

MODEL IT-12 Visual-Aural Signal Tracer

HEATHKIT[®]

ASSEMBLY MANUAL

Model IT-12 Visual-Aural Signal Tracer

HEATH COMPANY • BENTON HARBOR, MICHIGAN



Price \$2.00



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595-570-05

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Numérisation, Pascal Chour, 01/2004 et 11/2005.

ASSEMBLY AND OPERATION OF THE HEATHKIT VISUAL-AURAL SIGNAL TRACER MODEL IT-12



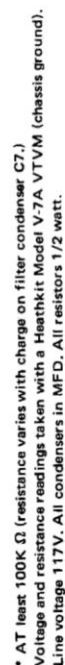
SPECIFICATIONS

Power Supply.....
Power Requirements
Tube Complement

Speaker
Probe and Test Leads

Dimensions
Net Weight

Transformer operated
117 volts AC, 50-60 cps, 25 watts.
V1 - 12AX7 high gain dual triode, input cascade amplifier.
V2 - 12CA5 beam power output tube.
V3 - 1629 electron beam visual indicator.
3 1/2" permanent magnet.
4' input lead for RF and audio w/switch in probe body.
Two 3' panel test leads with alligator clips.
4 1/2" wide x 7 1/2" high x 4" deep.
4 lbs.



**HEMATIC OF THE
HEATHKIT®
VISUAL-AURAL
SIGNAL TRACER
MODEL IT-12**

INTRODUCTION

The Heathkit Visual-Aural Signal Tracer is a compact, service-designed instrument incorporating many features that meet the everyday needs of the service technician. Some of the features and applications are listed below:

- High gain position for direct signal tracing in RF or IF circuits.
- High gain position for signal tracing in audio circuits.
- Convenient RF or audio switch in probe body.
- Tracer may be used for AM, FM, and TV circuit exploration.
- Visual signal indicator.
- Noise locator circuit.
- Utility amplifier for checking record changers, tuners, etc.
- Useful for checking microphones, musical instruments, pick-ups, and speakers.
- Substitution speaker and output transformer.
- Output level indicator.

CIRCUIT DESCRIPTION

The Heathkit Signal Tracer is a transformer operated, quality instrument, consisting primarily of a high-gain audio amplifier. A built-in 3-1/2" speaker is provided for sound and an electron ray tube permits visual observation of the output level. Additional features are RF and audio inputs in one convenient probe, noise locator circuit, and substitution speaker, and output transformer.

Observing the schematic it can be seen that the RF-audio switch S2, mounted directly in the shielded probe body, switches condenser C1 and a crystal diode in or out of the circuit for RF or audio applications. Condenser C1 isolates the crystal diode to prevent any voltage damage.

The Noise Switch S3, connects B+ to the probe lead through resistor R14 to provide the noise locator circuit. The switch S2 in the probe must be in the audio position for this function.

Signals from the probe are coupled, through condenser C2 to the gain-control R1 and in turn through condenser C3 to the input grid of VI. Condenser C2 and C3 prevent noisy operation of the gain-control.

The tube VI, 12AX7, is a high-gain dual triode with the plate of section A coupled through condenser C4 to the grid of section B.

The condenser C5 couples VI (B), to the grid of V2, 12 CA5 beam power output tube. The primary of the output transformer is center tapped and all three primary leads are brought out to terminals on the front panel. The power switch S1-B in the off position disconnects the B+ so the transformer may be used as a substitute output transformer.

The secondary leads are connected to the speaker voice coil panel terminals, and one side may be disconnected with the speaker switch S4 when the speaker is used as a substitute.

Resistor R9 and condenser C6 couple a small amount of the output signal to the grid of V3, 1629 eye tube.

The Signal Tracer is transformer operated, and uses a silicon diode in a half-wave rectifier circuit. The transformer also supplies 12.6 volts AC for the tube filaments.

CONSTRUCTION NOTES

This manual is supplied to assist you in every way to complete the instrument with the least possible chance for error. We suggest that you take a few minutes now and read the entire manual through before any work is started. This will enable you to proceed with the work much faster when construction is started. We suggest that you retain the manual in your files for future reference, both in the use of the instrument and for its maintenance.

UNPACK THE KIT CAREFULLY AND CHECK EACH PART AGAINST THE PARTS LIST. In so doing, you will become acquainted with each part. Refer to the charts and other information shown on the inside covers of the manual to help you identify any parts about which there may be a question. If some shortage is found in checking the parts, please notify us promptly.

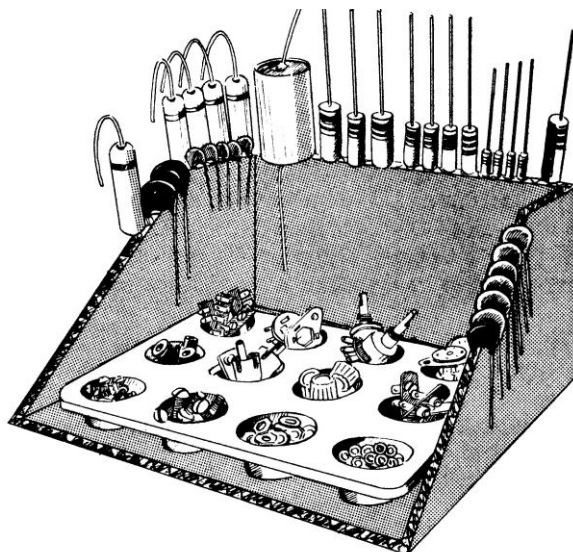
Resistors generally have a tolerance rating of 10 unless otherwise stated in the parts list. Therefore a 100 K Ω resistor may test anywhere from 90 K Ω , to 110 K Ω . (The letter K is commonly used to designate a multiplier of 1000.) Tolerances on condensers are generally even greater. Limits of +100 and -20 are common for electrolytic condensers. The parts furnished with your Heathkit have been specified so as to not adversely affect the operation of the finished instrument.

The Signal Tracer is not difficult to construct but it is extremely important that particular emphasis be placed on the desirability of following parts placement and wiring dress as shown in the manual. This is important in order that the operation of the Signal Tracer be hum free and that a motor boating condition is not induced. The wiring dress and parts layout in the manual has been proven thoroughly satisfactory through the construction of a series of laboratory models. While the arrangement shown is probably not the only satisfactory layout, it is the result of considerable experimentation and trial. If followed carefully, it will result in a stable instrument operating at a high degree of accuracy and dependability.

We suggest you do the following before work is started:

1. Attach the large fold-in pictorials to the wall above your workbench.
2. Go through the entire assembly and wiring instructions. This is an excellent time to read the entire construction section through and familiarize yourself with the procedure.
3. Lay out all parts so that they are readily available. Refer to the general information inside the front and back covers of this manual to help you to identify components

Most kit builders find it helpful to separate the various parts into convenient categories. Muffin tins or molded egg cartons make convenient trays for small parts. Resistors and capacitors may be placed in the edge of a piece of corrugated cardboard until they are needed. Values can be written on the cardboard next to each component. The illustration shows one method that may be used.



Leads on resistors, capacitors and transformers are generally much longer than they need to be to make the indicated connections. In these cases, the excess leads should be cut off before the part is added to the chassis. In general, the leads should be just long enough to reach their terminating points. Not only does this make the wiring much neater but in many instances, the excessively long leads will actually interfere with proper operation of the instrument.

Space has been provided for you to check off each operation as it is completed. This is particularly important in wiring and it may prevent omissions or errors, especially where your work is interrupted frequently as the wiring progresses. Some kit builders have also found it helpful to mark each lead in colored pencil on the pictorial as it is added.

Unless otherwise indicated, all wire used is insulated. Wherever there is a possibility of the bare leads on resistors and capacitors shorting to other parts or to chassis, the leads should be covered with insulated sleeving. This is indicated in the instructions by the phrase "use sleeving." Bare wire is used where the lead lengths are short and the possibility of short circuits are non-existent.

ROSIN CORE SOLDER HAS BEEN SUPPLIED WITH THIS KIT. THIS TYPE OF SOLDER MUST BE USED FOR ALL SOLDERING IN THIS KIT. ALL GUARANTEES ARE VOIDED AND WE WILL NOT REPAIR OR SERVICE EQUIPMENT IN WHICH ACID CORE SOLDER OR PASTE FLUXES HAVE BEEN USED. IF ADDITIONAL SOLDER IS NEEDED, BE SURE TO PURCHASE ROSIN CORE (60:40 or 50:50 TIN-LEAD CONTENT) RADIO TYPE SOLDER.
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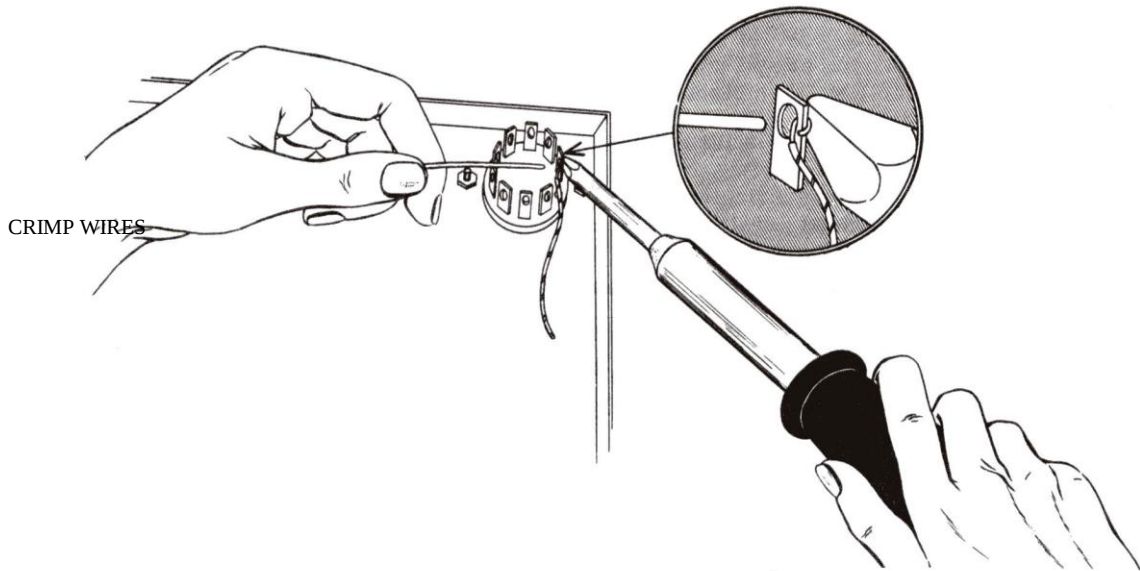
PROPER SOLDERING PROCEDURE

Only a small percentage of Heathkit purchasers find it necessary to return an instrument for factory service. Of these, by far the largest proportion function improperly due to poor or-improper soldering.

