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Springfield Speaker 2F15-Onkyo

Springfield Speaker 15-inch Foam Edge Surround Repair Kit Instruction Manual

Model: 2F15-Onkyo

INTRODUCTION

This manual provides detailed instructions for installing the Springfield Speaker 15-inch Foam Edge Surround Repair Kit. This kit is designed to restore the performance of your speaker drivers by replacing deteriorated foam surrounds. Following these steps carefully will ensure a successful repair and extend the life of your audio equipment.

KIT CONTENTS

Your Springfield Speaker repair kit includes the following components:

- 2 Premium American-made Foam Surrounds (enough for 2 speakers)
- Step-by-step installation instructions (printed sheet)
- 1 Bottle of professional-grade adhesive (solvent-based)
- 1 Adhesive application brush
- Voice coil shims (included for centering, though not explicitly used in all steps)



Image showing the complete Springfield Speaker 15-inch Foam Edge Surround Repair Kit, including two foam surrounds, a bottle of adhesive, and an application brush.

PRODUCT SPECIFICATIONS

This repair kit is designed for 15-inch speakers, including Onkyo S-55 and S-58 models.

Foam Surround Dimensions

Measurement	Value
Outer Diameter	14.75" (375mm)
Outer Roll Diameter	13.5" (343mm)
Cone Diameter	12.125" (308mm)
Inner Diameter	11.5" (292mm)
Roll Width	3/4" (19mm)
Inner Attachment	Flat

INSTALLATION INSTRUCTIONS







Before beginning the repair process, ensure you have a clean, well-lit workspace. It is crucial to remove the speaker from its cabinet before starting.

Required Tools

- Box cutter or razor knife
- Chisel (Optional)
- Sharpie (or similar size marker)
- Rubbing alcohol
- Cotton swabs
- Paper towel (or soft rag)

Step-by-Step Guide

1. **Step 1:** Slice down the middle of the damaged surround all the way around the speaker.

<p>Step 2 – Using your razor knife; Slice down the middle of the damaged surround all the way around the speaker. See figure 1</p>	 <p>Figure 1</p>
<p>Step 3 – Slowly and carefully peel the damaged surround from the cone. Be especially careful not to damage the cone. See figure 2</p>	 <p>Figure 2</p>
<p>Step 4 – Slip the point of your razor knife between the gasket and the speaker frame. Apply pressure and slowly turn the speaker to cut the gasket away from the frame. You must be very careful to salvage the gasket to reuse it later. NEVER pull the blade toward you. Carefully remove the gasket and set it aside to reuse later. See figure 3</p>	 <p>Figure 3</p>
<p>Step 5 – Using a chisel or your razor knife; remove any and all foam residue from the speaker frame. You don't necessarily have to remove all of the glue residue, but you MUST remove ALL of the foam residue. See figure 4</p>	 <p>Figure 4</p>
<p>Step 6 – Using a cotton swab; apply rubbing alcohol to foam and glue residue around edge of cone. Don't be afraid to saturate the cone edge if it is made of poly, be more careful with a paper cone. Allow to soak for 1-2 minutes. See figure 5</p>	 <p>Figure 5</p>
<p>Step 7 – Using your thumbnail, or a razor blade held perpendicular to the surface, scrape away all foam residue. Be VERY careful not to damage the cone. Especially if you saturated it in the previous step. While scraping, use your other hand to gently provide additional support from underneath the edge of the cone. See figure 6</p>	 <p>Figure 6</p>
<p>Step 8 – Use paper towel or a soft cotton rag dipped in rubbing alcohol to gently do a finishing wipe-down of cone edge and speaker frame. Allow cone and frame to dry completely. See figure 7</p>	

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Figure 1 from the instruction sheet, illustrating a hand using a razor knife to cut through the old foam surround on a speaker cone.

2. **Step 2:** Slowly and carefully peel the damaged surround from the cone. Be especially careful not to damage the cone.

