

Electro-Voice® SERVICE DATA

SRO/12 CONE KIT 85870

*Drop of Damping Comp
Rubber cement
epoxy*

TOOLS REQUIRED

Knife
Solder iron

Frame cleaning tool (Figure 1)
Light weight

CEMENTS

1. Resiweld: 1 part No. 97012 to 2 parts No. 97008. *epoxy*
2. Rubber Cement No. 9749.
3. Black Cap Cement No. 9741. *97345*
4. Damping Compound No. 97136. *97246*

CURING

Resiweld — Time: Over night (8 hours)
Heat: Until solid plus allow to set ½-hour.

Rubber Cement — Allow to set up. Apply NO heat. (½-hour).

Black Cap Cement — Allow to set up. Apply NO heat (1 hour).

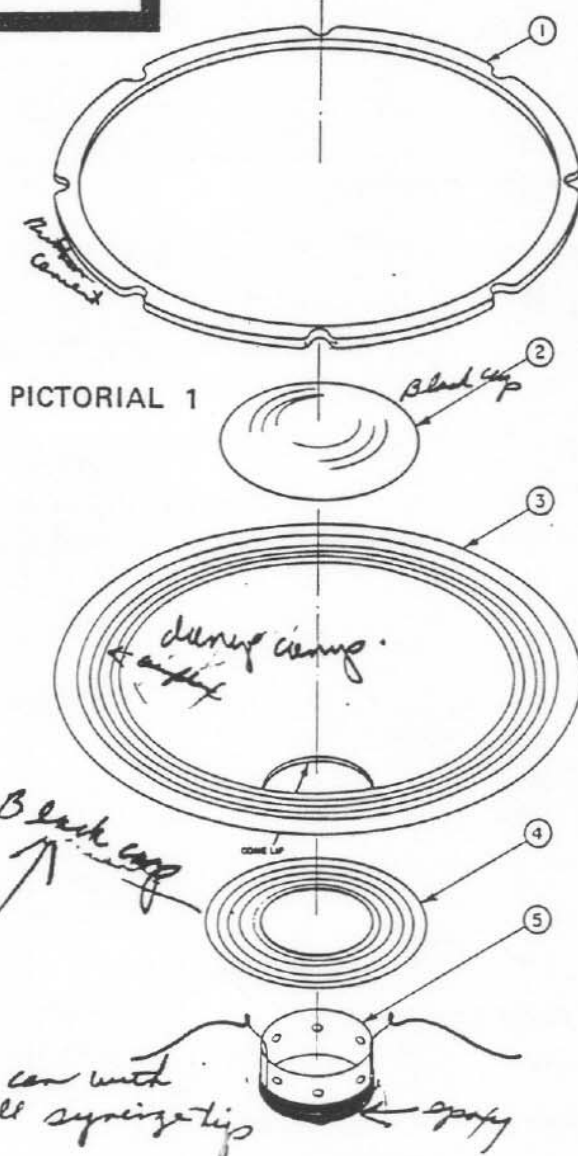
SPEAKER LIFE EXPECTANCY

Under normal use the speaker life expectancy is determined by the "points of flex" on the lead wires. Proper soldering and the use of rubber cement for a flex relief as described at these points will permit the longest possible speaker life expectancy.

