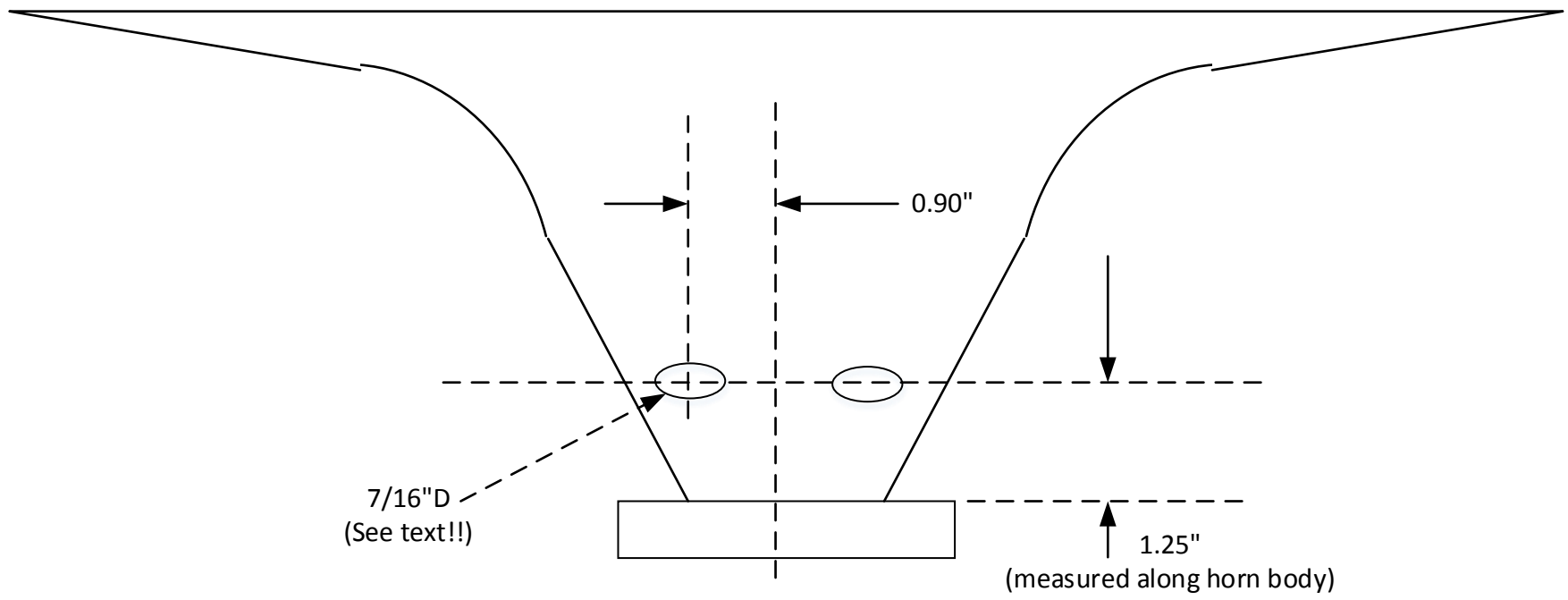


Material: 1/8" ply or 0.062" FR4 circuit board stock

Center driver on panel, mark mounting holes positions with pencil. Draw cross lines between hole center locations to find the center. Draw 1.75" radius circle using compass. Cut out the circle using jigsaw. Drill small holes for sheet metal screws for driver mounting

