

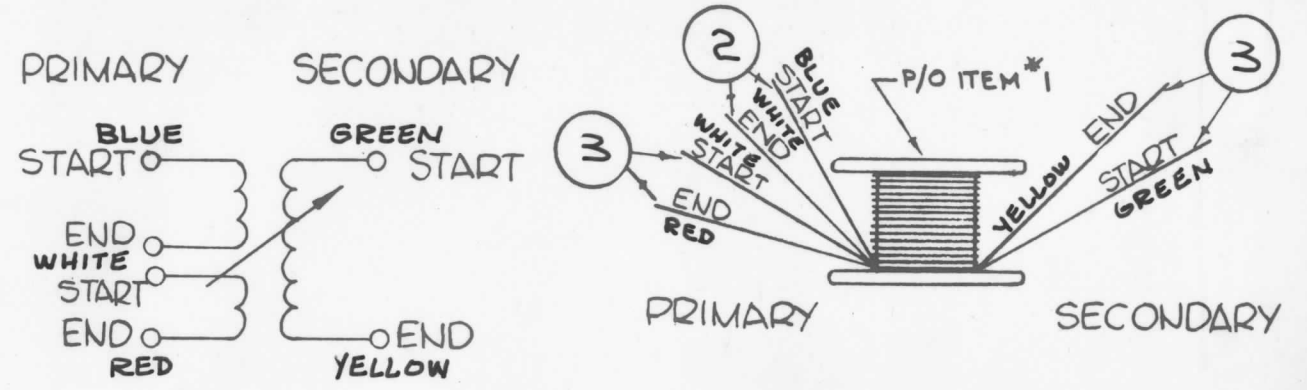
"Q" TEST FREQUENCY	"Q" MIN.	EXT. CAP. "Q" METER	NUMBER CODE	SYMBOL	INDUCTANCE 10KC BRIDGE
6.4 MC	50	—#—	—#—	—#—	5.75 μ H \pm .05 μ H

A3873

REVISIONS						
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X	EXPERIMENTAL RELEASE	11-12-64	X	<i>G. Jensen</i>		
0	ORIGINAL RELEASE FOR PRODUCTION	4-20-65	0	<i>LL</i>		

