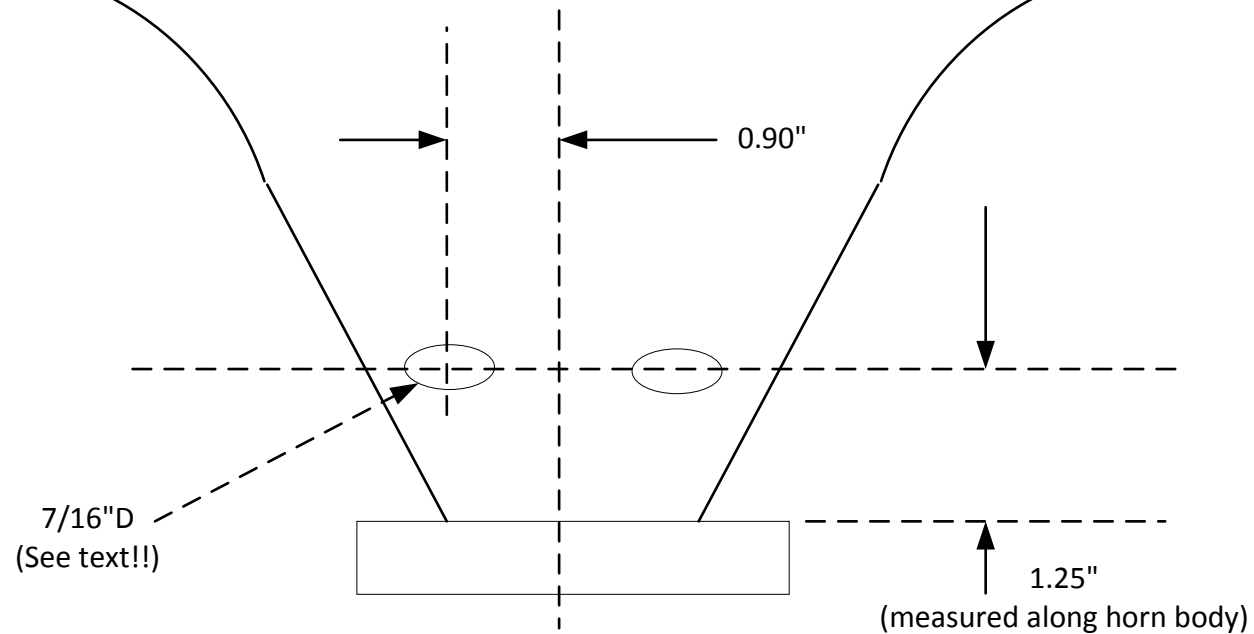


Material: 1/8" ply or 0.062" FR4 circuit board stock

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.

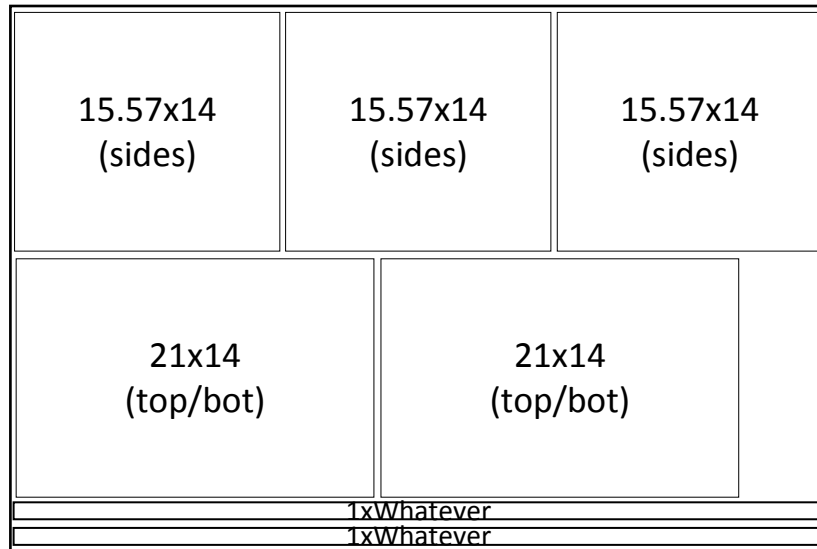
Drill 8x approx 0.125"D holes approx where shown to improve epoxy grip