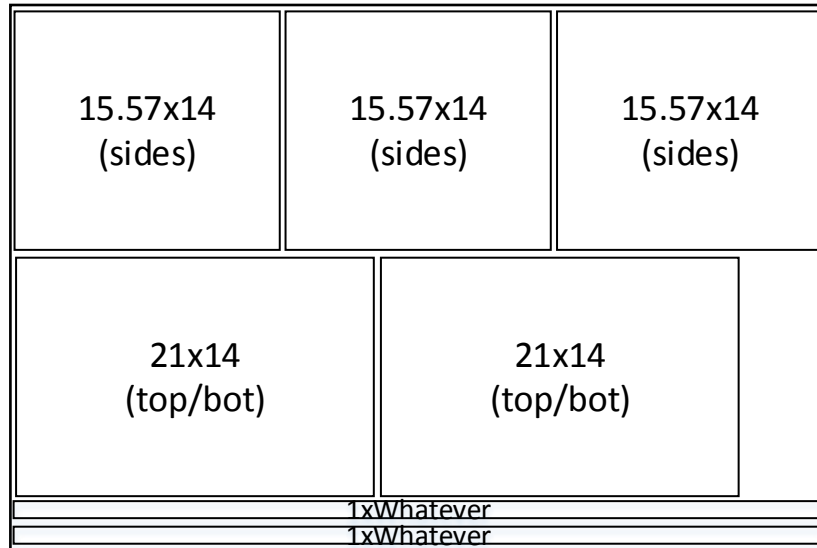
Cut off one corner around driver outline with jigsaw.

Drill 8x approx 0.125"D holes approx where shown to improve epoxy grip

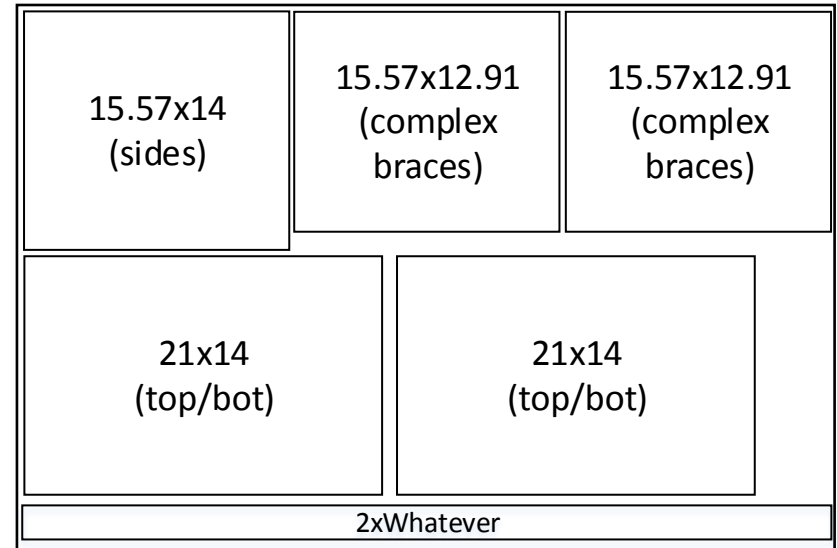


Dimensions assume that 3/4" nominal pre-veneered ply is 0.715" thick,
 Half inch ply is 0.5" thick,
 Quarter inch panels are 0.25" thick

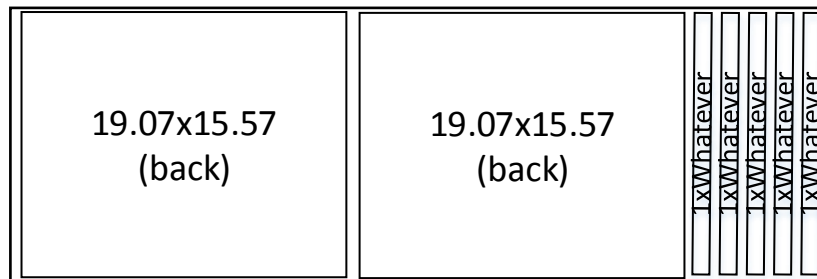
Panels shown for two speakers. 3/4" ply from qty 1, 4' x 8' panel



