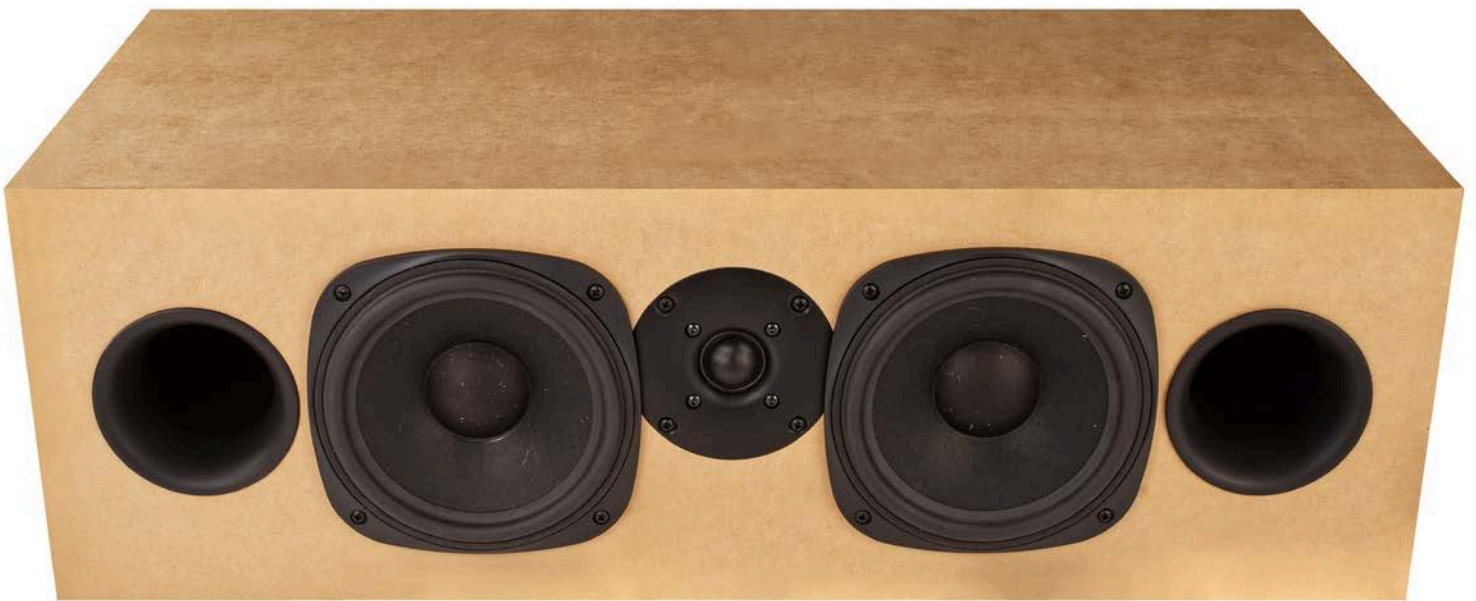




# C6S Assembly Instructions

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Designed and manufactured in Australia by The Loudspeaker Kit  
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### You will need:

- Phillips head screwdriver
- Woodworking glue
- Damp cloth
- Good quality masking tape
- Ratchet tie down strap (optional)
- Brick or other weight (optional)

## Preparation

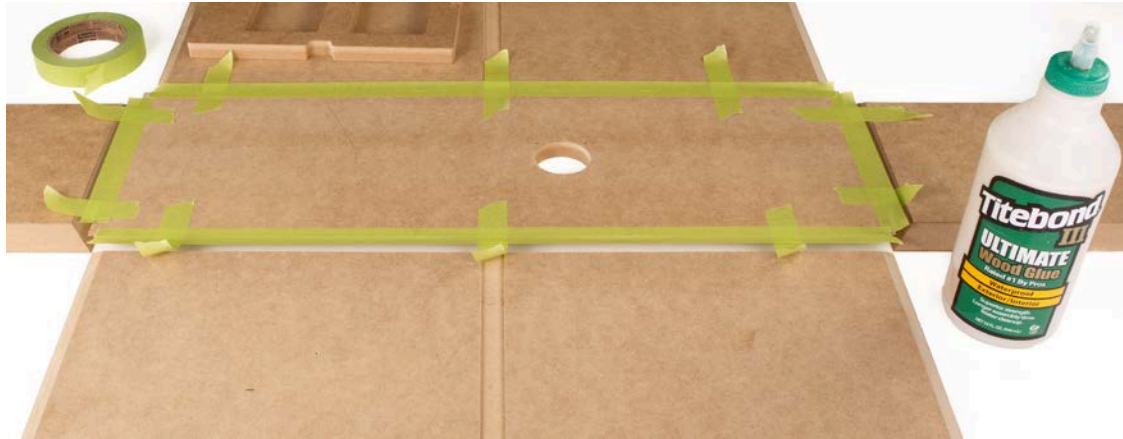
Lay the contents of the box out and check you have everything you need to complete the kit (see parts list on back page). Find a suitable work surface and make sure it won't be ruined if you spill some glue. If covering the work surface, avoid using newspaper as newsprint may rub off onto your kit. Baking paper is a good choice.

## Easier assembly with mitres

LSK kits now employ mitre construction, which offers greater ease of assembly with much less sanding. Butt joints are eliminated, avoiding visible hairline cracks that often appear after painting. Mitre construction puts the join right on the edge where it is less visible. Most constructors avoid using mitres due to the difficulty in getting the angles correct. Our manufacturing process provides a level of accuracy that is very difficult to achieve in a home workshop.

