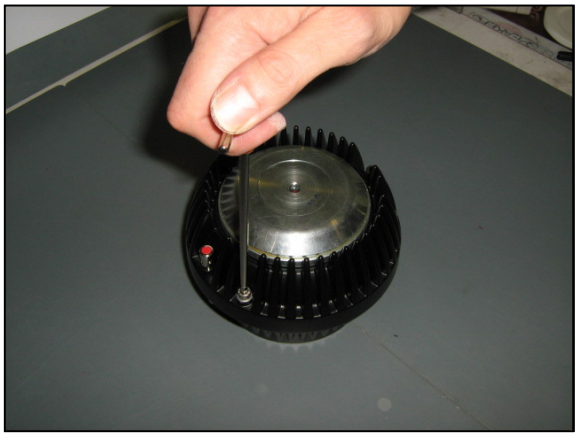
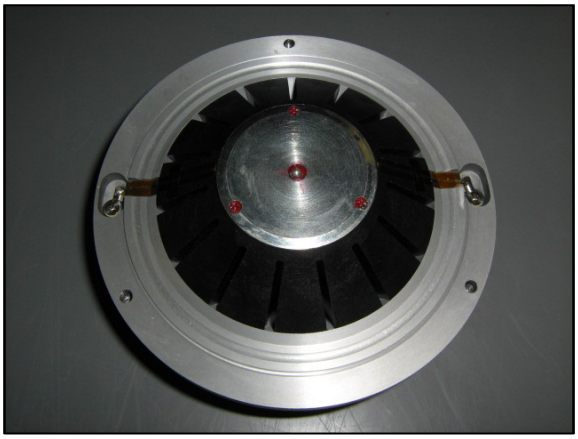
DCX50 HF UNIT DIAPHRAGM REPLACEMENT PROCEDURE
Rev 1.0

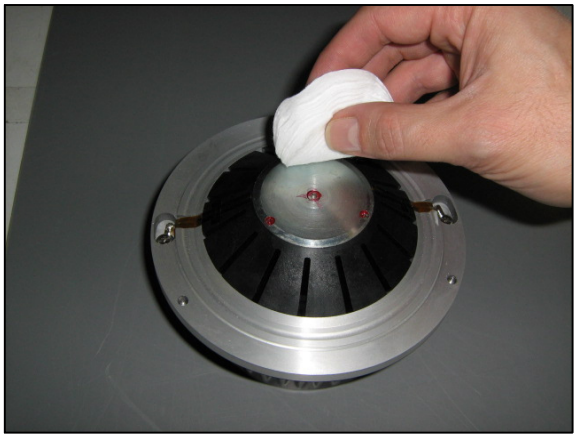
1. Unscrew the three screws that fix the MF unit assembly

