



Flow/1 Stands Assembly Guide

Table of Contents

Flow/1 Speaker Stands Assembly Guide	1
Bases	2
Required Hardware	3
Printing or Buying Stand Parts	6
Inspect the parts	6
Make The Wooden Base	7
Assemble the Wooden Base	9
Preparing the Swivel	10
Cradle to Wooden Base Assembly	12
Small Printed Stand Assembly Steps	15
Install a Flow/1 Speaker	17
Large Stand Assembly	21
Final Thoughts	22
Public Guide and Subscriber Resources	22
Disclaimer	22
Copyright and Design Rights Notice	22

Figures

Figure 1 Printed Stand Parts	1
Figure 2 Large Printed Base	2
Figure 3 Small Printed Base	2
Figure 4 Large Wooden Base (Shown in Oak With Adapter and Feet)	2
Figure 5 Small Wooden Base (Shown in Oak With Adapter and Feet)	3
Figure 6 Required Equipment and Hardware	3
Figure 7 Large Stand Heights	5
Figure 8 Small Stand Heights	6
Figure 9 Small Wooden Base Drawing	8
Figure 10 Wooden Base Assembly Diagram	9
Figure 11 Swivel Horizontal Tilt Grease Surfaces	10
Figure 12 Top Segment Detent Ring Grease Area	11
Figure 13 Swivel Tube Grease Area	11
Figure 14 Cradle to Wooden Base Assembly Diagram	13
Figure 15 Reference Small Stand with Wooden Base (shown with knob in place)	14
Figure 16 Printed Stands Assembly Diagram	16
Figure 17 Composite Views of Assembled Speaker on Small Stand	20
Figure 18 Large Stand Wiring Views	21

Tables

Table 1 Tools and Hardware Required Hardware for a Pair of Small Wooden-Base Stands	_	4
Table 2 Stands Printed Parts List	_____	4

Flow/1 Speaker Stands Assembly Guide

You've made a pair of Flow/1 speakers. Now you want more options for positioning them in a room or on a surface, such as a desk or table. Several options are available to accomplish this, and this manual will take you through the steps to make a pair of small stands with wooden bases.

The sequence for assembling the stands varies depending upon how tall you want them to be and whether you choose to print the bases or make them out of wood; options for both are presented.

There are two sizes of wooden bases: small, for desktop or bookshelf use, and large for floor-standing use—when one or more 'middle' segments are used. A 'wooden stand adapter' is used to attach the stand to either of the wooden bases. There are two sizes of middle segments: 20 cm and 25 cm, which extend the height of the stand. The 20 cm segment accommodates smaller FDM printers and provides more flexibility in overall stand height.

For printed bases, the only assembly needed is to attach the cradle to the swivel and snap the parts together. Wooden bases will have to be constructed by the Maker, and then attached to the stand using the base to stand adapter.

Figure 1 shows all the printable stand parts for reference. Figure 2 through Figure 5 show the various bases.

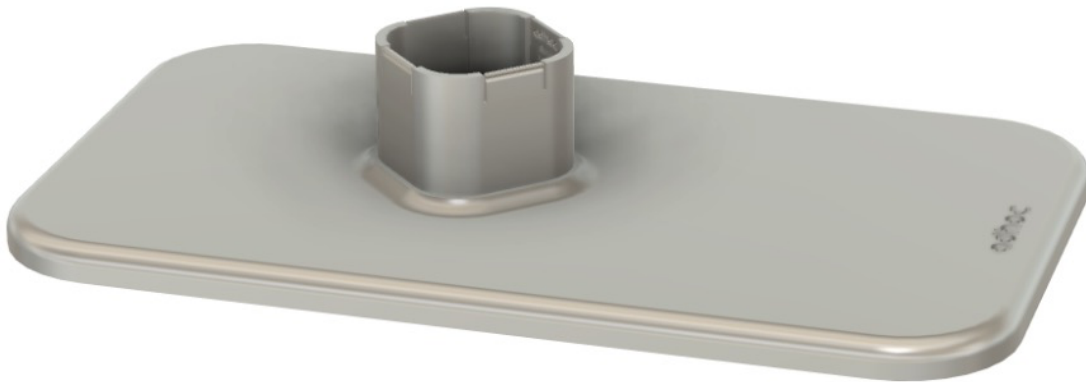
Figure 1 Printed Stand Parts



Bases

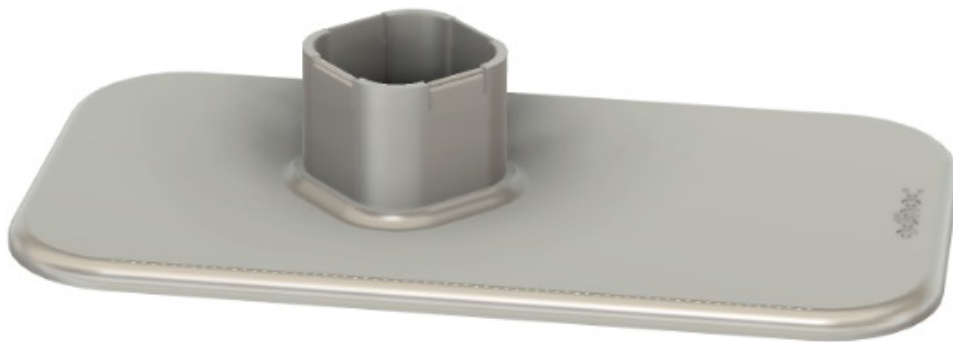
Here are the base options for the stands. Printed stands are not used in this build and are shown for reference only.