Step 2 – Using your razor knife; Slice down the middle of the damaged surround all the way around the speaker. **See figure 1**



Step 3 – Slowly and carefully peel the damaged surround from the cone. Be especially careful not to damage the cone. **See figure 2**



Step 4 – Slip the point of your razor knife between the gasket and the speaker frame. Apply pressure and slowly turn the speaker to cut the gasket away from the frame. You must be very careful to salvage the gasket to reuse it later. **NEVER** pull the blade toward you. Carefully remove the gasket and set it aside to reuse later. **See figure 3**



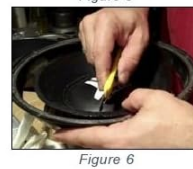
Step 5 – Using a chisel or your razor knife; remove any and all foam residue from the speaker frame. You don't necessarily have to remove all of the glue residue, but you **MUST** remove **ALL** of the foam residue. **See figure 4**



Step 6 – Using a cotton swab; apply rubbing alcohol to foam and glue residue around edge of cone. Don't be afraid to saturate the cone edge if it is made of poly, be more careful with a paper cone. Allow to soak for 1-2 minutes. **See figure 5**



Step 7 – Using your thumbnail, or a razor blade held perpendicular to the surface, scrape away all foam residue. Be **VERY** careful not to damage the cone. Especially if you saturated it in the previous step. While scraping, use your other hand to gently provide additional support from underneath the edge of the cone. **See figure 6**



Step 8 – Use paper towel or a soft cotton rag dipped in rubbing alcohol to gently do a finishing wipe-down of cone edge and speaker frame. Allow cone and frame to dry completely. **See figure 7**

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Figure 2 from the instruction sheet, showing a hand gently peeling away a section of the old foam surround from the speaker cone.

- Step 3:** Slip the point of your razor knife between the gasket and the speaker frame. Apply pressure and slowly turn the speaker to cut the gasket away from the frame. You must be very careful to salvage the gasket to reuse it later. **NEVER** pull the blade toward you. Carefully remove the gasket and set it aside to reuse later.

Step 2 – Using your razor knife; Slice down the middle of the damaged surround all the way around the speaker. **See figure 1**



Step 3 – Slowly and carefully peel the damaged surround from the cone. Be especially careful not to damage the cone. **See figure 2**



Step 4 – Slip the point of your razor knife between the gasket and the speaker frame. Apply pressure and slowly turn the speaker to cut the gasket away from the frame. You must be very careful to salvage the gasket to reuse it later. **NEVER** pull the blade toward you. Carefully remove the gasket and set it aside to reuse later. **See figure 3**



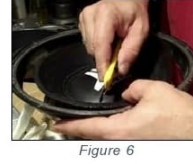
Step 5 – Using a chisel or your razor knife; remove any and all foam residue from the speaker frame. You don't necessarily have to remove all of the glue residue, but you **MUST** remove **ALL** of the foam residue. **See figure 4**



Step 6 – Using a cotton swab; apply rubbing alcohol to foam and glue residue around edge of cone. Don't be afraid to saturate the cone edge if it is made of poly, be more careful with a paper cone. Allow to soak for 1-2 minutes. **See figure 5**



Step 7 – Using your thumbnail, or a razor blade held perpendicular to the surface, scrape away all foam residue. Be **VERY** careful not to damage the cone. Especially if you saturated it in the previous step. While scraping, use your other hand to gently provide additional support from underneath the edge of the cone. **See figure 6**



Step 8 – Use paper towel or a soft cotton rag dipped in rubbing alcohol to gently do a finishing wipe-down of cone edge and speaker frame. Allow cone and frame to dry completely. **See figure 7**

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Figure 3 from the instruction sheet, depicting a razor knife being used to carefully separate the speaker gasket from the frame.

- Step 4:** Using a chisel or your razor knife, remove any and all foam residue from the speaker frame. You don't necessarily have to remove all of the glue residue, but you **MUST** remove **ALL** of the foam residue.