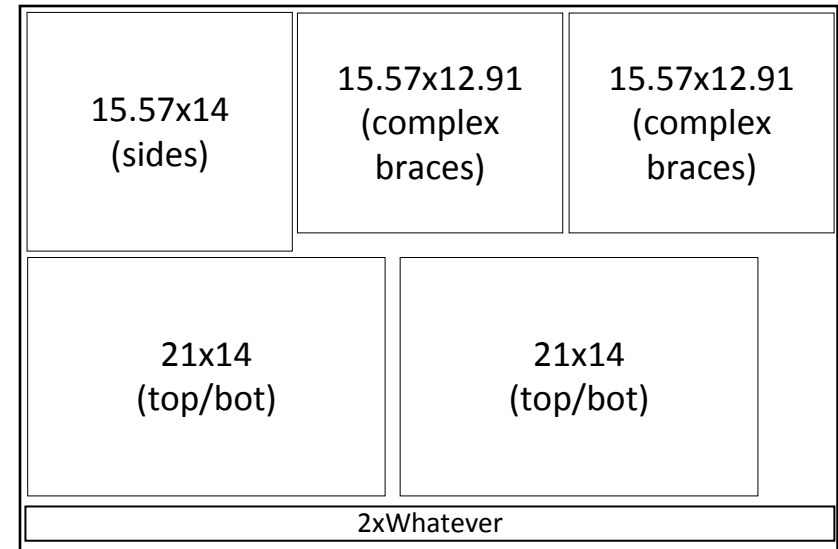


Dimensions assume that ¾" nominal pre-veneered ply is 0.715" thick,  
 Half inch ply is 0.5" thick,  
 Quarter inch panels are 0.25" thick

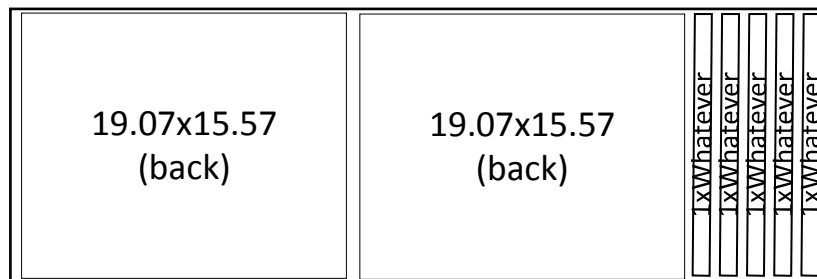
Panels shown for two speakers. ¾" ply from qty 1, 4' x 8' panel