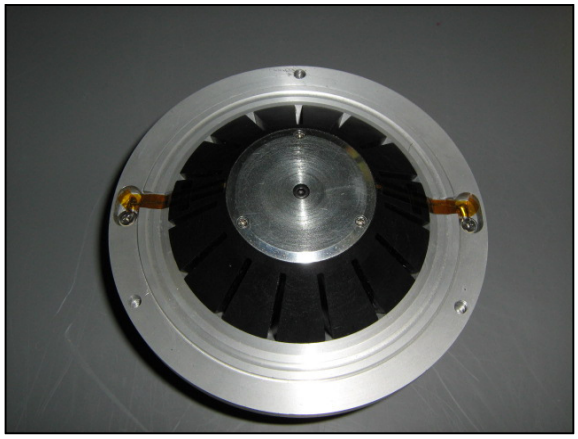


2. Remove the MF unit assembly

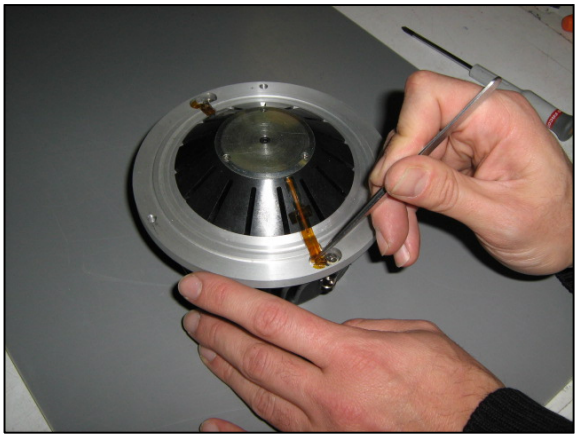


3. Remove the red varnish from the screws on the HF unit assembly using a soft cloth soaked in acetone



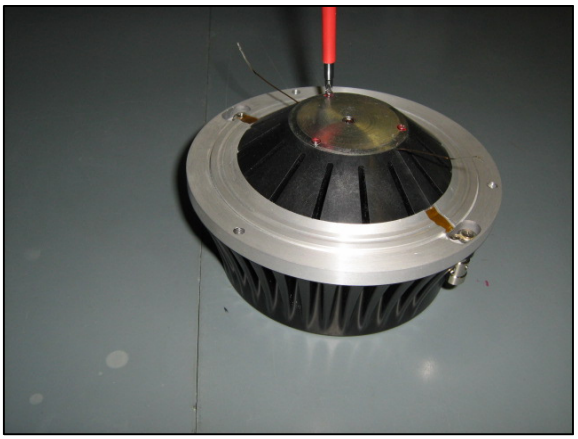


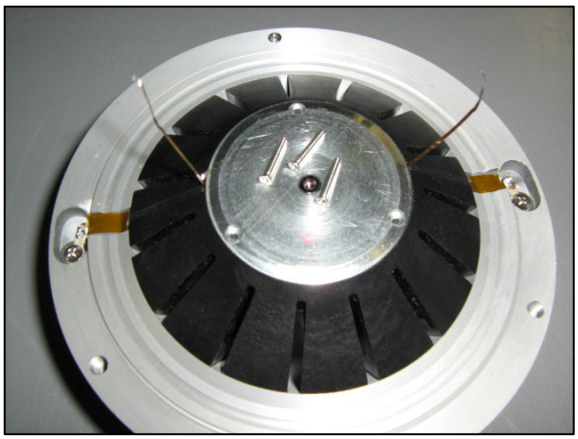
4. Remove the yellow adhesive tape from the lead wires using tweezers



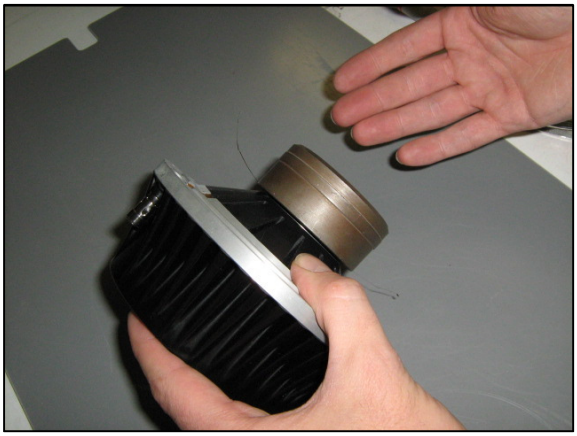
5. Unsolder the lead wires from the push button terminals

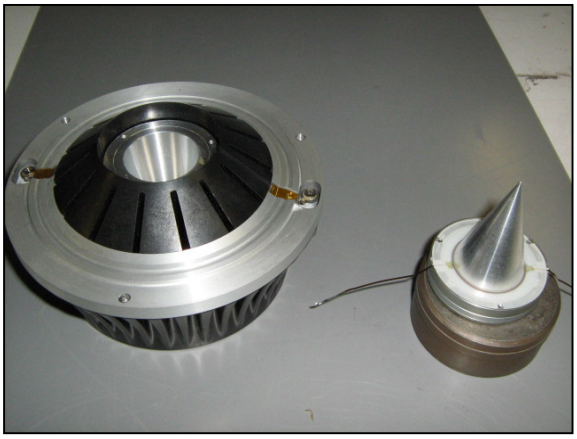
6. Unscrew the three small screws on the HF unit magnet assembly

