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Subject: Re: 3 Pi build

Posted by [Wayne Parham](#) on Sun, 05 Jan 2025 15:53:53 GMT

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I often use 18mm Baltic Birch. When doing so, the main thing to consider is port length. The effects from the minor change of internal displacement are small, so I am not as concerned about that as the port length. The port needs to remain 63.5mm. It can be off by a millimeter or so either way, but no more.

When making the port with 18mm stock, cut three 100mm squares. Plane one of those down to 9mm thickness. Glue all three - two 18mm thick and one 9mm thick - squares onto your baffle, centered where the port hole will be cut. Glue and clamp them in place. And then use a 2-1/2" hole cutter to drill the port hole through the baffle and port blocks. Something like this:

2-1/2 inch hole cutter

That will create a port that's 63mm diameter and 63mm long.

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