Correct soldering technique is extremely important. Good solder joints are essential if the performance engineered into the kit is to be fully realized. If you are a beginner with no experience in soldering, a half-hour's practice with odd lengths of wire and a tube socket will be a worthwhile investment.

If terminals are bright and clean and wires free of wax, frayed insulation and other foreign sub-stances, no difficulty will be experienced in soldering. Crimp or otherwise secure the wire (or wires) to the terminal, so a good joint is made without relying on solder for physical strength.

To make a good solder joint, the clean tip of the soldering iron should be placed against the joint to be soldered so that the terminal is heated sufficiently to melt solder. The solder is then placed against both the terminal and the tip of the iron and will immediately flow out over the joint. Refer to sketches on page 6 and 7. Use only enough solder to cover wires at the junction; it is not necessary to fill the entire hole in the terminal with solder. Excess solder may flow into tube socket contacts, ruining the socket, or it may creep into switch contacts and destroy their spring action. Position the work so that gravity tends to keep the solder where you want it.

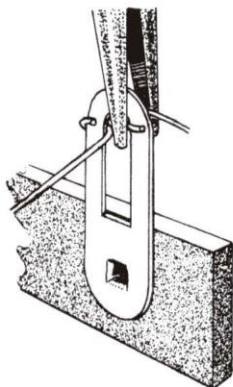


A poor solder joint will usually be indicated by its appearance. The solder will stand up in a blob on top of the connection with no evidence of flowing out caused by actual "wetting" of the contact. A crystalline or grainy texture on the solder surface, caused by movement of the joint before it solidified is another evidence of a "cold" connection. In either event, reheat the joint until the solder flows smoothly over the entire junction, cooling to a smooth, bright appearance. Photographs in the adjoining picture clearly indicate these two characteristics.

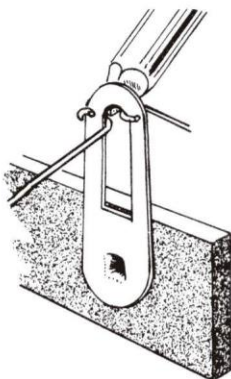


A good, clean, well-tinned soldering iron is also important to obtain consistently perfect connections. For most wiring, a 25 to 100 watt iron, or the equivalent in a soldering gun, is very satisfactory. Smaller irons generally will not heat the connections enough to flow the solder smoothly over the joint and are recommended only for light work, such as on etched circuit boards, etc. Keep the iron tip clean and bright. A pad of steel wool may be used to wipe the tip occasionally during use.

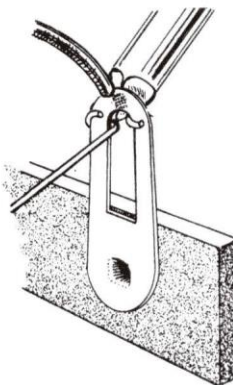
HOW TO MAKE PROPER SOLDER CONNECTION



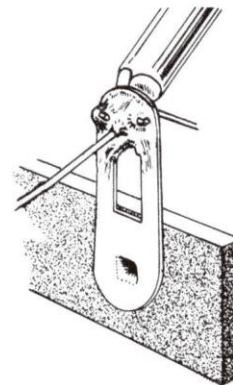
CRIMP WIRES



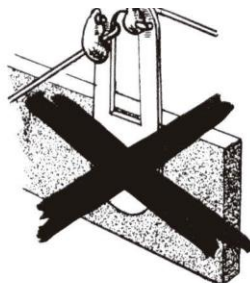
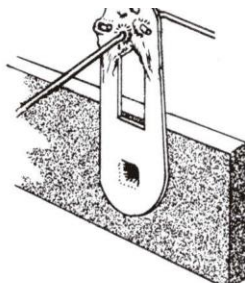
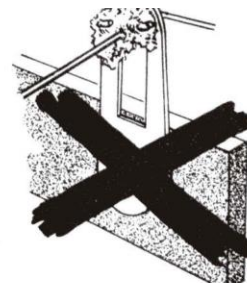
HEAT CONNECTION



APPLY SOLDER


ALLOW SOLDER
TO FLOW

Take these precautions and use reasonable care during assembly of the kit. This will insure the wonderful satisfaction of having the instrument operate perfectly the first time it is turned on.


COLD SOLDER JOINT
CONNECTION INSUFFICIENTLY
HEATED

PROPER SOLDER
CONNECTION

COLD SOLDER JOINT
CONNECTION MOVED
WHILE COOLING

IMPORTANT

In the step-by-step procedure the abbreviation "NS" indicates that the connection should not be soldered as yet, for other wires will be added. "When the last wire is installed, the terminal should be soldered and the abbreviation "S" is used to indicate this. Note that a number appears after each solder (S) instruction. This number indicates the number of leads connected to the terminal in question. For example, if the instructions read, "Connect one lead of a 47 KO resis-tor to lug 1 (S2)" it will be understood that there will be two leads connected to the terminal at the time it is soldered. This additional check will help avoid errors.

Use lockwashers under all 6-32 and 8-32 nuts. Lockwashers should be placed between controls and the chassis. When solder lugs are mounted under 6-32 nuts, the use of lockwashers is unnecessary.

Don't apply too much solder to the solder joint. Don't apply the solder to the iron only, expecting that it will roll down to the connection. Try to follow the instructions and illustrations as closely as possible.

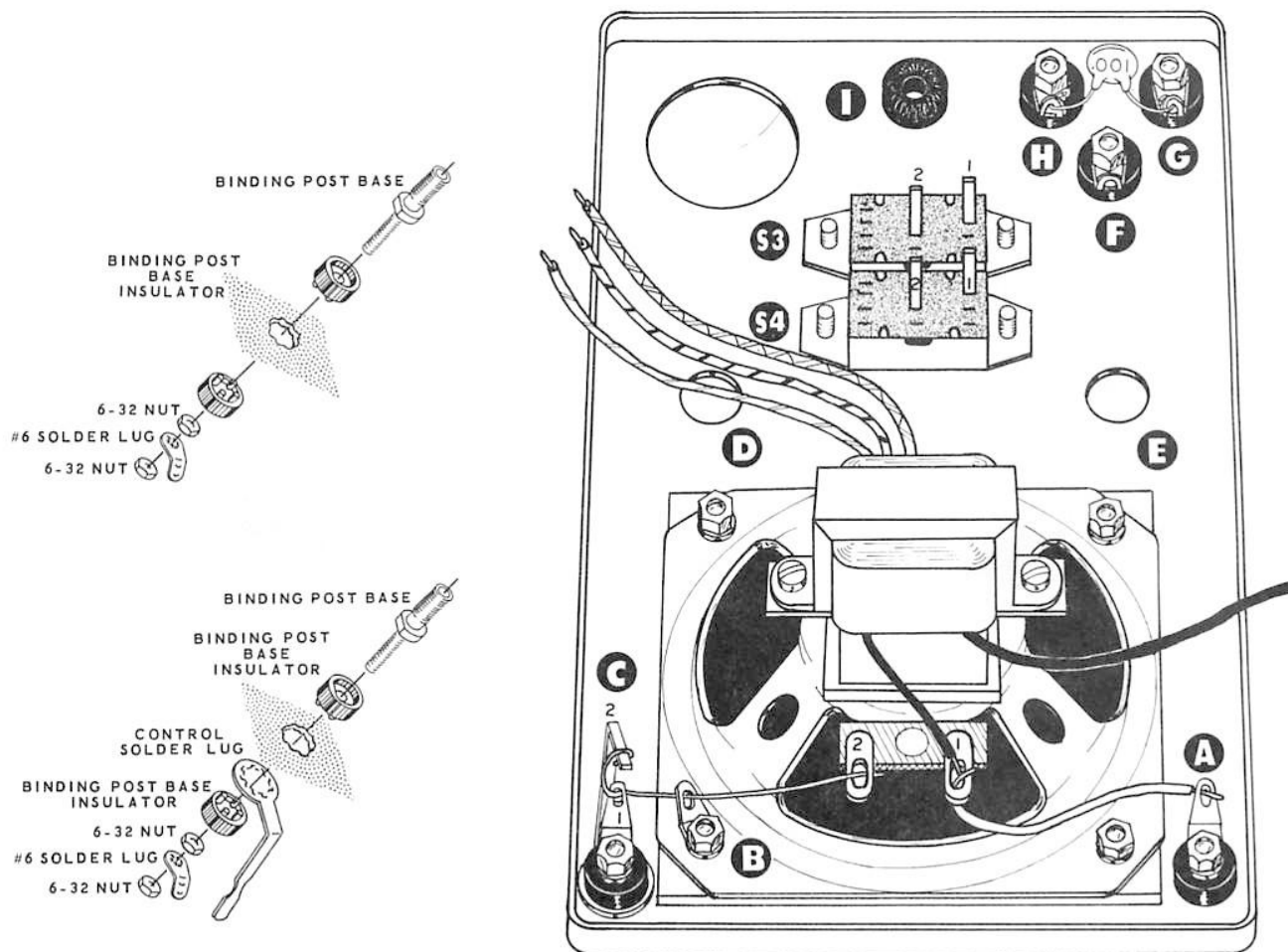
Don't bend a lead more than once around a connecting point. If it should have to come off due to a mistake or for maintenance it will be much easier to remove.

Keep your soldering iron clean. Wipe it quickly from time to time with steel wool or a rag.

When two or more connections are made to the same solder lug a common mistake is to neglect soldering the connections on the bottom. Make sure all the wires are soldered.

PANEL ASSEMBLY

- () Locate the short 6/32 screw and set aside to be used later.
- () Locate the front panel and position it as shown in Pictorial 1.
- () Mount binding post A using a 6-32 nut. Position solder lug as shown in Pictorial 1.
- () In like manner, mount binding post F, G and H.



