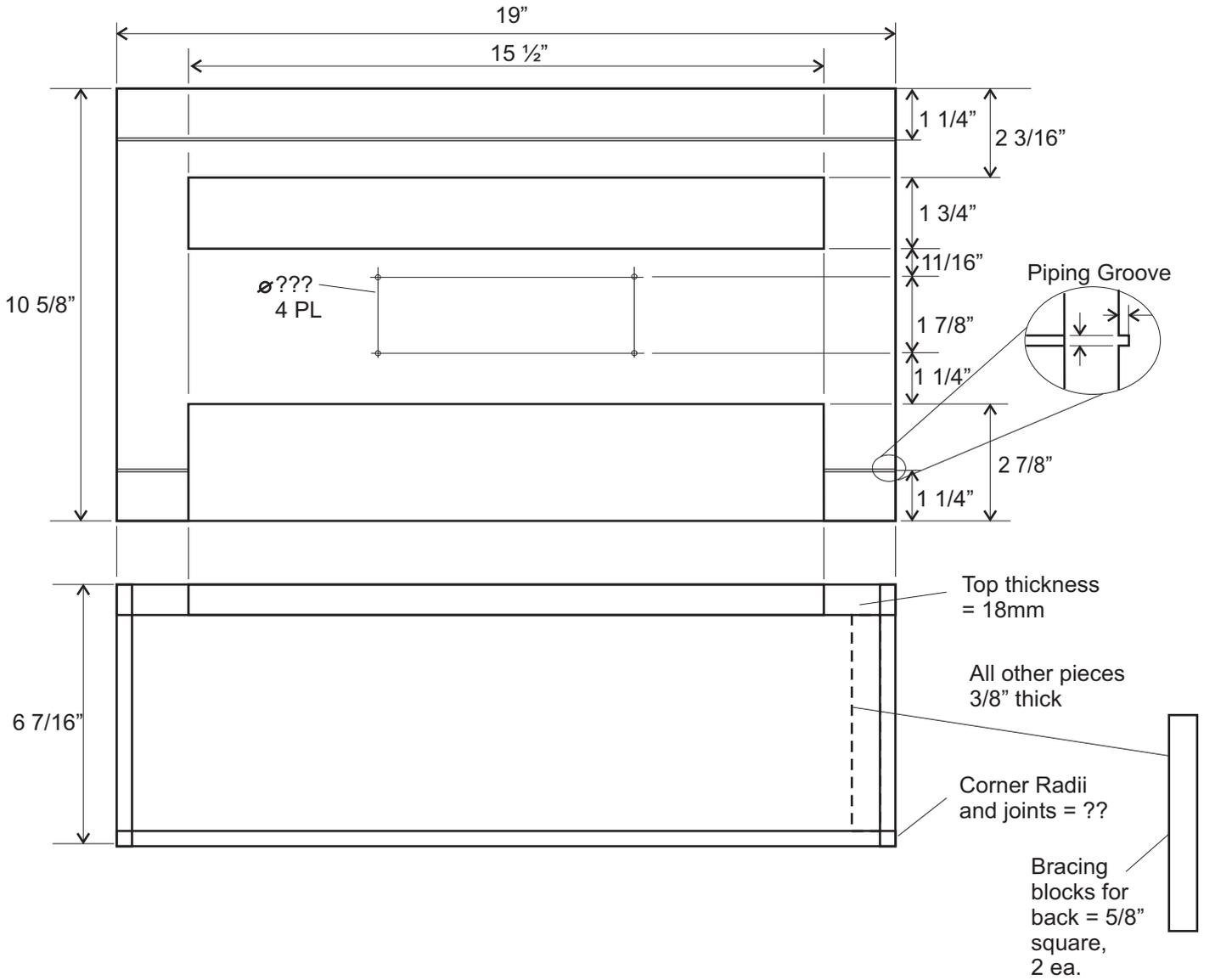
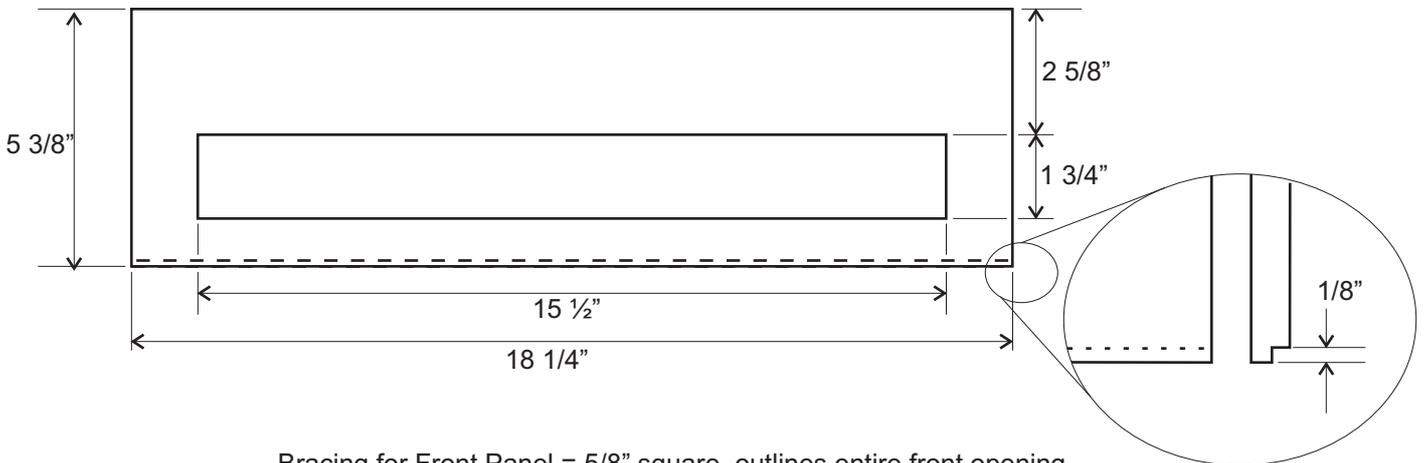