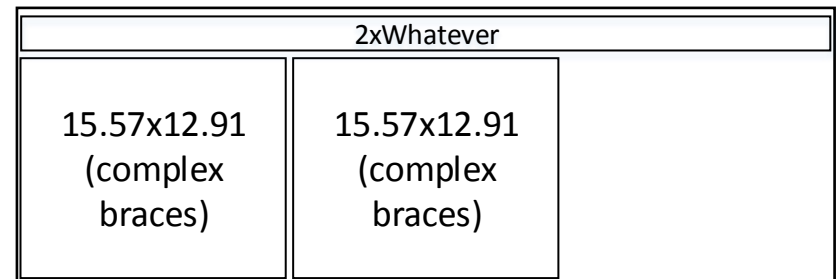
3/4" ply, approx 32 x 48



3/4" ply, approx 32 x 48



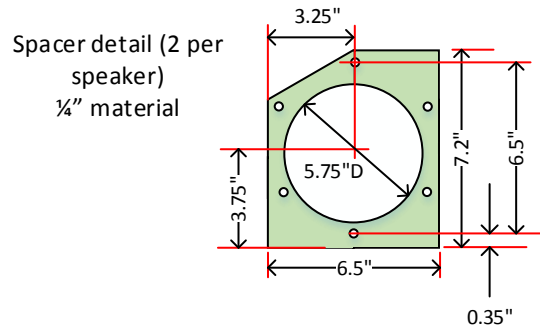
3/4" ply, approx 16 x 48



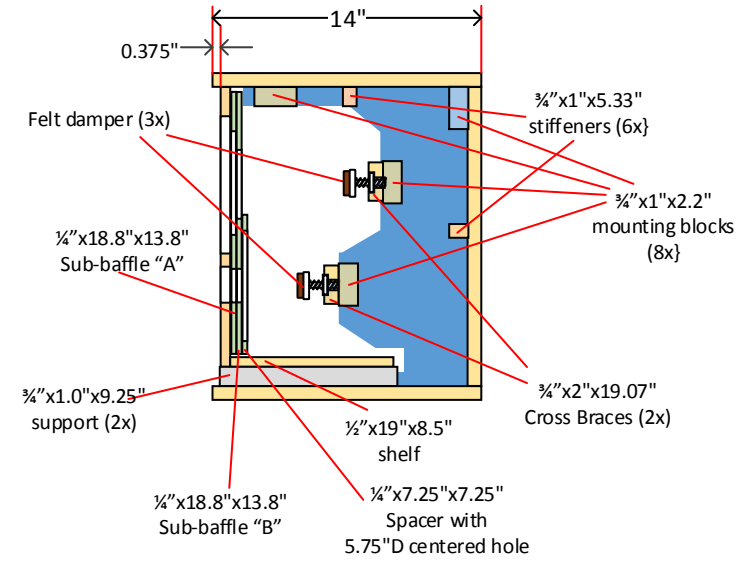
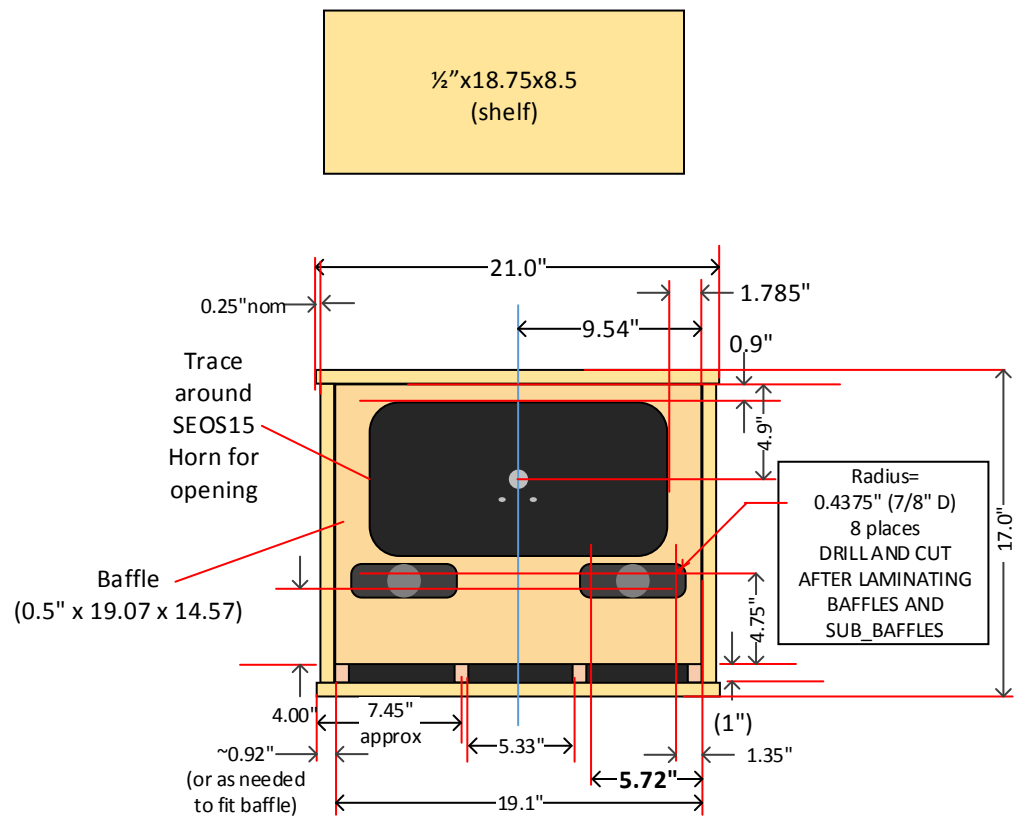
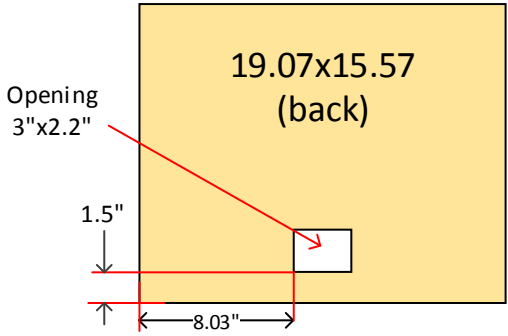
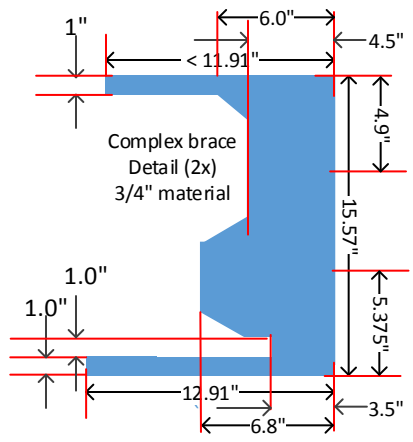
3/4" ply, approx 16 x 48