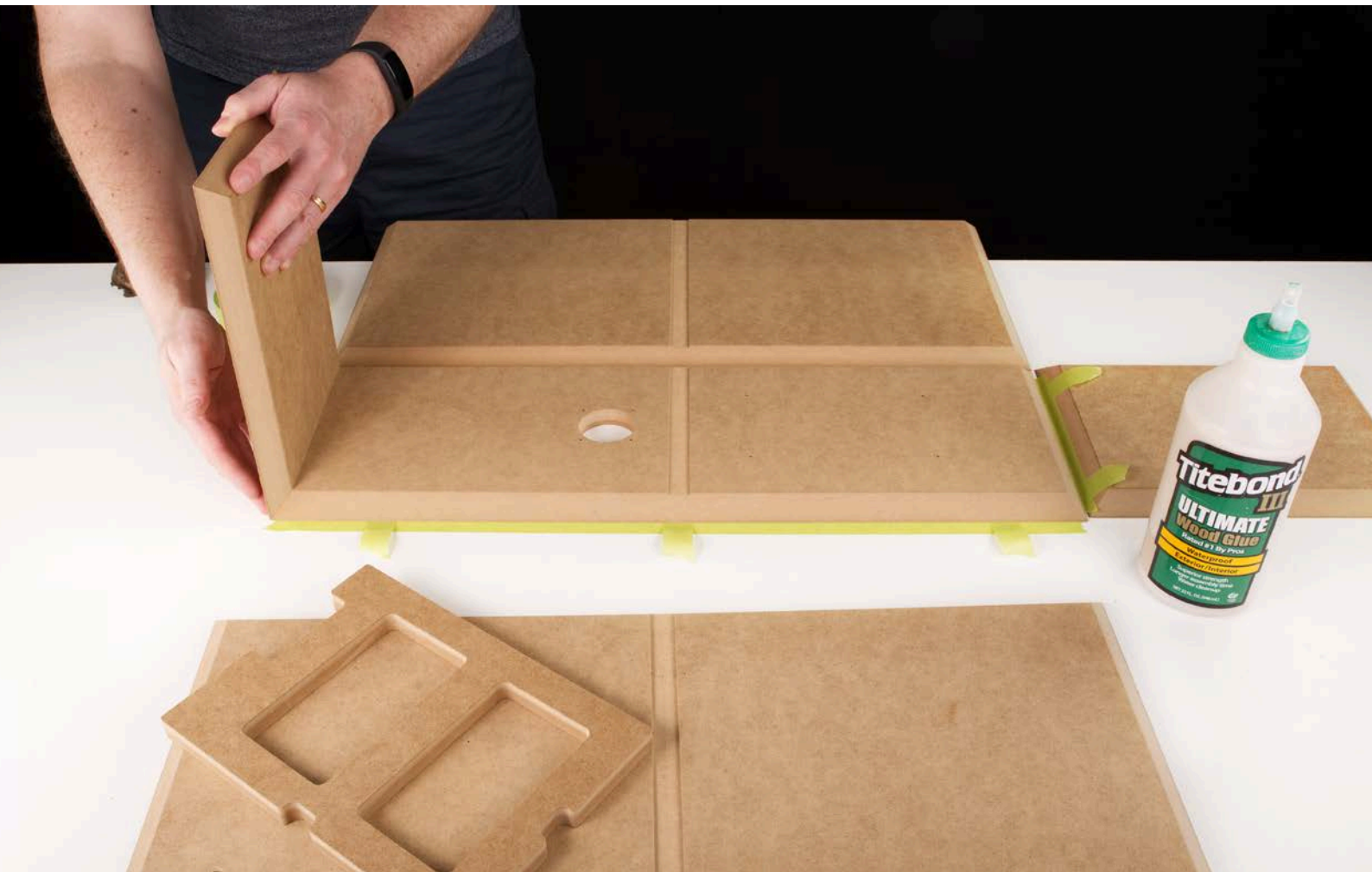
## Masking tape

We recommend avoiding cheap masking tape, which tends to break when applied under tension. Lay out the rear panel and apply masking tape as shown.



Flip over the panel to expose the mitres. Carefully position sides, top and bottom panels. Press the panels firmly along each join so that the masking tape on the other side adheres to the MDF. Now rotate up each of the four panels as shown below and press the masking tape firmly into the join.

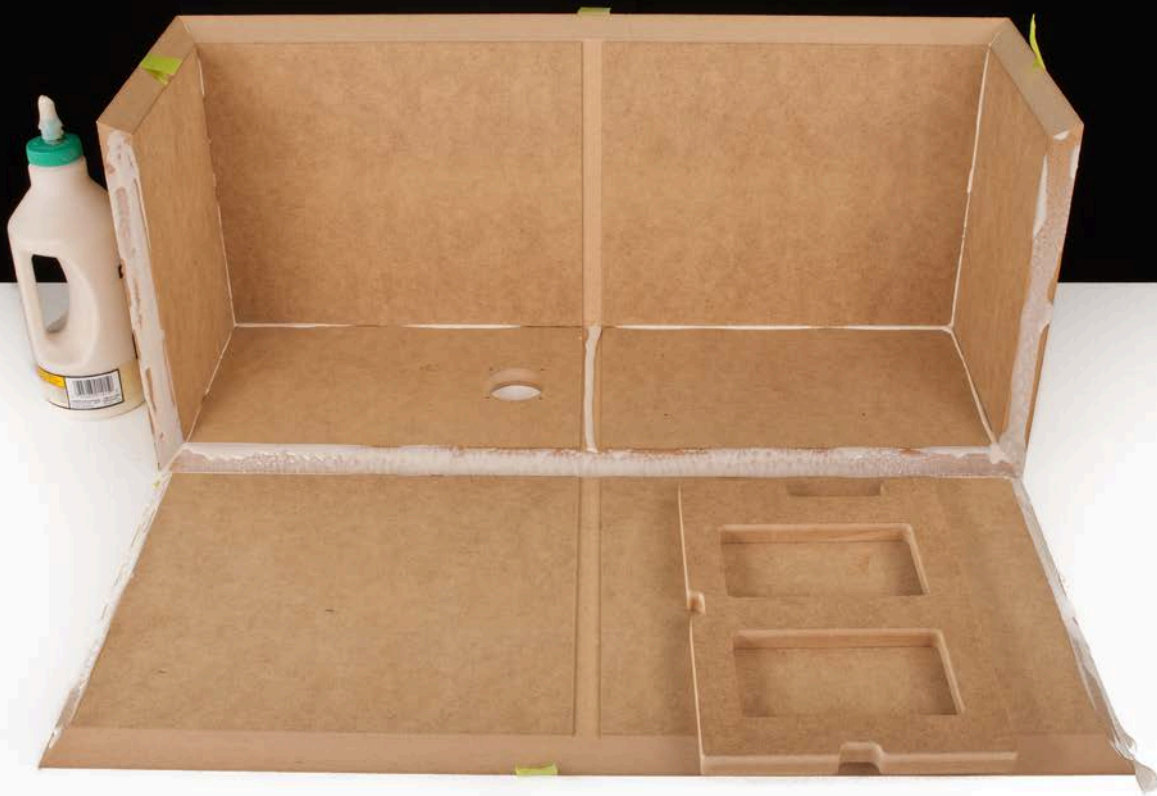
**Tip:** Overhang a small strip of masking tape on each of the four panels. These strips, which are shown on the next page, will make it easy to lift the panels.





Apply a glue bead to all four joins between the rear and adjacent panels. This first bead of glue should be applied to the bottom of the mitre. Then apply a second bead in the middle of the mitre. This bead should be thicker than the first, as you can see below.





Confirm that the glue adequately covers the entire surface of the joints by folding up each pair of panels to form a joint. Check the glue covers the entire surface of the joint. Add more glue where necessary. Fold up the first three panels as shown above. Wipe excess glue then firmly press the panels together as you hold them in place with masking tape. Initially, one strip of tape across the joint will hold them in position.

Glue up the three trenches for the brace and press into position so that the larger cutout for the tweeter magnet faces up. Then glue up the mitres and fold up the bottom panel.