Step 2 – Using your razor knife; Slice down the middle of the damaged surround all the way around the speaker. **See figure 1**

Step 3 – Slowly and carefully peel the damaged surround from the cone. Be especially careful not to damage the cone. **See figure 2**

Step 4 – Slip the point of your razor knife between the gasket and the speaker frame. Apply pressure and slowly turn the speaker to cut the gasket away from the frame. You must be very careful to salvage the gasket to reuse it later. **NEVER** pull the blade toward you. Carefully remove the gasket and set it aside to reuse later. **See figure 3**

Step 5 – Using a chisel or your razor knife; remove any and all foam residue from the speaker frame. You don't necessarily have to remove all of the glue residue, but you **MUST** remove **ALL** of the foam residue. **See figure 4**

Step 6 – Using a cotton swab; apply rubbing alcohol to foam and glue residue around edge of cone. Don't be afraid to saturate the cone edge if it is made of poly, be more careful with a paper cone. Allow to soak for 1-2 minutes. **See figure 5**

Step 7 – Using your thumbnail, or a razor blade held perpendicular to the surface, scrape away all foam residue. Be **VERY** careful not to damage the cone. Especially if you saturated it in the previous step. While scraping, use your other hand to gently provide additional support from underneath the edge of the cone. **See figure 6**

Step 8 – Use paper towel or a soft cotton rag dipped in rubbing alcohol to gently do a finishing wipe-down of cone edge and speaker frame. Allow cone and frame to dry completely. **See figure 7**

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Figure 1




Figure 2




Figure 3




Figure 4




Figure 5




Figure 6

Figure 4 from the instruction sheet, showing a tool scraping off foam residue from the speaker frame.

5. **Step 5:** Using a cotton swab, apply rubbing alcohol to foam and glue residue around the edge of the cone. Don't be afraid to saturate the cone edge if it is made of poly; be more careful with a paper cone. Allow to soak for 1-2 minutes.

Step 2 – Using your razor knife; Slice down the middle of the damaged surround all the way around the speaker. **See figure 1**

Step 3 – Slowly and carefully peel the damaged surround from the cone. Be especially careful not to damage the cone. **See figure 2**

Step 4 – Slip the point of your razor knife between the gasket and the speaker frame. Apply pressure and slowly turn the speaker to cut the gasket away from the frame. You must be very careful to salvage the gasket to reuse it later. **NEVER** pull the blade toward you. Carefully remove the gasket and set it aside to reuse later. **See figure 3**

Step 5 – Using a chisel or your razor knife; remove any and all foam residue from the speaker frame. You don't necessarily have to remove all of the glue residue, but you **MUST** remove **ALL** of the foam residue. **See figure 4**

Step 6 – Using a cotton swab; apply rubbing alcohol to foam and glue residue around edge of cone. Don't be afraid to saturate the cone edge if it is made of poly, be more careful with a paper cone. Allow to soak for 1-2 minutes. **See figure 5**

Step 7 – Using your thumbnail, or a razor blade held perpendicular to the surface, scrape away all foam residue. Be **VERY** careful not to damage the cone. Especially if you saturated it in the previous step. While scraping, use your other hand to gently provide additional support from underneath the edge of the cone. **See figure 6**

Step 8 – Use paper towel or a soft cotton rag dipped in rubbing alcohol to gently do a finishing wipe-down of cone edge and speaker frame. Allow cone and frame to dry completely. **See figure 7**

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Figure 1




Figure 2




Figure 3




Figure 4




Figure 5




Figure 6

Figure 5 from the instruction sheet, illustrating a cotton swab applying rubbing alcohol to the speaker cone edge to loosen residue.

6. **Step 6:** Using your thumbnail, or a razor blade held perpendicular to the surface, scrape away all foam residue. Be **VERY** careful not to damage the cone. Especially if you saturated it in the previous step. While scraping, use your other hand to gently provide additional support from underneath the edge of the cone.

