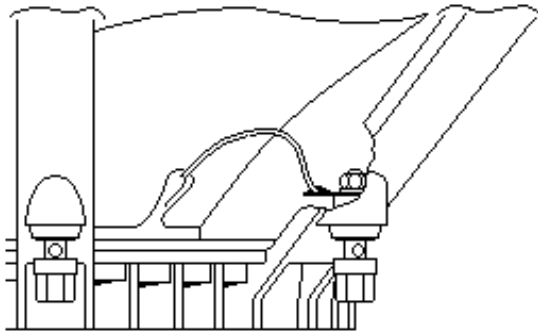




STANDARD RECONING INSTRUCTIONS

This recone kit has been carefully designed to ensure maximum reliability as well as to meet the original specification of the driver. Following these instructions will bring you the assurance that the reconed driver will perform as accurately as originally designed.

Before taking-off the cone assembly, **make a note of how the lead wires are positioned with the terminals as they must be in the same manner after the recone.**



Side view of lead-out braid positioning

1- Using a cutting tool, remove the cone assembly, gaskets and spider, desolder the lead wires from the terminal then carefully inspect the failed moving assembly to determine the cause of the failure. A burned coil can heavily contaminate the air-gap, which will have to be cleaned well. Use the adhesive side of a piece of masking tape, folded over itself, to remove any particles which may exist. Then protect the air-gap covering it with the adhesive tape. This cleaning must be carried out whatever the cause of failure.

2- Use a hot-air gun in conjunction with a scraper to remove ALL the glue left on the basket. The temperature of the hot-air can be set up to 200°C (400°F). Please note that there is no solvent available to remove the glue without damaging the paint of the basket.

3- Now test the assembly position without any glue to be sure that all is OK and test the gasket positioning. For doing that, fit the cone assembly in the speaker basket with the centering gauge located between the pole-piece and the voice-coil former. Slowly push the centering gauge downward until it hits the bottom of the gap. Check that the top of the centering gauge is flush with the top of the voice-coil former : this is the rest position of the diaphragm. If OK, remove all the parts, and apply an even bead of glue of 3 to 4 mm thick in the middle of the areas where the upper surround and the spider will be glued to the frame.

4- Immediately after this fit the cone assembly inside the basket, and do not forget to put the voice-coil centering gauge into position.

5- Apply a slight pressure all around the glued areas (spider + upper surround) in order to be sure that 100% of the contact areas are glued.

6- Immediately after this , apply an even bead of glue onto the outside flat area of the upper surround, then fit the 4 segments of the front gasket into place.

7- Put a flat plywood board on top of the speaker, then position a weight of 4 to 6kg on the board, applying pressure to the newly glued gasket.

8- Leave the driver in this position for at least 2 hours before removing the voice-coil centering gauge.

9- Then solder the lead-out braids in the same way as before : this is of prime importance for the reliability of the reconed speaker

10- Perform a rub test using a sine wave at #40Hz/ MAX. 20V to verify the voice-coil is free of rubbing. If all is OK, you can glue the dust-cap. Please note that this glue joint must be correctly made as it is severely stressed during the speaker operation. Use a piece of adhesive tape forming a "T" for easy handling of the dome. Place the dome central to the cone and load it with a small weight. Check for its correct centering then mark its outline on the cone with a pencil. Remove it and apply an even bead of glue (3 to 4mm thick) exactly on the drawn line. Fit immediately the dust-cap and load it with a small weight. Fill the channel between the edge of the dust-cap and the cone with a bead of glue until the edge of the dust-cap is covered. A bead of 6 – 7mm will suffice for this purpose, after a while it sinks into the shape of the channel. The glue included with the recone kit is the correct glue for this purpose.

11- Let the glue dry for at least 24 hours (48 hours is better) at ambient temperature over 15°C before any use of the loudspeaker.

12- Important : Power the speaker up gradually before applying any high power testing or use. This will ensure the maximum reliability of the driver.

13- RECOMMENDED GLUE :

The glue enclosed with this Kit has been carefully selected and fully qualified for driver reconing. It is a black tinted high temp. nitrile glue in synthetic solvent. Its drying process shows 2 phases : First from 0 to 2 hours is the solvent evaporation (the centering gauge can be removed, but the glue is not yet fully hard) ; the second phase duration is up to 48 hours and is the polymerisation due to ambient moisture leading to a very strong mechanical resistance.

Note : The 25 ml glue tube is suitable for reconing one driver up to 46cm (18").

PHL Audio

461 rue des Chênes, 77590 Chartrettes, France
Tel : +33 (0) 1 6068 7908
Email: contact@phlaudio.com