PICTORIAL 1

- () Mount binding post C with a control solder lug under the bushing. See Pictorial 1.
- () Mount the speaker switch S4 as shown in Pictorial 1. Use 6-32 screws.
- () In like manner, mount the noise switch S3.
- () Insert the 3/8 grommet I.
- () Connect one lead of a .001 ceramic disc condenser to terminal H (NS). Connect the other lead to terminal G (NS).

() Mount the output transformer on the speaker so the two black wires are next to the voice coil terminals. Use 6-32 hardware.

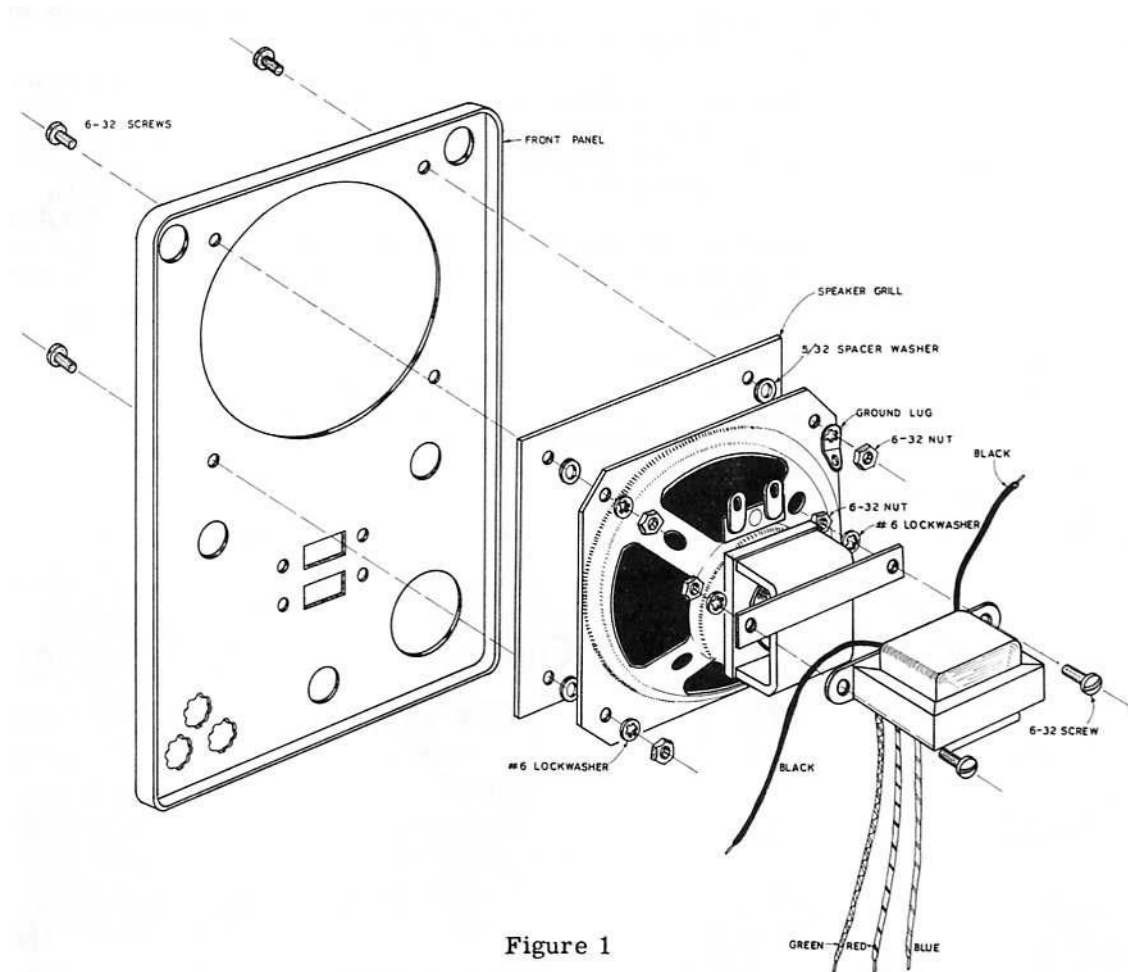


Figure 1

() Mount the speaker and the speaker grill to the panel. Place a spacer washer between speaker and grill. At the same time mount ground lug B. Use 6-32 hardware.

() Connect one end of a 3" length of bare wire to speaker lug 2 (S1). Feed the other end thru ground lug B (S2) thru terminal lug C1 (S2) and wrap around panel ground lug C2 (S1).

() Cut one of the black leads of the output transformer to length, strip the end and connect to speaker lug 1 (NS).

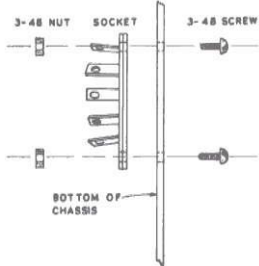
() Connect one end of a 2" length of hookup wire to terminal lug A (S1). Connect the other end to speaker lug 1 (S2).

This completes the panel assembly and wiring. Set aside to be mounted on the chassis later.

CHASSIS ASSEMBLY

NOTE: When mounting wafer tube sockets, be sure to mount each socket from the top of the chassis. If by mistake the sockets are mounted so the lugs pass through the chassis, they will short to the chassis where they pass through the mounting hole.

7 & 9 PIN SOCKET MOUNTING

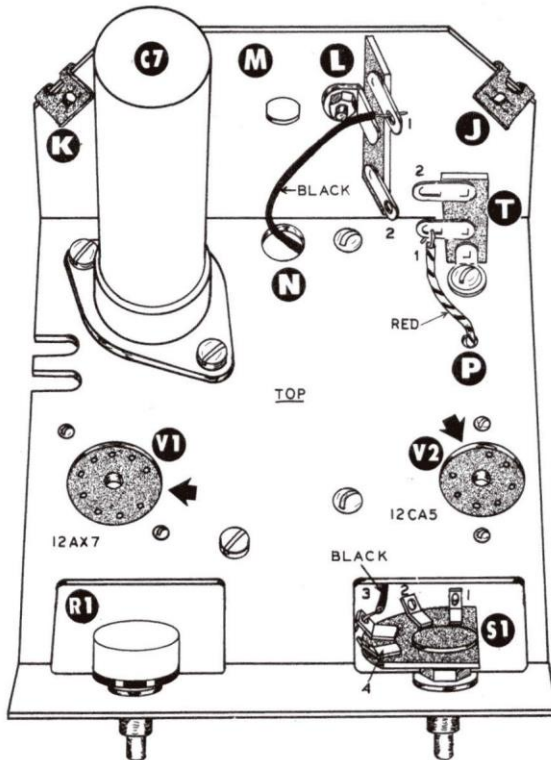
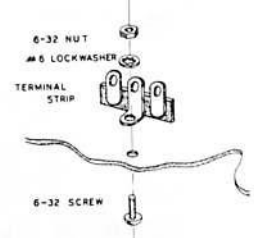


() Mount the 9 pin wafer tube socket V1 on the underside of the chassis as shown in Pictorial 3. Use 3-48 hardware. (Nolockwash-ers are used with 3-48 hardware.)

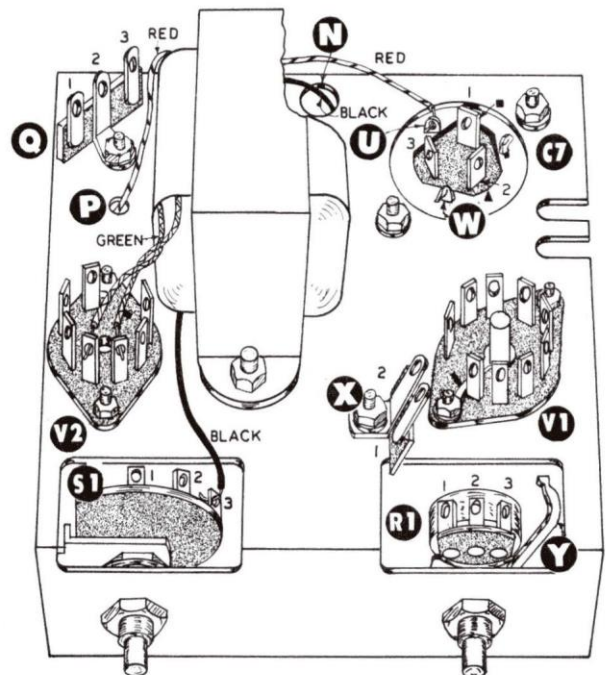
() In like manner mount the 7 pin wafer tube socket V2 as shown in Pictorial 3. Use 3-48 hardware.

() Mount the C7 condenser mounting wafer on top of the chassis, observing ground lug slot location as shown in Pictorial 3. Use 6-32 screws, lockwashers and nuts.

TERMINAL STRIP MOUNTING



PICTORIAL 2



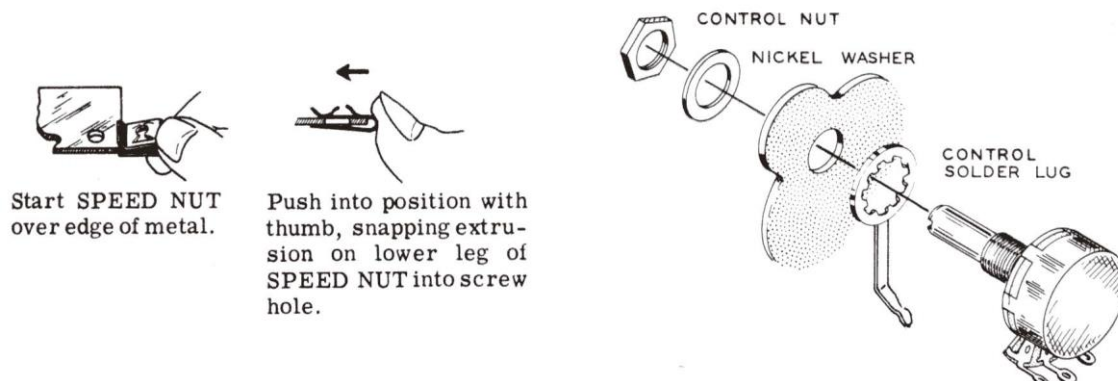
PICTORIAL 3

() Mount the 2 lug terminal strip X. Use 6-32 hardware.

() Turn the chassis over and mount the 2 lug terminal strip at L.

() Mount the 2 lug vertical terminal strip T and at the same time mount the 3 lug terminal strip Q. Use 6-32 hardware.