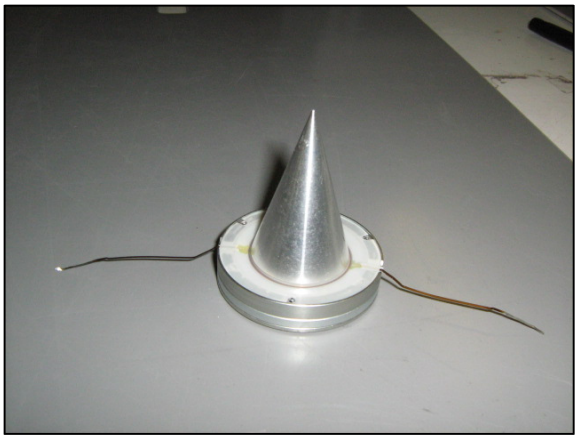




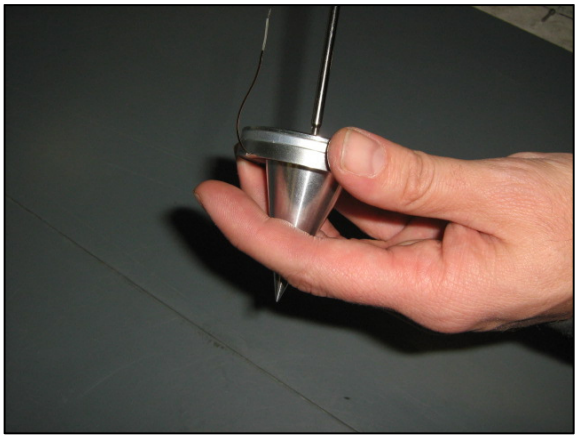
7. Using a metal tool, attach it to the HF unit magnet assembly and pull out the HF unit from its place

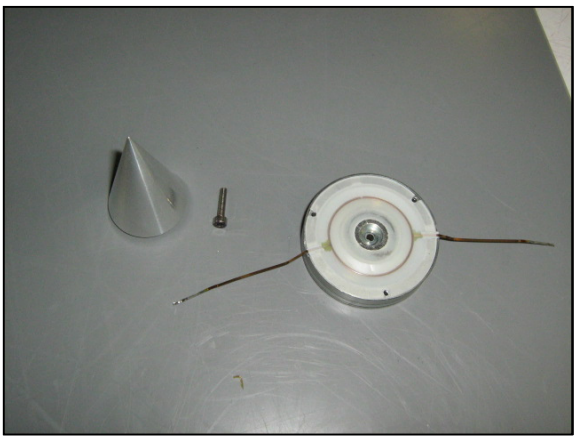




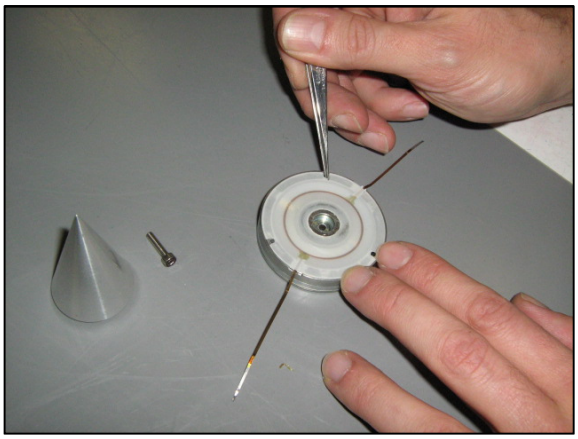


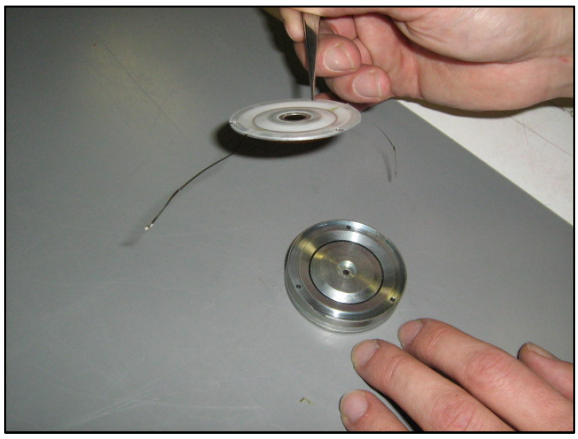
8. Remove the phase plug unscrewing the central screw on the magnet assembly



