HOW TO RECONE A 18 SOUND CONE DRIVER

01 Membrane cutting

Please remove the damaged moving assembly

Cut the membrane with a sharp edge tool


01.1


01.2

02 Voice coil removing

Unsold the output voice coil wirings

Cut the spider in the gluing area, keeping care of not creating metal particles that could be hidden into the magnetic gap


02.1


02.2

03 magnetic gap protection

Protect the magnetic gap via adhesive tape


03.1

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04 Gaskets removal Spider area cleaning

Remove the gaskets and the remaining spider parts

For best result we suggest to use a lathe, in order to remove completely gluing residues possibly left on magnetic complex and basket


04.1


04.2

05 Magnetic gap cleaning


05.1

06 Gluing dispensing on suspension and spider areas

Apply the glue on the suspension and spider metal areas. It is recommended to use solvent base glue, or bi-component epoxy

For DSS (Double Silicon Spider) technology products we recommend to use specific bi-component epoxy glue

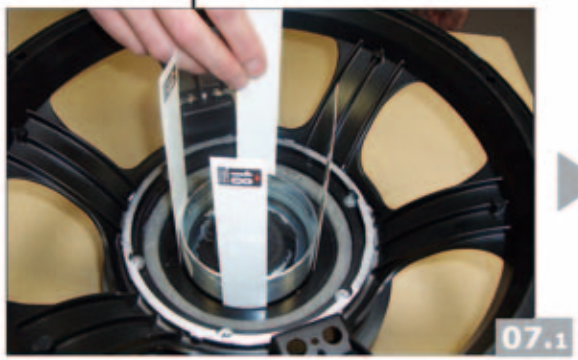

06.1


06.2

07 Moving assembly centering

Insert the supplied aligning tool (see figure below), using it for centring the moving assembly

Keep care of leaving the voice coil connection wires nearby basket's electrical connectors


07.1


07.2

08 Gluing dispensing over gaskets area

Distribute the proper glue over the membrane's suspension, in order to fix the gasket(s) provided in the packaging


08.1


08.2

09 Gaskets positioning

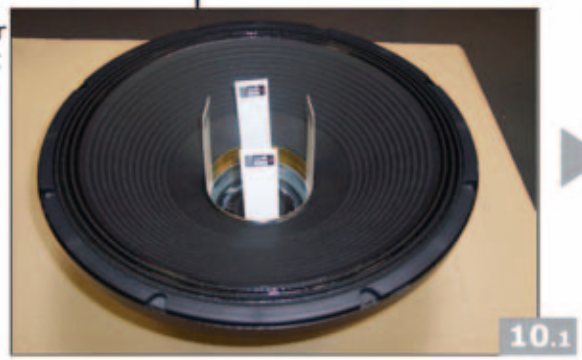
Place the gasket(s)

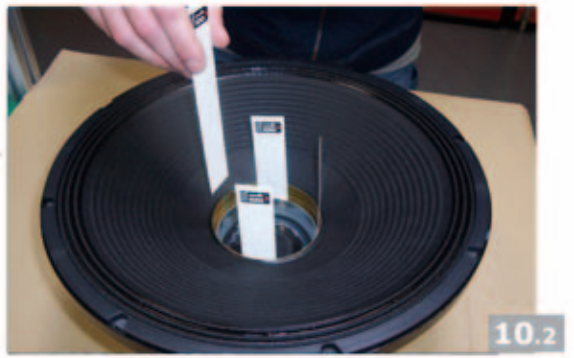

09.1

10 Gluing polymerisation

Let the glue polymerise for at least 24 hours without touching or moving

This will allow the glue to complete the entire polymerisation process, necessary to obtain the best power handling performances


10.1


10.2

11 Positioning dust cap

After 24 hour time please apply glue over the dust cap external area. Position it centred over the membrane, placing a weight over for keeping it stable

If necessary please apply an extra adhesive layer as shown in the picture below on the right


11.1


11.2

12 Wiring soldering

Sold the voice coil wiring terminals to the basket related connectors, taking care of leaving a little "bridge" adequate to support the natural mechanical excursion of the membrane
Finally provide to cut the exceeding wiring part


12.1


12.2

13 Polarity check

Check the electrical polarity via a 4,5V DC battery

Connecting the battery positive pole to the speaker red (plus) terminal you should report a positive (toward high) movement of the speaker moving assembly

13.1

14 Acoustic check

If possible please apply a 20Hz sine tone with voltage amplitude between 10V and 20V RMS

For little size speakers, like a 6inch 4 Ohm one, please apply 10V; for big size ones, like 18 inch 8ohm, please apply 20V

While applying this signal you should be able to verify acoustically that there are no spurious signal (such like rubbing or buzzing) due to bad moving assembly aligning