



## **D**

### **D) Knock down enclosure**

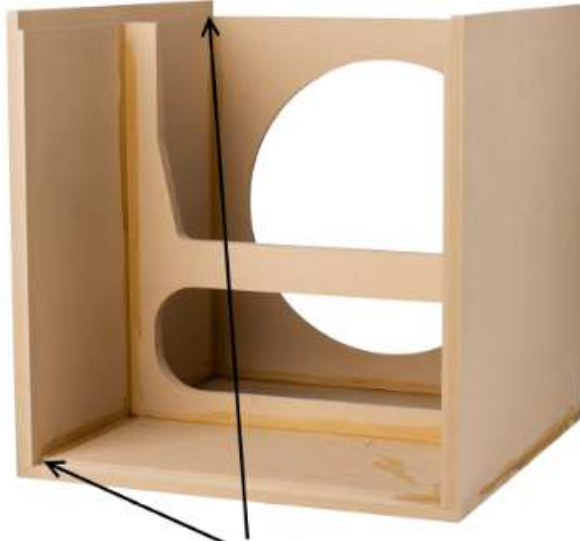
#### **Enclosure Assembly:**

- 1) First, set the enclosure parts out on a flat level surface and ensure that all pieces are free of dust and debris.
- 2) With the back panel lying flat, glue all mating surfaces of one side panel and the top panel and secure them to the back panel with clamps so that even pressure is applied to all glued surfaces. Using a damp rag or paper towel wipe away any glue squeeze-out on the outside of the enclosure and inside the rabbeted edges (excess glue on the inside is fine). Allow to dry according to the glue manufacturer's recommendations and remove clamps.



**Wipe away excess glue from rabbeted edges**

- 3) Next, glue all mating surfaces of the center brace and the bottom panel and secure them in place with clamps so that even pressure is applied to all glued surfaces. Using a damp rag or paper towel, wipe away any glue squeeze-out on the outside of the enclosure and inside the rabbeted edges (excess glue on the inside is fine). Allow to dry according to the glue manufacturer's recommendations and remove clamps.



**Wipe away any excess glue from rabbeted edge**

- 4) Then apply a thin layer of glue to all mating surfaces of the final side and front panel and secure them in place with clamps so that even pressure is applied to all glued surfaces. Using a damp rag or paper towel, wipe away any glue squeeze-out on the outside of the enclosure (excess glue on the inside is fine). Allow to dry according to the glue manufacturer's recommendations and remove clamps.



- 5) Finally, apply a thin layer of glue to the front panel of the enclosure and set the front baffle in place. While ensuring all edges are even and square, position clamps to apply even pressure to the baffle. Using a damp rag or paper towel, wipe away any glue

squeeze-out on the outside of the enclosure and inside the driver cutout. At this time double check that all edges are even and square (this cannot be adjusted once the glue is dry). Allow to dry according to the glue manufacturer's recommendations and remove clamps.



- 6) Sand and finish enclosure to your liking. See our web page for examples.

### **Acoustic foam application:**

- 7) Using a vacuum, remove any dust and debris from inside the enclosure ensuring you have a smooth and clean surface to adhere the Sonic Barrier acoustic foam.
- 8) Using scissors or a sharp knife, cut the Sonic Barrier acoustic foam into 6 pieces: (2) 8" x 18" and (4) 8" x 17.5"
- 9) Starting with the 8" x 18" pieces, peel off the adhesive backing and apply to the back panel on both sides of the center brace. Firmly press the foam sheets into place with your fingers starting at the middle of the panel and working towards the outside edges to force out any trapped air between the foam and enclosure walls.  
**Note:** Do not fold the Sonic barrier sheets once the backing has been removed, the adhesive is very aggressive and cannot be separated if it adheres to itself.
- 10) Remove the adhesive backing from the 8" x 17.5" pieces, apply to the top and bottom panel on both sides of the amplifier cutout. Firmly press the foam sheets into place with your fingers starting at the middle of the panel and working towards the outside edges to force out any trapped air between the foam and enclosure walls.