Figure 2 Large Printed Base



Length front to back 400 mm, Width 240 mm

Figure 3 Small Printed Base



Length front to back 370 mm, Width 200 mm

Figure 4 Large Wooden Base (Shown in Oak With Adapter and Feet)



Length (suggested) front to back 406 mm (16 in), Width 241 mm (9½ in), x 10-20 mm (¾ in)

Figure 5 Small Wooden Base (Shown in Oak With Adapter and Feet)



Length (suggested) front to back 368 mm (14½ in), Width 203 mm (8 in), 19-20 mm (¾ in)

Required Hardware

Figure 6 and Table 1 list the parts needed to make one pair of small stands with wooden bases.

Figure 6 Required Equipment and Hardware



Table 1 Tools and Hardware Required Hardware for a Pair of Small Wooden-Base Stands

Item	Description	Used For	Notes
Tool	PH2 and PH3 Phillips screwdrivers	Swivel Bolt and base adapter	PH3 best for swivel bolt but PH2 can be used.
Tool	13 mm socket and wrench	Swivel bolt	
Tool	Vaseline	Greasing the swivel	
Hardware	Nut (2) 	Swivel	M8 Flange Nut, McMaster-CARR Part #92461A400
Hardware	Bolt (2) 	Swivel	60 mm M8 Bolt, McMaster-CARR Part #95836a276
Hardware	Screw (8) 	Wooden Stand Adapter	25 mm M4 screw, McMaster-CARR Part# 90380A382
Hardware	Foot (12) 	Wooden bases	M6, 1/2" Thread Length, 1" OD, 70A Threaded stud bumper, McMaster-CARR Part#9541K84

Table 2 lists the 3D files you'll need to print in order to make a pair of small stands with wooden bases. Print the files you need for the number and type of stands you need. The large base provides more stability for taller stands having three or more middle segments. Print Wooden Base Adapters only if you are making your own base from wood or other material.

Table 2 Stands Printed Parts List

Filename (.STL/.STEP)	Quantity	Description
Cradle	2	Holds the speaker
Knob	2	Attaches Speaker to Cradle
Swivel	2	Connects Cradle to Stand
Bolt Cover	4	Covers the bolt ends
Top Segment	2	Attaches Swivel to Stand
Wooden Base Adapter	2	Adapter for Large or Small Wooden Bases

Note: This assembly guide describes making a pair of small stands with wooden bases. The small stand is designed to be made without the need for middle segments, so middle segments are not included in the build list. This section is included for reference only, in case you wish to print middle segments to add height to your speaker stand.

Each middle segment adds 20 or 25 cm to the length of the stand. A stand with three 25 cm middle segments will position the HF Driver axis at 1.09 meters (43 in) above the floor in the fully horizontal position, and 1.23 meters (48 3/8 in) in the vertical position. The Center of Mass (COM) is indicated by the "⊕" symbol, as shown in Figure 7.

A small base with no middle segments will place the HF driver center axis at 34 cm (13½ in) above the surface when oriented in the fully horizontal position, and 48 cm (~19 in) when in the vertical position, as shown in Figure 8. Note the COM positions.