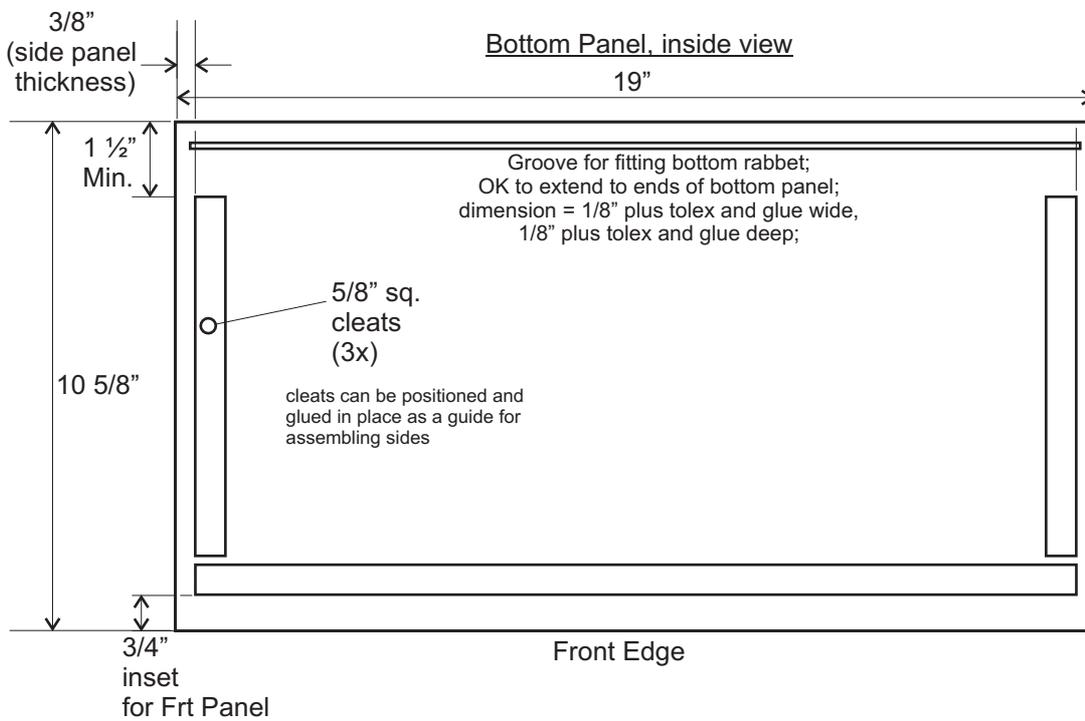
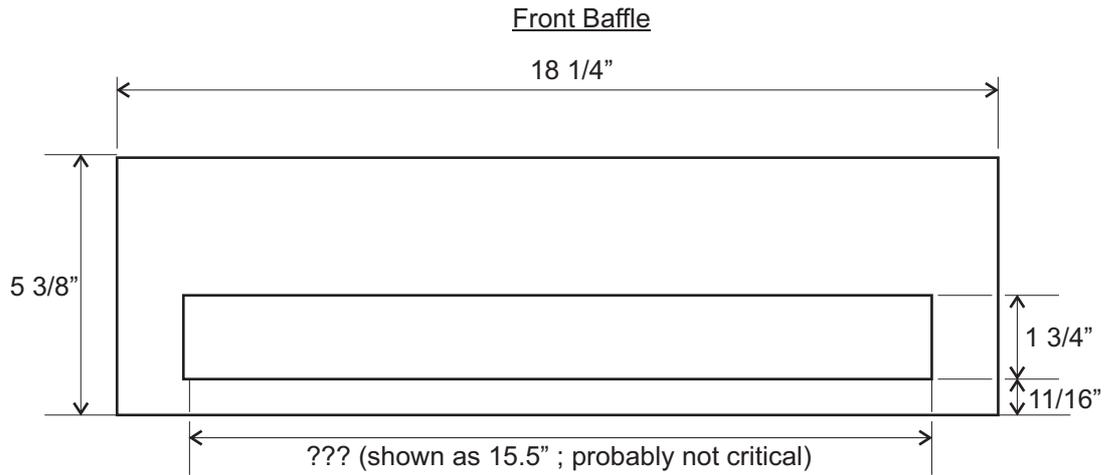
AC50 Enclosure - "Thin Edge"