**Baffle: 19.5x16 (qty 2, 1/2" Ply)
 18.8x13.8 (qty 4, 1/4" ply or MDF)**

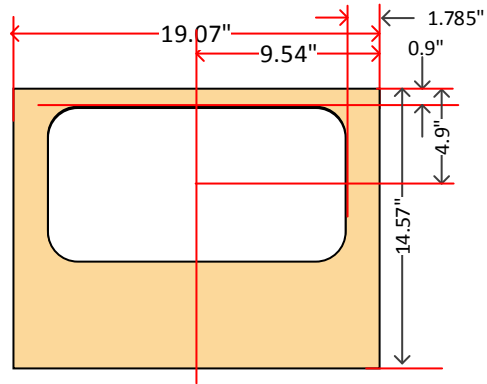
**Shelf: 19x8.5 (qty 2, 1/2" Ply)
 Spacers: 6.5x7.2 (qty 4, 1/4" ply or mdf)**



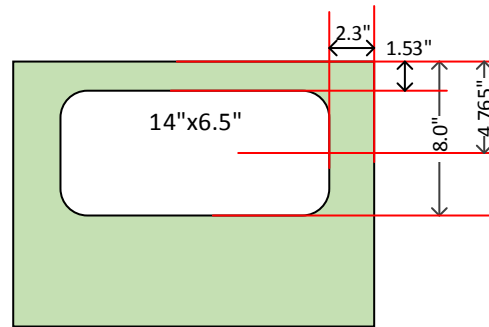
Spacer to be glued to back of Baffle assembly after port openings drilled and cut