Figure 7 Large Stand Heights

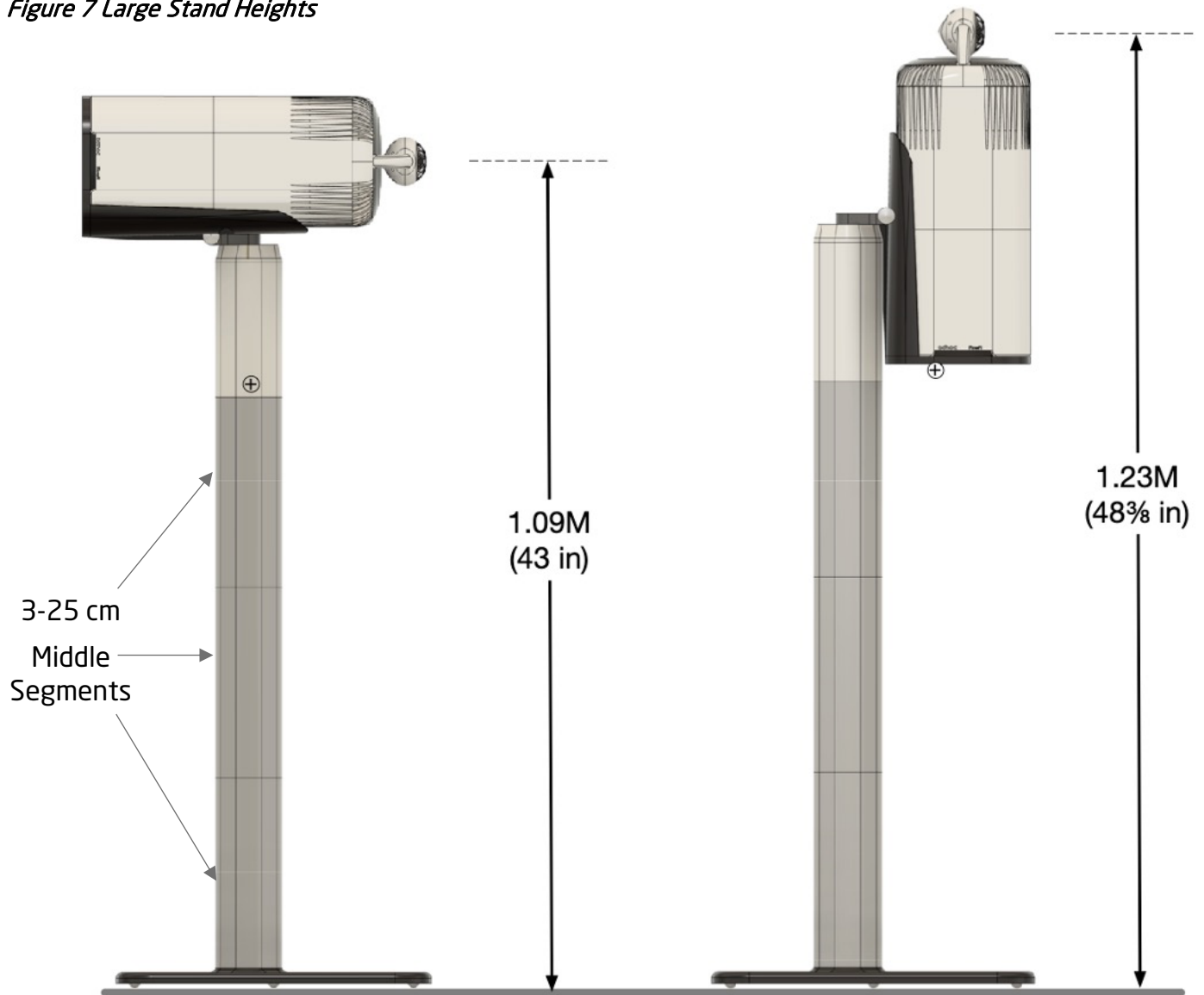
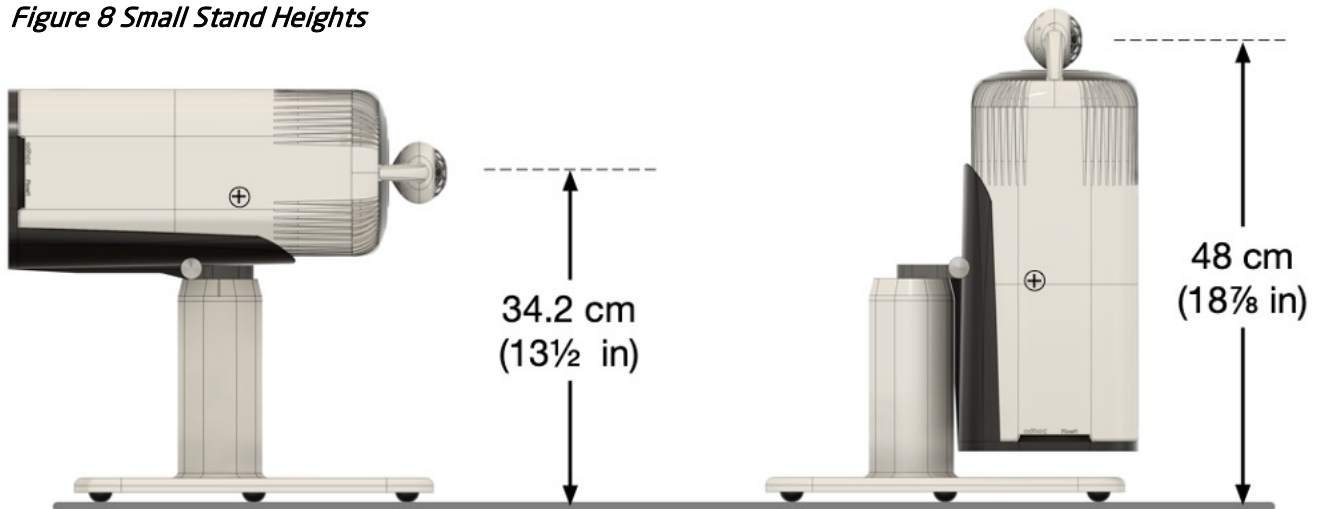


Figure 8 Small Stand Heights



Printing or Buying Stand Parts

Please review the sections in the Flow/1 Maker's Guide about Printing parts as they apply to the stand parts as well.

Some of the pieces are large and may exceed your printer's build volume. For example, the larger middle segments are 250 mm long; the large and small printed base lengths are 400 and 370 mm respectively. That is why the wooden base options are available; they are inexpensive and easy to construct, needing only a base adapter for attaching to the stand.