Back Panel, outside view; note rabbet fitting bottom



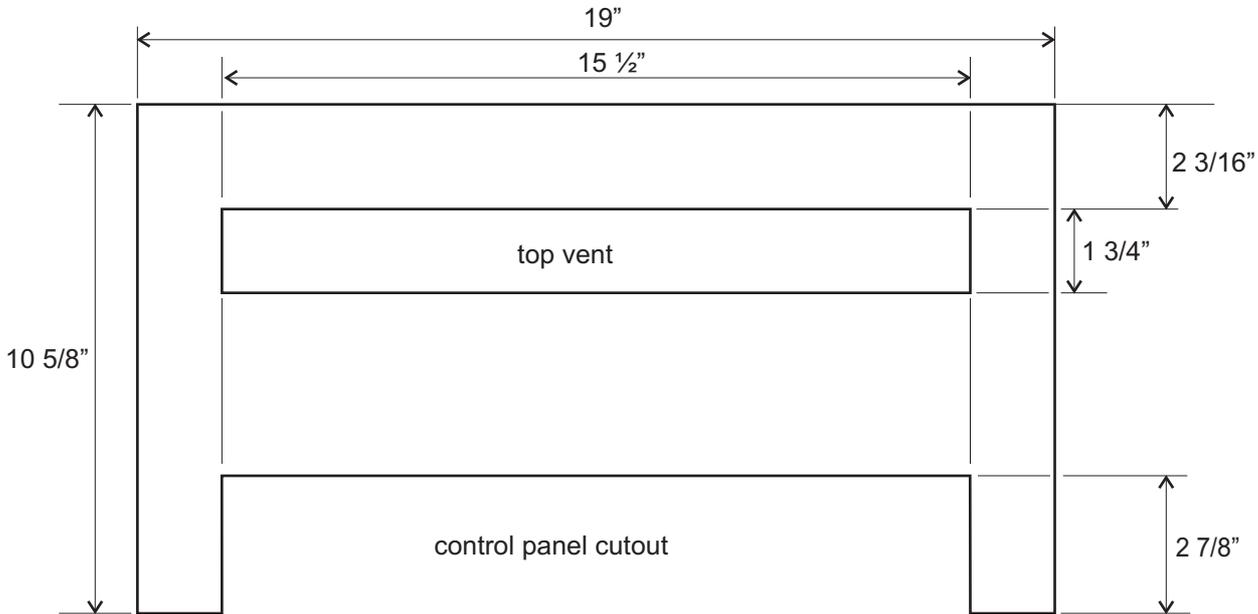
Bracing for Front Panel = 5/8" square, outlines entire front opening.