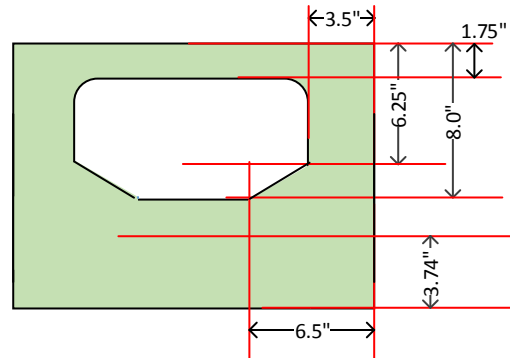
½" pre-veneered plywood



Sub-baffle A detail
(¼"x18.8"x13.8")

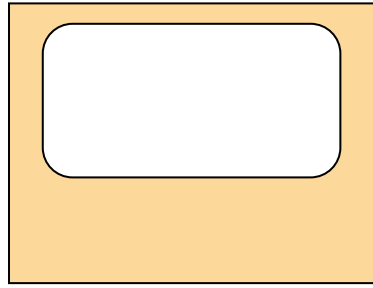


Sub-baffle B detail
(¼"x18.8"x13.8")

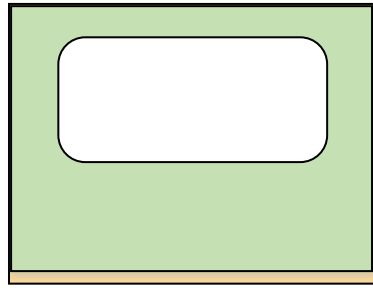


Sub-baffles to be laminated Spaced about 0.135" from top of baffle, 0.635" from bottom of baffle

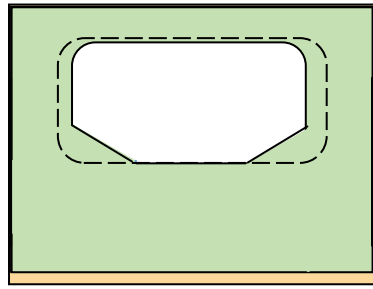
1) Place baffle face down on table



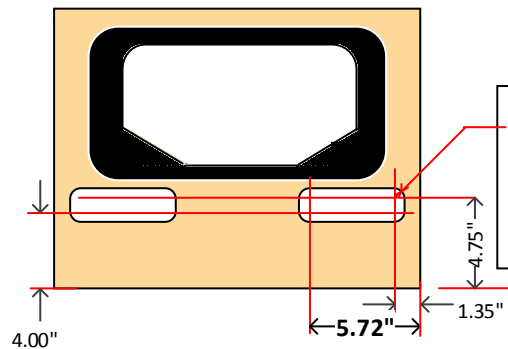
2) Glue sub-baffle A to back of baffle. Make sure the sub-baffled doesn't extend beyond outside edges of baffle and is at least 0.6" from bottom edge.



3) Glue sub-baffle B to back of sub-baffle A, align edges and clamp all three panels together until the glue cures.

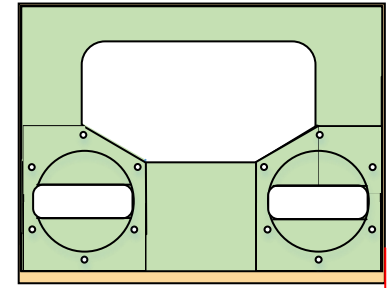


4) Mark and drill holes for woofer apertures on front of baffle, cut aperture outlines with jigsaw. (Cut through all three panels)

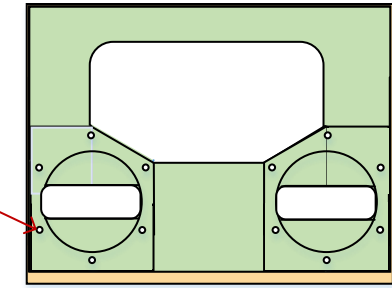


Radius= 0.4375" (7/8" D)
8 places
DRILL AND CUT
AFTER LAMINATING
BAFFLES AND
SUB_BAFFLES

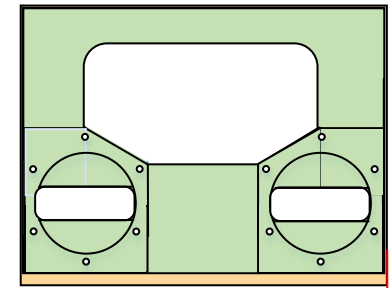
5) Glue the two spacer panels on the back of sub-baffle B, so they center on the woofer apertures (keep within sub-baffle outer outlines)