Inspect the parts

Confirm that you have printed or acquired every part needed to assemble your stands. Inspect your printed pieces to ensure the fit and finish meet your expectations. Light sanding, filling, or edge cleanup may be helpful. If you plan to paint your parts, test-fit them first without gluing them before painting.

If you are printing your base, then the only tools you will need are a screwdriver and socket wrench to attach the swivel bolt. No other tools will be needed; you will simply snap the parts or, optionally, bond them together.

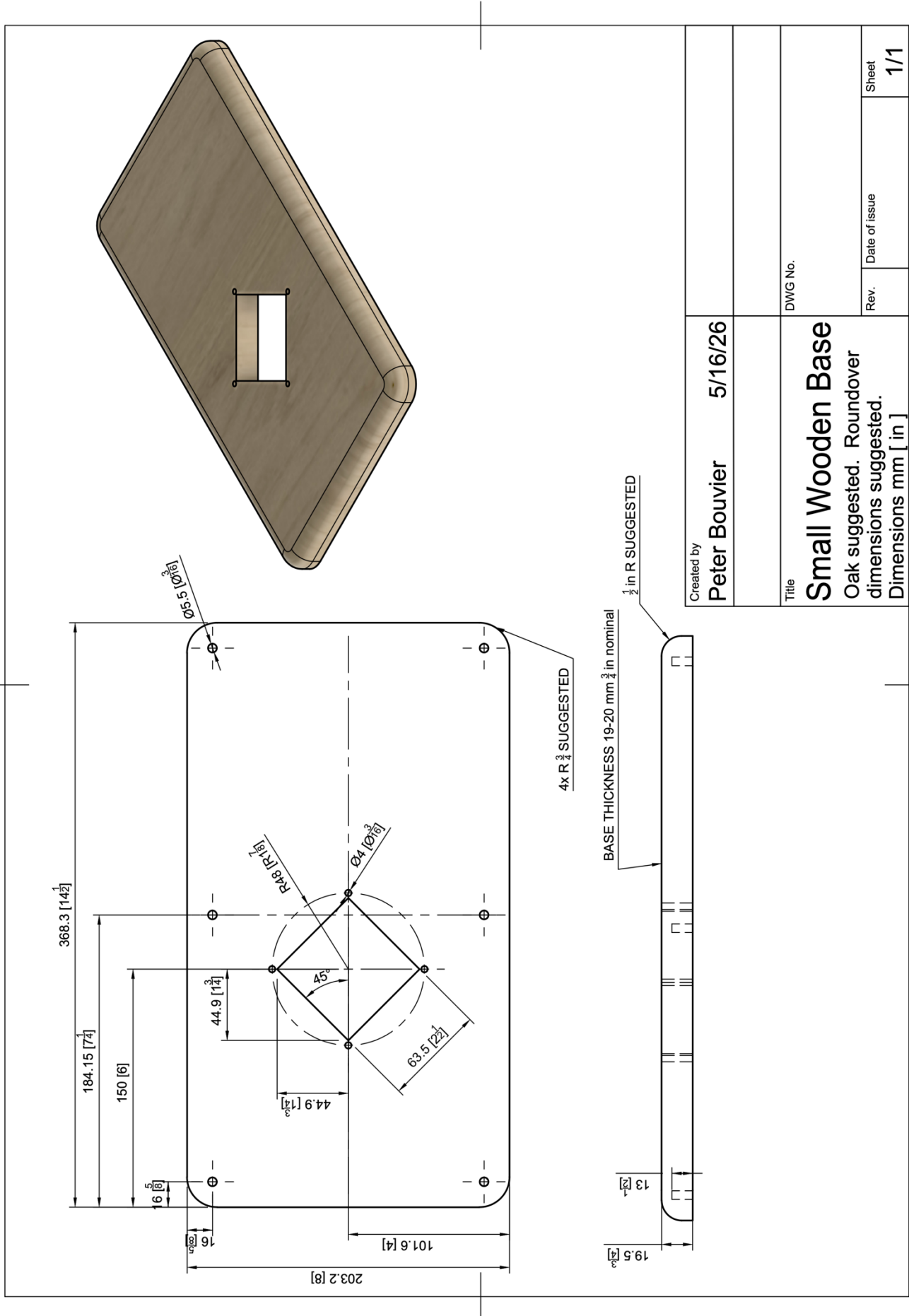
If you are making stands with wooden bases, you will need appropriate tools for cutting the base outline and the cutout for the adapter, and a drill for drilling the holes for the screws.

Make The Wooden Base

In addition to the hardware and printed parts you will need to make a wooden base according to the design drawing "Small Wooden Base.pdf" available for download and printing from the [adhoc resources page](#). Figure 9 shows that drawing for reference.

Making a base out of wood can save significant cost over a base that is 3D printed. Therefore, an adapter is provided to attach a wooden, or other material, base to middle or top segments, to create a stand without the need for printing a base.