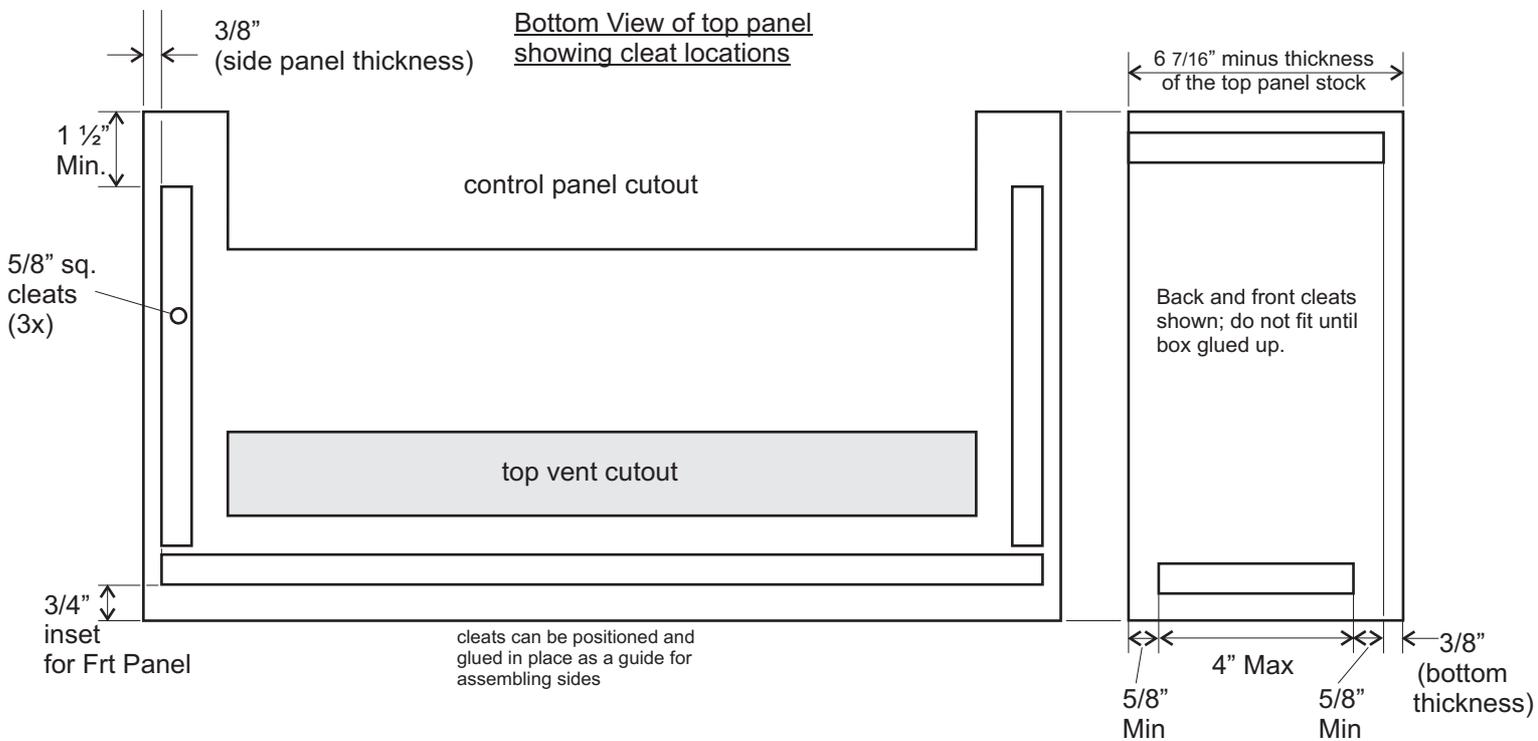
Pictures of some units show large round holes in the bottom, others do not. Perhaps this was for ventilation in some units? Unknown at this time.