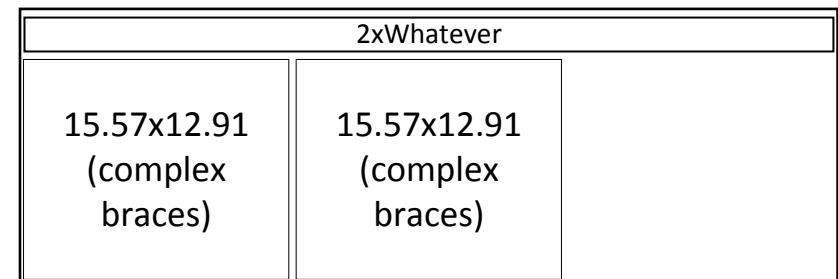
¾" ply, approx 32 x 48



¾" ply, approx 32 x 48



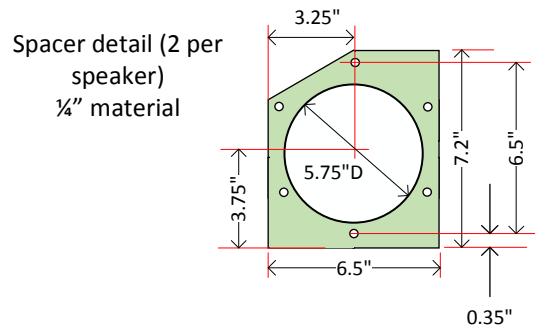
¾" ply, approx 16 x 48



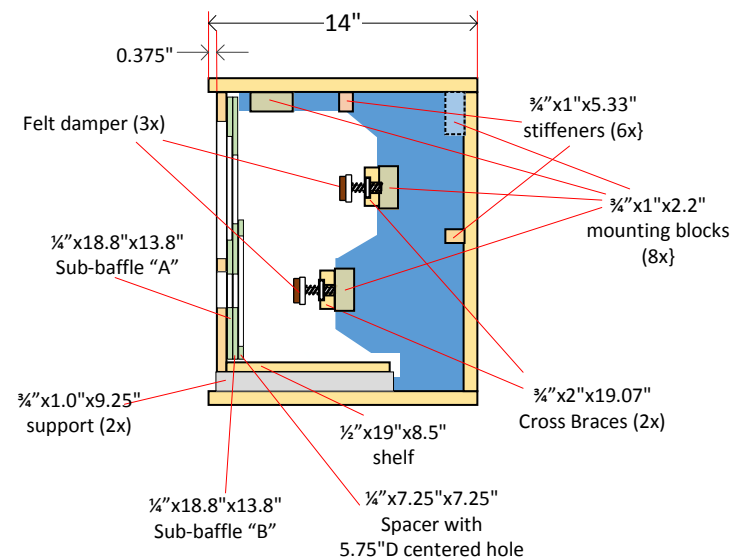
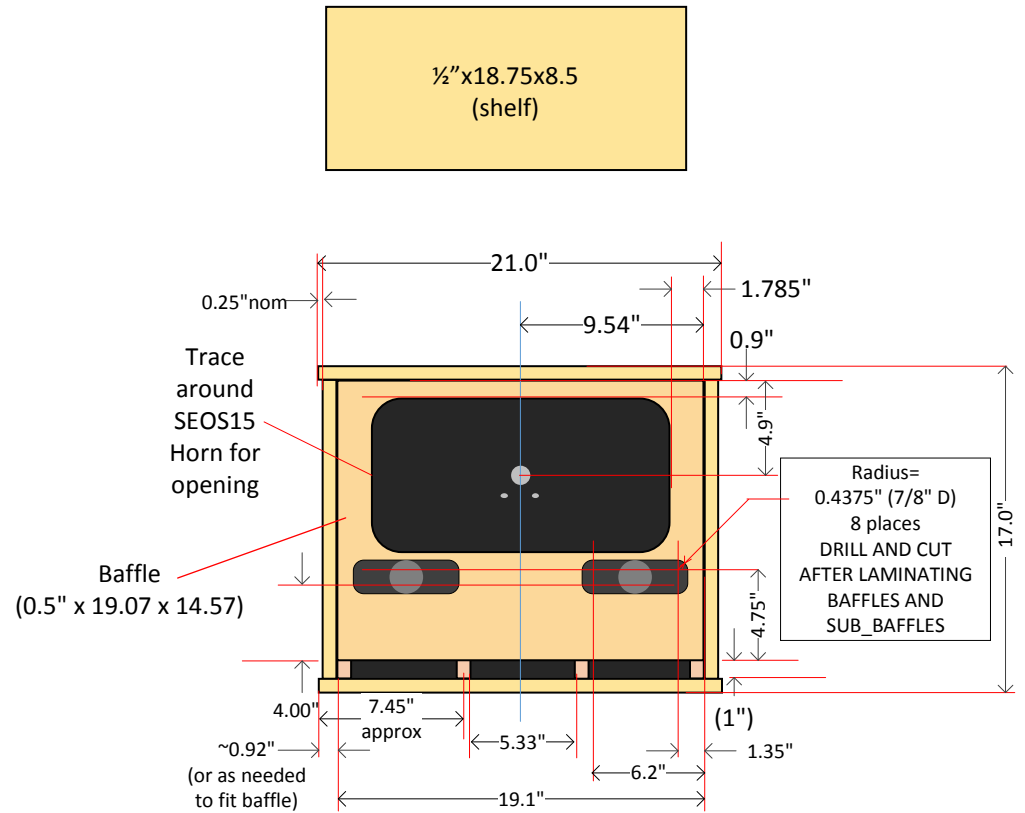
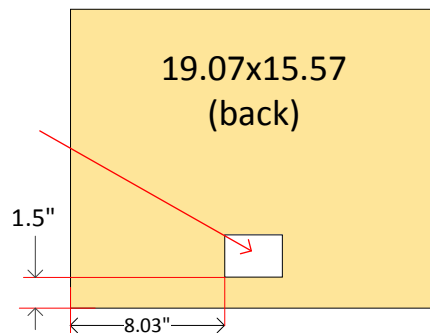
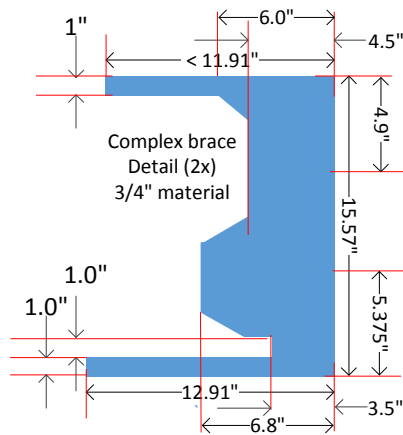
¾" ply, approx 16 x 48

