

# Driver Reconing Procedure

# 1

## Cone cutting

Cut the cone and spider with a sharp edge tool and remove the damaged cone.



# 2

## Voice coil removal

Unsolder the coil wires and remove the complete moving assembly



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## Basket cleaning

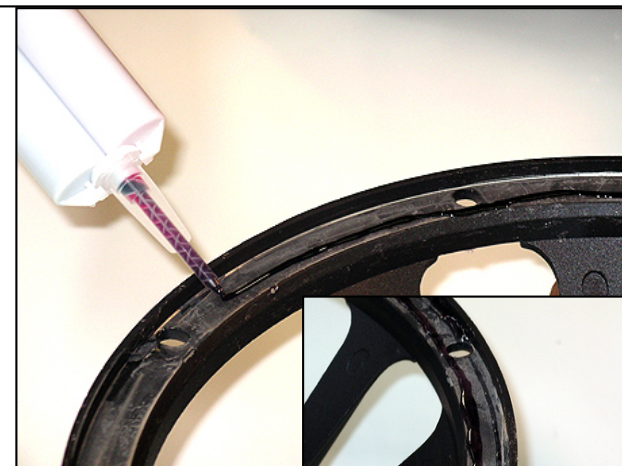
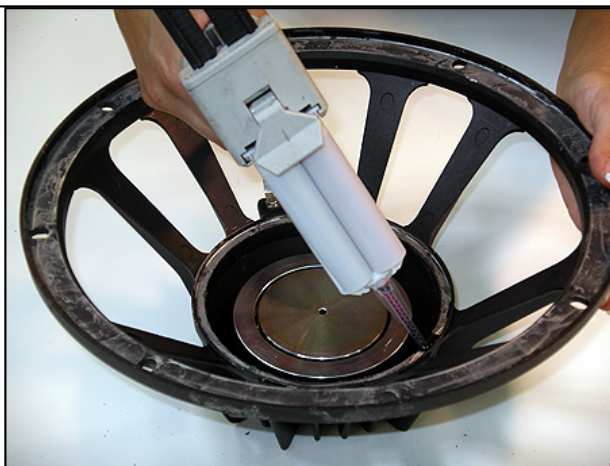
Protect the magnetic air gap via adhesive tape, remove gasket, spider parts and adhesive residue from surround and spider areas.



# 4

## Applying adhesive on cone and spider areas

Apply adhesive on the surround and spider areas.



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### Spacer Application

Measure the thickness of the base of the basket as shown in pictures **A** & **B**.

**A.** Should the thickness correspond to **5.70 mm (A)**, then proceed to glue the spacer on the spider landing area as shown in **Fig. 5.1**

**B.** Should the thickness correspond to **10.70 mm (B)**, please ignore this point and go directly to step 6 as no spacer is required.



**Fig. 5.1**

**Note:** This measurement is required only for the following models: **10PR310, 10PR320, 10PR330, 12PR310, 12PR320** and **12PR330**.

## 6

### Moving assembly centering

Insert the aligning tool on the voice coil recone kit and place the complete moving assembly on the basket, (as shown in the picture) taking care of leaving the voice coil lead wires aligned with the basket connectors. Let the adhesive cure, then take out the aligning tool.



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## Dust Cap

Apply adhesive on the dust cap and position it centered over the cone (voice coil opening).



# 8

## Dust Cap

Place a weight on the dust cap to keep it stable while the adhesive cures.



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## Wires soldering

Solder the voice coil wires to the basket connectors taking care of leaving a bridge to support the natural mechanical excursion of the cone.



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## Polarity check

Check the electrical polarity applying 4.5V DC (from battery or power supply).

Connect the positive pole to the red terminal. You should report an outward movement of the cone.

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## Acoustic check

Apply a sine tone around the resonance frequency of the speaker with the suggested voltage amplitude corresponding to 10-20 Watt.

You shouldn't hear spurious signals or noise due to improper assembly.

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## Suggested Adhesives

<i>Manufacturer</i>	3M	3M	3M	CIBA	CIBA	MOYEN
<i>Model</i>	DP-125	DP-420	DP-190	2011	2012	RS-3087
Voice Coil - Spider	OK		OK	OK	OK	
Spider - Basket	OK	OK		OK	OK	
Paper cone - Basket	OK					OK
Dust cap – Paper cone	OK		OK	OK		OK

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