## Tweeter magnet cutout

In the photo above and below you can see the brace with the tweeter magnet cutout facing the baffle, which is yet to be inserted. Note in the photo below that the brace is oriented to place the cutout towards the top of the enclosure.

After the top panel has been glued in place, wipe the joints. Then hold in position first with a strip of masking tape to each joint. Now add a second strip across the joint before taping along the edges as shown below.

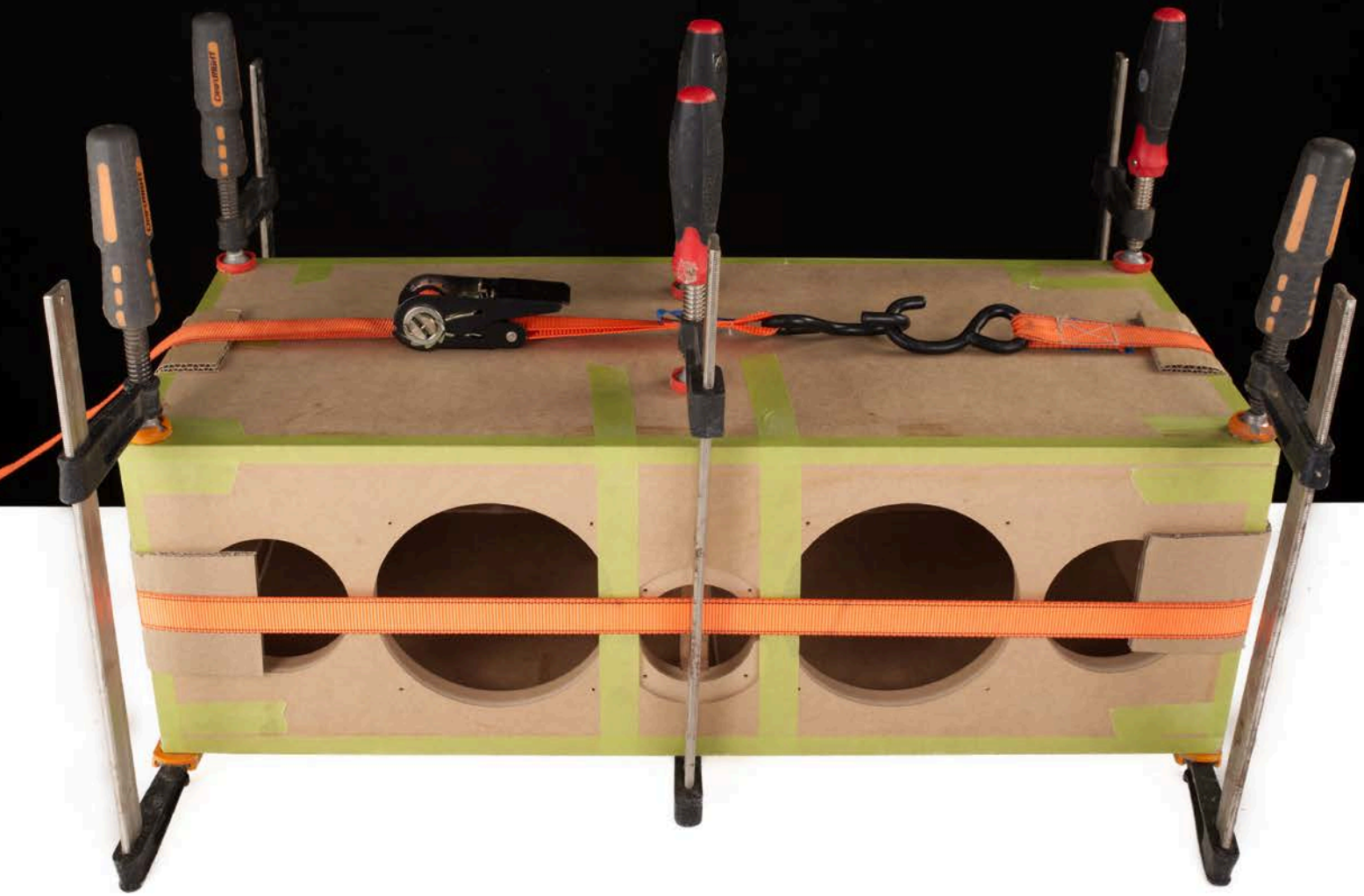




Apply one thick glue bead to the mitres on the front baffle. Alternatively, you may prefer to use a zig zag pattern. Confirm the amount of glue by pressing into position. The entire joint should be covered in glue – apply more glue where necessary. Now press the baffle firmly into place. Wipe excess glue and secure with masking tape.

Secure panels firmly with masking tape after wiping all joints with a damp cloth. Use firm pressure when applying the tape. The tape holds the panels together as the glue sets and should cover all joints. The tape should cover all edges.





## Clamping

Due to the brace that is used, we recommend at least two F clamps which are large enough to clamp across the height (greater than 220mm). Six or more F clamps in total are recommended, as shown above.

## Strapping

The use of two ratchet straps avoids the necessity of purchasing larger and more expensive F clamps. Two straps as shown work well. Be sure to protect all four corners with cardboard strips where each strap bends around a corner.



## Drying time

Typical wood glues can achieve moderate strength in as little as 30 minutes. If you are using PVA glue then a good indicator that it has set is the transparency. PVA becomes transparent once set. Ideally it's best to leave the enclosure clamped over night before moving on to assembly or finishing.

