

## SSR Custom Alpine Type R Recone Kit

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**BEFORE YOU BEGIN: READ ALL THE WAY THROUGH INSTRUCTIONS TO  
AVOID SURPRISES LATER!!!**

**\*\*DO STEPS 1-6 "DRY" (NO GLUE) FIRST TO MAKE SURE YOU GET EVERYTHING  
LINED UP CORRECTLY\*\***

**1** - You will shim the coil in place, and then set your cone in place. Make sure the leads on the coil either line up with where your terminals will be, or so that they are perpendicular to where the terminals will be for easy connection later. Then you'll raise the coil up or lower it down until it grads your cone by about 1/4". This will be your coil height. Add shims so the coil stays there nice and tight. (If additional shims are needed, use some kind of thin, stiff plastic, or business cards) Remove the cone, and start building sub like a birthday cake.

**2** - Lay the 1st spider in place with the inner lip up, then add a bead of black glue to the bottom side of the terminal ring, and lay it in place. Put in the crews to hold it down in place, (Glued on top of the bottom spider)

**3** - Glue the bottom spider to the coil with clear CA glue, and spray with 2 shots of accelerator.

**4** - Lay a bead of black glue to the top side of the terminal ring, and lay your top spider in place with the inner lip up. (DO NOT USE CA GLUE ON THIS SPIDER YET)

**5** - Set your cone in place to check for fit. Make sure that your cone slides down over the inner lip of the spider so that the lip is tucked inside the cone. You should be nearly perfect on your height because of step 1.

**6** - If all is good, then remove your cone, and place a bead of black glue around the outside diameter of the basket where the cone surround will attach, and set your cone back in place, with lead wire holes adjacent to outside terminals. (You will poke 2 more lead wire holes later). Now wait 30 minutes for glue to begin curing.

***...Wait 45 minutes, then continue to step #7 below...***

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- 7** - IF YOUR SUB DOES NOT HAVE A RUBBER MOUNTING BOOT/GASKET - Glue included Rubitex gasket pieces in place with black glue, and hold in place with clothes pins or small clamps. Use as many as you deem necessary.
- 8** - Lay a heavy bead of CA glue around the cone/spider/coil joint to make sure you get enough glue on all 3 pieces. Spray with 5-6 sprays of accelerator. DO NOT USE TOO MUCH ACCELERATOR AS IT WILL WEAKEN THE JOINT!!
- 9** - With an awl, or other sharp round tool; poke 2 more holes through the cone for your lead wires. Poke the holes adjacent to the original guide holes, and to the remaining outside terminals.
- 10** - Cut your lead wire into 4 equal pieces. Wrap the each of the coil leads around a piece of lead wire, and solder together. Slide lead wires through holes in cone toward your outside terminals. NOTE: The coil leads are grouped in pairs at the top of the coil former. Each pair is one coil, and the +/- polarity is already lined up with the corresponding outside terminals, so run your lead wires accordingly.
- 11** - Glue lead wires down inside sub near cone/spider/coil joint. MAKE SURE NONE OF THE WIRES ARE TOUCHING EACH OTHER. Don't be stingy on the glue here. This is very important. You can use either glue for this step, but make sure there is enough there to keep the wires from vibrating loose later.
- 12** - REMOVE ALL SHIMS!!
- 13** - Glue dust cap in place using black glue. Set a small weight in the center to hold the dust cap tight in place while the adhesive begins to cure. (Ideally you will leave weight there for 2 hours while you finish the rest of the work)
- 14** - Run your lead wires to the outside terminals. Slide included shrink tubing over each lead, and use lighter or heat gun to shrink in place. This will coat the lead wires, and prevent shorting something out later. Solder them in place leaving a healthy C-shaped arc in each one. Leave enough to allow full excursion of the sub without tightening up/snapping a lead, but not so much that there is too much sloppy slack that will touch other things and cause damage. Trim off the excess.
- 15** - Let the whole thing sit for 36 hours

**Enjoy the thump!!**

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