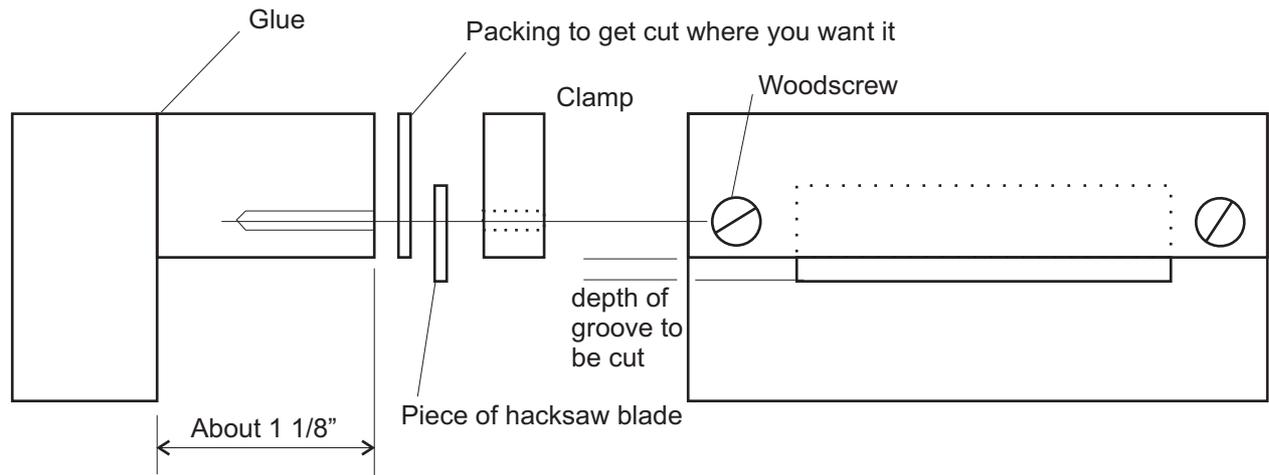
Individual Pieces

Top = 3/4" or 18mm thick
(plywood, not particle or MDF)



Inside view of left side panel
(right side is mirror image)





Special purpose tool for cutting gold piping groove in finished cabinet.

Cut a short section of hacksaw blade by grinding. Do not try to cut it with scissors, shears, etc. Won't work well. You need to NOT bend up the ends of the hacksaw blade.

Packing adjusts the cut for distance from edge. Clamp the blade in place so the depth of cut is correct.

Set the packing and ***test the cut on a piece of scrap *** before cutting the glued-up enclosure.

Cut the edge of the groove closest to the edge of the enclosure first. Then cut the edge of the groove furthest from the edge of the enclosure. Then cut away any remaining middle material.

Do not use a lot of pressure. First, it's not needed to cut wood, and second it can force the blade to cut a shallower groove. Make several low-pressure passes, pausing to blow out the cuttings so the blade does not clog.

Building it

1. Buy panel stock to make it from. Plywood in the USA is or has changed to metric, so measure the plywood you buy for thickness and adjust the dimensions shown to fit your stock. In particular, the top panel will probably be 18mm, which is not 3/4", nor is it the 23/32" it will be marked. Measure what you get and adjust the dimensions accordingly to get the same outside dimensions. You have been warned.

2. Having adjusted the dimensions of the panels to match the actual stock thickness, cut the panels. The top is 18"mm (or 3/4", or 23/32") thick. The other panels are all 3/8" (...or 9mm, or 9.5mm...) thick. The interior bracing cleats are nominally 5/8" square. It is likely, but unproven, that 18mm (or 3/4" or 23/32") thick off-cuts can be used to make the braces.

3. The original used fingerjoints on the four corners. To simplify the cabinet joinery, use butt joints and much larger cleats. This is the construction method shown. Once the panels are cut, work the cutouts and vents in the top, front baffle, and back panels.

4. Work the rabbet at the bottom of the back panel, then locate and cut the groove in the bottom panel that the rabbet fits into. In doing this, remember that the tolex to be applied will make the back panel thicker when it's applied.

5. Test fit the panels, and place the cleats in the four outer edges. Note and follow the insets on the cleats. The edge cleats must clear the vertical back posts and top/bottom cleats holding the front baffle.

6. When fit is correct, glue and screw the cleats to the top and bottom, then glue and screw the sides to the top and bottom to make the enclosure. Use some method of aligning the front edges, and some method of making sure the panels are held square while the glue sets.

7. When the glue is completely set, remove the screws - they're no longer needed. Drill out the screw holes and glue in wooden dowels both as mechanical supports and to allow you to round the corners on a router/shaper, or by hand.

8. Test fit the front baffle and back panel. The front panel is a fairly loose fit, since the panel will be covered with grille cloth and have the white piping strip stapled to it on its edges. The back panel must fit nicely into its bottom groove. Once the back fits correctly into the groove, align the back panel to be parallel with the back edge, and use the back panel position as a guide for placing the back panel support cleats on the sides. This ensures that the panel will fit the groove and cleats when the cleats are dry. When the cleats are located, glue and screw them to the sides; let glue set, then remove the screws and plug the screw holes.

9. Similarly, locate and attach the front baffle supporting side cleats.

10. When the glued enclosure is fully set - let it set for a couple of days to be sure! - you can round the corners and edges.

11. Once the outside is properly rounded, fill any divots or holes on the outside with wood filler. Let dry, then sand the outside with medium sandpaper to level and smooth it. Use a sanding block.

12. Work the grooves for the gold piping. Make up a grooving tool as shown on the preceding page.

13. Check your work. Correct any mistakes with wood filler and sandpaper. This is where you make your tolex application easier.

14. Spray black paint on the insides.

15. Tolex. Finish the baffle and back panel. Apply grille to the top and back vents.

16. Finish the mounting screw holes for the front baffle, chassis, and feet.

17. Apply gold piping.