01. Membrane cutting
Please remove the damaged moving assembly.
Cut the membrane with a sharp edge tool.

02. Voice coil removing
Unsold the output voice coil wirings.
Cut the spider in the gluing area, keeping care of not creating metal particles that could be hidden into the magnetic gap.

03. Magnetic gap protection
Protect the magnetic gap via adhesive tape.
04. **Gaskets removal**  
**Spider area cleaning**  
Remove the gaskets and the remaining spider parts  
For best result we suggest to use a lathe, in order to remove completely gluing residues possibly left on magnetic complex and basket.

05. **Magnetic gap cleaning**

06. **Gluing dispensing on suspension and spider areas**  
Apply the glue on the suspension and spider metal areas. It is recommended to use solvent base glue, or bi-component epoxy.  
For DSS (Double Silicon Spider) technology products we recommend to use specific bi-component epoxy glue.
07 Moving assembly centering
Insert the supplied aligning tool (see figure below), using it for centring the moving assembly.
Keep care of leaving the voice coil connection wires nearby basket’s electrical connectors.

08 Gluing dispensing over gaskets area
Distribute the proper glue over the membrane’s suspension, in order to fix the gasket(s) provided in the packaging.

09 Gaskets positioning
Place the gasket(s)
10 **Gluing polymerisation**
Let the glue polymerise for at least 24 hours without touching or moving.
This will allow the glue to complete the entire polymerisation process, necessary to obtain the best power handling performances.

11 **Positioning dust cap**
After 24 hour time please apply glue over the dust cap external area. Position it centred over the membrane, placing a weight over for keeping it stable.
If necessary please apply an extra adhesive layer as shown in the picture below on the right.

12 **Wiring soldering**
Sold the voice coil wiring terminals to the basket related connectors, taking care of leaving a little “bridge” adequate to support the natural mechanical excursion of the membrane. Finally provide to cut the exceeding wiring part.
13 Polarity check

Check the electrical polarity via a 4.5V DC battery.

Connecting the battery positive pole to the speaker red (plus) terminal you should report a positive (toward high) movement of the speaker moving assembly.

14 Acoustic check

If possible please apply a 20Hz sine tone with voltage amplitude between 10V and 20V RMS.

For little size speakers, like a 6inch 4 Ohm one, please apply 10V; for big size ones, like 18 inch 8ohm, please apply 20V.

While applying this signal you should be able to verify acoustically that there are no spurious signal (such like rubbing or buzzing) due to bad moving assembly aligning.