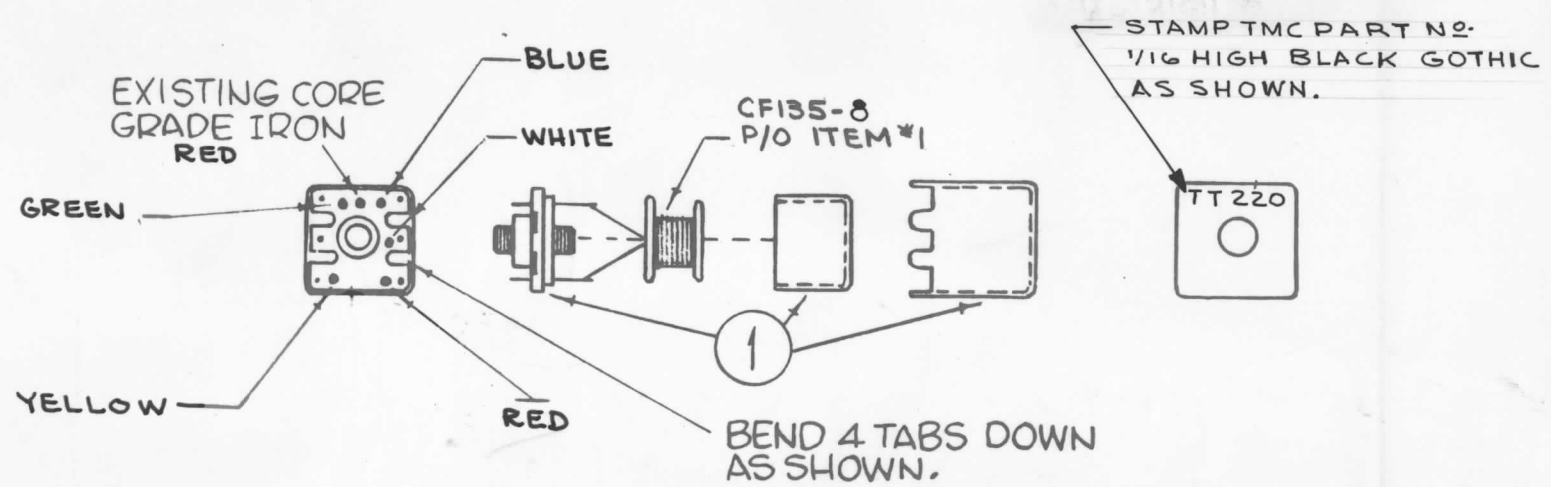
WINDING PROCEDURE

1. PRIMARY, WIND 16 TURNS OF ITEM #3 AND ITEM #2 TOGETHER BIFILAR STAKE WITH ITEM #4.
2. SECONDARY, WIND 1 TURN OF ITEM #3 OVER PRIMARY AND IN THE SAME DIRECTION, STAKE WITH ITEM #4.
3. SECONDARY, WINDING MUST BREAK OUT FROM OPPOSITE SIDE OF PRIMARY.
4. BAKE COIL FOR 15 MIN. AT 150°F REMOVE FROM OVEN AND COAT COIL WITH ITEM #5.
5. COLOR CODE TERMINALS ON BASE AS SHOWN.
6. STRIP AND TIN LEADS TO WITHIN 1/4" OF COIL.
7. PLACE BOBBIN OVER SLUG ON BASE, TAKING CARE TO POSITION NOTCHES ON RAISED PART OF BASE.
8. PRIMARY, SOLDER START OF ITEM #2 TO BLUE AND END TO WHITE, SOLDER START OF ITEM #3 TO WHITE AND END TO RED.
9. SECONDARY, SOLDER START TO YELLOW AND END TO GREEN.
10. ASSEMBLE AS PER ASSEMBLY DRAWING, PLACE IN CASE, BEND THE 4 TABS DOWN IN THE NOTCHES.
11. CUT OFF THE TWO LONG TABS.
- 12.
13. STAMP TMC PART NO. AS SHOWN BELOW.
14. TEST INDUCTANCE, AND "Q" AS SHOWN ABOVE. SET INDUCTANCE FIRST
15. BAKE COMPLETED ASSEMBLY FOR ONE HOUR AT 212°F.
16. REMOVE COMPLETED ASSEMBLY FROM OVEN AND ALLOW TO COOL TO ROOM TEMPERATURE.
17. REPEAT STEP NO. 14.
18. TEST COIL WITH A 1/4% 10KC UNIVERSAL BRIDGE.



SCHEMATIC DIAGRAM

WIRING DETAIL



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	6	BS 100	SOLDER, TIN ALLOY	
X	5	GL 130	ADHESIVE - Q-DOPE	
X	4	GL 103	ADHESIVE - N-CEL	
X	3	WI 141-34-2	WIRE, ELECTRICAL	
X	2	WI 141-34-5	WIRE, ELECTRICAL	
1	1	CI 136-3	CORE, ADJUSTABLE TUNING	

LIST OF MATERIAL

MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH	TITLE TT 220 TRANSFORMER, R.F. ADJUSTABLE			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN	DATE	FINAL APPROVAL	DATE
	<i>G. Jensen</i>	11-12-64	<i>G. Jensen</i>	
DECIMALS .X \pm .05 .XX \pm .01 .XXX \pm .005	TOLERANCES	FRACTIONS \pm 1/64 ANGLES \pm 0° 30'	ELECT. DES.	DATE
			<i>mqb</i>	
			SHEET	REV. LTR.
			A3873	0

NOTES

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