**Dokorder, Inc.**

HI-FI COMPONENTS

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SERVICE BULLETIN

TO: ALL SERVICE STATION DEPOTS

FROM: Shunichi Ogawa - Service Manager

SUBJECT: Model 1140 Replacement Circuit Board for
OUT OF WARRANTY REPAIR

A. Plug-In Type PCBs Such As

- a. Logic control PCB
- b. Multi-sync. PCB
- c. Bias PCB
- d. EQ amp. PCB

Will not be supplied for replacement. We expect you to fix them. But if you feel it is uneconomical, we will repair them for you under the following conditions.

- B. 1. Defective PCBs must be returned to Dokorder, Inc. with a note, "For Repair of Serial Number _____."
2. Returned PCBs must be in repairable condition. (Missing parts, cracks on PCB will not be accepted.)
3. Charges for labor, parts, postage and handling will be:

- a.
 - a. Logic Control PCB.....\$30.00
 - b. Multi-Sync. PCB.....\$20.00
 - c. Bias PCB.....\$20.00
 - d. EQ Amp PCB.....\$15.00

C. Note:

1. For your spare PCB they will be supplied under regular prices.
2. Full price will be charged for the replacement PCB if we determine that the returned PCB is beyond repair.
3. Call our parts man or technician first, prior to placing parts order for other than above, because most of the others are not plug-in type PCB and only individual components are available.

Thank you,

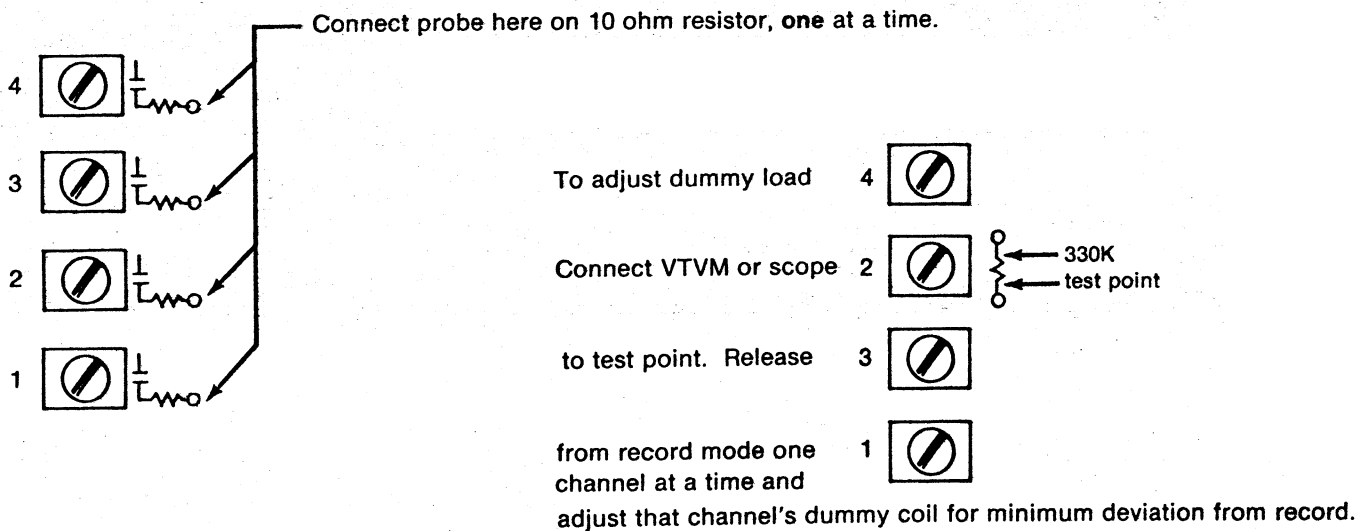
Shunichi Ogawa
Shunichi Ogawa
Service Manager

Model 1140 Replacement of Bias PCB (PCM313E) and Adjustment

1. Remove bottom cover.
2. Remove mu metal shield surrounding bias board.
3. Remove four mounting screws.
4. Unplug 18 pin and 10 pin connectors. (**Do not** turn over!)
5. Plug connectors into new board, making sure that connections are same (top of connectors are not reversed).
6. Install four mounting screws (do not tighten).
7. Reinstall mu metal shield **after** adjustment.

Adjustment

1. Load unit with tape, bias in fixed mode, unit in record, pause on, multi-sync off, all channels in record.
2. With VTVM or scope, adjust bias trap coils for minimum reading (see below).



3. Check playback bias traps located in upper deck.

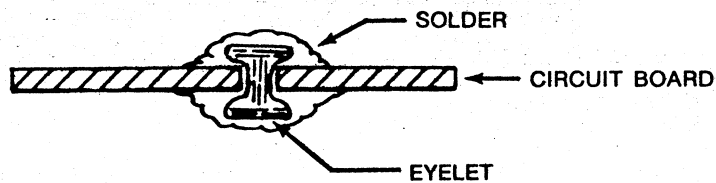
NOTES ON THE 1140

We have experienced intermittent connections in the following printed circuits:

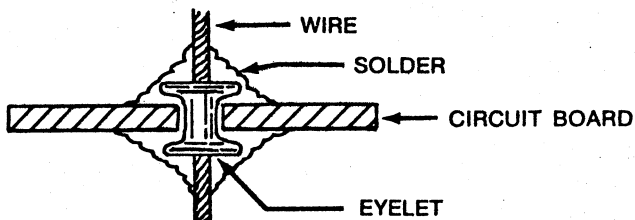
Head Amp EQ
Bias Oscillator
Multi-Sync

Rather than repair the intermittent board, we are asking that you replace all boards as per the following instructions.

The intermittent connections are the result of poor contact of an "eyelet" used to connect both sides of the circuit board (see below) to the solder.



The new boards have a wire through each eyelet, then soldered (see below).



If you replace the playback board PCM-342E (old type) with the PCM-418 (new type), a diode (SIB-0102) must be inserted in the small board (PCM-391) located next to the head amp.