Baffle: 19.5x16 (qty 2, ½" Ply)  
 18.8x13.8 (qty 4, ¼" ply or MDF)

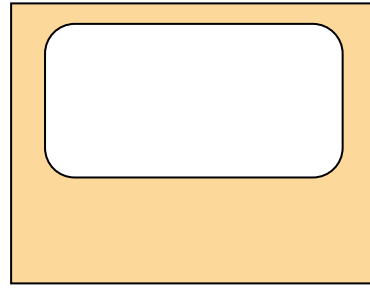
Shelf: 19x8.5 (qty 2, ½" Ply)  
 Spacers: 6.5x7.2 (qty 4, ¼" ply or mdf)



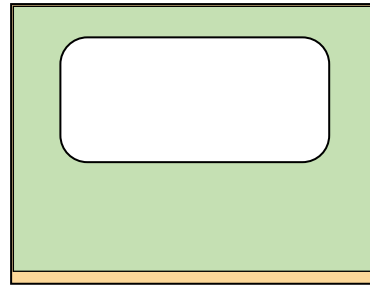
Spacer to be glued to back of Baffle assembly after port openings drilled and cut



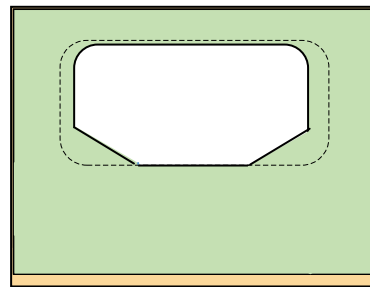
1) Place baffle  
face down on  
table



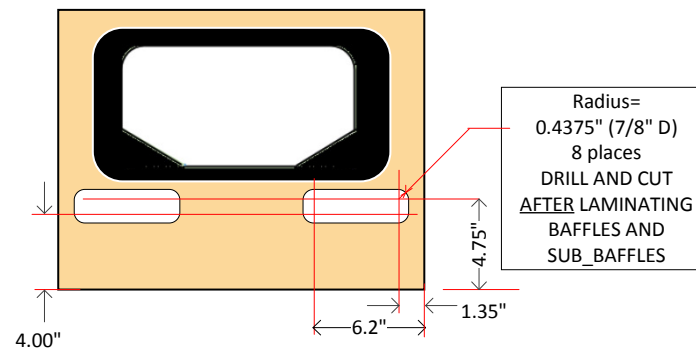
2) Glue sub-baffle A to back of  
baffle. Make sure the sub-  
baffled doesn't extend beyond  
outside edges of baffle and is at  
least 0.6" from bottom edge.



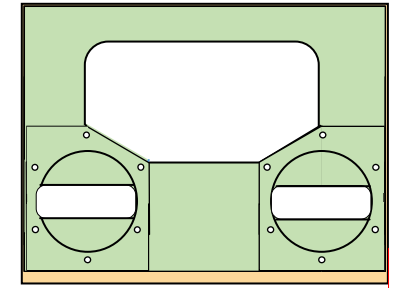
3) Glue sub-baffle B to back of  
sub-baffle A, align edges and  
clamp all three panels together  
until the glue cures.