() Slip the two speed nuts J and K over the corners of the rear apron of the chassis. Make sure that the flat side of the clip is towards the back and the holes in the clips are centered over the holes in the chassis.



() Temporarily, mount the 1 meg level control R1 using a control solder lug. Position as shown in Pictorials 2 and 3.

() In like manner mount the off-on switch S-1 using a control lockwasher between chassis and switch.

() Mount the filter condenser C7 so the lug marked with a square is towards the rear of the chassis. Twist the mounting lugs 1/8 turn only.

() Mount the power transformer on the bottom side of the chassis with the wires towards the V2 tube socket. Use 8-32 hardware.

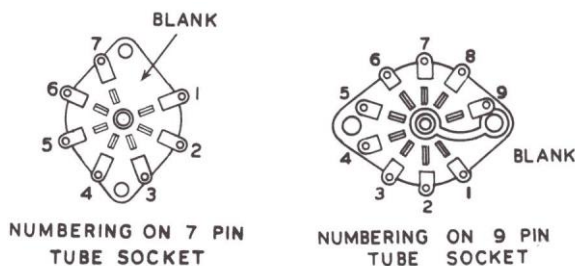
This completes the parts mounting, check all parts for correct position and make sure all screws and nuts are tightened securely.

CHASSIS WIRING

() Connect the short black wire of the power transformer to lug 3 (S1) of the off-on switch S1.

() Twist the two green filament wires of the transformer together, and connect one wire to pin 3 (NS) and the other wire to pin 4 (NS) of tube socket V2.

() Connect one red transformer wire to ground lug U (NS) of condenser C7.

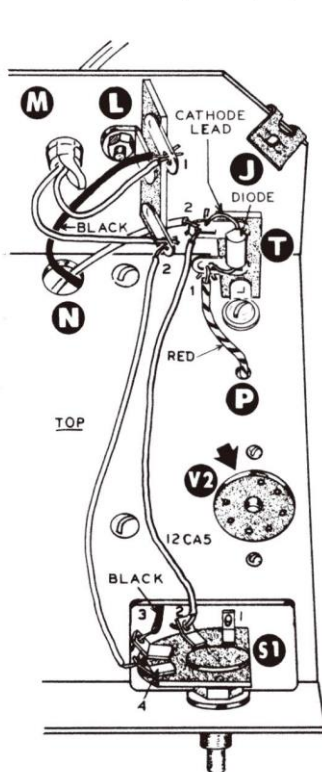


() Feed the other red wire from the power transformer through hole P and connect to lug 1 (NS) of terminal strip T.

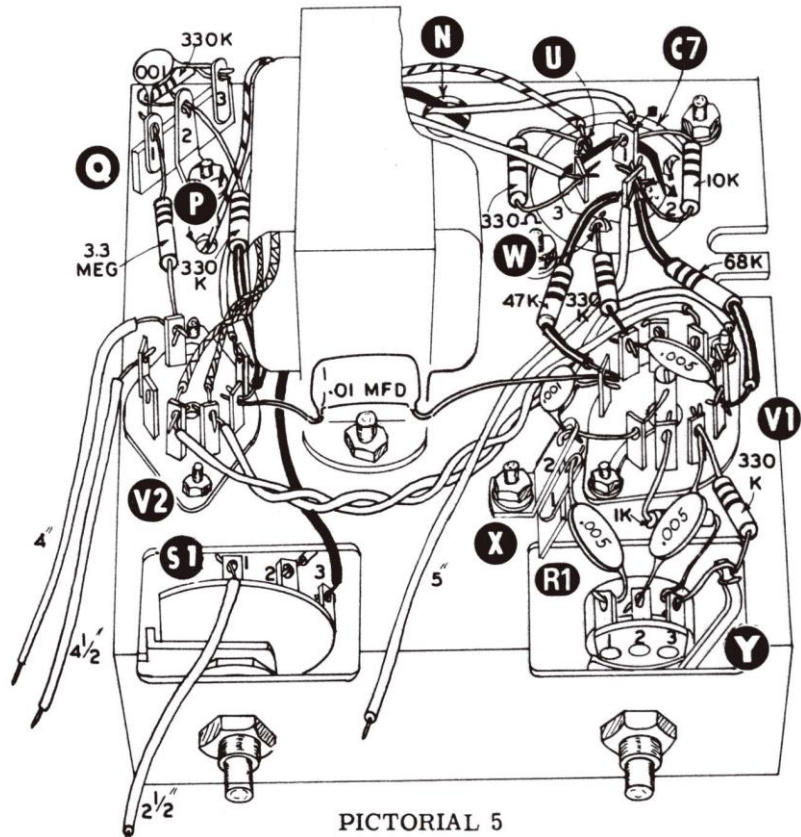
() Feed the remaining black wire through hole N and connect to lug 1 (NS) of terminal strip L.

() Connect one end of a 2" length of bare wire to pin 3 (SI) of VI tube socket. Feed the other end through the center ground lug (S2), through pin 9 (S2) and connect to lug 2(NS) of terminal strip X.

() Cut two 6" lengths of hookup wire and strip both ends. Twist the wires together and connect one wire to pin 3 (S2) of tube socket V2. Connect the other wire to pin 4 (S2). Connect the other ends to pin 4 (NS) and 5 (NS) of socket VI.



Pictorial 4



PICTORIAL 5

() Connect one end of a 4-1/2" length of hookup wire to pin 1 (SI) of V2. Connect the other end to lug 3 (NS) of filter condenser C7.

() Connect one lead of a 330 ohm resistor (orange-orange-brown) to lug 3 (S2) of C7. Connect the other lead to ground lug U (S2).

() Connect one lead of a 10 K ohm resistor (brown-black-orange) to lug 1 (NS) of C7. Con-nect the other lead to lug 2 (NS).

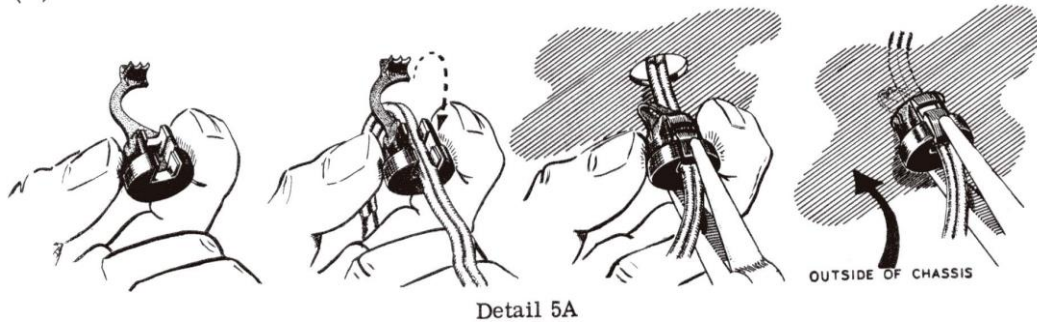
() Strip both ends of a 5" length of hookup wire, and connect one end to lug 2 (NS) of C7. Dress the wire towards the front of the chassis.

() Connect one lead of a 330 K ohm resistor (orange-orange-yellow) to pin 2 (NS) of socket VI. Connect the other lead to ground lug W (SI).

() Connect one lead of a 47 K ohm resistor (yellow-violet-orange) to pin 1 (NS) of socket VI. Connect the other lead to lug 2 (NS) of C7. Use sleeving on both leads.

- () Connect one lead of a 68 K ohm resistor (blue-grey-orange) to pin 6 (NS) of VI.
- () Connect the other lead to lug 2 of C7 (S4). Use sleeving on both leads. Connect one lead of a .005 mfd ceramic disc condenser to pin 2 (S2) of VI. Connect the other lead to pin 6 (S2).
- () Feed one lead of a 1 K ohm resistor (brown-black-red) through lug 3 (S2) of the level control R1 and wrap around the control solder lug Y (NS). Connect the other lead to pin 8 (S1) of VI.
- () Connect one lead of a 330 K ohm resistor (orange-orange-yellow) to pin 7 (NS) of VI. Wrap the other lead around solder lug Y (S2).
- () Connect one lead of a .005 mfd ceramic condenser to pin 7 (S2) of VI. Connect the other lead to lug 2 (S1) of control R1.
- () Connect one lead of a .005 mfd ceramic condenser to lug 1 (S1) of control R1. Connect the other lead to lug 1 (NS) of terminal strip X.
- () Connect one lead of a .001 mfd ceramic disc condenser to pin 1 (NS) of socket VI. Connect the other lead to lug 2 (NS) of terminal strip X.
- () Connect one lead of a .01 mfd condenser to pin 1 (S3) of tube socket VI. Connect the other lead to pin 2 (NS) of tube socket V2.
- () Connect one lead of a 330 K ohm resistor (orange-orange-yellow) to pin 2 (S2) of socket V2. Use sleeving. Connect the other lead to lug 2 (NS) of terminal strip Q.
- () Connect one lead of a 330 K ohm resistor (orange-orange-yellow) to lug 3 (NS) of terminal strip Q. Connect the other lead to lug 2 (NS).
- () Connect one lead of a .001 mfd ceramic condenser to lug 1 (NS) of terminal strip Q. Connect the other lead to lug 3 (NS).
- () Connect one lead of a 3.3 megohm resistor (orange-orange-green) to lug 1 (S2) of terminal strip Q. Connect the other lead to pin 7 (NS) of tube socket V2.
- () Strip both ends of a 4" length of wire and connect one end to pin 7 of V2 (S2). Dress the wire towards front of chassis.
- () Strip both ends of a 4 1/2" length of wire and connect one end to pin 6 (S1) of V2. Dress towards the front center of chassis.
- () Strip both ends of a 2 1/2" length of wire and connect one end to lug 1 (S1) of switch S1.
- () Connect one end of a 4 1/2" length of wire to lug 1 (NS) of condenser C7. Feed the other end through hole N and connect to lug 2 (NS) of terminal strip T on the top side of the chassis.
- () Connect one end of a 5 1/2" length of wire to lug 2 (NS) of terminal strip T. Connect the other end to lug 2 (S1) of switch S1.
- () Connect one end of a 5" length of wire to lug 2 (NS) of terminal strip L. Connect the other end to lug 4 (S1) of switch S1.
- () Connect the cathode lead of a silicon diode to lug 2 (S3) and the other lead to lug 1 (S2) of terminal strip T. The cathode end is marked with a color end, a color dot, or a color band.
- () Pass the line cord through hole M. Connect one wire to lug 1 (S2) and the other wire to lug 2 (S2) of terminal strip L.

