

**TOOLS AND SUPPLIES REQUIRED:**

Box spanner, glue, plastic spacer, razor knife, masking tape, epoxy glue, cloth rags, methyl ethyl ketone (MEK), cotton swabs, and, if possible, audio oscillator and amplifier.

**PREPARATION :**

- 1.-Using razor knife and spanner, remove old cone-coil assembly and plastic ring, and clean the surface where surround will mount of old parts and glue.
- 2.-Check air gap for proper size and alignment.
- 3.-Check frame for tightness to magnet, cracks or warp.
- 4.-Inspect new coil-suspensions system for shipping damage.

**INSTALLATION :**

- 1.-Fold a piece of masking tape lengthwise around a piece of cardboard (70 mm x 25 mm x 1 mm), with adhesive side exposed and insert it in the air gap and rotate. Repeat this until tape remains clean when withdrawn. Check gap with magnifying light. Clean top plate and magnet of any debris.
- 2.-Apply a small amount of glue on frame surface (2 or 3 points) where spider will mount. Carefully guide voice coil assembly down spacer onto frame and into proper position. Slide the plastic spacers between voice coil and pole piece, allowing overhang 10-12 mm below bottom of voice coil. Replace plastic ring mounting screws. Unit can be sound at this point with 10 Hz or lower signal, at moderate power (remove plastic spacers before).
- 3.-Keep the cone and open the neck until this can slide over the voice coil. This must be done carefully with a round metal piece, like a screwdriver, enlarging the neck diameter by pressing inside around it without excess, to avoid cone damage.
- 4.-Using the tube of glue supplied, apply a bead of glue on frame surface where surround will mount and in the junction between coil and top spider. Place the cone on the proper position.
- 5.-Take a small rag dipped in MEK and use it to press down on surround where it joins to frame.
- 6.-Lay a bead of glue on gasket area. Wait for 5 minutes and place gasket segments on frame in proper position.
- 7.-Rotate down the device and allow glue 3-4 hours to dry.
- 8.-Apply a bead of epoxy glue in the junction of cone and coil and allow 24 hours to dry.
- 9.-To coat surround use a water base plasticiser and apply on it. Allow 2-3 hours to dry.
- 10.-To install dust cap, first remove plastic spacers and lay a bead of glue around cone collar. Be careful, too much glue may drip down inside of voice coil, and too little glue may cause a loose dome. Center dome onto cone. Apply another bead of glue at junction of cone and dome and allow to dry.
- 11.-After adhesive is thoroughly dry, sound speaker with audio oscillator and amplifier at moderate power.