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TOOLS AND SUPPLIES REQUIRED

Gap gauges, glue gun, glue, masking tape, soldering iron, solder, MEK (Methyl Ethyl Keotone), cloth rags, plastic VC spacer tube(s), dome weights, tweezers, wire cutters, razor knife & blades, Q-tips, philips screwdriver, magnifying light, small mallet, audio oscillator and amplifier, cardboard diggers.

RECONING PROCEDURE

A. Preparation

1. Using razor knife, remove old cone/coil assembly and clean all surfaces where spider and compliance will mount of old glue.
2. Use gap gauge to check for proper gap size and alignment.
3. Check frame for tightness to magnet, cracks or warp.
4. Unsolder old VC leads from terminals, check terminals for tightness and alignment.
5. Inspect new cone/coil assembly for shipping damage, etc.

B. Installation

1. Fold piece of masking tape lengthwise around cardboard "digger" with adhesive exposed. Insert in gap and rotate. Repeat until tape remains clean when withdrawn. Check gap with magnifying light. Clean top plate area of any debris.
2. Using glue gun, apply bead of glue on frame surfaces where spider and compliance will mount.
3. Fold VC spacer tube and insert inside new VC assembly, allowing overhang below bottom of VC. Slide spacer tube over pole piece and down into gap, making sure tinsel leads on assembly are aligned to terminals on frame. Carefully guide VC assembly down spacer onto frame and into proper position. Do not force.
4. Take a small rag dipped in MEK and use it to press down on spider where it joins to frame. Work back and forth to even out spider and secure bond to frame. Repeat for compliance, working out bumps.
5. Use tweezers to guide tinsel leads through solder lugs. Allow enough slack for full cone excursion, but do not allow leads to touch (short). Solder leads to terminals and trim excess.
6. Allow glue 24 hours to dry, and then carefully pull out VC spacer tube. Unit can be sound tested at this point.



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C. Gasket Installation and Doming

1. Place gasket segments on frame to check for proper fit and alignment. Remove gasket pieces, and lay bead of glue on horizontal mounting surface. Install gasket.
2. To install dome, first use glue gun to place a bead of glue around cone collar. Be careful, too much glue may drip down inside of VC, and too little glue may cause a loose dome. Use glue gun to cover leads on cone face. Center dome onto cone. Apply another bead of glue at junction of cone and dome. Clean up excess glue with Q-tip and MEK. Place padded weight on top at dome and allow to dry.
3. After glue is thoroughly dry, sound check speaker with oscillator and amplifier.

REDIAPHRAGM PROCEDURE

A. Preparation

1. Check unit for damage (cracked throat, shifted top plate, etc.). Remove back cover and old diaphragm assembly. On ring radiators, remove inner and outer horns and unsolder old diaphragm.
2. Using gap gauge, check gap for size and alignment.
3. On 2-inch throat drivers, tap on top of phasing plug - unit should make a solid sound - "hollow" or "clicking" sound indicates loose phasing plug.

B. Diaphragm Installation

1. Fold piece of masking tape lengthwise around a cardboard digger with adhesive side exposed. Insert in gap and rotate to clean out debris. Continue cleaning until tape is clean when withdrawn. Inspect visually with magnifying light.
2. Inspect new diaphragm for damage. Line up holes in diaphragm to mounting pins or driver. Carefully lower assembly into place. Replace diaphragm mounting screws. On ring radiators, solder leads to terminals.
3. On drivers, hook unit up to oscillator set at 3-4 volts at proper frequency (550 Hz on 1-inch drivers, 350 Hz on 2-inch drivers). Listen for buzzing. Use small mallet to tap lightly on side of diaphragm frame until unit is centered in gap and buzzing ceases. Tighten down diaphragm mounting screws.
4. Reconnect terminal leads onto diaphragm assembly and replace cover. On ring radiators, replace inner and outer horn.
5. Perform final sound test.