() Install the line cord strain relief in hole M. See Detail 5A.



PREPARING THE EYE TUBE ASSEMBLY

() Start the two #6 sheet metal screws in the eye tube mounting bracket.

() Clip off the prongs of the spring tube holder as indicated in Figure 2.

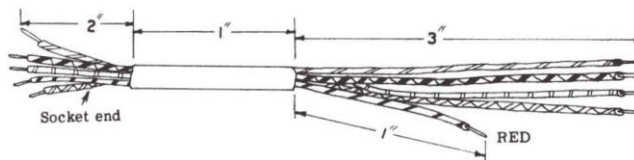
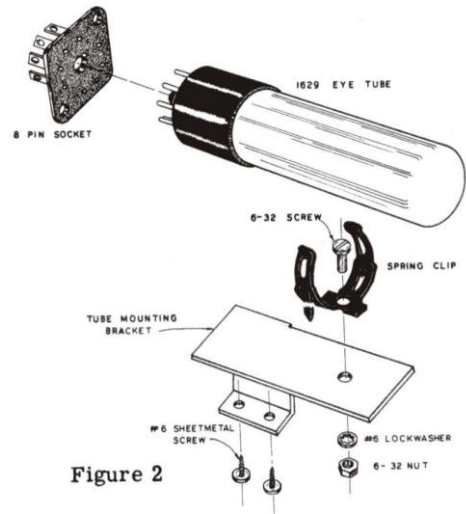
() Mount the spring tube holder on the bracket using the short 6-32 screw and a lockwasher and nut.

() Prepare the 8 pin wafer tube socket by bending the lugs as shown with a pair of long nose pliers.

() Connect one end of a 1 meg resistor (brown-black-green) to pin 3 (SI). Connect the other end to pin 4 (NS).

() Prepare the 6" length of 8-wire cable by cutting 3" of the plastic cover off one end and 2" off the other end.

() Pull the black, white and yellow wires out of the cable



1- GRASP
UPPER HALF
OF LUG



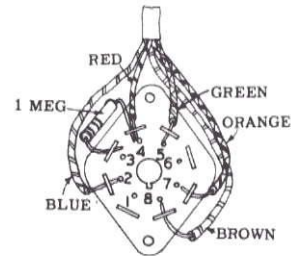
2- BEND LUG
SLIGHTLY
AS SHOWN
TO CLEAR
PIN SLEEVE
IN FRONT



3- NOW BEND
LUG UNTIL
IT POINTS
DOWN AS
SHOWN

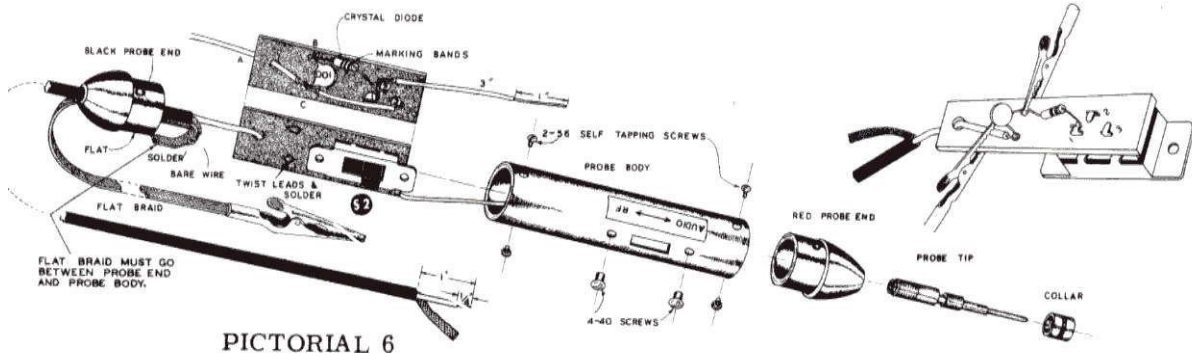


- () Cut 2" off the red wire and strip both ends of all the wires.
- () Connect the blue wire to pin 2 (S1) of the eye tube.
- () Connect the red wire to pin 4 (S2).
- () Connect the green wire to pin 5 (S1).
- () Connect the orange wire to pin 7 (S1).
- () Connect the brown wire to pin 8 (S1).
- () Plug the socket on the 1629 eye tube and push the tube into the spring clip holder.



PREPARING THE PROBE AND TEST LEADS

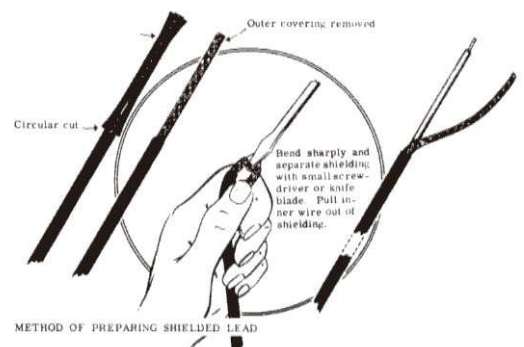
- () Mount the RF-Audio switch S2 on the terminal board by bending the lugs on the switch as shown.



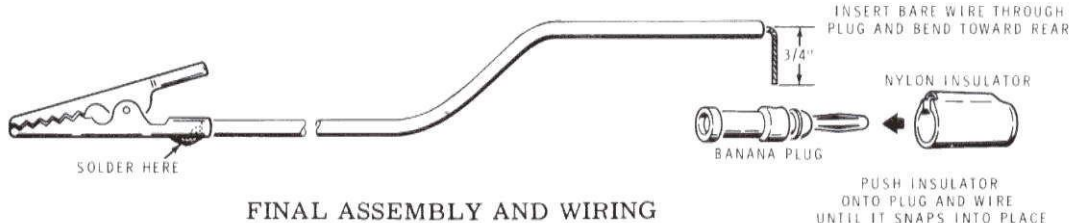
- () Push one end of a 1 3/4" length of wire through hole C of the terminal board. Connect the other end to lug 3 (S1) of switch S2.
 - () Connect one end of a 3" length of wire to lug 2 (S1) of switch S2. Strip the other end approximately 1".
 - () Push one lead of a .001 ceramic disc condenser through hole C of the terminal board, and the other lead through hole B.
 - () Connect the lead closest to the marking bands of the crystal diode to lug 1 of switch S2 (S1).
- Caution:** Crystal diodes can be damaged by excessive heat. Use as little heat as possible when soldering. Push the other lead of the diode through hole B and twist together with the condenser lead. Solder the two leads on the switch side of the board and trim off any excess lead. (Use an alligator clip to hold wires in board).

- () Cut away one inch of the outer insulation of the coaxial cable. Double the lead over and pull the center conductor through the side of the braid as shown. Strip off 1/4" of the insulation from the center conductor.

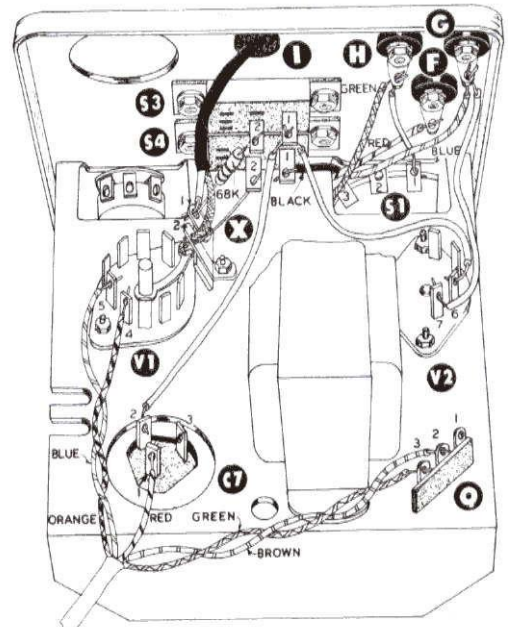
- () Slip the black probe end over the opposite end of the cable and cut off 2" of the outer insulation. Pull the center conductor through the braid, strip off 1/4" of the center conductor insulation and feed the wire through hole A in terminal board, from the switch side. Push the end of the wire through hole C. Twist the three wires together and solder on the switch side of the board trim off excess lead.



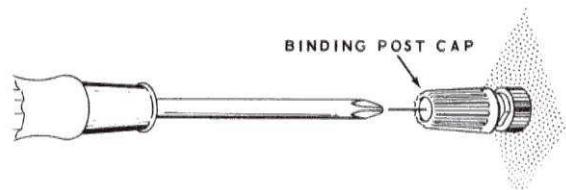
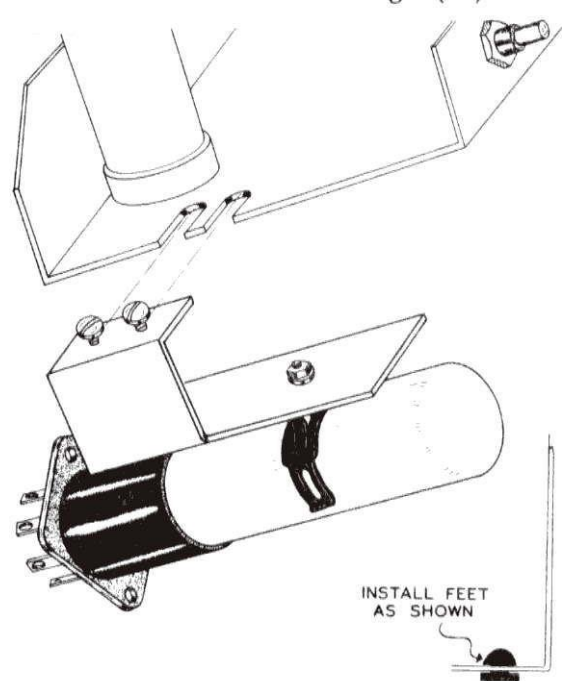
- () Slip the length of flat braid through the probe end and bend over as shown. Wrap a short length of bare wire around the flat braid and the cable shield and solder. Cut off excess cable shield. Do not cut off braid.
- () Solder an alligator clip to the other end of the braid.
- () Slip the terminal board and switch into the probe body and mount the switch with the two small 4-40 screws.
- () Push the black probe end into the end of the probe body, making sure that the flat braid is between the probe body and the flat side of the probe end. Fasten the end with two small self tapping screws.
- () Screw the probe tip into the red probe end, and remove the collar from the tip. Slip the red end into the probe body, making sure the wire comes through the hole in the tip. Secure the end in the probe body with the two self tapping screws. Wrap the wire around the probe tip and replace the collar.
- () Remove the paper backing from the RF-AUDIOdecal, and place it on the probe body with the audio end towards the tip.
- () Assemble the red and black test leads as shown.



