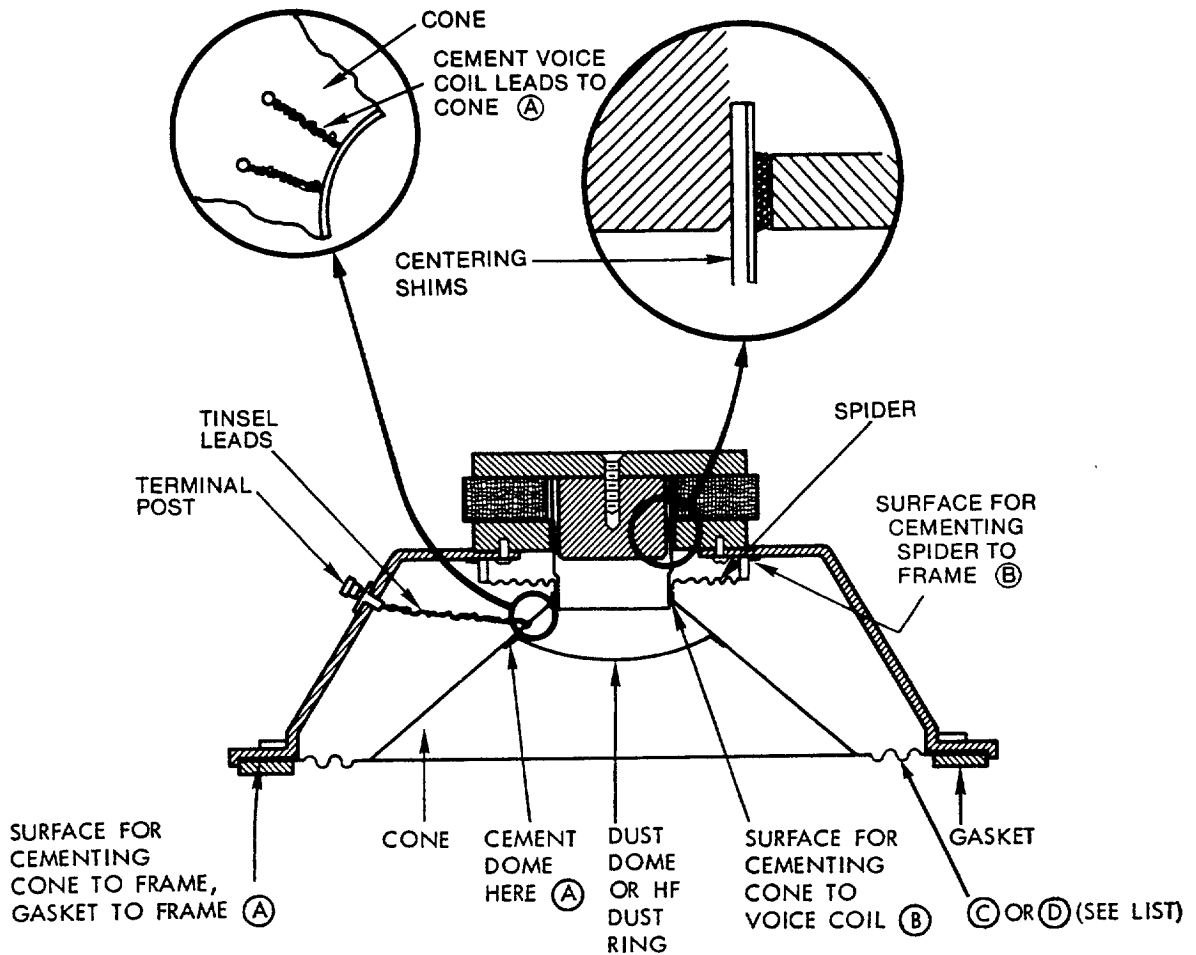




Replacement Diaphragm Assembly Kit B Method



1. Remove speaker from enclosure or mounting baffle and take it to the work area.
2. Unsolder tinsel leads from inner side of terminal posts.
3. Remove gasket ring (or gasket ring segments), cone, spider and voice coil assembly.
4. Cover voice coil gap with masking tape to prevent debris from entering gap.
5. Clean old cement from all surfaces with suitable solvent such as acetone or methyl ethyl ketone (MEK). These solvents may stain the paint, or remove a layer of it. Some types of cement are not soluble, and require scraping with a razor blade. Brush away all debris, particles, etc.
6. Remove masking tape from voice coil gap.
7. Clean foreign material from voice coil gap with a short strip of masking tape, one inch wide. Fold tape back to form a strip with adhesive exposed on both sides. Insert edges of folded tape into voice coil gap to full depth, and wipe clean completely around circular perimeter. Repeat cleaning procedure several times with fresh tape until tape remains clean when withdrawn.
8. Apply proper cement to surface of speaker frame where spider rests. See cement applicability table and speaker illustration.
9. Place new spider assembly loosely in position and insert Armité shims between pole piece and voice coil as shown in the illustration detail. Carefully seat spider on speaker frame, using a twisting motion to center voice coil in gap.

Table of Cement Applicability

Description	Where Used
7008	B
4585 Black	A
54007	C*
54007 15%	D

*Use with R918/421-8A, R421-16, R917-16, R921-16, R904/604-8HP, R604-16HP

NOTE: Voice coil must be aligned with terminals on speaker frame.

10. Fasten spider by pressing down against cemented surface of speaker frame, completely around perimeter of spider. A small amount of cement should flow up through the fibre. Cotton-tipped applicators are useful for running around the spider to push it down. Allow to dry 5 minutes before putting on the cone, and inspect carefully to see that the spider is level.
 11. Apply proper cement to surface of speaker frame where edge of cone rests. See cement applicability table and speaker illustration.
 12. Place new cone loosely in position, checking that voice coil leads are inside cone apex and aligned with eyelets in cone.
 13. Fasten outer edge of cone by pressing down against cemented surface of speaker frame, completely around perimeter of cone.
- NOTE:** Be certain that cone apex is free and evenly spaced around voice coil support junction. Allow apex to seek its own level on voice coil form.
14. Apply proper cement to area of cone apex-voice coil support junction. See cement applicability table and speaker illustration.

NOTE: While cement is still wet, lay voice coil leads along inside surface of cone.

15. Allow ten to fifteen minutes of drying time for cone-voice coil junction cement, before passing voice coil leads through eyelets in cone.
16. Cover voice coil leads neatly with proper cement. See cement applicability table and speaker illustration.
17. Cement gasket segments in place with proper cement. See cement applicability table and speaker illustration.
18. Place speaker (cone oriented down) on top of gasket segments as soon as possible, to press gasket in place. Leave in position at least four hours while cement sets. Do not attempt to move speaker during this drying time.
19. Remove centering shims and check that no foreign material is in voice coil gap.

NOTE: A clicking sound may be heard if leads are short-circuited, and cone/voice coil assembly is depressed in gap.

20. Solder leads of voice coil to terminal posts, allowing enough slack for full cone excursion, but not so much slack that leads may touch one another or the speaker frame.
21. Place a small piece of masking tape on top of dust cap dome to use as a handle. Apply a small bead of proper cement to flange of dust cap. See cement applicability table and speaker illustration.
22. Place dust cap on cone and press edge against cone to seat.
23. Allow 24 hours to dry, and reinstall speaker.



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