

SERVICE BULLETIN - OPTIONAL

Part No.: TS150 Loudspeakers

Description: Loudspeaker 150W External	Service Bulletin No.: TS150-603-0001
Service Manual: ASM-TS150_TS300	Subject: Re-entrant Tip Securing (MOD 1)
ECO No.: ECO1143	

Prepared By:  Duane Stewart Designer 10-Jul-2025	Checked By:  Adam Pembleton Designer 08-Jul-2025	Approved By:  Johnathon White Program Manager 10-July-2025
---	---	---

1. Planning Information

1.1 Applicability

This modification is applicable to all TS150 s/n 121227 and below. All units above these serial numbers will contain this modification from the factory.

1.2 Reason

The TS150 is being modified to improve the fastening of the Re-entrant Tip to the speaker assembly.

1.3 Description

This modification consists of 2 parts:

- a) Replacing Phillips head screws and lock washers that secure the compression driver to the mounting bracket with low profile screws installed with Loctite 242 and torqued to 30 in-lb.
- b) Securing the Re-entrant Tip with Loctite 222MS.

1.4 Compliance

This Service Bulletin is optional for customers. This change may be performed on all units without MOD 1 applied.

1.5 Approval

No certification approval exists for the TS150.

1.6 Costing

This modification consists of a design improvement and does not constitute changes to correct a malfunction. The modification is therefore not subjected to warranty consideration.

1.6.1 Parts and Labour

One (1) hour estimated. Please contact Product Support for current parts pricing.

The following items are required to complete MOD 1:

Part Number	Manufacturer	Description	Qty
125-26-015	AEM	Screw, Low Profile Head, 1/4"-20, 3/8" Long	4
LOCTITE® 242	Henkel Adhesives	Medium Strength Threadlocker	As Required
25-20-009	AEM	Fiber Washer, 1.4" ID, 1.9" OD, 0.02" Thick	2
LOCTITE® 222MS	Henkel Adhesives	Low Strength Threadlocker	As Required

1.7 Equipment Required for MOD 1

The following tools are required to complete MOD 1:

Part Number	Manufacturer	Description
N/A	N/A	Phillips Screw Driver, #3
N/A	N/A	1/8" Hex Screw Driver
N/A	N/A	Torque Wrench capable of 30 in-lb
N/A	N/A	1/8" Hex Bit

1.8 Weight and Balance

Not affected.

1.9 Electrical Load Data

Not affected.

1.10 References

None.

1.11 Other Publications Affected

ASM-TS150_TS300 Installation and Operations Manual

2. Modification Procedure for MOD 1

The Modification Status on the Product Label must be updated with a permanent marking to indicate MOD 1 has been incorporated.

- 2.1.1 Referencing Figure 1, remove cone (Item #2) by unscrewing it from the speaker assembly. Ensure fiber washer (Item #5) remains in the cone. Remove rubber washers (Item #4) from the cone and the large fiber fiber washer (Item #6), retain for re-assembly.

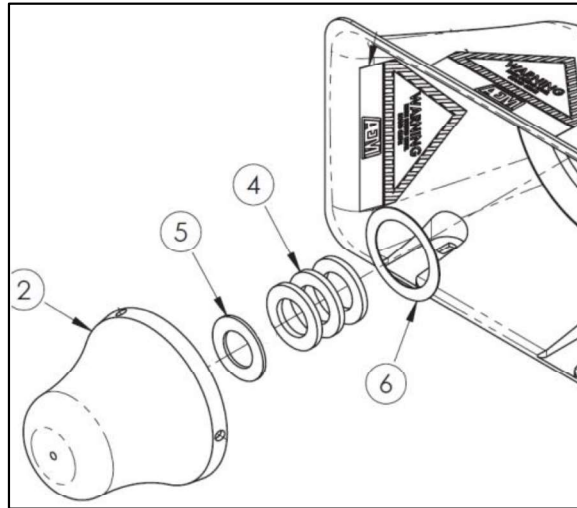


Figure 1

- 2.1.2 Referencing Figure 2, remove bell (Item #1). Retain fiber washer (Item #6) and steel washers (Item #9) for re-assembly noting the order they were removed. Remove and discard screws (Item #11) and lock washers (Item #7). Rest speaker driver (Item #16) in place as it will be detached from the mounting bracket (Item #17).