Figure 9 Small Wooden Base Drawing

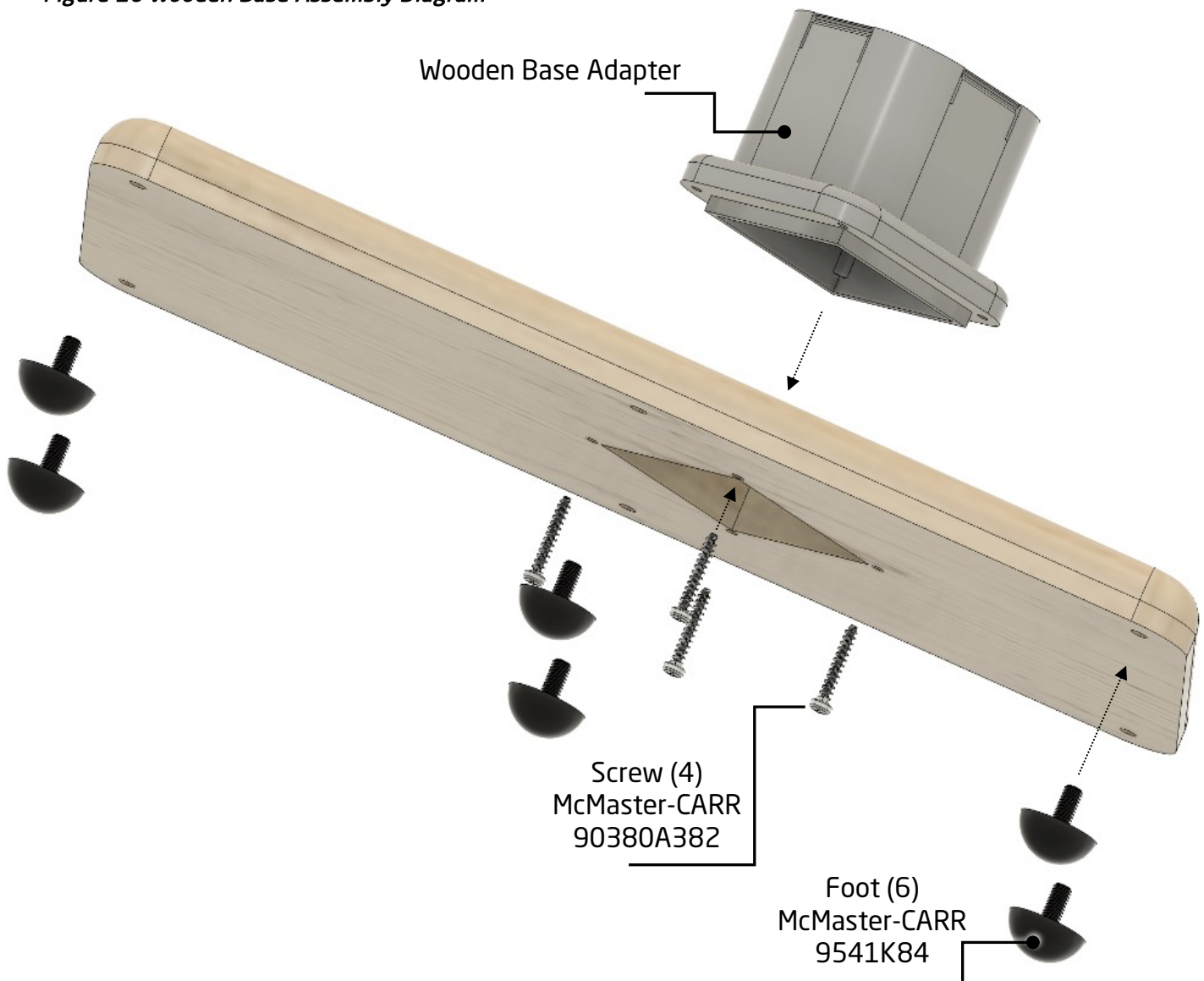


Assemble the Wooden Base

After you have finished the base (paint, stain, etc.) and the adapter (paint, etc.), the wooden base parts can be assembled in any order. I recommend attaching the adapter to the base first, then attaching the feet. The drawing specifies holes sized for the specified feet to be easily screwed into the holes. Individual feet can be adjusted later to ensure the stand is level and balanced. If you use a wood thickness different from the diagram, you may have to countersink the screw holes to ensure the screws have sufficient thread engagement in the adapter.

Figure 10 is a quick assembly diagram for attaching a base adapter to a small wooden base:

Figure 10 Wooden Base Assembly Diagram



Now that your wooden base is assembled, we can prepare the Cradle, Swivel and Top segment for attachment to the base.