Step 2 – Using your razor knife; Slice down the middle of the damaged surround all the way around the speaker. **See figure 1**



Step 3 – Slowly and carefully peel the damaged surround from the cone. Be especially careful not to damage the cone. **See figure 2**



Step 4 – Slip the point of your razor knife between the gasket and the speaker frame. Apply pressure and slowly turn the speaker to cut the gasket away from the frame. You must be very careful to salvage the gasket to reuse it later. **NEVER** pull the blade toward you. Carefully remove the gasket and set it aside to reuse later. **See figure 3**



Step 5 – Using a chisel or your razor knife; remove any and all foam residue from the speaker frame. You don't necessarily have to remove all of the glue residue, but you **MUST** remove **ALL** of the foam residue. **See figure 4**



Step 6 – Using a cotton swab; apply rubbing alcohol to foam and glue residue around edge of cone. Don't be afraid to saturate the cone edge if it is made of poly, be more careful with a paper cone. Allow to soak for 1-2 minutes. **See figure 5**



Step 7 – Using your thumbnail, or a razor blade held perpendicular to the surface, scrape away all foam residue. Be **VERY** careful not to damage the cone. Especially if you saturated it in the previous step. While scraping, use your other hand to gently provide additional support from underneath the edge of the cone. **See figure 6**



Step 8 – Use paper towel or a soft cotton rag dipped in rubbing alcohol to gently do a finishing wipe-down of cone edge and speaker frame. Allow cone and frame to dry completely. **See figure 7**

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Figure 6 from the instruction sheet, showing a hand using a thumbnail to carefully scrape remaining foam residue from the speaker cone.

- Step 7:** Use a paper towel or a soft cotton rag dipped in rubbing alcohol to gently do a finishing wipe-down of the cone edge and speaker frame. Allow cone and frame to dry completely.

Step 9 – Place new foam surround in place upside down to test fit. Use your fingers to move cone into place and make a visual note of how new surround will lie in relation to cone. **See figure 8 ++Read ahead before continuing because once you hit the next step there is no turning back.++**

Step 10 – Read instructions included with your adhesive, and move to well-ventilated area prior to continuing. With surround still in place upside down; carefully apply small bead of adhesive to innermost flange/lip of surround. Use bottle tip to evenly spread adhesive around the inner flange/lip as it is applied. Allow adhesive to breathe for a few seconds. **See figure 9**

Step 11 – After allowing your adhesive to breathe; carefully pick up your surround, flip it right side up, and carefully lay it in place. Be sure to lay it in place correctly the first time, as it will begin to stick immediately. **See figure 10**

Step 12 – With new surround properly placed; use your finger, the butt end of a sharpie, or something similar to gently press the surround into place. Slowly trace your way around the edge to help the adhesive bond to take. Carefully repeat this step 3-4 times over the next 10 minutes. **See figure 11**

Step 13 – Use a paper towel lightly dampened with warm water or nail polish remover to clean up extra glue residue before it dries, and then **Take a 45-60 minute break...**

Step 14 – Now that your first adhesive application has cured a little bit; use the butt end of your sharpie to gently hold the outer edge of the surround away from the frame while you apply adhesive to the surface of the speaker frame where the surround will attach. Apply adhesive all the way around the frame. Allow surround to fall into place on the frame. **See figure 12**

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Figure 7




Figure 8




Figure 9




Figure 10




Figure 11




Figure 12

Figure 7 from the instruction sheet, depicting a hand wiping the speaker cone edge with a paper towel soaked in rubbing alcohol.

8. **Step 8:** Place the new foam surround in place upside down to test fit. Use your fingers to move the cone into place and make a visual note of how the new surround will lie in relation to the cone. **Read ahead before continuing because once you hit the next step there is no turning back.**

Step 9 – Place new foam surround in place upside down to test fit. Use your fingers to move cone into place and make a visual note of how new surround will lie in relation to cone. **See figure 8 ++Read ahead before continuing because once you hit the next step there is no turning back.++**

Step 10 – Read instructions included with your adhesive, and move to well-ventilated area prior to continuing. With surround still in place upside down; carefully apply small bead of adhesive to innermost flange/lip of surround. Use bottle tip to evenly spread adhesive around the inner flange/lip as it is applied. Allow adhesive to breathe for a few seconds. **See figure 9**

