH0256BN6	NUT, HEX	
1	8	TM124-3	TERMINAL, COLLAR	
—	7	GL128-2	COMPOUND, POTTING (RED)	
1	6	CF135-3	FORM, COIL (BOBBIN TYPE)	
—	5	GL130	CEMENT, Q DOPE	
—	4	GL103	DUCO	
—	3	GL125	EPOXY ADHESIVE	
—	2	WI 123-36	WIRE, MAGNET, HEAVY	
2	1	CI 119 TI J	CORE, CUP	

M. GELLMAN

LIST OF MATERIAL

MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH	TITLE CL 316 ASSEMBLY			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN W. Peter	DATE 5-27-63	FINAL APPROVAL
		CHECKED @	DATE 5-7-64	
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		ELECT. MECH.	DATE	
FRACTIONS ± 1/64 ± 0° 30'		TOLERANCES		
		A 3355		0
		SHEET		REV. LTR.

NOTES