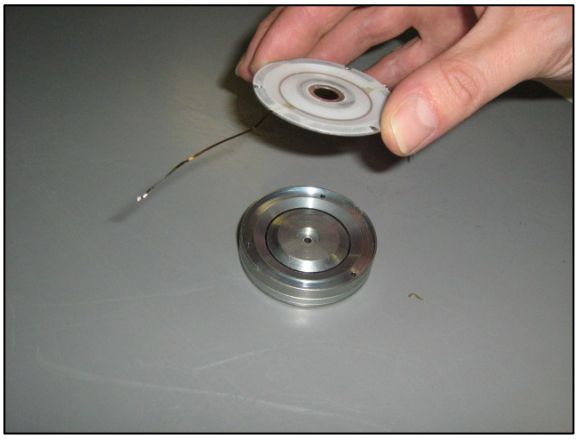


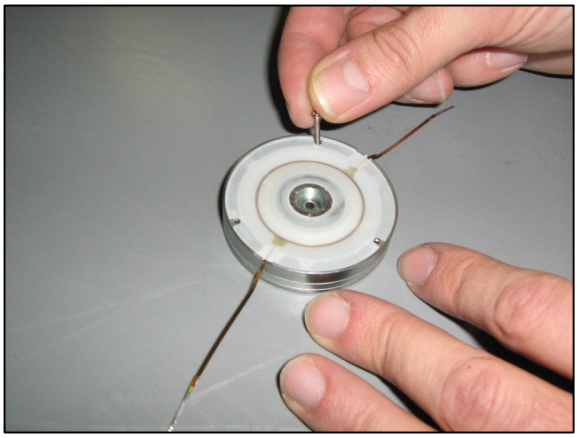
9. Pull out the diaphragm from the magnet structure



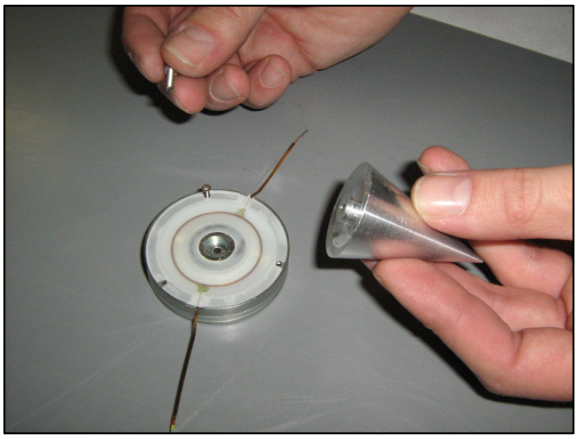


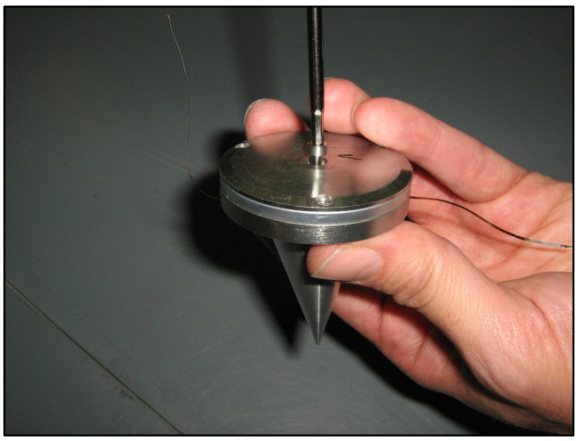
10. Place the new diaphragm on the magnet assembly, paying attention to align the diaphragm holes to the threaded holes on the magnet assembly. It's recommended to use a thread to fix temporarily the diaphragm in place