## Grille assembly

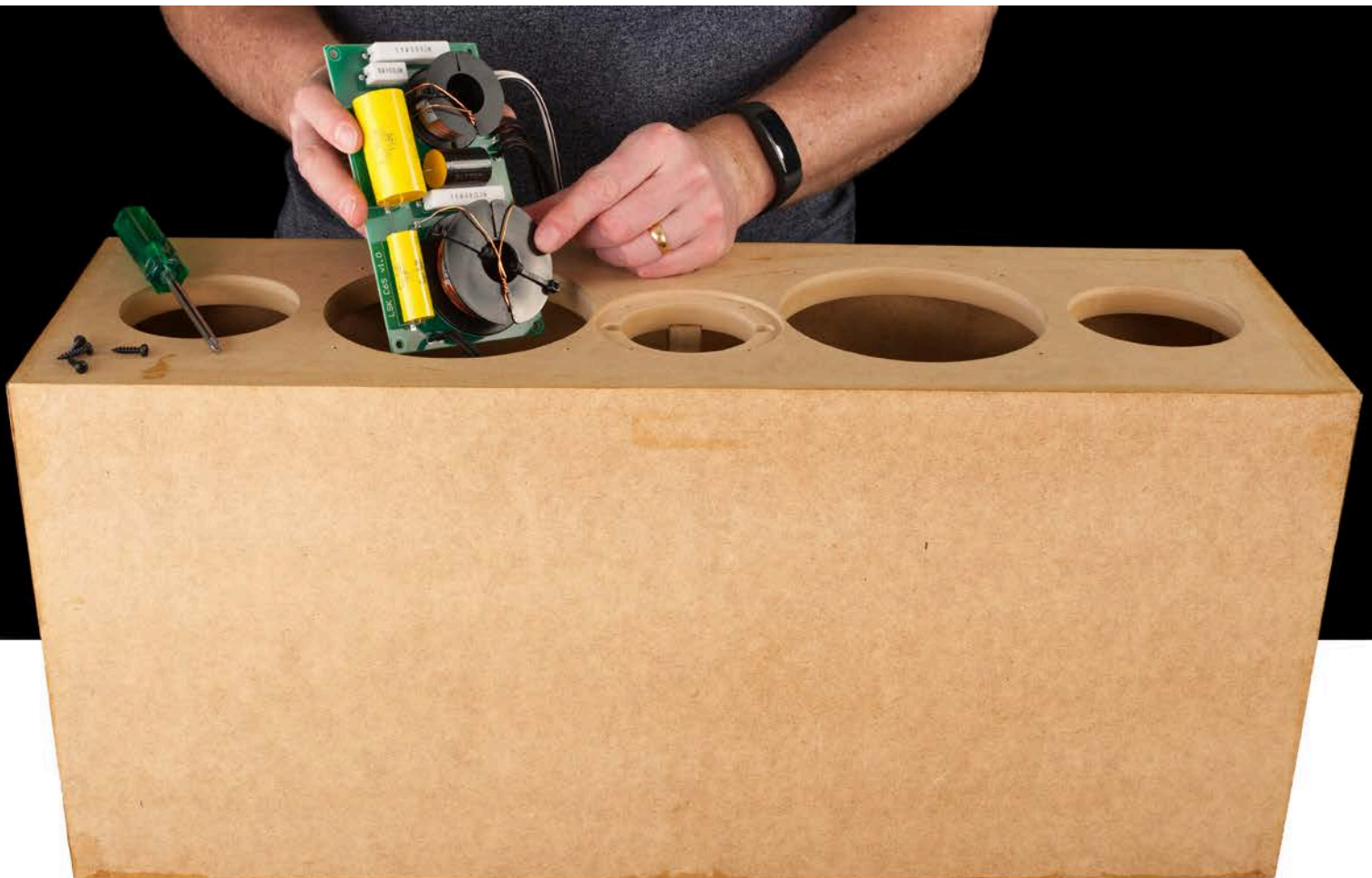
This kit uses a clever neo magnet attachment system that avoids the use of traditional grille clips. Flat packs contain neo magnets which have been concealed in the front baffle and grille.

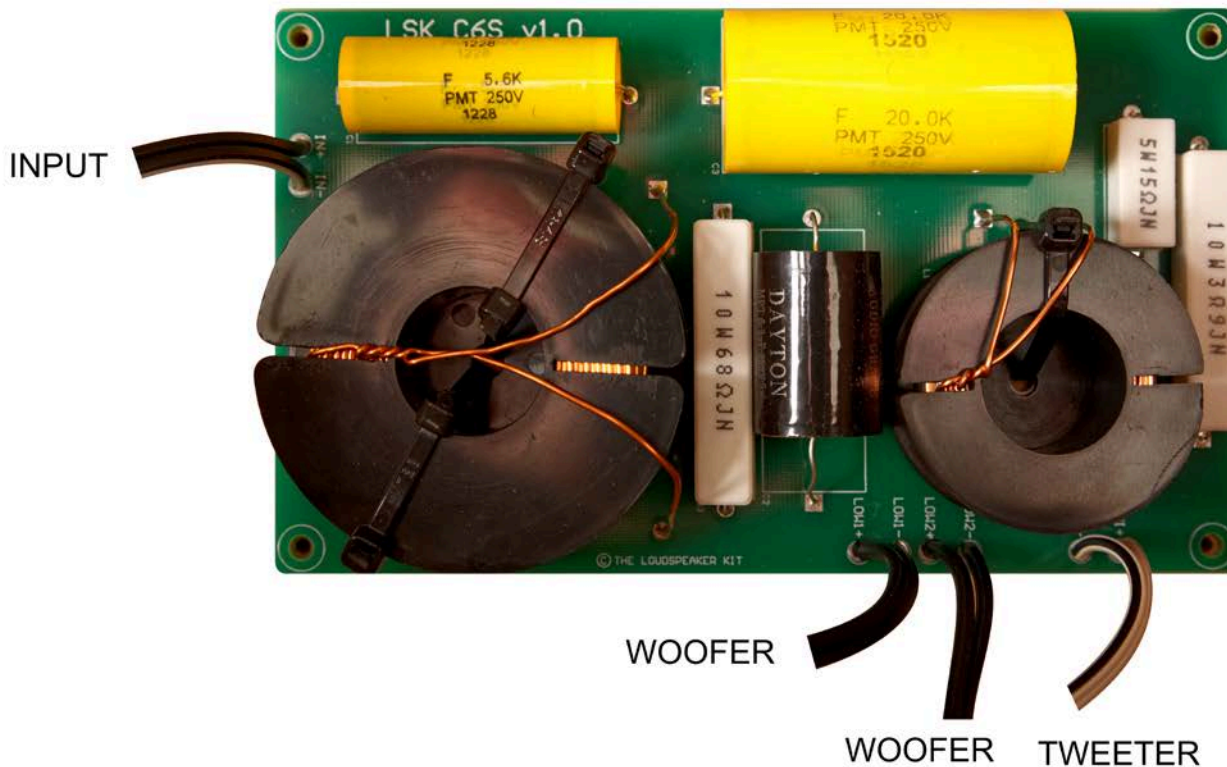
## Sequence tip

Final assembly should be done after you have applied your chosen finish. Otherwise, drivers and terminals will get damaged and the internal lining will be covered in MDF dust.

## Insert the crossover board

Insert the crossover board into the enclosure through the woofer hole and then position so that the four holes in the crossover board align with the four pilot holes in the internal rear surface of the enclosure.





## Installing the crossover board

There are three sets of cables:

- **Input terminals:** located near the larger inductor on the end of the board.
- **Tweeter output:** easily identified by the white cable (HI+ HI -)
- **Woofer output:** black cable next to the tweeter outputs (LOW+ LOW-)

The crossover is fixed in place with 4 short button head self tapping screws. It's best to screw them in place with a screwdriver by hand. Orient so the input loom is near the terminal cutout.

