

TECHNICAL DRAWING FOR THE INTERIOR OF WOODEN SUBSTRATE

1. SCOPE	1.1. This drawing is for the interior of the wooden substrate, not for the exterior.
2. MATERIAL	2.1. The material used for the interior of the wooden substrate is 1.15mm thick Russian plywood.
3. DIMENSIONS	3.1. The dimensions of the interior of the wooden substrate are as follows: 3.1.1. The width of the interior is 415.0mm. 3.1.2. The height of the interior is 415.0mm. 3.1.3. The depth of the interior is 415.0mm.
4. FINISHES	4.1. The interior of the wooden substrate is finished with a 1.15mm thick Russian plywood.
5. TOLERANCES	5.1. The tolerances of the interior of the wooden substrate are as follows: 5.1.1. The width of the interior is ± 0.5 mm. 5.1.2. The height of the interior is ± 0.5 mm. 5.1.3. The depth of the interior is ± 0.5 mm.

Model: Skybambu Science & Technology Industry Co., Ltd. China
www.skybambu.com

Assembly Instructions (Refer to the Notes)

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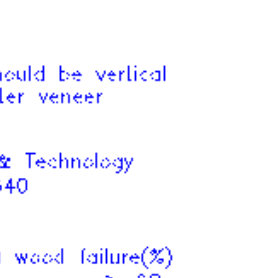
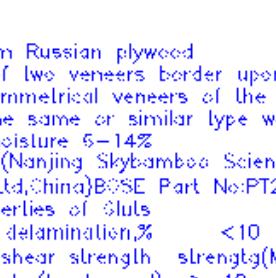
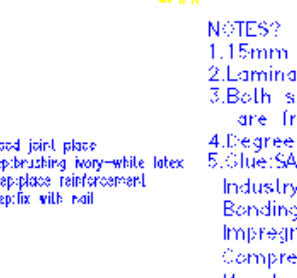
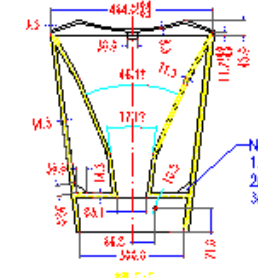
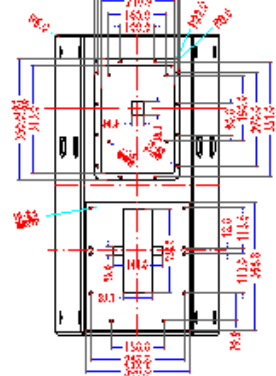
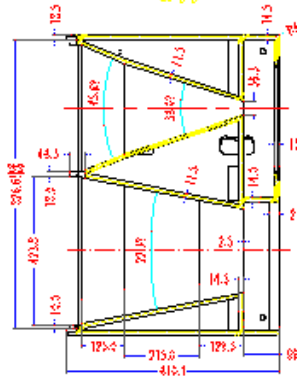
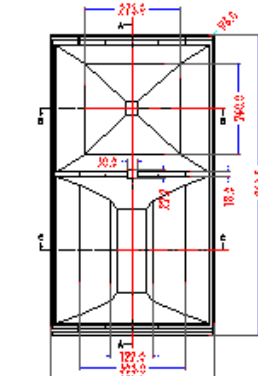
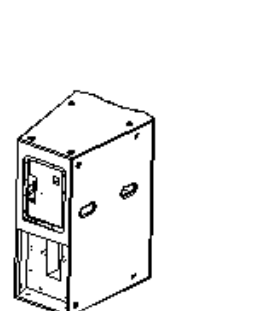
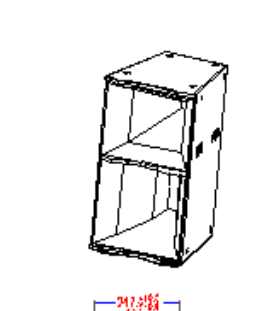
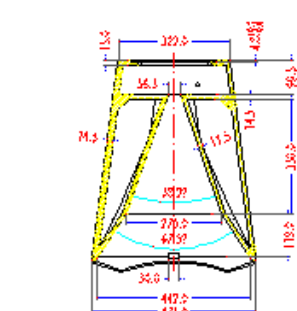
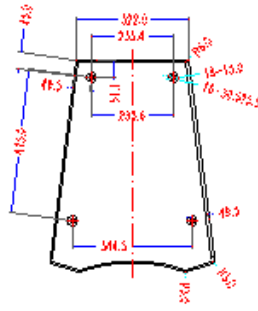
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- NOTES:
1. Material: 1.15mm Russian plywood
 2. Adhesive: Nanjing Skybambu Science & Technology Industry Co., Ltd. China
 3. Inner angle: must meet the inner angle inspection standard (n6 relative standard)
 4. Rigging: must meet the rigging insert inspection standard (n6 relative standard)
 5. Structure:
 - a) It should be T-groove connection between board and board (n6 relative drawings for shape and size details)
 - b) The degree of adhesive intensity is based on wood broken ratio. Ensure the wood broken ratio is 100%.
 - c) Position, quantity and space of glue spreading and nail must meet the requirement of relative drawings.
 6. Geometry:
 - a) Geometry precision must meet the drawing requirement (n6 drawing for details)
 - b) Add diagonal inspection to ensure the cabinet structure. The difference between two diagonal should be 0.25mm.
 7. Finish:
 - a) Color: 2 colors, 3 shading, n6 samples
 - b) Adhesion: n6 inspection
 8. Key points:
 - a) Counter sink of rigging screws: diameter 3.0mm; depth: 3.0mm
 - b) Match of glue and cabinet: verticality: 0.5mm; horizontal: 0.5mm; depth: 0.5mm
 - c) In the place of compression driver plate mounting (n6 attached drawing), there should be no dirt, ridge, glue or paint dot.
 - d) In the place of Yee-2 assembly mounting area (n6 attached drawing), there should be no dirt, ridge, paint or cabinet adhesive dot.
 - e) Two holes of Yee-2 assembly should be symmetrical to the cabinet center, tolerance: 0.5mm
 - f) Mounting hole for the rear cover of compression driver should be counter sink, with depth: 3.0mm. The bottom should be flat, no protrusion dot.
 - g) Clear up all dirt before glue spreading and cabinet final assembly. Ensure that there's no dirt in the T-groove connection gap.
 - h) Ensure the rotation angle in the joint of them and cabinet, ensure the consistency of each line direction and symmetry of relative line.
 - i) It's 0.5mm in the joint, make sure the line is clear.
 - j) Clear up all surfaces and spread all glue on the thread line before being rigging screws into inner angle.
 - k) Fill the large groove.

