

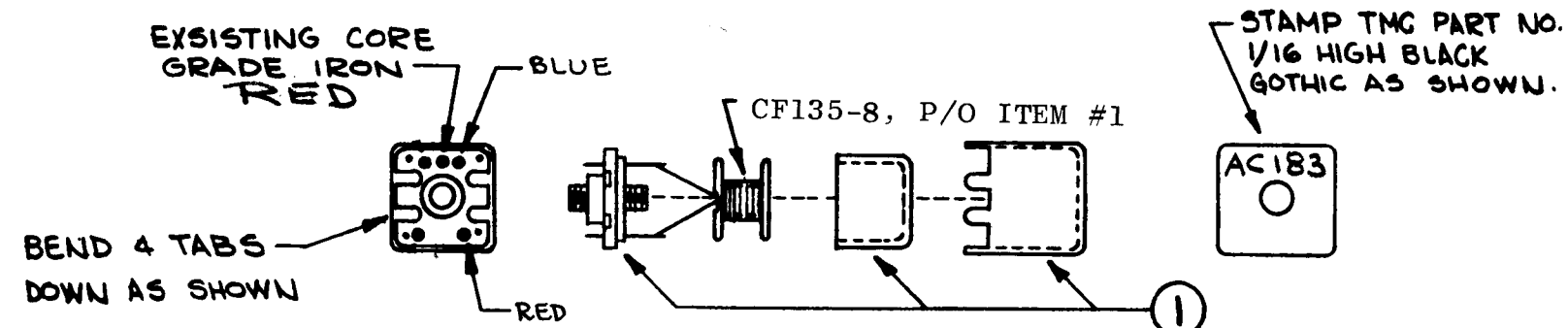
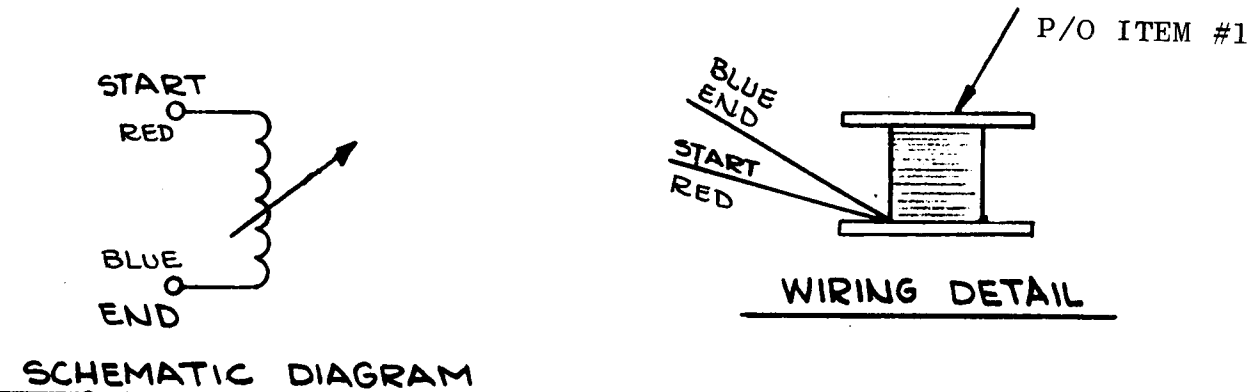
Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	NO. CODE	SYMBOL	INDUCTANCE 10KC BRIDGE
6.5 MC	80	#	#	#	6.34H ± .14H

A3890

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPER. RELEASE	6-20	X		
Ø	ORIGINAL RELEASE FOR PRODUCTION	4-20-65	Ø		

WINDING PROCEDURE

- 1- WIND 23 TURNS OF ITEM 3 ON ITEM 1, STAKE WITH ITEM 4.
- 2- BAKE COIL FOR 15 MIN. AT 150°F, REMOVE FROM OVEN AND COAT COIL WITH ITEM #5.
- 3- COLOR CODE TERMINALS ON BASE AS SHOWN.
- 4- STRIP AND TIN LEADS TO WITHIN 1/4" OF COIL.
- 5- PLACE BOBBIN OVER SLUG ON BASE, TAKING CARE TO POSITION NOTCHES ON RAISED PART OF BASE.
- 6- SOLDER ALL LEADS TO PROPER COLOR-CODED TERMINALS ON BASE.
- 7- ASSEMBLE AS PER ASSEMBLY DRAWING, PLACE IN CASE; BEND THE 4 TABS DOWN IN THE NOTCHES.
- 8- DO NOT CUT OFF THE TWO LONG TABS.
- 9- ~~DELETED~~
- 10- STAMP TMC PART NO. AS SHOWN ABOVE.
- 11- TEST INDUCTANCE, AND Q AS SHOWN ABOVE. SET INDUCTANCE FIRST
- 12- BAKE COMPLETED ASSEMBLY FOR ONE HOUR AT 212°F.
- 13- REMOVE COMPLETED ASSEMBLY FROM OVEN AND ALLOW TO COOL TO ROOM TEMPERATURE.
- 14- REPEAT STEP NO. 11.
- 15- TEST COIL WITH A 1/4% 10KC UNIVERSAL BRIDGE. (INDUCTANCE ONLY)
- 16- TUNE THE CORE INTO THE COIL TO REACH THE INDUCTANCE AS SHOWN ABOVE.
- 17- TEST COIL WITH "Q" METER 260A (FOR "Q" ONLY).
- 18- SET THE TEST FREQUENCY AS SHOWN ABOVE. AND SET THE (MULTIPLY "Q" X) TO 1.
- 19- TUNE THE INDUCTANCE DIAL. TO REACH THE MAX. READING ON THE "Q" METER.



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	6	BS-100	SOLDER, SOFT	
X	5	GL-130	ADHESIVE, Q-DOPE	
X	4	GL-103	ADHESIVE, N-CEL	
X	3	WI141-34-2	WIRE, ELECTRICAL,	
✓	2			
1	1	CI-136-2	CORE, ADJUSTABLE TUNING	

LIST OF MATERIAL			
MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
FINISH	TITLE AC183 ASSEMBLY		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN	DATE	FINAL APPROVAL
	CHECKED	DATE	DATE
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	TOLERANCES	FRACTIONS ± 1/64 ANGLES ± 6° 30'	ELECT. DES.
			MECH. DES.
DATE			DATE
SHEET			REV. LTR.

1	VLRB-1	A3653
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	
#	A	
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.		

NOTES