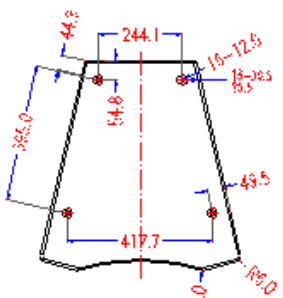
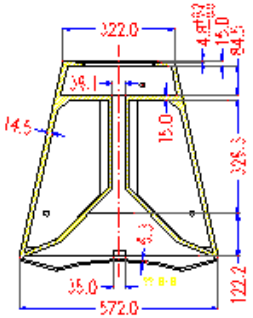
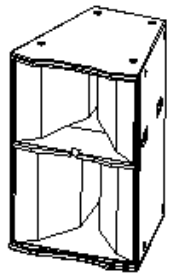
POLYURETHANE COATING FOR THE EXTERIOR OF WOODEN SUBSTRATES

REVISIONS				
REV	DESCRIPTION	CHK	ENG	DATE

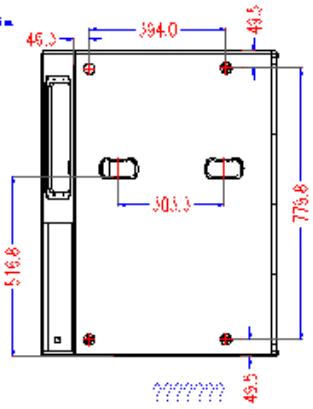


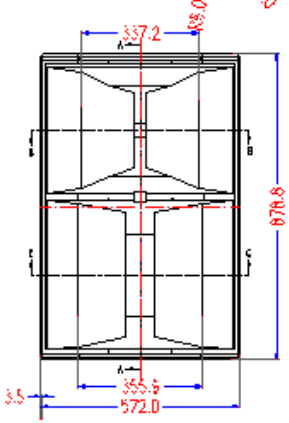


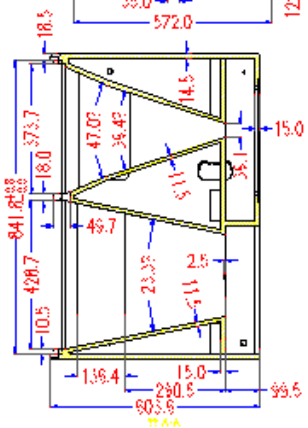


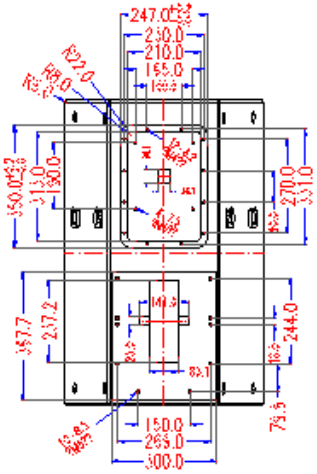
Nanjing Skybamboo Science & Technology Industry Co., Ltd. China
www.skybamboo.com

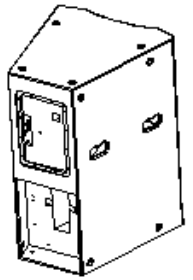
Japanese Polymerization Adhesives for Wood



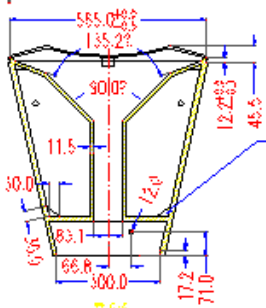








NOTES:
1. Material: 15mm ,12mm Russian plywood
2. Adhesive : Nanjing Skybamboo Science & Technology Industry Co.,Ltd,China SE-100 AB
3. Brace angle : must meet the brace angle inspection standard (ref relative standard)
4. Rigging insert: must meet the rigging insert inspection standard (ref relative standard)
5. Structure :
   1) It should be T-groove connection between board and board (ref relative drawings for shape and size details)
   2) Judgement of adhesive intensity is based on wood broken ratio. Ensure the wood broken ratio≥70%
   3) Position, quantity and space of glue spreading and nails must meet the requirement of relative drawings.
6. Geometry:
   1) Geometry precision must meet the drawing requirement. (ref drawing for details)
   2) Add diagonal inspection to ensure the cabinet structure. The difference between two diagonal should be≤2.5mm.
7. Finish:
   1) color 2) veins 3) shining ref samples
   4) adhesion ability inspection
8. Key points :
   1) Counter sink of rigging screw: diameter20.5-0.2; depth 5.5+0.3
   2) Match of grille and cabinet: vertical≤1mm; horizontal -0.5mm; depth -0.3mm
   3) In the place of compression driver plate mounting (ref attached drawing A), there should be no dent, ridge, glue or paint dot.
   4) In the place of Vcc-2 assembly mounting area (ref attached drawing B), there should be no dent, ridge, paint or calcium carbonate dot.
   5) Two holes of bass Vcc-2 assembly should be symmetrical to the cabinet centre, tolerance≤0.5mm.
   6) Mounting hole for the rear cover of compression driver should be counter sink, with depth 5±0.3mm. The bottom should be flat, no protrudent dot.
   7) Clear up all fibers before glue spreading and cabinet final assembly. Ensure that there's no fiber in the T-groove connection gap.
   8) If there's radiation angle in the joint of horn and cabinet, ensure the consistency of each line direction and symmetry of relative line.
      If it's 90angle in the joint, make sure the line is clear.
   9) Clear up all surfaces and spread AB glue on the thread line before fixing rigging screws into brace angle.
   10) Fill the logo groove.



NOTES?
1.15mm ,12mm 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 6-14%
5.Glue:SA-100;(Nanjing Skybamboo Science & Technology Industry Co.,Ltd,China)BOSE Part No:PT2806#40

Bonding Properties of Gluts		
Impregnation delamination,%	<10	
Compressive shear strength	strength(MPa)	wood failure(%)
Manchurian ash (hard wood)	>=10	>=90
Spruse (soft wood)	>=5	>=65

a.peeling off rate after dipping in test % ?10
b.peeling off rate after serv. % ?10
6.CHEMTHANE 7030 polyurethane protective coating for wood.
7.CHENMTHANE 1400 aliphatic water-based coating

Unless otherwise specified dimensions are in millimeter. Tolerances are: Decimals Angles X. +/-1.2 +/- .X +/- 0.5 .XX+/-	THIRD ANGLE PROJECTION	LEVEL 3	DRAWTER	DATE: 09/01/08	ELDER AUDIO MANUFACTORY the Third Industrial Bobid Wenlong Dongguan Guangdong 523121 China.
			CHECKED		DESCRIPTION: SABINE1 LI3402-WP
	MATERIAL: See Notes	2	ENGINEER	09/01/08	SIZE C; FSCM; CLASS; DWG NO.: ELY-XIAOLIN-SA0029; REV
	FINISH: See Notes	1	APP BY		SCALE: NONE; SHEET of

FNAME REVDATE USER