COIL FORM CENTERING FIXTURE 87772-F1

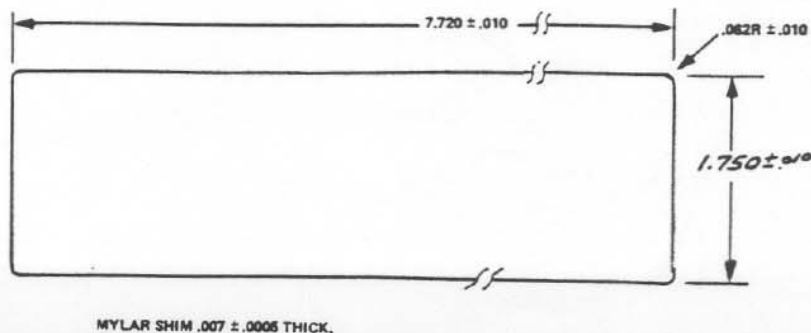
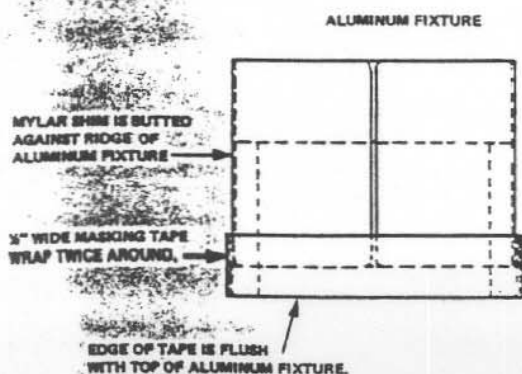
Electro-Voice supplies the coil form centering fixture assembly (Pictorial 2). However, occasionally a fixture assembly may require repair. The special Mylar shim is available from Electro-Voice.

Special care must be taken in preparing the assembly. Place the special Mylar shim on the aluminum fixture, fitting it snug against the fixture ridge (Pictorial 2). Secure the Mylar shim in position using ½-inch masking tape, wrapping tape around sleeve twice. Tape must be flush with end of aluminum sleeve.



PARTS LIST

REF NO	PART NO.	DESCRIPTION
1	37248	Gasket
2	7271	Dome - Dust
3	A79195	Cone
4	79194	Spider
5	87772-XX	Coil Form Assembly



PICTORIAL 2

Under the use...

PREPARING SPEAKER FRAME

The speaker frame and pot assembly must be completely clean when installing a new cone kit. Remove the defective cone and spider by simply cutting it out with a knife. Remove rubber cement from speaker frame and pot assembly (Figure 1). A file cut down and sharpened as shown is the best tool for this purpose. Use methyl-ethyl-ketone (MEK) solvent to aid cleaning. Clean the pot assembly air gap with a folded piece of adhesive tape with the adhesive surface facing out.

Cover air gap completely with tape to prevent particles from entering.

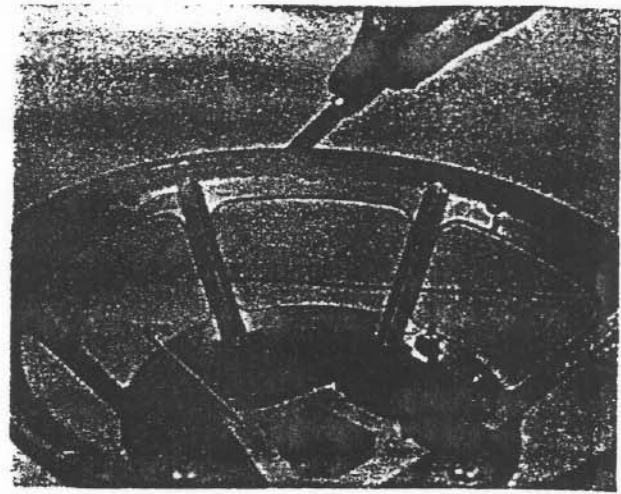
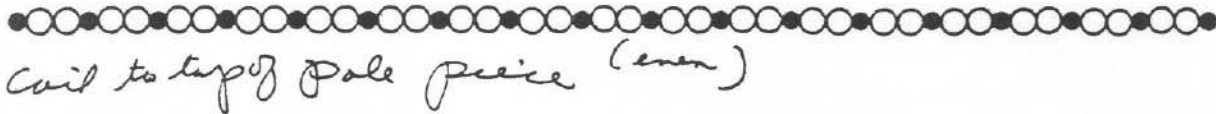


FIGURE 1



INSTALLING CONE KIT

Cone kit preparations and cautions (Pictorial 1):

CAUTION: A critical point exists where the coil leads come off the coil form (5). Care must be exercised at all times not to accidentally bend a coil lead.

Check the cone (3) lip for easy fitting over coil form and spider lip. The cone lip must easily set over the lip of spider. If necessary, enlarge the cone lip inside diameter. Note — Do not enlarge the spider lip.

Punch two lead wire holes in the speaker cone (3). Locate these holes $\frac{1}{4}$ -inch apart and $\frac{1}{4}$ -inch from cone lip (Figure 2).