Notes: wood joint place
1st step: brushing ivory-white latex
2nd step: place reinforcement
3rd step: fix with nail

- NOTES:
1. 1.15mm, 1.2mm Russian plywood
 2. Lamination of two veneers border upon should be vertical
 3. Both side symmetrical veneers of the center veneer are from the same or similar type wood
 4. Degree of moisture: 5-14%
 5. Glue: SA-100 (Nanjing Skybambu Science & Technology Industry Co., Ltd. China) BOSE Part No: PT280640
 6. Bonding Properties of Glue:

Impregnation delamination (%)	<10	
Compressive shear strength (MPa)	strength (MPa) wood failure (%)	
Manchurian ash (hard wood)	>=10	>=60
Spruce (soft wood)	>=6	>=65
 7. a. peeling off rate after dipping in test % ?10
b. peeling off rate after ferv. % ?10
 8. CHEMTHANE 7030 polyurethane protective coating for wood.
 9. CHEMTHANE 1400 aliphatic water-based coating

Unless otherwise specified dimensions are in millimeter.	THIRD ANGLE PROJECTION	LEVEL	DRAWN	DATE	ELDER AUDIO MANUFACTORY			
Tolerances are:			CHECKER	09/01/09	The third Industrial Road, Ningbo Gangqian Gangqian 321021 China			
Decimals					DESCRIPTION			
Angles					SARNEI L114102-WP			
X: +/- 1.2					SIZE			
X +/- 0.5					FSCM			
.XX +/-					CLASS			
					DWG NO.			
					E17-RIFGIM-SMG73			
					SCALE			
					NONE			
					SHEET			
					of			