Step 11 – After allowing your adhesive to breathe; carefully pick up your surround, flip it right side up, and carefully lay it in place. Be sure to lay it in place correctly the first time, as it will begin to stick immediately. **See figure 10**

Step 12 – With new surround properly placed; use your finger, the butt end of a sharpie, or something similar to gently press the surround into place. Slowly trace your way around the edge to help the adhesive bond to take. Carefully repeat this step 3-4 times over the next 10 minutes. **See figure 11**

Step 13 – Use a paper towel lightly dampened with warm water or nail polish remover to clean up extra glue residue before it dries, and then **Take a 45-60 minute break...**

Step 14 – Now that your first adhesive application has cured a little bit; use the butt end of your sharpie to gently hold the outer edge of the surround away from the frame while you apply adhesive to the surface of the speaker frame where the surround will attach. Apply adhesive all the way around the frame. Allow surround to fall into place on the frame. **See figure 12**

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Figure 7




Figure 8




Figure 9




Figure 10




Figure 11




Figure 12

Figure 8 from the instruction sheet, showing a new foam surround placed upside down on the speaker cone for a test fit.

- Step 9:** Read instructions included with your adhesive, and move to a well-ventilated area prior to continuing. With the surround still in place upside down, carefully apply a small bead of adhesive to the innermost flange/lip of the surround. Use the bottle tip to evenly spread adhesive around the inner flange/lip as it is applied. Allow adhesive to breathe for a few seconds.

Step 9 – Place new foam surround in place upside down to test fit. Use your fingers to move cone into place and make a visual note of how new surround will lie in relation to cone.

See figure 8 ++Read ahead before continuing because once you hit the next step there is no turning back.++

Step 10 – Read instructions included with your adhesive, and move to well-ventilated area prior to continuing. With surround still in place upside down; carefully apply small bead of adhesive to innermost flange/lip of surround. Use bottle tip to evenly spread adhesive around the inner flange/lip as it is applied. Allow adhesive to breathe for a few seconds. **See figure 9**

Step 11 – After allowing your adhesive to breathe; carefully pick up your surround, flip it right side up, and carefully lay it in place. Be sure to lay it in place correctly the first time, as it will begin to stick immediately. **See figure 10**

Step 12 – With new surround properly placed; use your finger, the butt end of a sharpie, or something similar to gently press the surround into place. Slowly trace your way around the edge to help the adhesive bond to take. Carefully repeat this step 3-4 times over the next 10 minutes. **See figure 11**

Step 13 – Use a paper towel lightly dampened with warm water or nail polish remover to clean up extra glue residue before it dries, and then **Take a 45-60 minute break...**

Step 14 – Now that your first adhesive application has cured a little bit; use the butt end of your sharpie to gently hold the outer edge of the surround away from the frame while you apply adhesive to the surface of the speaker frame where the surround will attach. Apply adhesive all the way around the frame. Allow surround to fall into place on the frame. **See figure 12**



Figure 7



Figure 8



Figure 9



Figure 10



Figure 11



Figure 12

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Figure 9 from the instruction sheet, illustrating applying a bead of adhesive to the inner flange of the new foam surround while it is upside down on the speaker.

- Step 10:** After allowing your adhesive to breathe, carefully pick up your surround, flip it right side up, and carefully lay it in place. Be sure to lay it in place correctly the first time, as it will begin to stick immediately.

Step 9 – Place new foam surround in place upside down to test fit. Use your fingers to move cone into place and make a visual note of how new surround will lie in relation to cone.

See figure 8 ++Read ahead before continuing because once you hit the next step there is no turning back.++

Step 10 – Read instructions included with your adhesive, and move to well-ventilated area prior to continuing. With surround still in place upside down; carefully apply small bead of adhesive to innermost flange/lip of surround. Use bottle tip to evenly spread adhesive around the inner flange/lip as it is applied. Allow adhesive to breathe for a few seconds. **See figure 9**

Step 11 – After allowing your adhesive to breathe; carefully pick up your surround, flip it right side up, and carefully lay it in place. Be sure to lay it in place correctly the first time, as it will begin to stick immediately. **See figure 10**