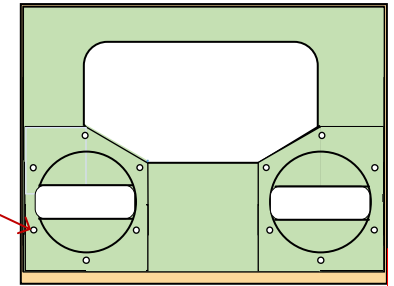
4) Mark and drill holes for  
woofer apertures on front  
of baffle, cut aperture  
outlines with jigsaw. (Cut  
through all three panels)



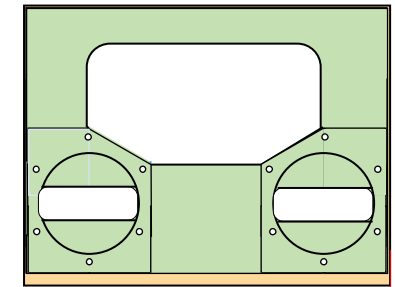
5) Glue the two spacer  
panels on the back of sub-  
baffle B, so they center on  
the woofer apertures  
(keep within sub-baffle  
outer outlines)



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)

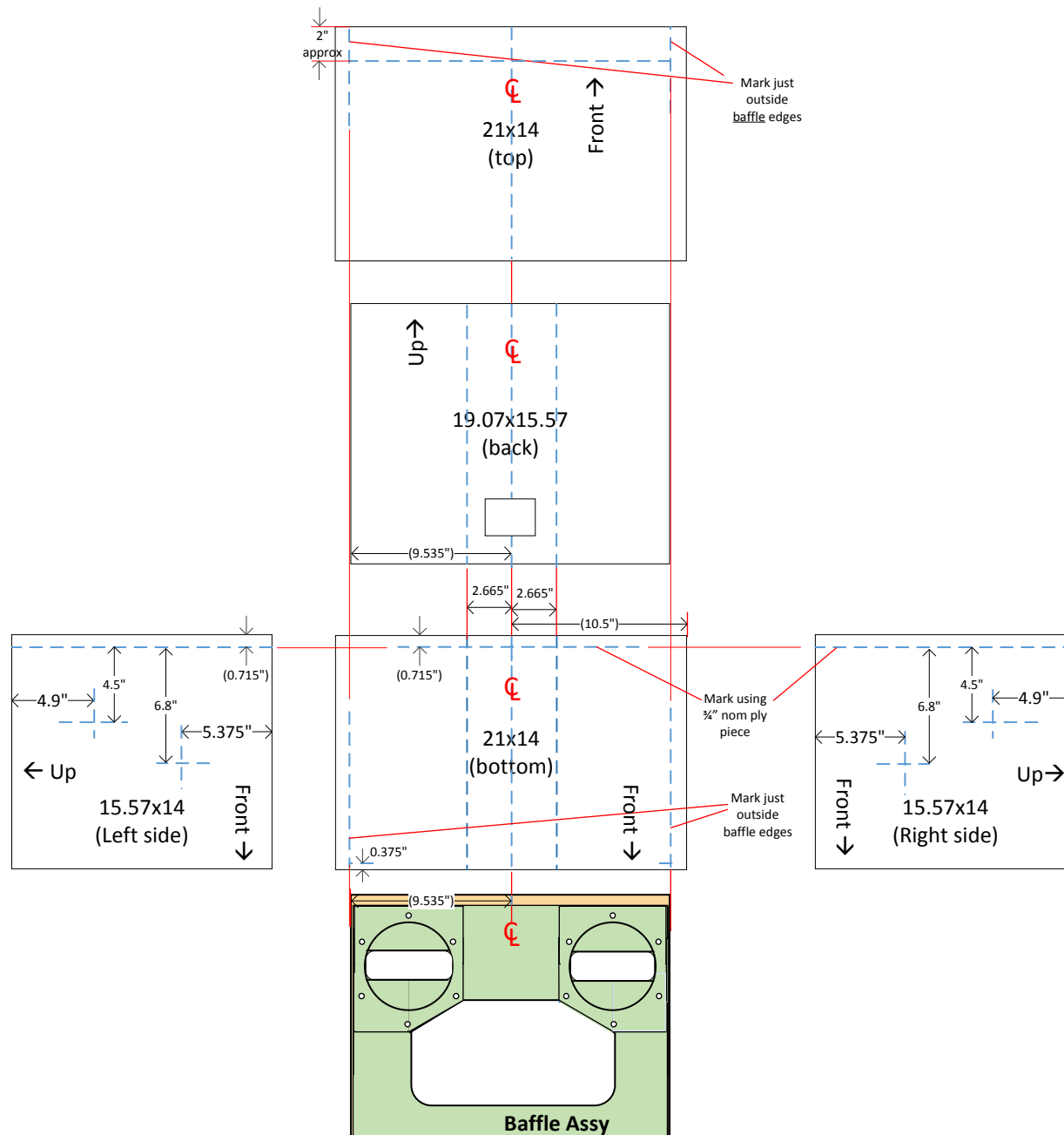


7) Iron-on the veneer tape  
to the bottom of the baffle  
and trim

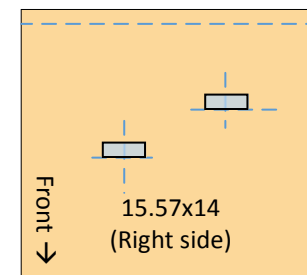
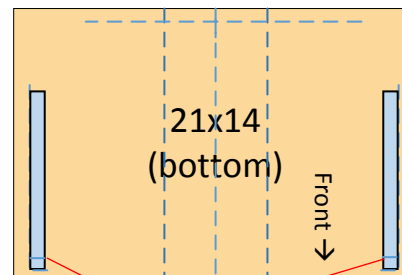
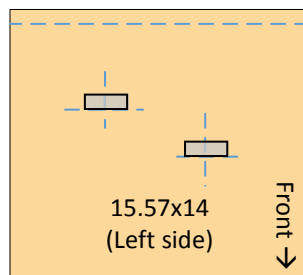
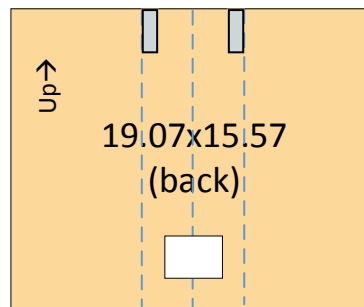
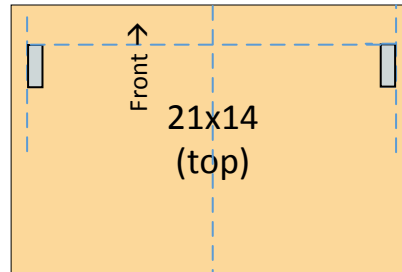


(optional: apply veneer tape to  
inside of woofer apertures.... Not  
easy, though)

Guide Line Markings  
(all panels are inside view)