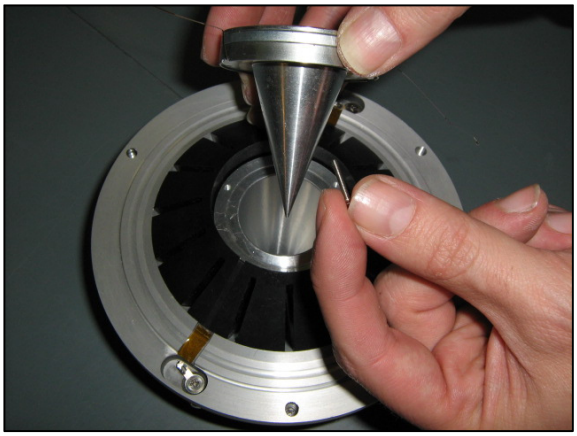


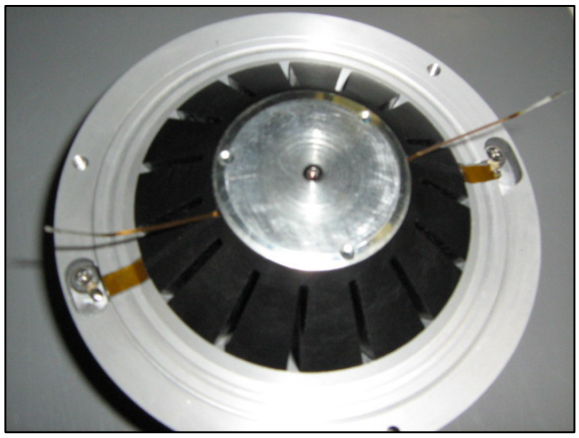
11. Fix the phase plug, screwing it on the HF magnet assembly



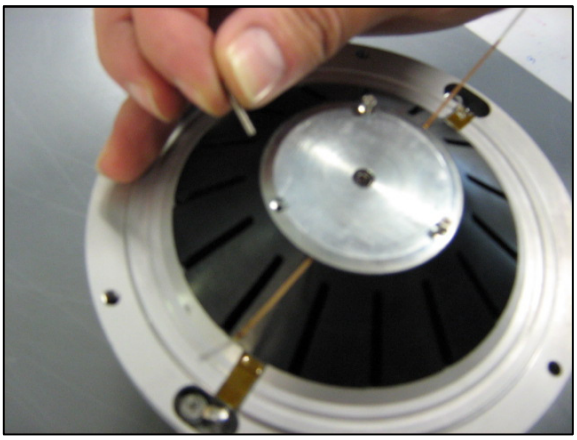


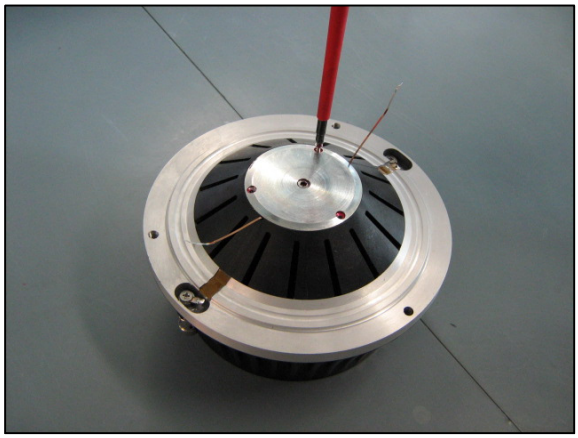
12. Remove the screw that fixed the diaphragm and insert the HF unit in the DCX assembly paying attention to align it to the threaded holes