Step 12 – With new surround properly placed; use your finger, the butt end of a sharpie, or something similar to gently press the surround into place. Slowly trace your way around the edge to help the adhesive bond to take. Carefully repeat this step 3-4 times over the next 10 minutes. **See figure 11**

Step 13 – Use a paper towel lightly dampened with warm water or nail polish remover to clean up extra glue residue before it dries, and then **Take a 45-60 minute break...**

Step 14 – Now that your first adhesive application has cured a little bit; use the butt end of your sharpie to gently hold the outer edge of the surround away from the frame while you apply adhesive to the surface of the speaker frame where the surround will attach. Apply adhesive all the way around the frame. Allow surround to fall into place on the frame. **See figure 12**



Figure 7



Figure 8



Figure 9



Figure 10



Figure 11



Figure 12

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Figure 10 from the instruction sheet, showing carefully placing the new foam surround, right side up, onto the speaker cone after adhesive application.

11. **Step 11:** With the new surround properly placed, use your finger, the butt end of a sharpie, or something similar to gently press the surround into place. Slowly trace your way around the edge to help the adhesive bond to take. Carefully repeat this step 3-4 times over the next 10 minutes.

Step 9 – Place new foam surround in place upside down to test fit. Use your fingers to move cone into place and make a visual note of how new surround will lie in relation to cone.

See figure 8 ++Read ahead before continuing because once you hit the next step there is no turning back.++

Step 10 – Read instructions included with your adhesive, and move to well-ventilated area prior to continuing. With surround still in place upside down; carefully apply small bead of adhesive to innermost flange/lip of surround. Use bottle tip to evenly spread adhesive around the inner flange/lip as it is applied. Allow adhesive to breathe for a few seconds. **See figure 9**

Step 11 – After allowing your adhesive to breathe; carefully pick up your surround, flip it right side up, and carefully lay it in place. Be sure to lay it in place correctly the first time, as it will begin to stick immediately. **See figure 10**

Step 12 – With new surround properly placed; use your finger, the butt end of a sharpie, or something similar to gently press the surround into place. Slowly trace your way around the edge to help the adhesive bond to take. Carefully repeat this step 3-4 times over the next 10 minutes. **See figure 11**

Step 13 – Use a paper towel lightly dampened with warm water or nail polish remover to clean up extra glue residue before it dries, and then **Take a 45-60 minute break...**

Step 14 – Now that your first adhesive application has cured a little bit; use the butt end of your sharpie to gently hold the outer edge of the surround away from the frame while you apply adhesive to the surface of the speaker frame where the surround will attach. Apply adhesive all the way around the frame. Allow surround to fall into place on the frame. **See figure 12**



Figure 7



Figure 8



Figure 9



Figure 10



Figure 11



Figure 12

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Figure 11 from the instruction sheet, depicting a hand gently pressing the new foam surround into place around the speaker cone to ensure proper adhesion.

- Step 12:** Use a paper towel lightly dampened with warm water or nail polish remover to clean up extra glue residue before it dries, and then **Take a 45-60 minute break...**

Step 9 – Place new foam surround in place upside down to test fit. Use your fingers to move cone into place and make a visual note of how new surround will lie in relation to cone. **See figure 8 ++Read ahead before continuing because once you hit the next step there is no turning back.++**

Step 10 – Read instructions included with your adhesive, and move to well-ventilated area prior to continuing. With surround still in place upside down; carefully apply small bead of adhesive to innermost flange/lip of surround. Use bottle tip to evenly spread adhesive around the inner flange/lip as it is applied. Allow adhesive to breathe for a few seconds. **See figure 9**

Step 11 – After allowing your adhesive to breathe; carefully pick up your surround, flip it right side up, and carefully lay it in place. Be sure to lay it in place correctly the first time, as it will begin to stick immediately. **See figure 10**

Step 12 – With new surround properly placed; use your finger, the butt end of a sharpie, or something similar to gently press the surround into place. Slowly trace your way around the edge to help the adhesive bond to take. Carefully repeat this step 3-4 times over the next 10 minutes. **See figure 11**

