



Heat Speaker Cone to Cure Epoxy

Objective Heat the top surface of a speaker basket to cure epoxy between the basket and a paper insert.

Material Steel Speaker Cone Measuring 6.5" (165.1mm) by 9.125"(231.8mm)

Temperature 375°F (190.6°C) to 425°F (218.3°C)

Frequency 138 kHz

Equipment

- Ambrell 5kW induction heating system equipped with a remote workhead
- An induction heating coil designed and developed specifically for this application

Process A two turn helical coil with concentrator plate is used to heat top area of the speaker basket where the epoxy is located. The epoxy cures in 3.5 seconds at a temperature of 400°F (204.4°C).

Results/Benefits Induction heating provides:

- Minimized coating defects
- Repeatable results
- Faster production times