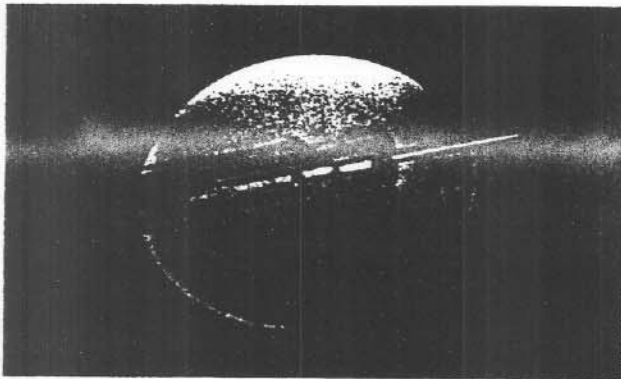


FIGURE 2

1. Set the coil form centering fixture assembly upright on a workbench. Slide the coil form assembly (5) over shim on fixture until end of coil form touches tape on the centering fixture (Figure 3).
2. Place coil and fixture on pot structure assembly (Figure 4). Place coil form wire leads inside the centering fixture.

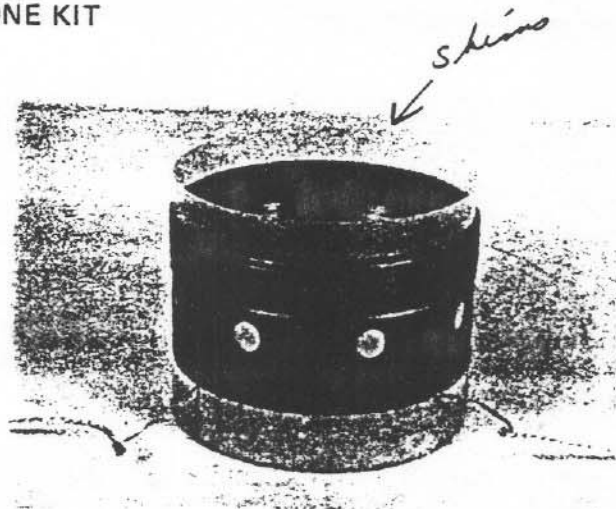


FIGURE 3

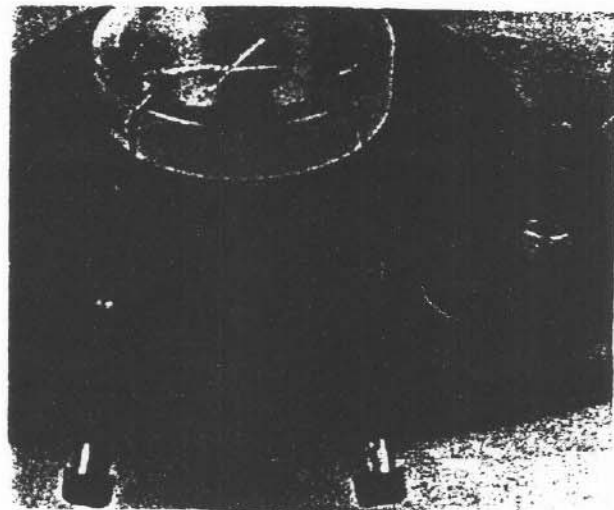
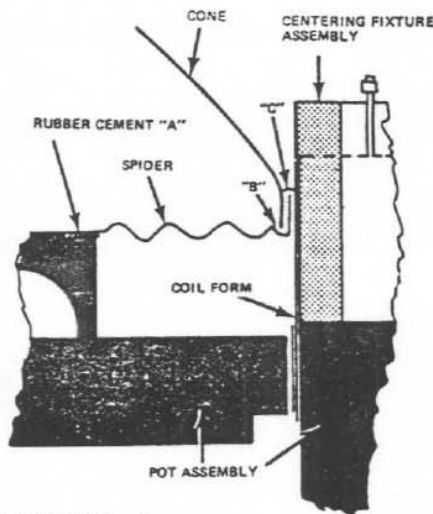


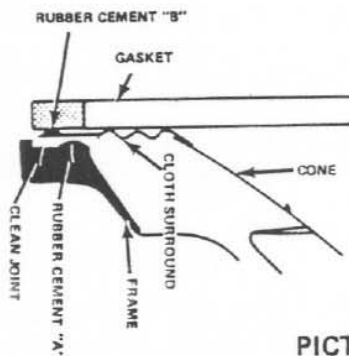
FIGURE 4

- Place a generous bead of No. 9749 rubber cement along the inner edge of speaker frame (Pictorial 3 "A"). Carefully slip spider (4) over coil form and centering fixture shim and properly seat on speaker frame inner edge.