Preparing the Swivel

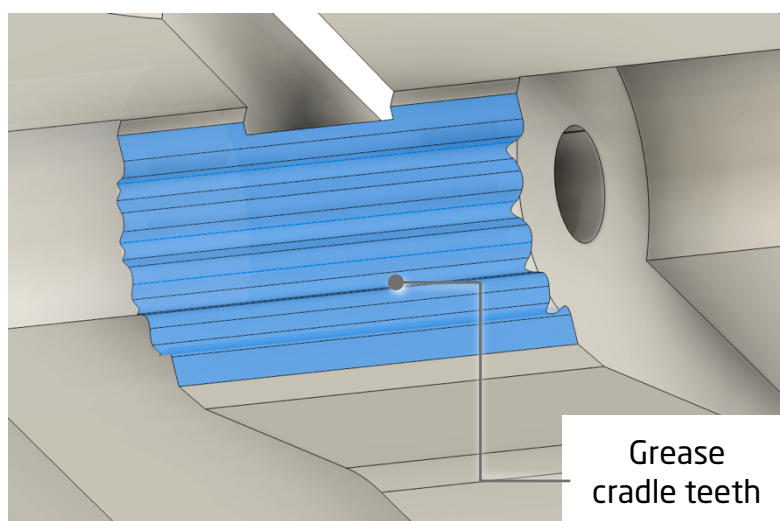
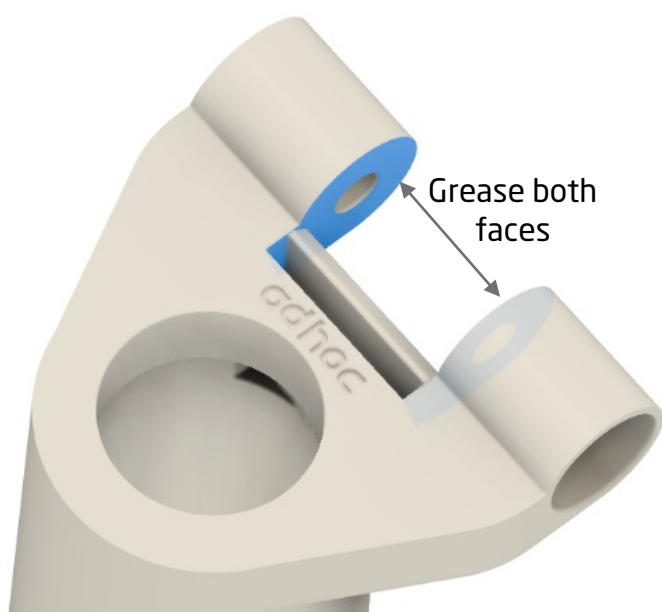
Prior to assembling the stand, you will need to grease the swivel areas where parts will bear against each other to ensure smooth, lasting operation.

There are two detented swivel joints in the stands, one to tilt the speaker vertically and horizontally and one to spin the speaker horizontally. The areas needing grease are highlighted in blue as shown in Figure 11 through Figure 13.

Step 1: Grease the teeth on the cradle and both of the inside swivel tilt faces as shown in Figure 11.

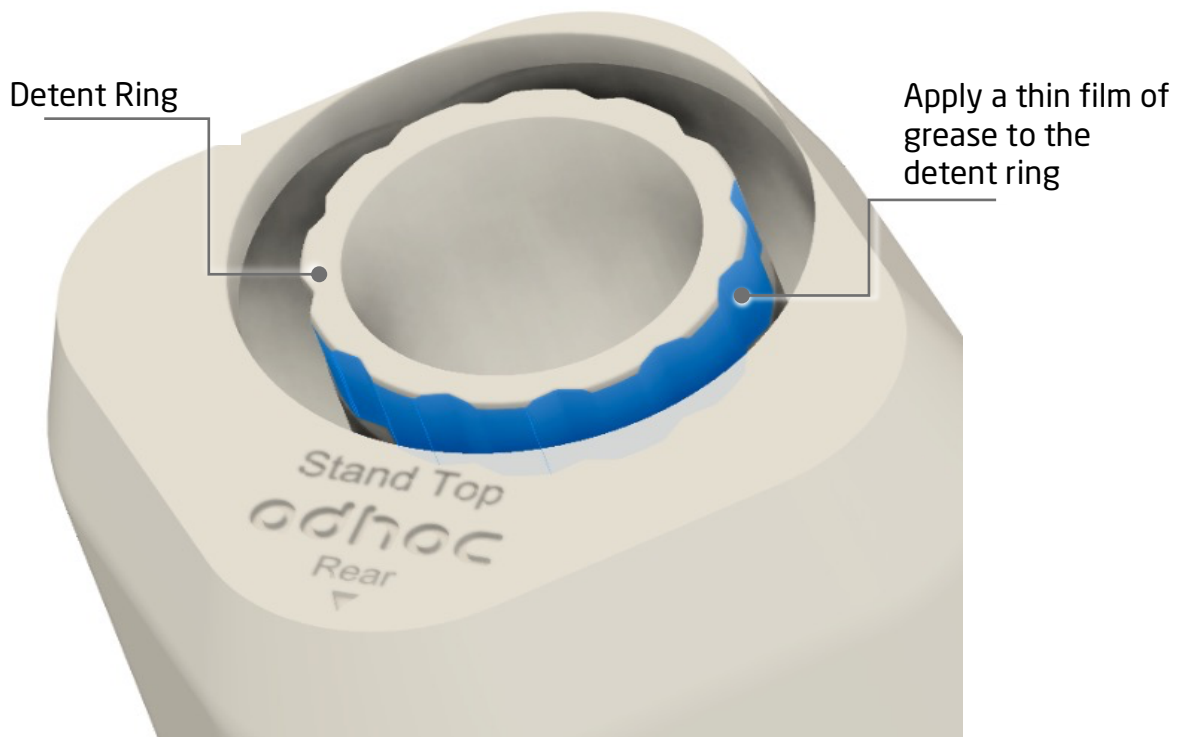
This is the joint for the 0- to 90-degree horizontal-vertical cradle tilt angle.