6) Drill with small bit from the back, through baffles, centered at spacer holes (12 places) (drill with baffle face on a scrap surface to avoid splintering)



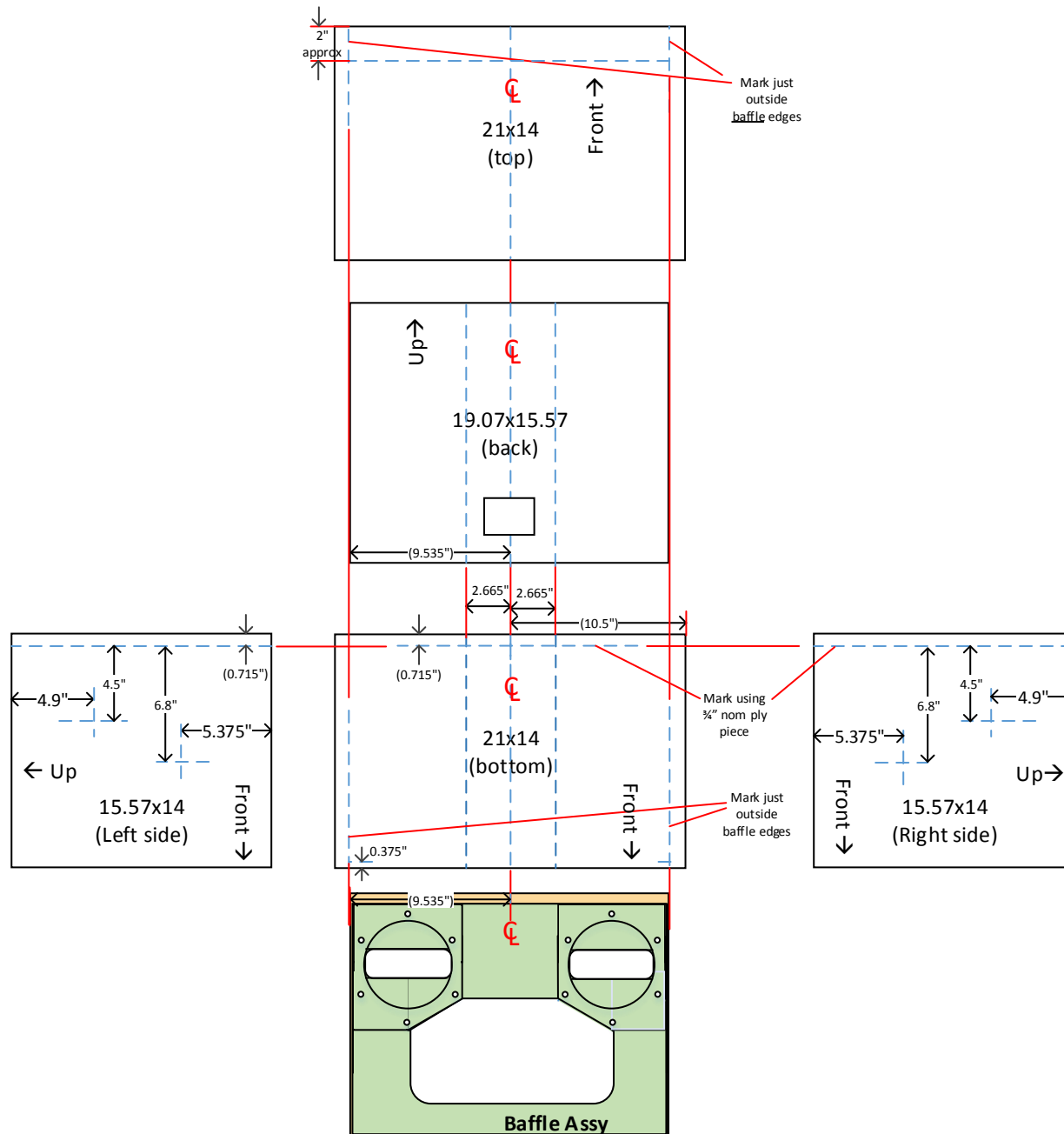
7) Iron-on the veneer tape to the bottom of the baffle and trim