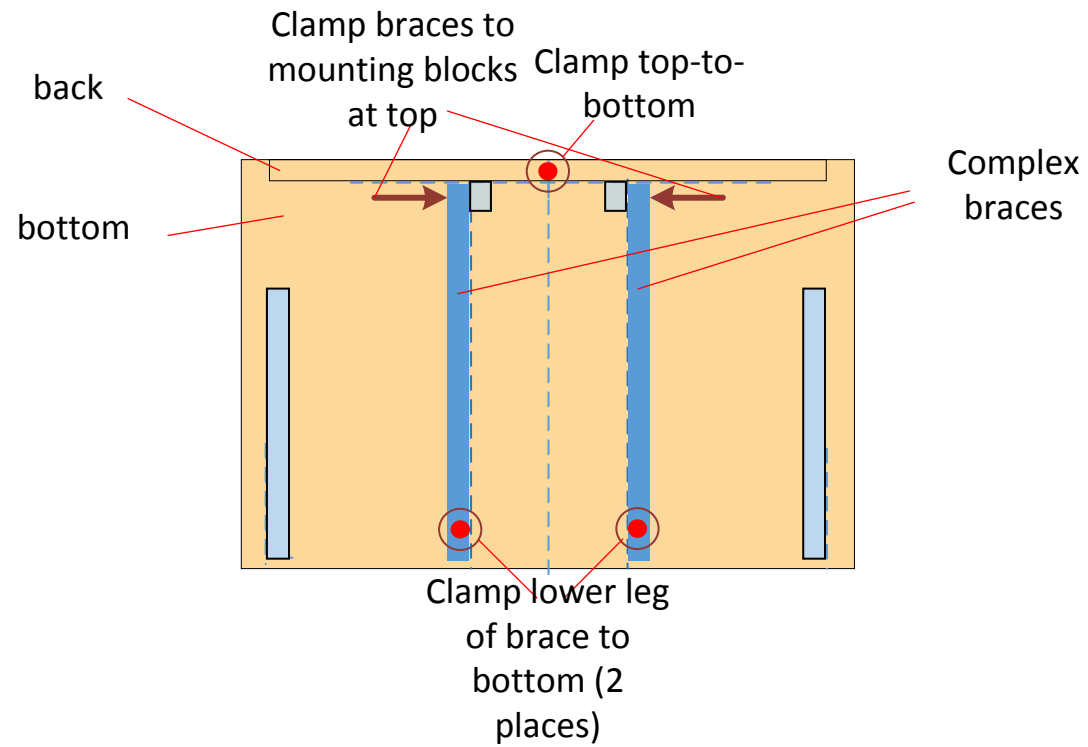


Glue positions of mounting  
blocks and supports  
(all mount ON NARROW EDGE)



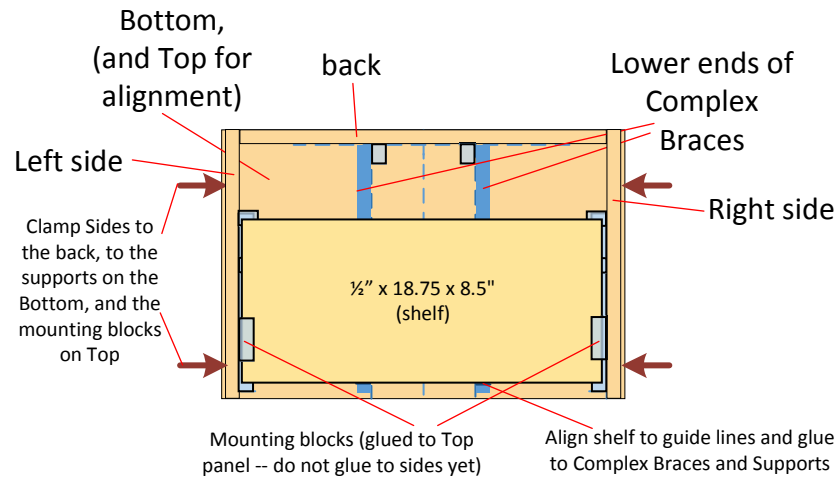
Draw guide lines 0.5" from front  
end of support (use thickness of  
main baffle panel)

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

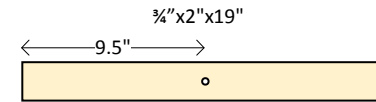




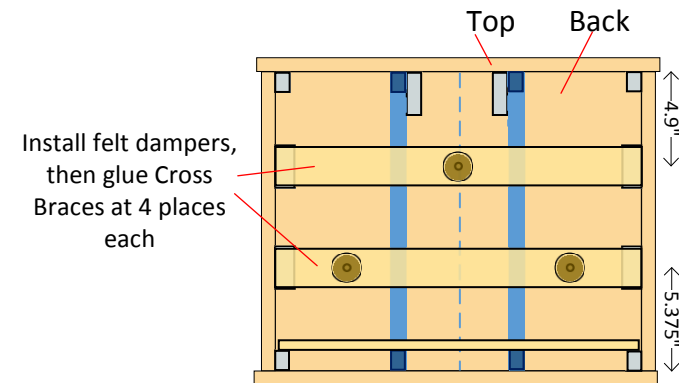
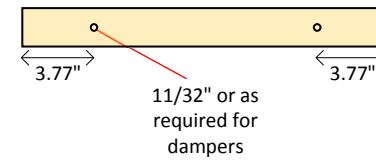
**Glue and clamp all newly joining surfaces EXCEPT TOP PANEL: Do not glue top panel yet, it's only for alignment of the sides for now!**



Upper Cross Brace  
(behind waveguide)



Lower Cross Brace  
(behind woofers)



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