- () Remove the 3/8 nuts from control R1 and switch S1. Mount the chassis to the panel using a nickel control washer between the panel and the 3/8 control nuts.
- () Feed the four remaining wires from the out-put transformer through the chassis slot behind switch S1. Connect the black wire to lug 1 (S1) of speaker switch S4.
- () Connect a short length of bare wire between lug 2 (S1) of switch S4 and lug 2 (NS) to terminal strip X.
- () Connect one lead of a 68 K ohm resistor (blue-grey-orange) to lug 2 (S1) of noise switch S3. Connect the other lead to lug 1 (NS) of terminal strip X.
- () Connect the wire from lug 2 of condenser C7 to lug 1 (NS) of switch S3.
- () Connect the wire from pin 6 of V2 to lug 1 (S2) of switch S3.
- () Connect the lead from lug 1 of the on-off switch to panel terminal H.
- () Connect the green wire from the output transformer to terminal H.
- () Connect the red transformer lead to terminal F (S1). Connect the y



- () Connect the blue transformer wire to terminal G (S3).
- () Feed the probe cable through grommet I and connect the inner conductor to lug 1 (S3) of terminal strip X. Connect the cable shield to lug 2 (S4)
- () Twist the green and brown leads from the eye tube socket and connect the green lead to lug 3 (S3) of terminal strip Q. Connect the brown lead to lug 2 (S3).
- () Connect the red lead to lug 1 (S3) of condenser C7.
- () Twist the orange and blue leads together and connect the orange lead to pin 4 (S2) of socket VI. Connect the blue lead to pin 5 (S2). This completes the T-4 wiring. Check over connections and make sure that all have been soldered.
- () Install the 12AX7, VI and the 12CA5, V2 tubes.
- () Mount the eye tube by sliding the two sheet metal screws into the slots in the chassis and tightening down, and then push the tube forward against the panel.
- () Install an 8-32 x 1/4" setscrew in each of the two knobs.
- () Install the level control and off-on switch knobs. Position the pointers so they line up with panel markings.
- () Install red binding post caps on the speaker and the C. T. post.
- () Install black caps on the B+ and P post.
- () Slightly spread the open end of the binding posts with a phillips screwdriver after the binding post caps have been screwed on. Tap the screwdriver lightly. This will keep the binding post caps from falling off.
- () Install the four rubber feet on the bottom of the cabinet.
- () Install the handle using the two #10 sheet metal screws.



NOTE: The blue and white identification label shows the Model Number and Productions Series Number of your kit. Refer to these numbers in any communications with the Heath Company; this assures you that you will receive the most complete and up-to-date information in return.

- () Carefully peel away the backing paper from the blue and white identification label. Then press the label onto the rear of the cabinet.

Before installing the instrument in the cabinet, using 6-32 screws, these preliminary tests should be performed. Turn on the instrument and advance the level control. Turn the speaker switch on and the noise switch off. After a few seconds the 1629 eye tube should light green, thus indicating that the B+ and filament circuits are functioning properly. The shadow position of the tube may be adjusted in the panel by rotating the tube. A loud hum should be heard when the probe tip is touched with the hand.

- () If operation is normal, install the cabinet with 6-32 screws. If the Signal Tracer did not operate properly, refer to the In Case Of Difficulty section of the manual.

IN CASE OF DIFFICULTY

If the Signal Tracer failed to operate in the preliminary test, again check over all connections for unsoldered or poor joints. Using the pictorial diagrams, trace each lead with a red pencil to make sure each one is connected properly. Make sure that no component leads are shorted to each other or to the chassis. Trace through the instrument by touching the grid

(pin 2) of the 12CA5 output tube with a screwdriver that is held in contact with your finger. A low level hum should be heard. Move the screwdriver to the grid of the 12AX7 tube section B (pin 2) and then to the grid of section A (pin 7). The hum or noise should become louder with each stage. If no sound is heard, look for trouble in that particular stage.

CAUTION: To avoid any shock hazard when making the above test, make sure that only the pins that are mentioned in the text are touched with the screwdriver, and the other hand or any other part of the body is not in contact with the chassis or any other conductor that may provide a return path to ground.

If after careful checks the trouble is still not located, check voltage and resistance readings found on the schematic diagram. Note: All voltage and resistance readings were taken with a Heathkit Vacuum Tube Volt Meter. Voltage and resistance readings may vary 20% due to line voltage variations and the tolerance of components. A reading that is off more than 20% would indicate probable trouble in that particular stage. A review of the circuit description may also be helpful in indicating where to look for the trouble. **NOTE:** In an extreme case where you are unable to resolve a difficulty, refer to the "Customer Service" information inside the rear cover of the Manual. Your Warranty is inside the front cover.

USING THE SIGNAL TRACER

The IT-12 Signal Tracer is one of the simplest, yet most effective instruments the service technician can use for rapid, accurate trouble-shooting in radio and TV circuits. The tracer is of the untuned type to simplify operation thus holding control manipulation to an absolute minimum.

This instrument features a number of useful applications which will enable the service technician to quickly locate and diagnose the trouble in the circuit under test. Many of the tests will be performed automatically, and will require only a few seconds of the technician's time. It is suggested however, that the user familiarize himself with all phases of the instrument's operation, so that maximum benefit can be realized from the investment in the kit.

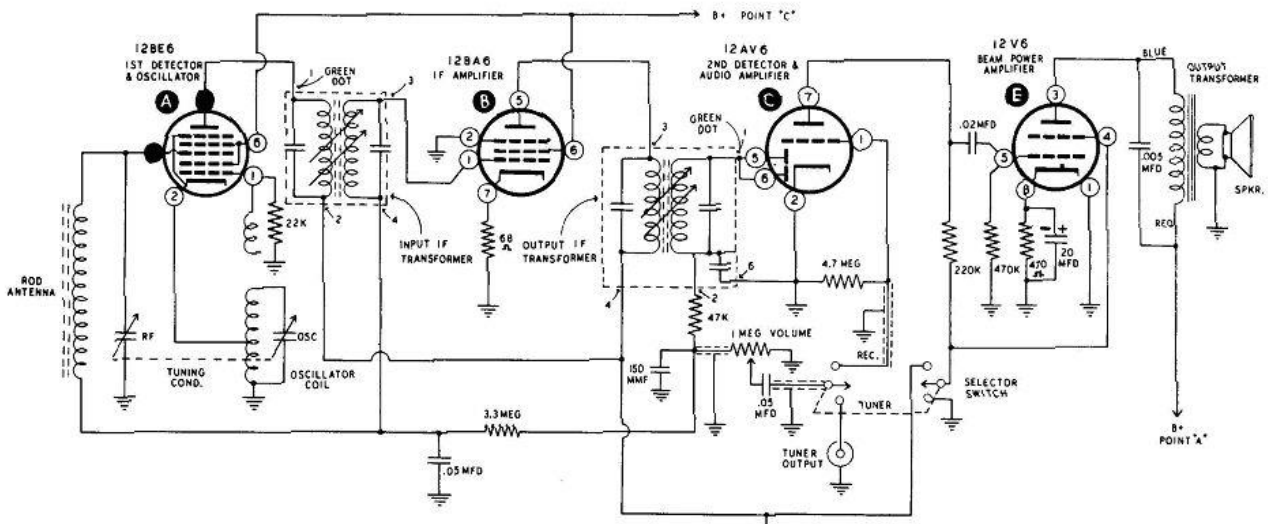
The procedures to be followed when using the Signal Tracer are outlined in a general manner only, and do not represent the limits of its applications. Each individual will develop his own procedures and applications by using the instrument.

RF Signal Tracing

To use the Signal Tracer for RF signal tracing, the probe switch should be in the RF position, the off "on switch and the speaker switch to the ON position, and the noise switch to OFF. The level control should be adjusted as needed. In some cases it may be desirable to turn off the speaker and observe the approximate signal level on the indicator tube. Note: At near maximum settings of the level control a certain amount of hum will be present; this is due to the high sensitivity of the unit and the fact that the input grid has been extended to the probe permitting it to pick up spurious AC fields.

To illustrate the use of this instrument, a typical radio schematic is presented so the test points may be clearly pointed out. Let us assume that the receiver under test has a specific complaint of low volume. Since the receiver is in partial operating condition, it could be turned on and tuned to a familiar station. The volume control should be turned down so that the speaker output will not interfere with the signal tracer results. The flexible ground lead of the probe should be clipped to the B- or ground circuit of the receiver.

If the receiver is tuned to a strong station, and the probe connected, a signal should be present at the loop antenna, the tuning condenser and at the grid (pin 7) of tube A. When the probe is moved to the plate, (pin 5 of tube A) a substantial increase in signal should be observed. Note: At radio frequencies, the D. C. voltages used in the IF stages need not be filtered 100%. Coupled with this fact, the signal at the mixer or converter plate (pin 5) is very weak and requires a high



gain setting of the tracer. These combined conditions result in the hearing of a high hum level in the tracer when the probe is connected to the plate. On some receivers the hum over-rides the signal making it necessary to move the probe to the secondary of the input IF transformer, (pin 1 of tube B) in order to check the gain of the first stage.

The path of the signal can be traced through any succeeding IF stages to the detector. During these tests an approximate estimation of gain per stage can be made. The amount of gain that can be expected in a circuit can best be determined by previous experience in making similar tests.

In some cases the RF probe causes a slight detuning effect when applied to tuned circuits. In these cases advance the probe to the following test point, and if a good signal is present it would be reasonable to assume that the preceding circuit is functioning properly.

The same general procedure may be used in checking RF and IF stages in FM and TV circuits. Since the actual signal is the prime factor of consideration, the signal tracer will detect the presence or absence of said signal regardless of the type of circuit involved.