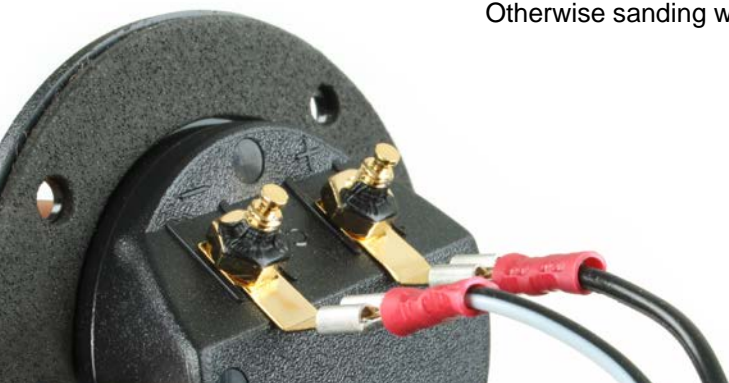
**Note:** Although two sets of woofer outputs are shown (LOW1 & LOW2), it does not matter which woofer is connected to which of these two outputs. They are both the same.

### How to identify positive and negative cables

All negative cables have a stripe. The white tweeter cable has a black stripe. The black woofer and input cables have a white stripe.

To ensure positive and negative speaker outputs are not reversed, the spade connectors have different sizes to prevent mistakes. However, extra care is required with the input cable, since the terminals for this are both of the same size.

**Sequence tip:** Normally this step would follow finishing the speaker. Otherwise sanding will get MDF dust over the crossover.



**Note:** The cable with the white strip goes to the negative terminal

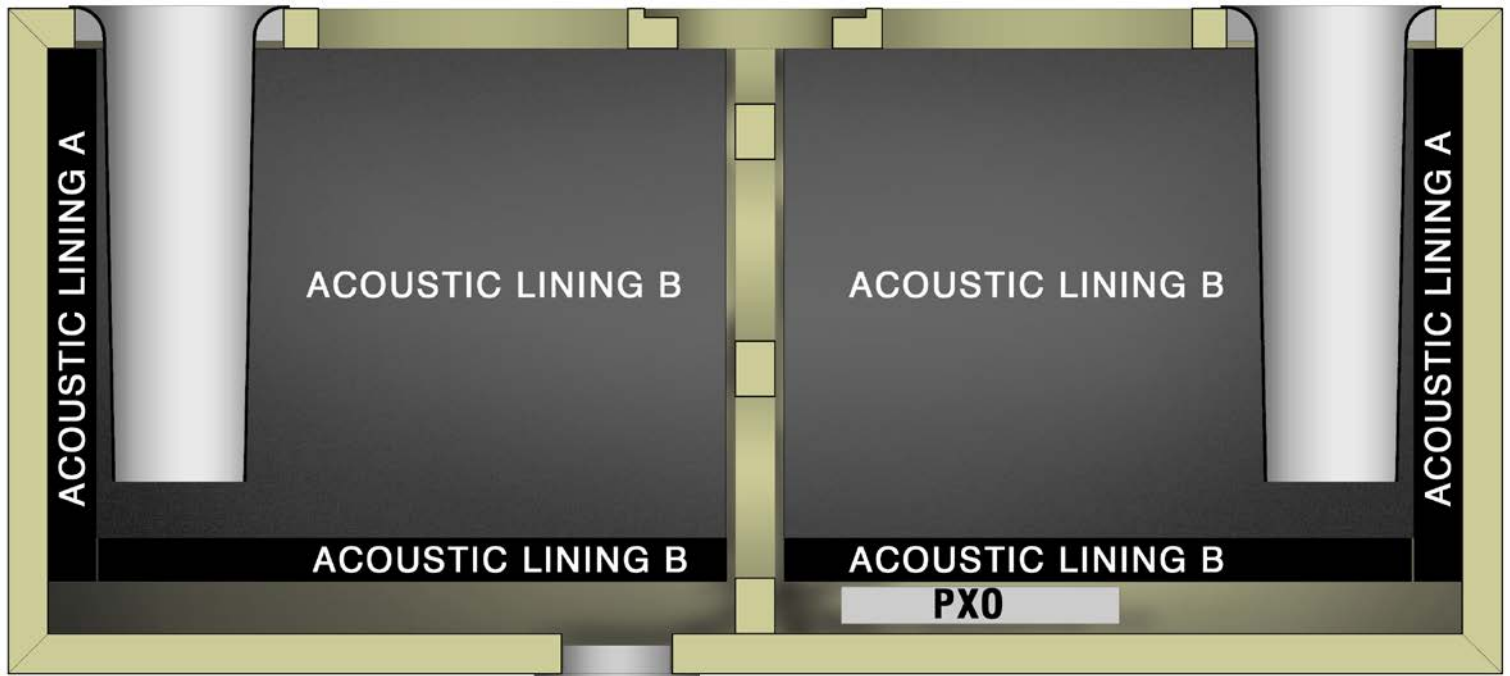


As shown above, driver cutouts provide access to fix the passive crossover board in place. Using the shorter screws, fix the board in place with a Phillips head screw driver. Avoid over tightening. Ensure the board is oriented so the inputs with the shortest cable pair are near the terminal cut out.

## Installing terminals

Find the shortest pair of cables on the crossover board and feed them through the rear terminal cutout. Orient the box with the rear facing upwards. Push spades onto the terminal lugs, ensuring the negative cable with the strips is connected onto the negative terminal. The polarity of the terminal lugs is shown on the back of the terminal with a large + and – as seen on the previous page.

