

# Speaker Egg Build Instructions

## 3D PRINTED PARTS

Print time is roughly 160 hours for all 8 pieces @ 60 mm/s.

### Enclosure Top, Base and Ring Print Settings

- Low warp filament recommended
- 0.2mm layer height
- 50% infill
- 4 shells
- Support is required (I was able to increase angle to 60 degrees from 45)
- Raft required

### Front Speaker Panel

- Low warp filament recommended
- 0.2mm layer height
- 50% infill
- 4 bottom layers
- Support optional
- Raft not required
- Brim optional

## FINISHING 3D PRINTS

1. Remove all support material and rafts.
2. Start by sanding down each outer portion of the printed parts - starting with 120 and slowly progressing up to 320 (or higher if desired).
3. Using a lightly damp cloth, wipe down sanded parts to remove any dust.
4. Apply 1-2 coats of primer.
5. Lightly sand down dry primed parts with 600+ grit sandpaper.
6. Using a lightly damp cloth, wipe down sanded parts to remove any dust.
7. Apply 2-3 coats of paint to each component. I chose a glossy white paint for the top, metallic silver for the ring and speaker panel, and used a brown under coat for the hydrodipped base. The base was then dipped in a burl wood pattern. See my hydrodipping guide [here](#) for instructions on how to apply this type of finish.
8. I clear coated each of the parts — glossy clear coat for the top, speaker panel, and ring and a matte clear coat for the wood base.

## WIRING AND ASSEMBLY

1. Review the pictures and wiring diagram and lay out the components to understand where they go prior to gluing or wiring.
2. Glue crossover components to back panel inside top according to pictures. I used a combination of glue and hot glue
  1. Do not wrap the crossover components to one another until you have the wiring ready to be soldered as to make sure you have a good connection for all points (I made the mistake of wrapping the crossover components together first and it made the wiring later much more difficult due to the rigidity of the inductor and capacitor wires).
3. Get the wiring into place according the wiring diagram and confirm everything is in the right place and you feel confident you understand where each lead will go.
4. Combine all leads correctly and solder together.
5. Install the tweeter and speaker into the speaker panel. I used glue first and screws for the speaker.
6. Install the speaker binding posts to the bases.
7. Use sealant to seal the binding posts to the base – apply both inside and outside.
8. Wire the positive and negative leads to the corresponding locations on both the tweeter and the speaker. Solder the connections.
9. Wire the amp wiring inside the speaker enclosure to the binding posts and solder the connection.
10. Glue the ring to the base. Use a sealant to fill any seams.
11. Glue the speaker panel to the top enclosure, then use the sealant on the inside seams.
12. Glue the assembled top to the base assembly. Pre-apply the sealant where it makes sense to try fill any seams. The sealant I used, applied white and dried clear so I filled all out seams with the sealant then wiped off the excess.
13. Wire amp speakers to binding posts – ensure the negative & positive as well as the left and right are all correctly wired.
14. Plug in amp power, turn on, and enjoy!