Audio Signal Tracing

After detection has taken place in the receiver, the use of the RF probe is not required and the switch in the probe should be switched to the audio position. Here again the same general conditions previously described apply to the use of the indicator tube and the speaker. From the detector stage (pin 5 and 6 of tube C) the signal can be traced through the various coupling circuits, through the audio and output stage (tube C and E) and the output transformer. These tests can be made quickly and easily and any circuit fault would be indicated by a loss of gain or signal in succeeding stages. Intermittent or faulty volume controls and coupling condensers can also be quickly spotted. When using the tracer keep in mind that the Signal Tracer will detect the presence as well as the absence of signal. For example, it is a common practice to use a high capacity by-pass condenser in the cathode circuit of the output tube (pin 8 of tube E). In event the condenser is open there will be a definite indication of a signal at the cathode, whereas a good condenser would by-pass the signal to ground in the desired manner.

As a signal is traced through the audio system the signal level will be extremely high, and it will be necessary to reduce the setting of the signal tracer gain control. A definite reduction in gain will be noted as the probe is moved from the primary to the secondary of the output transformer. This is normal and is due to difference in the turns ratio and impedance of the windings in the transformer.

Noise Locator

A rather unique and definitely useful application of the Signal Tracer is its ability to locate noisy and intermittent components in various circuits. Basically the noise locating feature of the signal tracer permits the application of a DC test voltage to any component in the receiver circuit, and the action of the DC voltage in the component is picked up and amplified in the signal tracer itself. This DC voltage of approximately 100 volts is available at the tip of the probe, and of course the ground clip of the probe provides the necessary return circuit. Some precaution should be observed so that the service technician will not encounter a relatively harmless shock hazard. The circuit arrangement is such that even under a dead short circuit condition of ground clip to the test probe, the current drain will not exceed 1 mil and therefore, the possibility of damage to a receiver component is eliminated. To use the Signal Tracer as a noise locator the following conditions should be observed:

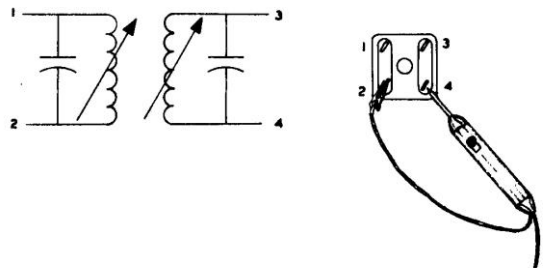
First of all it is important that the receiver to be checked should be disconnected entirely from the AC supply line as all tests will be made on an inoperative receiver. The probe switch should be in the audio position for this test, and the panel noise switch to ON. As previously mentioned, a DC voltage in the order of 100 volts is now present between the probe tip and the ground clip.

WARNING: When testing in transistor circuits, it is suggested that one end of the component being tested be disconnected from the circuit before applying the DC voltage. Failure to do so could result in transistor breakdown. Do not apply the test voltage directly across transistor connections.

To illustrate an example of usage, the ground clip should be connected to a B+ supply point in the circuit. The test probe is then applied directly to the plate terminal of an IF tube. The gain control of the signal tracer should be at near maximum position. As the test probe is applied to the plate of the IF tube, a sharp click will be heard in the signal tracer's speaker. A good, clean click will indicate proper circuit continuity and operation. If there is any frying or crackling sounds present, it would be reasonable to assume that some difficulty is being experienced along the circuit, and then the test probe should be moved step-by-step through each portion of the circuit in order that each component may be progressively checked. As the test probe is moved along through coils, resistors and other elements toward the ground clip, it is quite likely that at some point the noise will disappear. When this condition occurs, the preceding step should be repeated and further investigation made of the particular circuit involved for a possible faulty component.

Noisy resistors will very definitely show up as a buzzing or crackling sound. The same condition holds true for a cold or rosin soldered connection in the receiver wiring. Shorted turns in an IF transformer will also be evident by the noise content. The important thing to remember is that a satisfactory component will permit a sharp click to be heard in the speaker, whereas a faulty component will result in a characteristic of an objectionable noise.

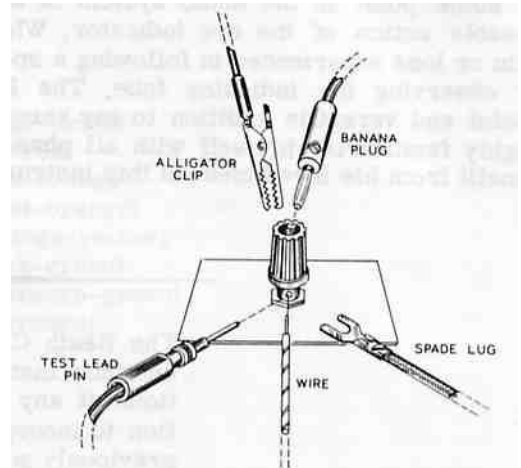
Obviously the test voltage can be applied to any component in the receiver. For example, if an audio coupling condenser is suspected, the voltage can be applied across the condenser terminal, and then, the condenser lightly jiggled or prodded to determine whether or not a noisy or intermittent condition may be present. Noisy volume controls can be detected, and of course the same condition holds true for the rotor section of variable condensers. Voltage can be applied to the condenser while it is being rotated, and any shorting will be quickly evident. Of course it will be necessary to disconnect any external circuit wiring connected to the condenser terminals. Transformer windings that are faulty will also show up as noise in the signal tracer's speaker. The continuity of the winding can be checked and any leakage from winding to frame can quickly be determined.



There is practically no limit to the variety of useful applications afforded by this feature of the signal tracer. It is suggested that the service technician further investigate other test procedures where application of a DC voltage to a component in conjunction with a high gain amplifier will permit observation of voltage action.

Panel Connections

For additional flexibility of operation, the signal tracer panel features five binding posts. These binding posts differ slightly from the conventional type, in the respect that it is possible to insert a banana plug into the top of each jack. They will also accommodate alligator clips, spade lugs and conventional hook-up wire. Test leads such as used in the VTVM can be used interchangeably with this instrument when required. The panel arrangement of the Signal Tracer will permit the utilization of other shop equipment for test procedure. For an example, a VTVM can be connected either from B+ to plate or from plate to common ground terminal. The VTVM will of course be switched to the AC position and the calibrated scale of the meter could be read directly for precise measurements during alignment procedures and gain calculation. The output transformer secondary connections should be utilized if the test requirements required the elimination of the DC voltage present in the primary circuit. A reduction in gain indication should be expected.



Test Speaker

In service work it is frequently necessary to remove the chassis of a radio or TV receiver to the repair shop in order to properly complete repair work. In many instances the speaker is a separate piece of equipment, and in some cases it is installed in a rather inaccessible cabinet location. With the Signal Tracer at your disposal, it is not necessary to remove the speaker in view of the fact that the output transformer and speaker are available as test or substitution units. In the majority of cases, the original receiver circuit requirements specify the use of a permanent magnet type speaker and therefore, the substitution can be readily made. The advantage of this feature of the signal tracer is readily apparent when consideration is given to the time and effort conserved by eliminating the necessity for speaker removal and reinstallation on every service job. In addition, the possibility of damage to the speaker cone during the handling process is eliminated.

Audio System

Quite frequently the service technician will be called upon to service automatic record-changers or phono mechanism. Of course this equipment is usually removed from the cabinet of the receiver and transported to the service shop. On making mechanical repairs or adjustments on the changer mechanism, it is frequently desirable that the output of the phono cartridge be checked and actual conditions of tone reproduction simulated. Here again, it is a relatively simple matter to connect the audio input of the Signal Tracer to the output cable of the record changer. The changer output as heard in the speaker of the tracer will permit detection of any irregularity in mechanical operation, such as turn-table wow or thump, or any objectional noise that could be transmitted through the phono cartridge and reproduced as an undesirable condition.

This same procedure could be used in checking microphones and musical instrument pickups, and here again the results obtained are interpreted on the basis of comparison made with previous tests on similar equipment. The signal tracer can be used in checking FM tuners or other equipment requiring the use of an audio system



Output Level Indicator

The Signal Tracer can be used as a level indicator merely by connecting the audio probe to some point in the audio system of a receiver and regulating the amount of gain to permit useable action of the eye indicator. While performing alignment adjustments, the amount of gain or loss experienced in following a specific alignment procedure can quickly be determined by observing the indicator tube. The Heathkit Signal Tracer will prove itself an extremely useful and versatile addition to any service shop. It is earnestly suggested that the user thoroughly familiarize himself with all phases of its operations, so that he may obtain maximum benefit from his investment in this instrument.

The Heath Company reserves the right to discontinue instruments and to change specifications at any time without incurring any obligation to incorporate new features in instruments previously sold

PARTS LIST

To order replacement parts, refer to the Replacement Parts Price List and use the Parts Order Form furnished with this kit.

PART No.	PARTS Per Kit	DESCRIPTION
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Resistors

1-4	1	330 ohm 1/2 w. resistor (orange-orange-brown)
1-9	1	1 K ohm 1/2 w. resistor (brown-black-red)
1-20	1	10 K ohm 1/2 w. resistor (brown-black-orange)
1-25	1	47 K ohm 1/2 w. resistor (yellow-violet-orange)
1-31	4	330 K ohm 1/2 w. resistor (orange-orange-yellow)
1-35	1	1 megohm 1/2 w. resistor (brown-black-green)
1-38	1	3.3 megohm 1/2 w. resistor (orange-orange-green)
1-60	2	68 K ohm 1/2 w. resistor (blue-grey-orange)

Condensers

21-140	4	.001 ceramic condenser
21-27	3	.005 ceramic condenser
27-36	1	.01 condenser
25-65	1	50/50 - 150 v. + 20 - 25 v. 3 lug twist prong condenser

Tubes-Diodes-Rectifiers

56-26	1	Crystal diode
57-27	1	Silicon diode
411-26	1	12AX7 tube
411-30	1	1629 tube
411-111	1	12CA5 tube

Terminal Strips-Sockets-Binding Posts

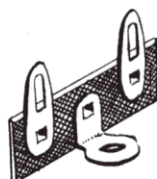
75-17	10	Insulator bushing
75-22	1	Terminal board
427-3	5	Binding post base
431-2	1	2 lug terminal strip
431-10	1	3 lug terminal strip
431-16	1	2 lug terminal strip
431-51	1	2 lug vertical terminal strip
434-15	1	7 pin wafer tube socket
434-31	1	8 pin octal tube socket
434-77	1	9 pin wafer tube socket with center ground
100-16-2	2	Binding post cap, black
100-16-18	3	Binding post cap, red