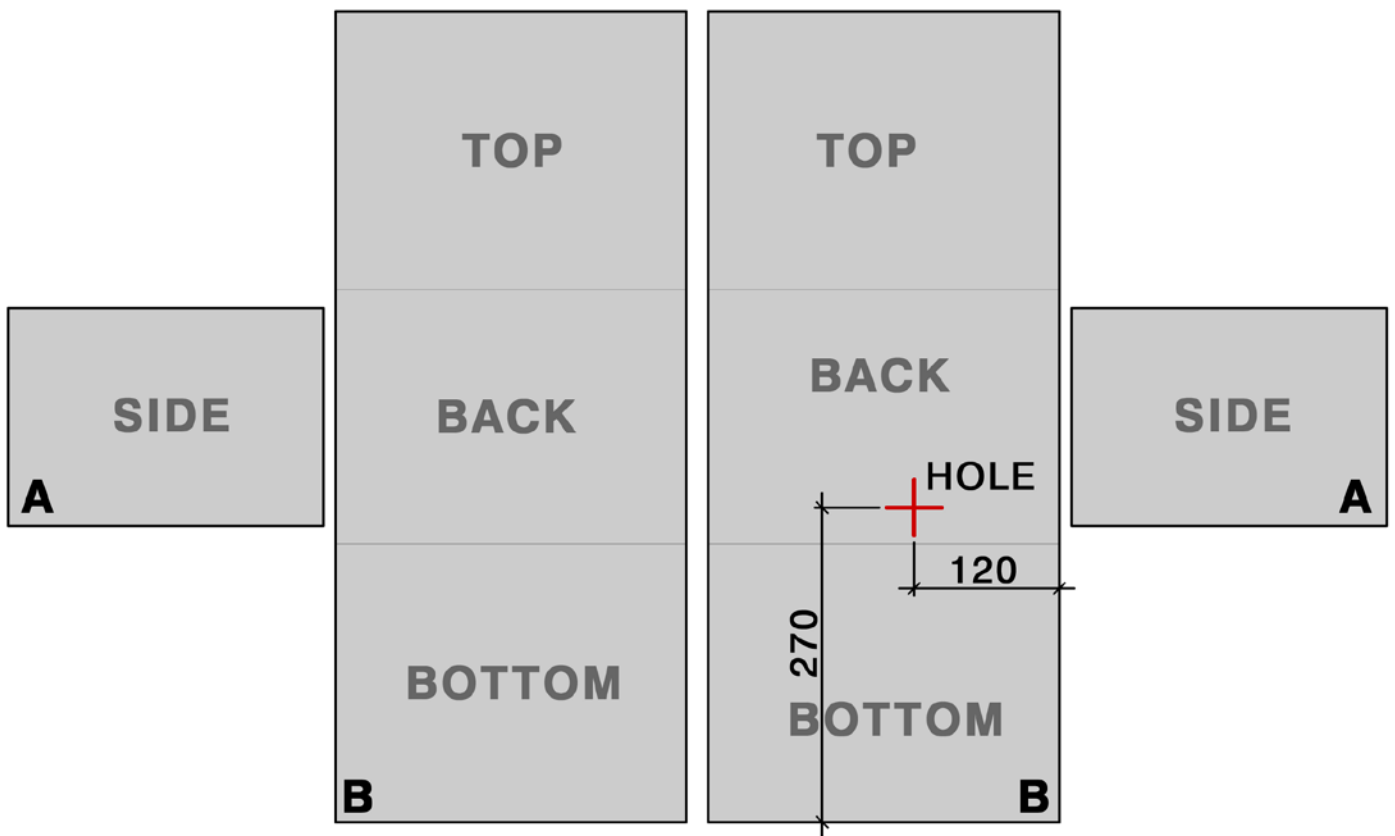




**C6S section diagram**

## Acoustic lining

The acoustic lining provided with the kit covers all internal cabinet walls. Each of the smaller pieces (A) cover the side walls. The larger pieces (B) are folded into a U shape to cover top, bottom and rear walls, when the speaker is horizontally oriented as shown on the cover photo.



The diagram above shows the acoustic lining layout. The wire loom from input terminal to crossover runs beneath the larger pieces (B). Likewise, the cable to the woofer on the opposite side of the brace also runs direct. The other two outputs for tweeter and woofer run through a hole, which is dimensioned above. Cut an X with a sharp blade and pull the wire looms through the hole prior to installing drivers.



To insert the lining, roll it up and insert through one of the woofer cutouts. No adhesive is necessary to keep the lining in place.

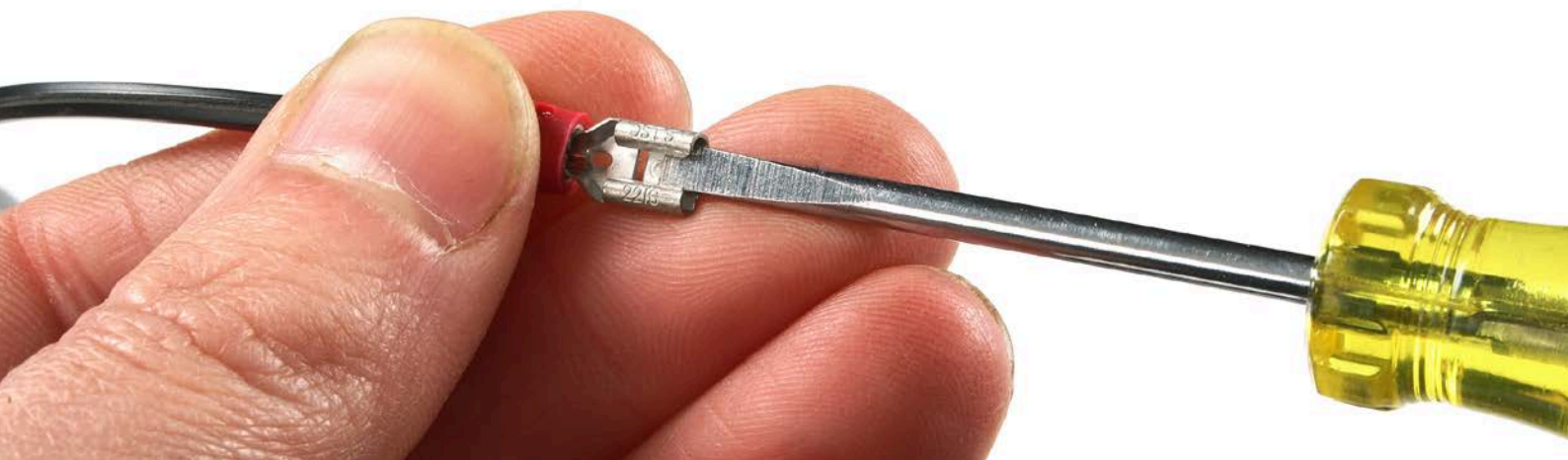
## Installing drivers

We recommend using a Phillips head screwdriver, as some powered drivers are more likely to cause damage if the head slips off the screw head. Impact drivers should be avoided. If using a powered driver, it's best to use one which has a clutch, so that once the screws are adequately tightened, the driver will not over-tighten. Choose the lowest setting on the clutch and then increase as needed for the right amount of force. This avoids stripping the MDF pre drilled holes or damage to the screw heads. If using a screwdriver, your left hand can hold the shaft to prevent the head slipping off and damaging the drivers.

## Connectors

The connectors are designed to prevent mixing up positive and negative terminals. Avoid excessive force, which can damage terminals. Lower the tweeter into its recess, aligning the terminals with the cutout slots. Then secure in place with the provided screws.

**Tip:** The spades on the crossover cables have a very tight fit and damage to the driver terminals is likely if too much force is used. Use a small flat head screwdriver, as shown below, to open out the spade until the spades can be pushed on without excessive force.





## Tweeter

The tweeter must be installed first as the woofer flanges overlap. Find the white wire loom for the tweeter and push the connectors onto the driver tabs.

**Caution: tweeter terminals are fragile – observe instructions on the previous page about how to safely connect the cable without causing damage**

Insert the provided screws into position and tighten with a Phillips head screwdriver as shown below.