Step 13 – Use a paper towel lightly dampened with warm water or nail polish remover to clean up extra glue residue before it dries, and then **Take a 45-60 minute break...**

Step 14 – Now that your first adhesive application has cured a little bit; use the butt end of your sharpie to gently hold the outer edge of the surround away from the frame while you apply adhesive to the surface of the speaker frame where the surround will attach. Apply adhesive all the way around the frame. Allow surround to fall into place on the frame. **See figure 12**

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Figure 7




Figure 8




Figure 9




Figure 10




Figure 11




Figure 12

Figure 12 from the instruction sheet, showing cleaning excess adhesive from the speaker frame with a damp paper towel.

13. **Step 13:** Now that your first adhesive application has cured a little bit; use the butt end of your sharpie to gently hold the outer edge of the surround away from the frame where you apply adhesive to the surface of the speaker frame where the surround will attach. Apply adhesive all the way around the frame. Allow surround to fall into place on the frame.

THE FOLLOWING STEP IS PRIORITY #1

Step 15 –Use your fingers to apply pressure evenly to the center of the cone. Listen for any rubbing or scratching sounds from the voice coil as the cone flexes in and out. Adjust cone side to side until cone can be manipulated all the way in and out without any rubbing. **See figure 13**



Figure 13

Step 16 – As you did in Step 12, use your sharpie to press the surround gently into place on the frame. **REPEAT STEP 15!!**



Figure 14

Step 17 – **REPEAT STEPS 15 & 16!!** Apply adhesive to the underside of your original gasket, or replacement if you purchased one. Align holes in gasket with mounting holes in frame, and set gasket in place. Press gasket in place. **See figure 14**



Figure 15

Step 18 – **REPEAT STEPS 15 & 16!!** Pick speaker up and place face down on hard level surface. This will allow weight of speaker to press gasket permanently into place while the adhesive cures. **See figure 15**

YOU'RE DONE!!!**



****Allow 24-36 hours for adhesive to fully cure before placing a full load on your newly-refoamed speaker.**

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Figure 13 from the instruction sheet, illustrating applying adhesive to the outer edge of the speaker frame where the new foam surround will attach.

- Step 14:** Use your fingers to apply pressure evenly to the center of the cone. Listen for any rubbing or scratching sounds from the voice coil as the cone flexes in and out. Adjust the cone side to side until the cone can be manipulated all the way in and out without any rubbing.

THE FOLLOWING STEP IS PRIORITY #1

Step 15 –Use your fingers to apply pressure evenly to the center of the cone. Listen for any rubbing or scratching sounds from the voice coil as the cone flexes in and out. Adjust cone side to side until cone can be manipulated all the way in and out without any rubbing. **See figure 13**



Figure 13

Step 16 – As you did in Step 12, use your sharpie to press the surround gently into place on the frame. **REPEAT STEP 15!!**



Figure 14

Step 17 – **REPEAT STEPS 15 & 16!!** Apply adhesive to the underside of your original gasket, or replacement if you purchased one. Align holes in gasket with mounting holes in frame, and set gasket in place. Press gasket in place. **See figure 14**



Figure 15

Step 18 – **REPEAT STEPS 15 & 16!!** Pick speaker up and place face down on hard level surface. This will allow weight of speaker to press gasket permanently into place while the adhesive cures. **See figure 15**

YOU'RE DONE!!!**



****Allow 24-36 hours for adhesive to fully cure before placing a full load on your newly-refoamed speaker.**

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Figure 14 from the instruction sheet, depicting gently pressing the center of the speaker cone to check for voice coil rubbing after initial adhesive application.