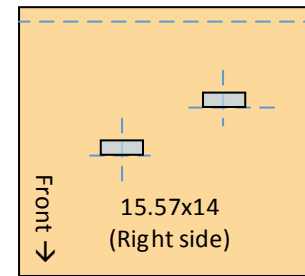
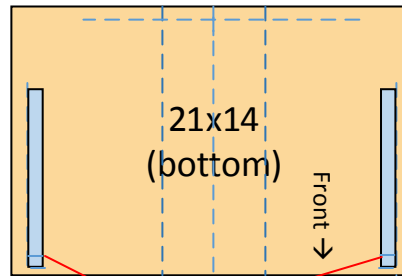
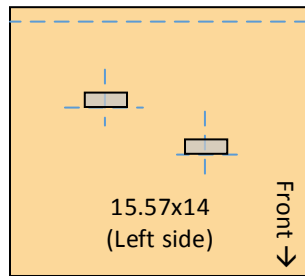
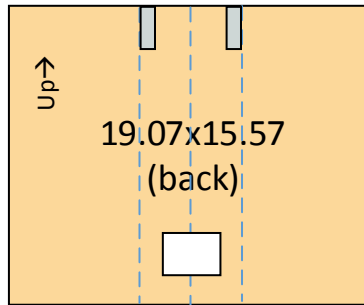
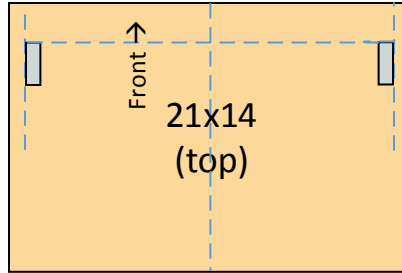
Existing Woofer apertures: 5.25" wide, 1.75" high, 0.9125" from edge.

(optional: apply veneer tape to inside of woofer apertures.... Not easy, though)

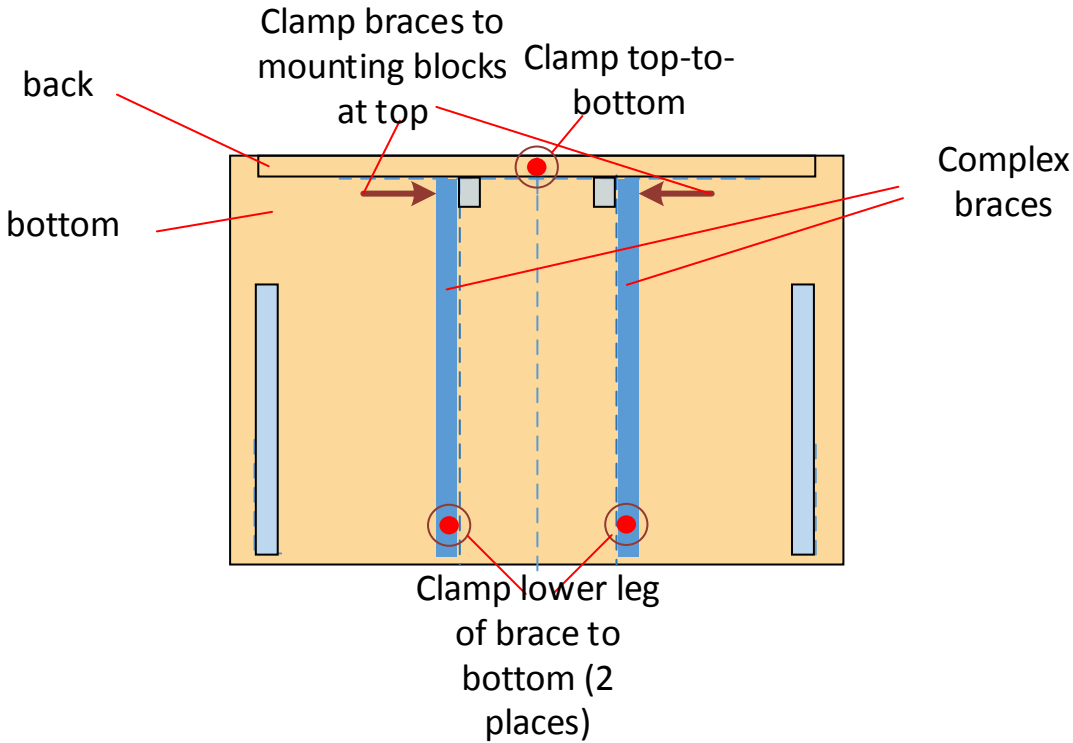
Guide Line Markings (all panels are inside view)



