



TECHNICAL INFORMATION BULLETIN

TITLE: USING 3M 1300L ADHESIVES - RECONE

NAME: TB-004

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DATE: July 19, 1991

During qualification of our new JBL 3" voice coil "M" series drivers, a very effective method of installing recone kits using the 3M brand 1300L adhesive was developed.

To attain the superior bonding qualities of this adhesive requires a longer curing period to reach fixture strength than Bostik or brown glue. During this curing period, care must be taken to avoid separation of spider from the loudspeaker frame. The following technique will assure maximum bond:

1. Be sure the frame has been cleaned thoroughly and is free of dust and grease.
2. Apply a thin coat of glue to the spider and the compliance where they will contact the frame.
3. Apply the usual bead of adhesive to the frame at the spider land and compliance land.
4. Allow these glue beads to dry for approximately 3 minutes. The beads will "skin over" and become very tacky.
5. Install the cone kit as normal. The tackiness of the pre-drying of the glue beads will hold the compliance and spider in place during curing.
6. After the tinsel leads have been soldered and the transducer is ready to set aside for curing, press the spider down onto the spider land of the frame one final time using a dry wooden stick such as a popsicle stick.

Do not use M.E.K (methyl-ethyl-keytone) during this final process. MEK does not "reactivate" 1330L as it does Bostik.

7. Allow the reconed speaker to cure, undisturbed, overnight before applying power.

This technique is now being used very successfully during factory assembly of our 600-watt woofers as well as the new "M" series transducers. Please also ensure that only the 1300L adhesive supplied with our 600-watt recone kits is used when reconing. This glue is identified with a red cap.