Wire-Sleeving

89-1	1	AC line cord
340-2	1	Length bare wire
341-1	1	Length black test lead
341-2	1	Length red test lead
343-2	1	Length RG58U Coax.
344-59	1	Length hookup wire
345-1	1	Length braid
346-1	1	Length 1/16 sleeving
347-1	1	Length 8 wire cable

Controls-Switches

10-67	1	1 meg control
60-1	2	SPST slide switch
60-7	1	SPDT slide switch small button
63-145	1	2 position rotary switch 1 wafer



431-2



431-10



431-51

PART No.	PARTS Per Kit	DESCRIPTION
<u>Cabinet-Chassis-Speaker</u>		
90-236	1	Cabinet, aluminum
209-10	1	Speaker grille
211-15	1	Handle
401-21	1	3-1/2" speaker
200-150	1	Chassis
203-143-2	1	Front panel
204-150	1	Tube mounting bracket
<u>Hardware</u>		
208-6	1	Spring clip
250-212	4	2-56 self tapping screw
250-2	4	3-48 x 5/16" RHMS
250-8	2	#6 sheet metal screw
250-18	2	8-32 RHMS
250-52	2	4-40 x 1/4" PHMS
250-31	1	6-32 short RHMS
250-83	2	#10 sheet metal screw
250-89	17	6-32 x 3/8" BHMS
250-43	2	8-32 x 1/4" setscrew
252-1	4	3-48 nut
252-3	22	6-32 nut
252-4	2	8-32 nut
252-7	2	3/8" control nut
252-22	2	Speed nut
253-10	2	Nickel control washer
253-27	4	5-32 flat washer
254-1	11	#6 lockwasher
254-2	2	#8 lockwasher
254-4	1	3/8" control lockwasher
259-1	6	Solder lug
259-10	2	Control solder lug
438-47	2	Banana plug
477-3	1	Solderless phone tip
481-2	1	Condenser mounting wafer 3 prong
<u>Miscellaneous</u>		
51-31	1	Transformer, output
54-64-24	1	Transformer, power
70-10	1	Black nylon sleeve
70-11	1	Red nylon sleeve
73-1	1	3/8" grommet
75-24	1	Line cord strain relief
260-1	3	Alligator clip
261-4	4	Rubber feet
390-40	1	Label
462-187	2	Knob
476-11	1	Probe body for switch
	1	Manual (see front cover for part number)
459-2	1	Red probe end
459-3	1	Black probe end
		Solder

REPLACEMENT PARTS PRICE LIST

To order a replacement part, use the Parts Order Form furnished with this kit. If a Parts Order Form is not available, refer to "Replacement Parts" inside the rear cover of the Manual.

PART No.	PRICE Each	DESCRIPTION	PART No.	PRICE Each	DESCRIPTION
RESISTORS			CONTROLS-SWITCHES		
1-4	.10	330 ohm 1/2 w.	10-67	.55	1 meg control
1-9	.10	1 K ohm 1/2 w.	60-1	.15	SPST slide switch
1-20	.10	10 K ohm 1/2 w.	60-7	.20	SPDT slide switch small button
1-25	.10	47 K ohm 1/2 w.	63-145	.75	2 position rotary switch
1-31	.10	330 K ohm 1/2 w.			1 wafer
1-35	.10	1 megohm 1/2 w.			
1-38	.10	3.3 megohm 1/2 w.			
1-60	.10	68 K ohm 1/2 w.			
CONDENSERS			CABINET-CHASSIS-SPEAKER		
21-140	.10	.001 ceramic condenser	90-236	2.70	Cabinet, aluminum
21-27	.10	.005 ceramic condenser	209-10	.25	Speaker grille
27-36	.15	.01 condenser	211-15	.20	Handle
25-65	1.05	50/50 - 150 v. + 20 - 25 v. 3 lug twist prong condenser	401-21	2.15	3-1/2" speaker
TUBES-DIODES-RECTIFIERS			200-150	1.10	Chassis
56-26	.30	Crystal diode	203-143-2		
57-27	.60	Silicon diode		.70	Front panel
411-26	1.30	12AX7 tube	204-150	.15	Tube mounting bracket
411-30	2.05	1629 tube			
411-111	1.45	12CA5 tube			
TERMINAL STRIPS-SOCKETS-BINDING POSTS			HARDWARE		
75-17	.10	Insulator bushing	208-6	.10	Spring clip
75-22	.10	Terminal board	250-212	.05	2-56 self tapping screw
427-3	.15	Binding post base	250-2	.05	3-48 x 5/16" RHMS
431-2	.10	2 lug terminal strip	250-8	.05	#6 sheet metal screw
431-10	.10	3 lug terminal strip	250-18	.05	8-32 RHMS
431-16	.10	2 lug terminal strip	250-52	.05	4-40 x 1/4" PHMS
431-51	.10	2 lug vertical terminal strip	250-31	.05	6-32 short RHMS
434-15	.10	7 pin wafer tube socket	250-83	.05	#10 sheet metal screw
434-31	.10	8 pin octal tube socket	250-89	.05	6-32 x 3/8" BHMS
434-77	.15	9 pin wafer tube socket with center ground	250-43	.05	8-32 x 1/4" setscrew
100-16-2	.10	Binding post cap, black	252-1	.05	3-48 nut
100-16-18	.10	Binding post cap, red	252-3	.05	6-32 nut
WIRE-SLEEVEING			252-4	.05	8-32 nut
89-1	.35	AC line cord	252-7	.05	3/8" control nut
340-2	.05/ft	Length bare wire	252-22	.05	Speed nut
341-1	.05/ft	Length black test lead	253-10	.05	Nickel control washer
341-2	.05/ft	Length red test lead	253-27	.05	5-32 flat washer
343-2	.10/ft	Length RG58U Coax.	254-1	.05	#6 lockwasher
344-59	.05/ft	Length hookup wire	254-2	.05	#8 lockwasher
345-1	.10/ft	Length braid	254-4	.05	3/8" control lockwasher
346-1	.05/ft	Length 1/16 sleeving	259-1	.05	Solder lug
347-1	.10/ft	Length 8 wire cable	259-10	.05	Control solder lug
			438-47	.15	Banana plug
			477-3	.15	Solderless phone tip
			481-2	.10	Condenser mounting wafer 3 prong



<u>PART</u> <u>No.</u>	<u>PRICE</u> <u>Each</u>	<u>DESCRIPTION</u>
MISCELLANEOUS		
51-31	1.60	Transformer, output
54-64-24	4.45	Transformer, power
70-10	.10	Black nylon sleeve
70-11	.10	Red nylon sleeve
73-1	.10	3/8" grommet
75-24	.10	Line cord strain relief
260-1	.15	Alligator clip
261-4	.05	Rubber feet
390-40	.10	Label
462-187	.30	Knob
476-11	.50	Probe body for switch
331-6	.15	Solder
	2.00	Manual (see front cover for part number)
459-2	.15	Red probe end
459-3	.25	Black probe end

The above prices apply only on purchases from the Heath Company where shipment is to a U.S.A. destination. Add 10% (minimum 25 cents) to the price when ordering from a Heathkit Electronic Center to cover local sales tax, postage, and handling. Outside the U.S.A. parts and service are available from your local Heathkit source and will reflect additional transportation, taxes, duties, and rates of exchange.



REPLACEMENT PARTS

If you need a replacement part, please fill in the Parts Order Form that is furnished and mail it to the Heath Company. Or, if you write a letter, include the:

- Part number and description as shown in the Parts List.
- Model number and Series number from the blue and white label.
- Date of purchase.
- Nature of the defect.

Please do not return parts to the factory unless they are requested. Parts that are damaged through carelessness or misuse by the kit builder will not be replaced without cost, and will not be considered in warranty.

Parts are also available at the Heathkit Electronic Centers listed in your catalog. Be sure to provide the Heath part number. Bring in the original part when you request a warranty replacement from a Heathkit Electronic Center.

NOTE: Replacement parts are maintained specifically to repair Heathkit products. Parts sales for other reasons will be declined.

TECHNICAL CONSULTATION

Need help with your kit?.... Self-Service?.... Construction?.... Operation? Call or write for assistance. You'll find our Technical Consultants eager to help with just about any technical problem except "customizing" for unique applications.

The effectiveness of our consultation service depends on the information you furnish. Be sure to tell us:

- The Model number and Series number from the blue and white label.
- The date of purchase.
- An exact description of the difficulty.
- Everything you have done in attempting to correct the problem.

Also include switch positions, connections to other units, operating procedures, voltage readings, and any other information you think might be helpful.

Please do not send parts for testing, unless this is specifically requested by our Consultants

Hints: Telephone traffic is lightest at midweek. . .please be sure your Manual and notes are on hand when you call.

Heathkit Electronic Center facilities are also available for telephone or "walk-in" personal assistance.

REPAIR SERVICE

Service facilities are available, if they are needed, to repair your completed kit. (Kits that have been modified, soldered with paste flux or acid core solder, cannot be accepted for repair.)

If it is convenient, personally deliver your kit to a Heathkit Electronic Center. For warranty parts replacement, supply a copy of the invoice or sales slip.

If you prefer to ship your kit to the factory, attach a letter containing the following information directly to the unit:

- Your name and address.
- Date of purchase.
- Copies of all correspondence relevant to the service of the kit.
- A brief description of the difficulty.
- Authorization to return your kit C.O.D. for the service and shipping charges. (This will reduce the possibility of delay.)

Check the equipment to see that all screws and parts are secured. (Do not include any wooden cabinets or color television picture tubes, as these are easily damaged in shipment.) Place the equipment in a strong carton with at least THREE INCHES of resilient packing material (shredded paper, excelsior, etc.) on all sides. Use additional packing material where there are protrusions (control sticks, large knobs, etc.). If the unit weighs over 15 lbs., place this carton in another one with 3/4" of packing material between the two.

Seal the carton with reinforced gummed tape, tie it with a strong cord, and mark it "Fragile" on at least two sides. Remember, the carrier will not accept liability for shipping damage if the unit is insufficiently packed. Ship by prepaid express. United Parcel Service, or insured Parcel Post to:

Heath Company
Service Department
Benton Harbor, Michigan 49022

HEATH

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