

9. Apply a bead of MI-1500 2-part epoxy about 1/8" (3mm) wide to the voice coil-to-spider joint area all the way around the coil. Install the cone and apply another bead the same size to the TOP of the cone-to-coil-to-spider joint area. Allow to dry for 1 hour.

See photo # 8.



Photo # 8



10. Lift surround edge and apply a bead of MI-3035 glue around upper frame. Allow to dry 1 to 2 hours. Remove the shim from voice coil and check for free cone movement. Trim and solder the coil leads to the flexible lead-wire.

See photo # 9.



Photo # 9



11. **INSTALL CAP & GASKET:** Run lead-wires through holes in cone as shown and install the dust cap using MI-2000 black adhesive (JBL, EV, Altec styles). For dust caps with a glue lip apply the glue directly to the dust cap lip and then install. **For aluminum caps, be sure to isolate the cap from the lead wires!** Dress the lead-wires using MI-2000 black adhesive. Dry 1 hour.

See photo # 10.



Photo # 10



12. If your recone kit uses an untreated cloth surround, apply MI-1291 edge sealer over entire surround using a small paint brush. Apply a small bead of the sealer around each groove of the surround first and then use the brush to spread evenly.

13. Apply 1/8" (3mm) bead of MI-3035 adhesive to top of surround. Install gasket. Turn speaker over and allow to dry for 1 hour. Solder lead-wires to terminals on speaker frame. Test speaker. Enjoy!

See photo # 11.



Photo # 11



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Speaker Recone Kit



SS Audio ® Speaker Repair Kits

Inside!

Easy to use instructions for
SS Audio ®
speaker recone kits



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Parts Needed

- Utility knife
- Soldering iron & solder
- Masking tape
- Shop vacuum
- Audio amplifier
- Small paint brush
- SS Audio speaker recone kit
- Adhesive kit (if applicable)

Please read all instructions before starting repair.

(These instructions apply to most models, including Altec, JBL, Cerwin Vega, etc.)

1. **CLEAN SPEAKER FRAME:**

Cut the old cone edge all the way around with a utility knife. Cut a circle in the cone around the dust cap. Remove the cone body. Cut out the dust cap.

2. **Take note of the relative height of the ORIGINAL voice coil in the magnet gap.**

Cut the spider all the way around and remove the voice coil & spider assembly. **See photo # 1.**

3. **Cover the voice coil gap with masking tape.**

Scrape all remaining cone & glue from frame using the edge of utility knife. De-solder and remove any lead wire remnants from the speaker terminal. **See photo # 2.**

4. **Clean all dust and debris from inside and outside of speaker frame.**

Make sure all magnetic particles are removed from magnet assembly. Remove tape from magnet gap and inspect gap with flashlight. Use shop vacuum or compressed air to clean around the magnet gap. Clean magnet gap using masking tape folded sticky side out on the edge of a business card. **The magnet gap must be perfectly clean to insure proper operation!**

See photo # 3.



Photo # 1



Photo # 2



Photo # 3



5. **INSTALL COIL & SPIDER:**

Insert the plastic shim around the center pole of the magnet. Position voice coil around the shim and set height (refer to original coil if needed). Coil leads must line up with the terminals on speaker frame. Be sure voice coil is snug against the center pole so it will not move during installation of other parts. If the shim is too thick, you may cut the shim into strips 1" wide and space them equally around the pole piece to insure the voice coil is tight and evenly spaced.

See photo # 4.

6. **Apply a uniform bead of MI-3035 adhesive to the spider landing.**

This glue bead should be about 1/8" (3mm) wide.

See photo # 5.

7. **Install the spider and turn it evenly to distribute the adhesive.**

Clean any extra adhesive from the frame while it is still wet. Be sure the spider is level and straight around the voice coil. Allow the spider adhesive to dry for 1 to 2 hours.

See photo # 6.

8. **INSTALL CONE:**

Dry fit the cone to check for proper fit around the voice coil. There should be a small space all the way around the cone neck to allow the 2-part epoxy adhesive to attach the spider, cone neck, and the voice coil together. If your model has a space between the spider and bottom of the cone, be sure the cone neck is tight when fitted to prevent adhesive running down the voice coil former. Pierce the cone for the lead-wires.

See photo # 7.

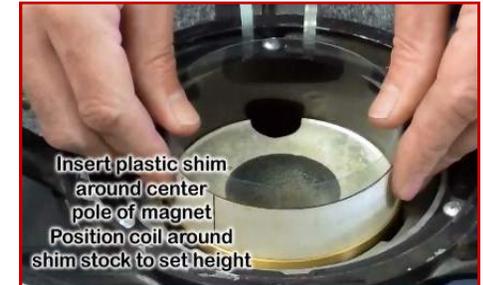


Photo # 4



Photo # 5



Photo # 6



Photo # 7