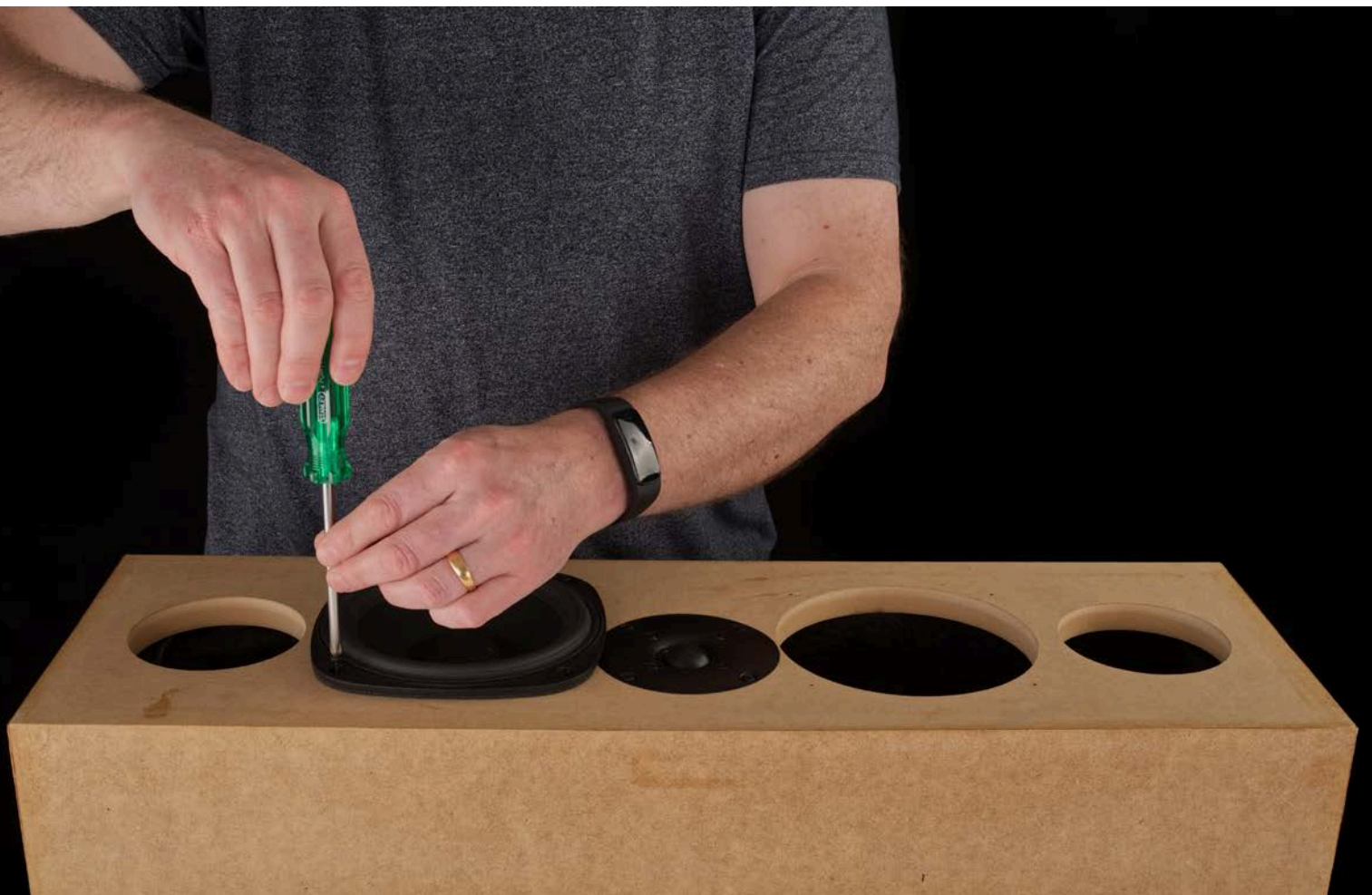


## Woofers

Find the white wire loom for each woofer and push the connectors onto the driver tabs.

**Caution: Observe instructions on the previous page about how to safely connect the cable without causing damage.**

Insert the provided screws into position and tighten with a Phillips head screwdriver as shown below.





Now press both ports into position. No glue is necessary as the cutouts are precisely machined for a tight fit.

## Grille assembly

### Masking

On the backside of the grille, you will notice a cut line inset from the edges. This cut line defines the area where the cloth will be glued to the frame. The area inside this line needs to be masked, so the spray adhesive is applied only to the strip around the edge. This allows you to use spray contact adhesive, which provides flat and even coverage in addition to a fast application. To protect from overspray, cover your work surface.

### Adhesive

Spray contact adhesive is the simplest and quickest to use and it goes on evenly. Be sure to carefully read the instructions on the can as each one is slightly different. Shake the can for at least one minute or longer if specified on the can. Spray contact adhesive onto the small strip (approx 8mm wide) between the cut line and edge. Hold the can at a distance indicated on the can and move fairly quickly, applying two or three passes until you get good coverage.



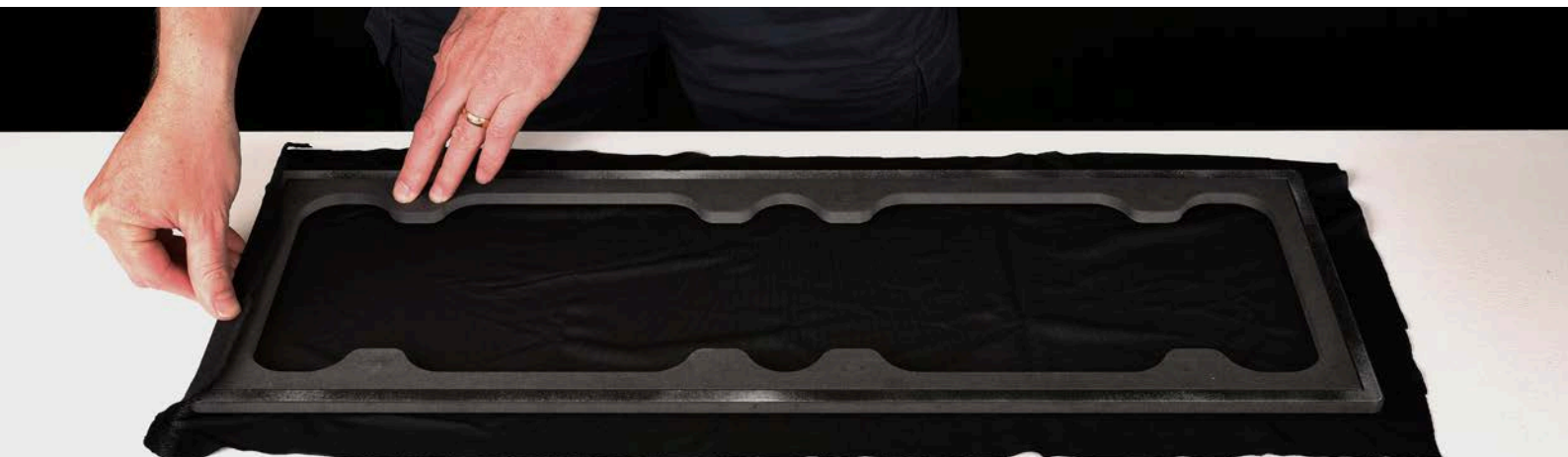


When you've finished spraying, turn the can upside down and spray briefly until you notice the amount of spray reduces. Usually after about one second, the paint stops but the solvent continues. This cleans out the nozzle and avoids blocking next time you want to continue using it. Check the nozzle to ensure that it looks clear. If you see any glue there, wipe with a clean cloth with mineral turpentine to clean.