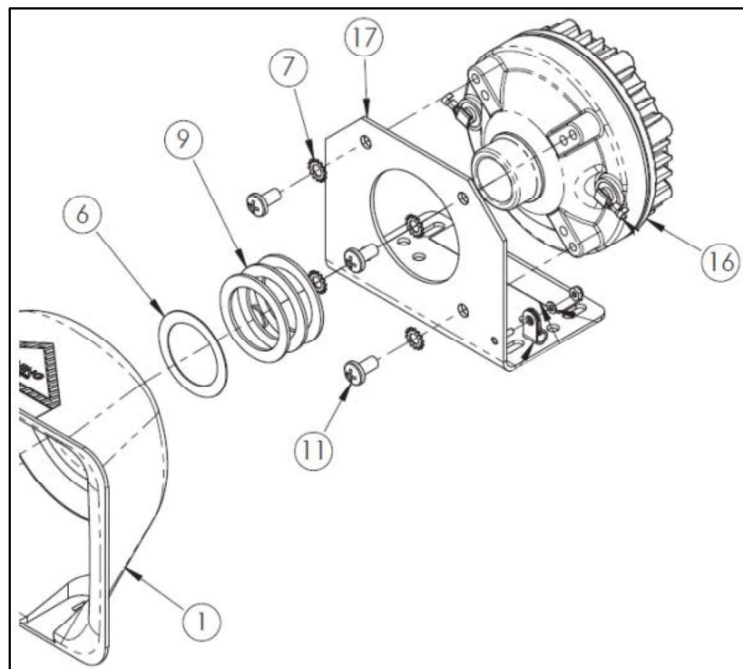


Figure 2

Reference Figure 3 for the following steps.

Note: Some of the components item numbers have changed for the following steps.

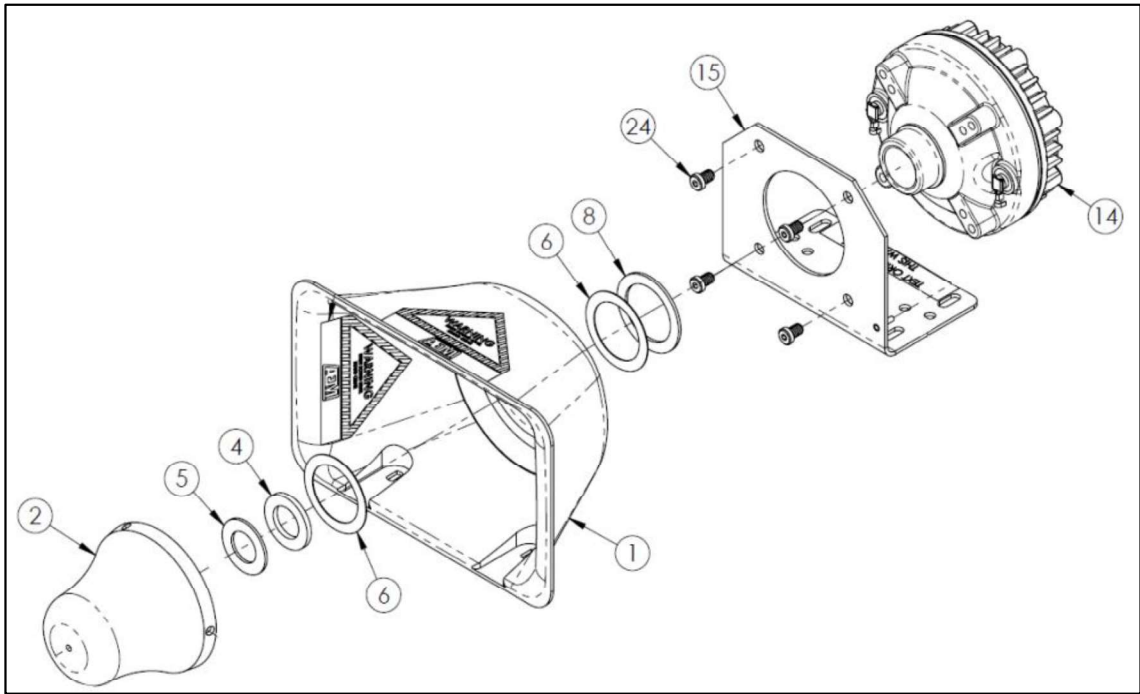


Figure 3

- 2.1.3 Secure speaker driver (Item #14) to mounting bracket (Item #15) with four screws (Item #24), apply Loctite 242 to screw threads. Torque to 30 in-lb.
- 2.1.4 Place one of the retained steel washers (Item #8) and retained fiber washer (Item #6) from step 2.1.2 over the end of speaker driver (Item #14). Discard the remaining steel washers. Temporarily place the horn (Item #1) over the speaker driver (Item #14), check the clearance to the screw heads (Item #24). Add up to two more fiber washers (Item #6, supplied by AEM) to obtain a minimum clearance of 0.02 inches between the horn (Item #1) and screw heads (Item #24).
- 2.1.5 Place horn (Item #1) then fiber washer (Item #6) over the speaker driver (Item #14).
- 2.1.6 Ensure fiber washer (Item #5) is in the cone (Item #2). Then insert one rubber washer (Item #4) that was retained from step 2.1.1.
- 2.1.7 Apply Loctite 222MS onto the threads of speaker driver (Item #14) spaced evenly at 3 locations then tighten cone (Item #2) onto speaker driver (Item #14). Ensure horn (Item #1) is oriented straight and the cone is tightened securely.

Note: Loctite 222MS sets in 10 minutes and fully cures in 24 hours.

End of Service Bulletin