



BOX SECTION (from the left end):

Your box may be a different shape, but you'll need to allow for the dimensions listed on the accompanying page.

Ideal inside width of your finished box would be at least 215mm (8 1/2") for 72-note or 175mm (7") for 50-note.

Inside depth (front to back) would be 100mm (4").

This allows about 12mm (1/2") around all sides of the movement.

50 note movements are 150mm (5 7/8") long,
75mm (3") wide (front to back) and 35mm (1 3/8") high.

72 note movements are 190mm (7 1/2") long,
75mm (3") wide (front to back) and 35mm (1 3/8") high

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TITLE

SANKYO 50 & 72 NOTE CRITICAL DIMENSIONS

SIZE

A

CAGE CODE

DWG NO

REV

1.1

SCALE

NTS

STEVE HEINZE

SHEET

END SECTION

In the example drawn, the wood liner pieces that hold the glass are glued to the inside of the box. The exception is the piece on the right end. It is not grooved for the glass, but after the glass is installed, it slides down from the top - capturing the glass. The radiused top edges of the liner pieces transfer vibration into the lid and also create an air cushion when the lid is dropped, so it won't slam.

Dimensions Referenced in the above drawing:

- A. 4-6mm (3/16"-1/4") is the recommended total sounding board thickness (for best resonance). The winding key limits sounding board thickness to a maximum of 10mm (3/8") unless you use a key extender, which adds 15mm (9/16") to the length of the winding key shaft. A good way to do the sounding board is to use 3mm (1/8") solid stock or plywood and add strips of the same on top of the sounding board, leaving a "dado" about 38-45mm (1 1/2"-1 3/4") wide down the middle running from one end of the box to the other (as drawn). The thinner part in the middle seems to increase bass resonance just a little.
- B. 17mm (11/16") minimum - the distance from the tabletop the box will sit on, to the surface the movement will be mounted on. Less than this and the winding key will hold the box up off the table!
- C. 10mm (3/8"+) height of on/off lever dado. The "L" lever is 9.5mm high, and must slide freely in the dado.
- D. 7-10mm (1/4-3/8") - the on-off button and "L" lever are spaced apart by the button shaft, and the spring takes up any extra space, allowing for this range of thickness. This could be the thickness of the front of your box if you were to add liner pieces below and above the lever, leaving a "dado" for your lever in between (not as drawn). If you choose the 1/4" end of the range, you will need to lightly bend the spring to increase tension.
- E. 1/2" is enough to fully capture the "L" lever in the dado, preventing all rotation.
- F. 15 -20mm (9/16"-13/16") - height from top of movement mounting surface to bottom of dado. Stopper lever (or feather) is 22mm (7/8") above the bottom of the movement base plate. Vertical placement of the on-off button for aesthetics will determine where in the range your "L" lever dado is placed.
- G. 7-8mm (5/16") diameter hole for on-off button should be centered vertically on the "L" lever dado and horizontally on the box. By adjusting dimension "F" above, you can place this where it will look best.
- H. 41mm (1 5/8") is recommended (allows 1/4" between movement and glass). Single-strength glass [usually about 2mm (3/32") thick] is recommended to seal out dust and fingers, and help increase bass resonance.

Though these dimensions have been carefully checked, but we cannot guarantee that Sankyo will not change anything (though we think it very unlikely they would do so without informing us first).