PICTORIAL 3

- Place a generous bead of No. 9749 rubber cement along the outer edge of frame basket (Pictorial 4 "A"). Orientate cone lead wire holes properly with speaker terminals. Place cone (3) over coil form and seat properly to rest lip of cone on spider as shown in Pictorial 3 "B". Seat edge of cone on speaker frame (Pictorial 4).



PICTORIAL 4

Apply rubber cement along outer edge of the cone's cloth surround (Pictorial 4 "B"). Place gasket (1) in proper position and secure to frame. Periodically check seating of gasket on frame during following steps to ensure uniform curing.

- Place a bead of Resiweld completely around corner formed by the cone and coil form (Pictorial 3 "C").

CAUTION— Do not glue the coil form to the centering fixture shim during any point of this step.

Wrap the slack in the coil flat lead wire around the braided lead wire next to the wire clamp (Figure 5). Push free ends of braided lead wires through cone holes. Place wire clamps next to coil form and Resiweld wire wrap. Push coil wire against outside of coil form and apply additional Resiweld between clamp, coil wire, and coil form (Figure 6).

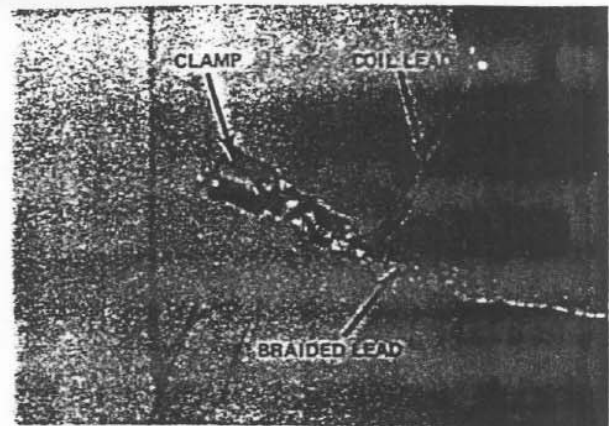
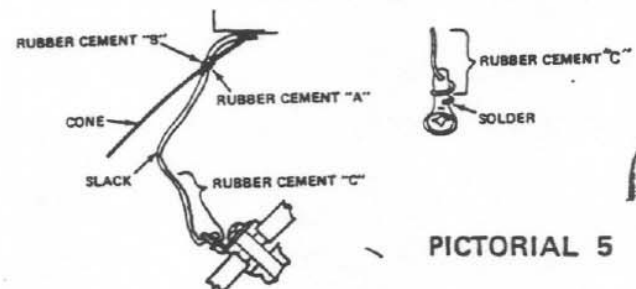


FIGURE 5

- Cure Resiweld and rubber cement. Place a weight (or a second twelve-inch speaker) over gasket for curing rubber cement uniformly.
- After curing of Resiweld, remove centering fixture from pot assembly. Apply rubber cement No. 9749 to lead wires as shown in Pictorial 5 "A" and "B." Bridge lead wires away from cone as shown in Figure 6. Leave a small amount of slack in lead wires and solder lead wires to terminal lugs, being careful *not* to place any solder in the lug eyelets. Trim excess wire lead. After solder has cooled, apply rubber cement to lead wires and end of lugs (Pictorial 5 "C").



FIGURE 6



PICTORIAL 5

- Cure rubber cement.
- Place the dust dome (1) in position and weigh down with a light weight to keep in position. Apply a bead of Black Cap cement No. 9741 around edge of dome.
- Apply damping compound on the cloth cone surround (E-V No. 97136).