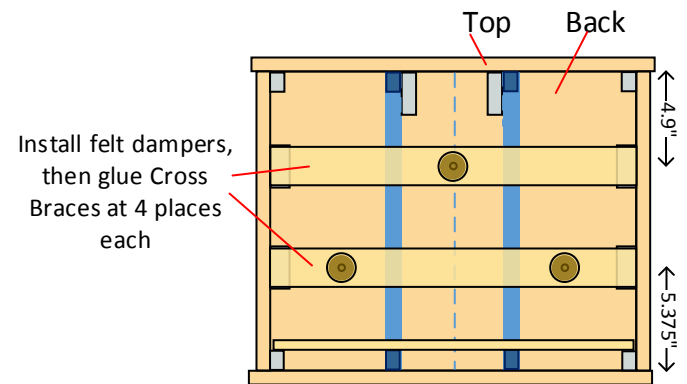
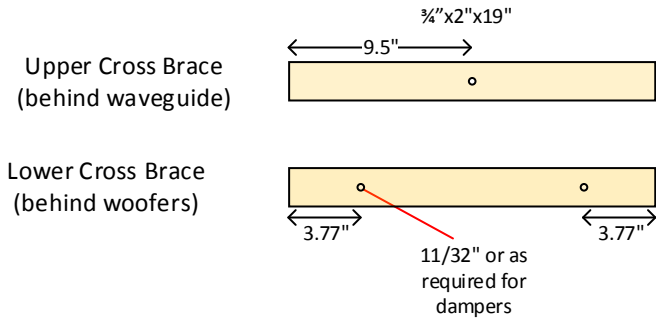
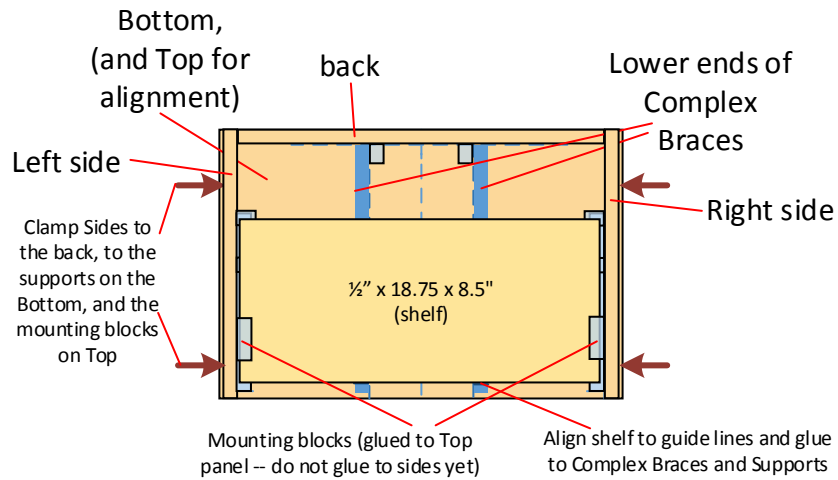
Glue positions of mounting
blocks and supports
(all mount ON NARROW EDGE)



**Glue all joining surfaces
(need minimum 3 small and 2
large clamps)**



Glue and clamp all newly joining surfaces EXCEPT TOP PANEL: Do not glue top panel yet, it's only for alignment of the sides for now!



Glue front panel next (all joining surfaces), then the top panel