15. **Step 15:** As you did in Step 11, use your sharpie to press the surround gently into place on the frame. **REPEAT STEP 14!**

THE FOLLOWING STEP IS PRIORITY #1

Step 15 –Use your fingers to apply pressure evenly to the center of the cone. Listen for any rubbing or scratching sounds from the voice coil as the cone flexes in and out. Adjust cone side to side until cone can be manipulated all the way in and out without any rubbing. **See figure 13**



Figure 13

Step 16 – As you did in Step 12, use your sharpie to press the surround gently into place on the frame. **REPEAT STEP 15!!**



Figure 14

Step 17 – **REPEAT STEPS 15 & 16!!** Apply adhesive to the underside of your original gasket, or replacement if you purchased one. Align holes in gasket with mounting holes in frame, and set gasket in place. Press gasket in place. **See figure 14**



Figure 15

Step 18 – **REPEAT STEPS 15 & 16!!** Pick speaker up and place face down on hard level surface. This will allow weight of speaker to press gasket permanently into place while the adhesive cures. **See figure 15**

YOU'RE DONE!!!**



****Allow 24-36 hours for adhesive to fully cure before placing a full load on your newly-refoamed speaker.**

Enjoy the Music...

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Figure 15 from the instruction sheet, showing using a sharpie to press the outer edge of the new foam surround onto the speaker frame for final adhesion.

- Step 16:** Apply adhesive to the underside of your original gasket, or replacement if you purchased one. Align holes in the gasket with mounting holes in the frame, and set the gasket in place. Press the gasket in place.

THE FOLLOWING STEP IS PRIORITY #1

Step 15 –Use your fingers to apply pressure evenly to the center of the cone. Listen for any rubbing or scratching sounds from the voice coil as the cone flexes in and out. Adjust cone side to side until cone can be manipulated all the way in and out without any rubbing.
See figure 13



Figure 13

Step 16 – As you did in Step 12, use your sharpie to press the surround gently into place on the frame. **REPEAT STEP 15!!**



Figure 14

Step 17 – **REPEAT STEPS 15 & 16!!** Apply adhesive to the underside of your original gasket, or replacement if you purchased one. Align holes in gasket with mounting holes in frame, and set gasket in place. Press gasket in place. **See figure 14**



Figure 15

Step 18 – **REPEAT STEPS 15 & 16!!** Pick speaker up and place face down on hard level surface. This will allow weight of speaker to press gasket permanently into place while the adhesive cures. **See figure 15**

YOU'RE DONE!!!**



****Allow 24-36 hours for adhesive to fully cure before placing a full load on your newly-refoamed speaker.**

Enjoy the Music...

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This image from the instruction sheet illustrates the process of applying adhesive to the underside of the speaker gasket before placing it back onto the speaker frame.

17. **Step 17:** Pick the speaker up and place it face down on a hard, level surface. This will allow the weight of the speaker to press the gasket permanently into place while the adhesive cures.

THE FOLLOWING STEP IS PRIORITY #1

Step 15 –Use your fingers to apply pressure evenly to the center of the cone. Listen for any rubbing or scratching sounds from the voice coil as the cone flexes in and out. Adjust cone side to side until cone can be manipulated all the way in and out without any rubbing. **See figure 13**



Figure 13

Step 16 – As you did in Step 12, use your sharpie to press the surround gently into place on the frame. **REPEAT STEP 15!!**



Figure 14

Step 17 – **REPEAT STEPS 15 & 16!!** Apply adhesive to the underside of your original gasket, or replacement if you purchased one. Align holes in gasket with mounting holes in frame, and set gasket in place. Press gasket in place. **See figure 14**



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YOU'RE DONE!!!**



****Allow 24-36 hours for adhesive to fully cure before placing a full load on your newly-refoamed speaker.**

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This image from the instruction sheet shows the speaker placed face down on a flat surface to allow the gasket adhesive to cure under pressure.

IMPORTANT CURING INFORMATION

Allow **24-36 hours** for the adhesive to fully cure before placing a full load on your newly re-foamed speaker. This curing period is essential to ensure maximum bond strength and longevity of the repair.

SUPPORT INFORMATION

For further assistance or questions regarding your repair kit, please contact Springfield Speaker customer support.

Phone: 1-800-397-9575

Website for Instructional Videos: SpringfieldSpeakerRepair.com/DIY

Business Hours: Monday - Friday, 9 AM - 6 PM (Central U.S. time)