



CRIMP WIRES    HEAT CONNECTION    APPLY SOLDER    ALLOW SOLDER TO FLOW    PROPER SOLDER CONNECTION

### CHASSIS WIRING AND SOLDERING

1. All wire used is the type with colored insulation (hookup wire). In preparing a length of hookup wire, 1/4" of insulation should be removed from each end unless directed otherwise in the assembly step.
2. Leads on resistors, capacitors, and similar components are generally much longer than need be to make the required connections. In these cases, the leads should be cut to proper length before the part is installed. In general, the leads should be just long enough to reach their terminating points.
3. Crimp or bend the wire around the terminal just enough to hold it in place until it is soldered. Do not knot or twist the wire around the lug.
4. Position the work, if possible, so that gravity will help to keep the solder where you want it.
5. Place a flat side of the soldering iron tip against the joint to be soldered until it is heated sufficiently to melt the solder.
6. Then place the solder and it will immediately flow over the joint; use only enough solder to thoroughly wet the junction. It is usually not necessary to fill the entire hole in the terminal with solder.
7. Remove the solder and then the iron from the completed joint. Use care not to move the leads until the solder is solidified.

A poor or cold solder joint will usually look crystalline and have a grainy texture, or the solder will stand up in a blob and will not have adhered to the joint. Such joints should be reheated until the solder flows smoothly. In some cases, it may be necessary to add a little more solder to achieve a smooth, bright appearance.

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.