Figure 11 Swivel Horizontal Tilt Grease Surfaces



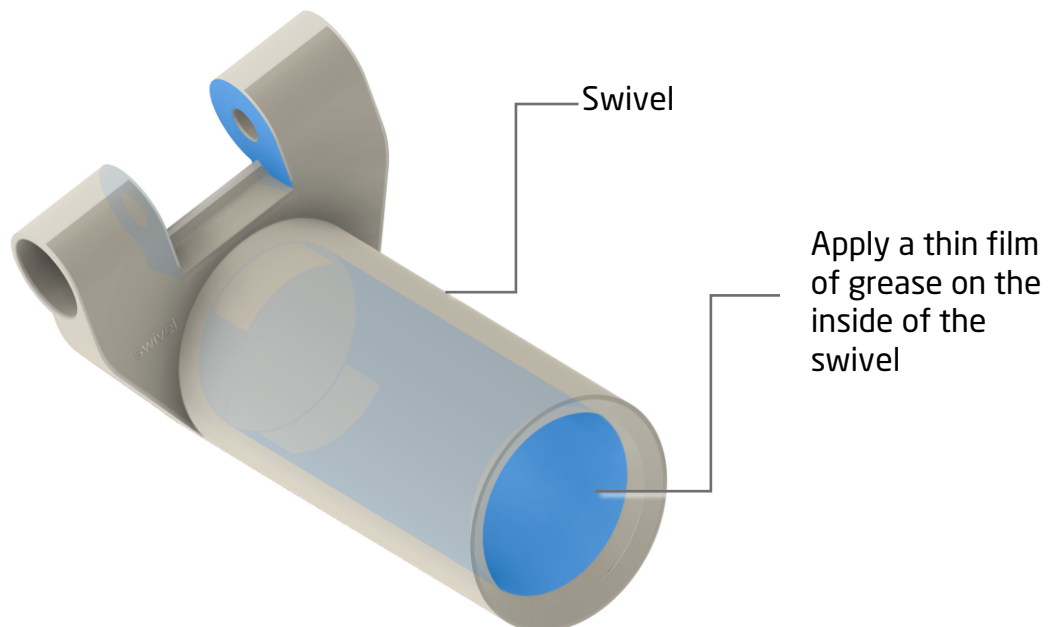
Step 2: Apply grease to the horizontal rotation gear faces as shown in Figure 12.
This is the joint for the 360-degree horizontal swivel.

Figure 12 Top Segment Detent Ring Grease Area



Step 3: Apply a thin film of grease to the inside of the swivel tube as it bears on a coaxial tube in the stand top as shown in Figure 13.

Figure 13 Swivel Tube Grease Area



The friction-bearing parts have been properly greased and are ready for assembly.

Cradle to Wooden Base Assembly

Most of the stand parts snap together without the need for tools. Refer to Figure 14 as you follow these steps to assemble one small stand with a wooden base.

Step 1: Align the cradle with the swivel body.

Position the cradle so its pivot holes line up with the pivot holes in the swivel body.

Step 2: Insert the cradle pivot bolt.

Slide the bolt through one side of the cradle, through the swivel body, until it stops.

Step 3: Install the nut loosely.

Thread the nut onto the bolt, but do not fully tighten it yet. The cradle must still be able to tilt.

Step 4: Insert the swivel into the stand top.

Lower the swivel body into the stand top so the swivel fits over the stand-top detent ring and seats on the lubricated bearing surfaces. Push until it clicks into place.

Step 5: Attach the stand-top / swivel / cradle assembly to the wooden stand adapter.

Orient the stand top so that "REAR" points to the rear of the base (the shorter side where the wires exit the base). Insert the stand-top assembly onto the wooden base adapter and push down until it clicks into place. Optionally, if you do not plan to disassemble the stand (for example, converting to a tall stand by adding middle segments), apply a small amount of contact adhesive to the corners to secure the top segment onto the base.

Step 6: Tighten the pivot nut.

Tighten the nut only until the cradle holds its indexed tilt positions while still being adjustable by hand. Do not overtighten; the cradle should not bind.

Step 7: Install the bolt caps.

Press the bolt caps into place on both sides of the swivel.