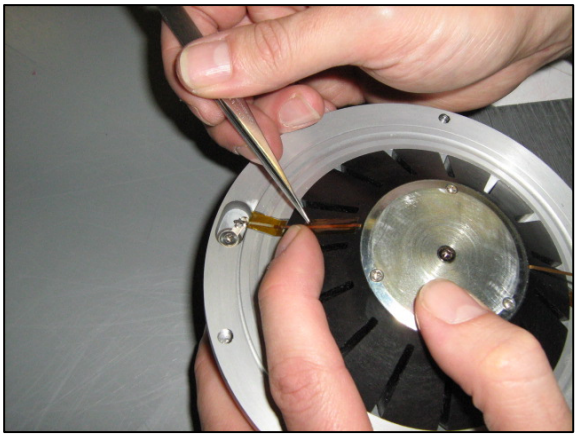
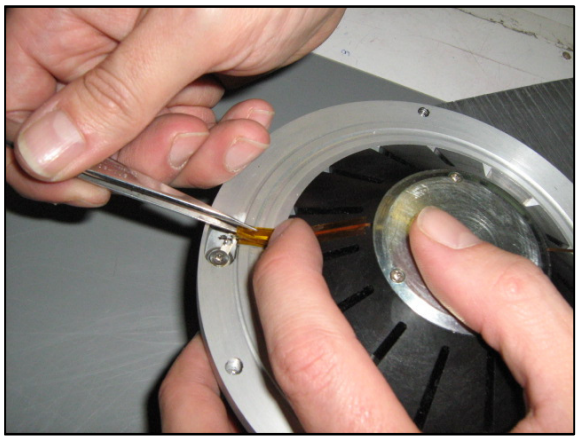
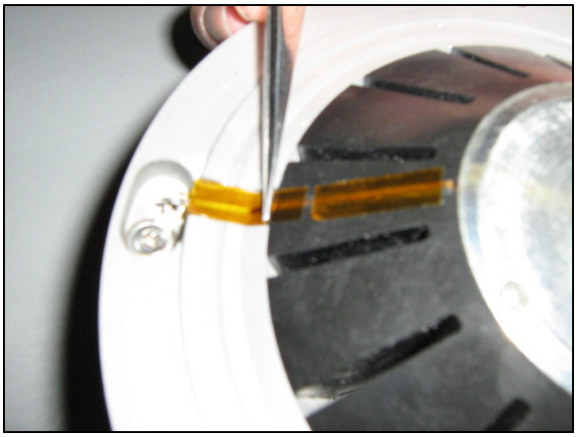
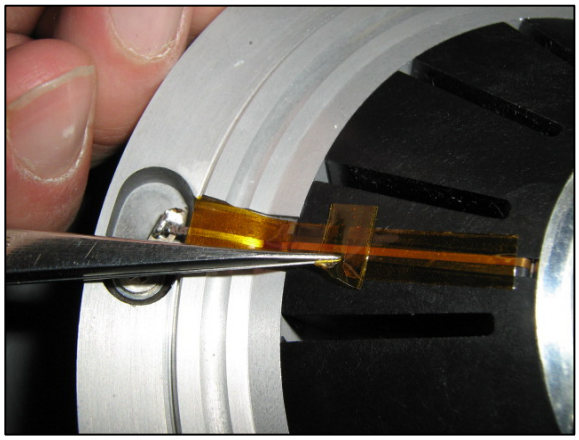


13. Fix the HF unit screwing it on the DCX assembly

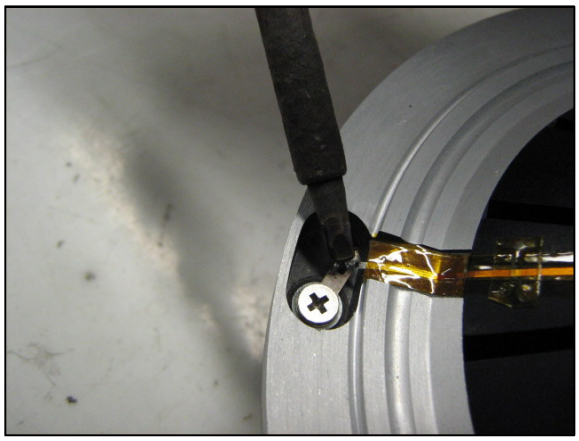




14. Fix the lead wires on the DCX phase plug using some small strips of adhesive tape

15. Solder the lead wires to the push button terminals



16. Assemble again the MF unit to finish the complete DCX50 unit. The push button of the MF and HF units should result aligned.