

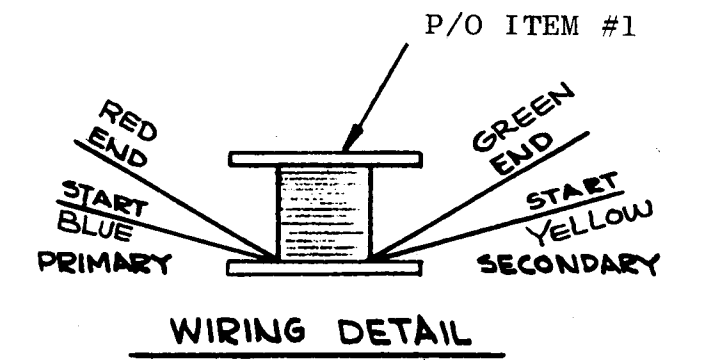
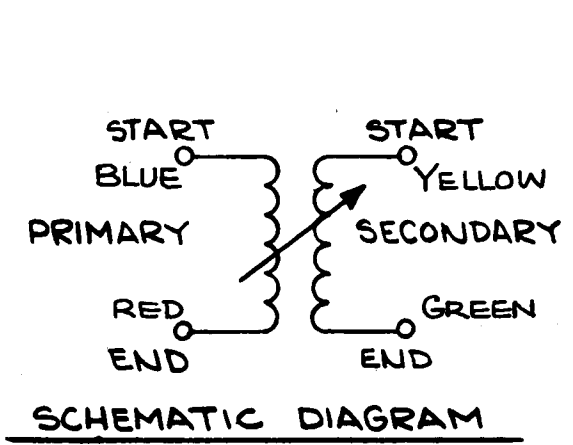
"Q" TEST FREQ.	"Q" MIN.	EXT. CAP. Q METER	SYMBOL	INDUCTANCE 10KC BRIDGE
10.0 MCS	100	—	—	2.10 μ h \pm .10 μ h

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPER. RELEASE	3-16-65	X	HCA	
Ø	ORIGINAL RELEASE FOR PRODUCTION	4-7-65	Ø	DL	

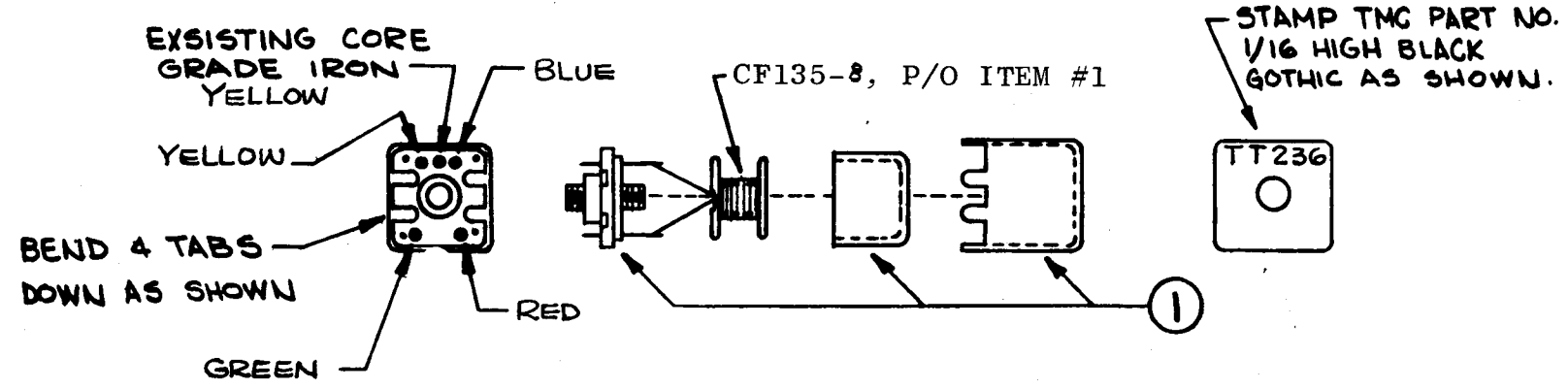
A3944

WINDING PROCEDURE

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



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	5	BS-100	SOLDER, SOFT	
X	4	GL-130	ADHESIVE, Q-DOPE	
X	3	GL-103	ADHESIVE, N-CEL	
X	2	WI-141-28-9	WIRE, ELECTRICAL,	
—	—	—	—	
1	1	CI-136-4	CORE, ADJUSTABLE TUNING	



NOTES

1	LFSB-1	A3791
QTY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE	CODE	
	A	

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LIST OF MATERIAL

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

TITLE: TT236
TRANSFORMER, RF, ADJUSTABLE

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN H. AUSTIN	DATE 3-16-65	FINAL APPROVAL	DATE
DECIMALS .X \pm .08 .XX \pm .01 .XXX \pm .008	CHECKED	DATE 3-29-65	A3944	Ø
FRACTIONS \pm 1/64 ANGLE \pm 0° 30'	ELECT. DES. MAB	DATE		
TOLERANCES	MECH. DES.	DATE	SHEET	REV. LTR.