Glue is only required on the back surface as shown here – no glue is required to the sides or the front.

You can start applying the grille cloth right away but we recommend waiting 2 minutes. Peel off the mask with care. A small flat head screwdriver is helpful here to prevent the frame from lifting up or flipping over as you remove the masking tape. Hold the frame down with the screwdriver in one hand, gently pulling back the tape with the other. Then lay the frame over the grille cloth as shown below.

Now press the cloth onto the glue on the back of the frame. Start with one side as shown below but avoid the corners, which should be pressed on last. It's critical that the corners are done as the final step to avoid wrinkles bunching up.





Press the cloth onto the opposite edge. Above you can see the wrinkles across the grille which indicate sufficient tension has been applied. Again, stop short of the corners.

Now press the grille cloth to the frame on the third side. Then finally, press the cloth to the remaining side of the frame. In this step, all wrinkles that could be seen from the front should have been stretched out.





## Wrinkle free corners

The biggest challenge in assembling a grille is the corners. If not done correctly, these will bunch up. With a little care, you can avoid this problem and get a professional looking grille.

Gather the fabric at the corners with both hands, as shown above. Pull the cloth at a 45 degree angle to each edge, stretching the fabric to eliminate as many wrinkles as possible. You can see in the photo above that there are some potential wrinkles here, which we can remove in the next step.

Keeping the tension on the cloth, transfer the fabric to one hand, so that your other hand is free. Press out any wrinkles with your finger as shown below.

If there are some wrinkles you can't press out this way, the adhesive provides some work time during which you can lift up the cloth and press it down again. When lifting up the cloth from the frame, stretch the cloth more tightly than before. Then press it down again. Avoid lifting any more of the cloth than necessary.

You may have several wrinkles around each corner. Work through each one until you have pressed out all wrinkles.

Now at this point, you should have removed all wrinkles between the edge of the frame and the cut line.





## Trim the cloth

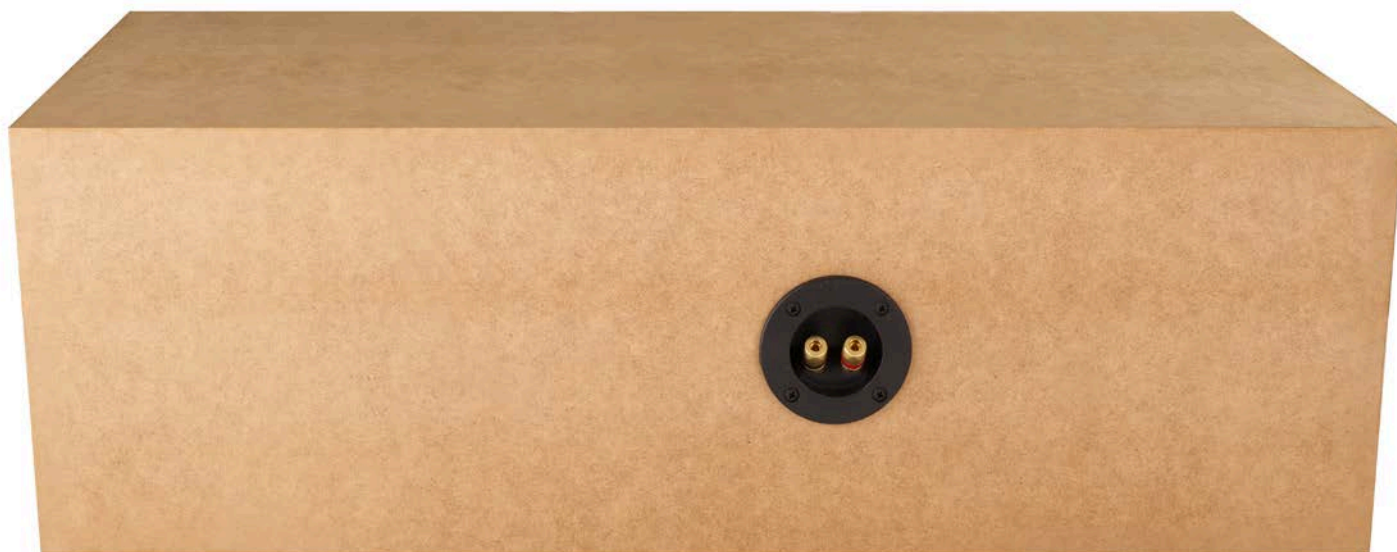
Now you can use your thumbnail to find the cut line. Pressing your nail into the trench, score all the way around. This helps to confirm that you've effectively avoided wrinkles. Then with a sharp blade, slowly and carefully cut away the grille cloth, using the trench as a guide.

### Tips for a better cut:

- Choose a knife with snap off blades like the one below – Stanley knives are usually too blunt for the job
- Start with a new blade – snap off the previously used part of the blade
- Cut with multiple passes – avoid the temptation to try to cut all the way through in one pass
- Cut slowly and carefully, ensuring that the blade stays on track
- Cut with a shallow angle as shown below – this avoids any tearing away at the fabric

This step now completes the build.





## Parts List:

- 2 x 6" Woofers (SB16PFC25-08)
- 1 x 1" Tweeters (SB26ST-C0005)
- 1 x Crossover Network
- 1 x Round input Terminal
- 7 x Panels CNC machined 18mm MDF panels
- 1 x CNC machined 12mm MDF grille frame
- 1 x Grille cloth (320mm W x 780mm L)
- 16 x Self tapping Screws (18mm length)
- 4 x Self tapping Screws (12mm length)
- 2 x 70mm Tuning Ports
- 4 x Pieces of Acoustic Lining (2 x 180mm W x 260mm L, 2 x 290W x 670mm L)

## SPECIFICATIONS:

|                                 |                                       |
|---------------------------------|---------------------------------------|
| <b>Tweeter</b>                  | 1" SB Acoustics SB26ST-C0005          |
| <b>Woofers</b>                  | 6" SB Acoustics woofer SB16PFC25-08   |
| <b>Frequency Response</b>       | 50 Hz - 20 kHz                        |
| <b>Impedance (nominal)</b>      | 16 ohm                                |
| <b>Sensitivity (2.83V)</b>      | 87 dB                                 |
| <b>Power handling (AES)</b>     | 80W                                   |
| <b>Power handling (program)</b> | 160W                                  |
| <b>Recommended amplifier</b>    | 50 - 200W                             |
| <b>Dimensions (mm)</b>          | 220 mm high x 677mm wide x 300mm deep |
| <b>Weight</b>                   | 13 kg                                 |