Figure 14 Cradle to Wooden Base Assembly Diagram

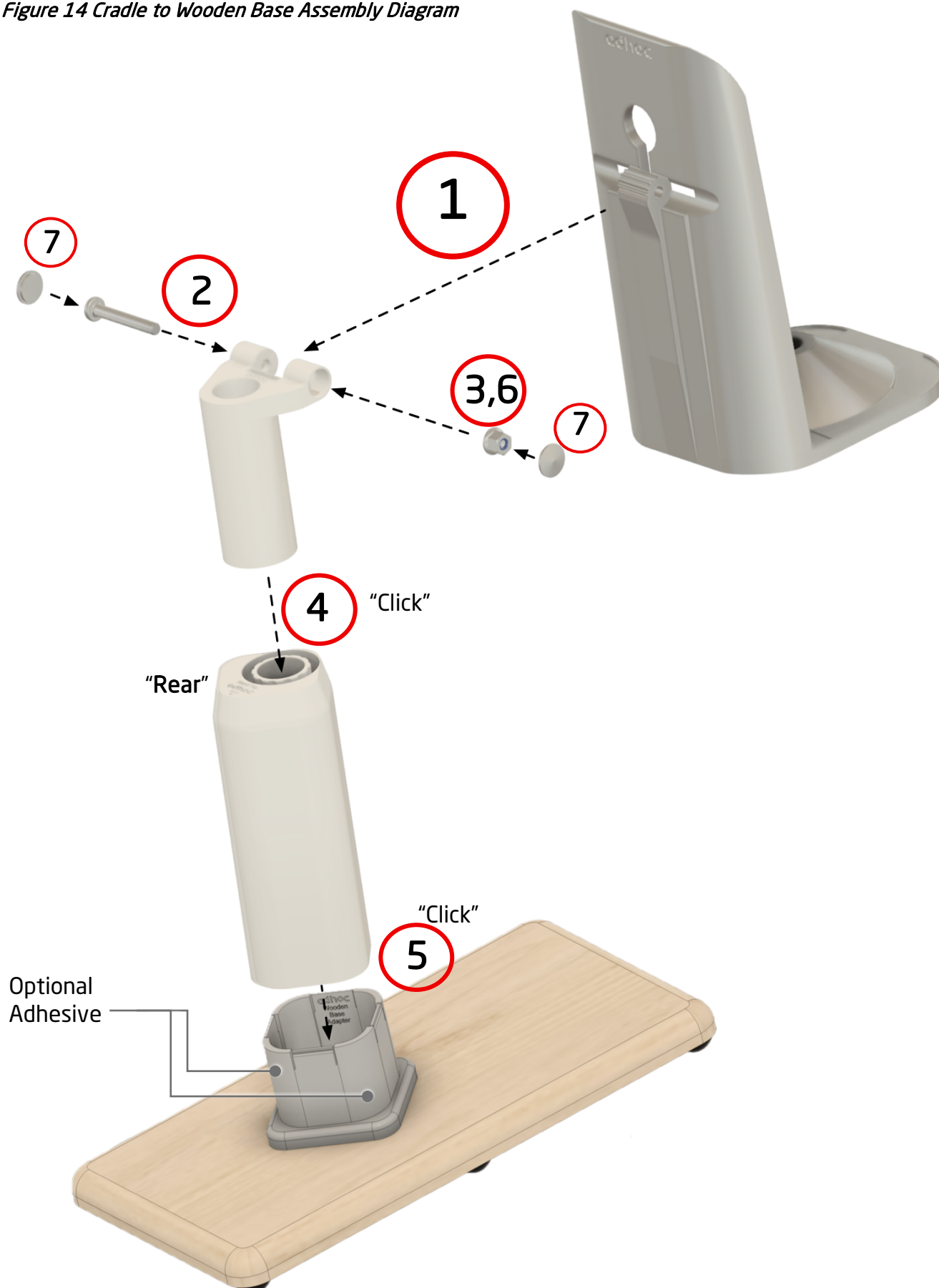


Figure 15 is a rendering of a completed small stand made with a wooden base. In this image the base is constructed according to the reference drawing, with optional beveled top edges and rounded corners.

Figure 15 Reference Small Stand with Wooden Base (shown with knob in place)



For completeness, here are the steps for assembling a small stand with a printed base. Refer to Figure 16 while following these steps.

Small Printed Stand Assembly Steps

Step 1: Screw the feet to the base.

Install the six feet on the underside of the base. The holes are sized for screwing the M6-1 mm threaded lugs.

Step 2: Align the cradle with the swivel body.

Position the cradle so its pivot holes line up with the pivot holes in the swivel body.

Step 3: Insert the cradle pivot bolt.

Slide the bolt through one side of the cradle, through the swivel body, until it stops.

Step 4: Install the nut loosely.

Thread the nut onto the bolt, but do not fully tighten it yet. The cradle must still be able to tilt.

Step 5: Insert the swivel into the stand top.

Lower the swivel body into the stand top so the swivel fits over the stand-top detent ring and seats on the lubricated bearing surfaces. Push until it clicks into place.

Step 6: Attach the stand-top / swivel / cradle assembly to the base.

Orient the stand top so that "REAR>" points to the rear of the base (the shorter side where the wires exit the base). Snap the stand-top assembly onto the base and push down until it clicks into place. Optionally, if you do not plan to disassemble the stand (for example, converting to a tall stand by adding middle segments), apply a small amount of contact adhesive to the corners to secure the top segment onto the base.

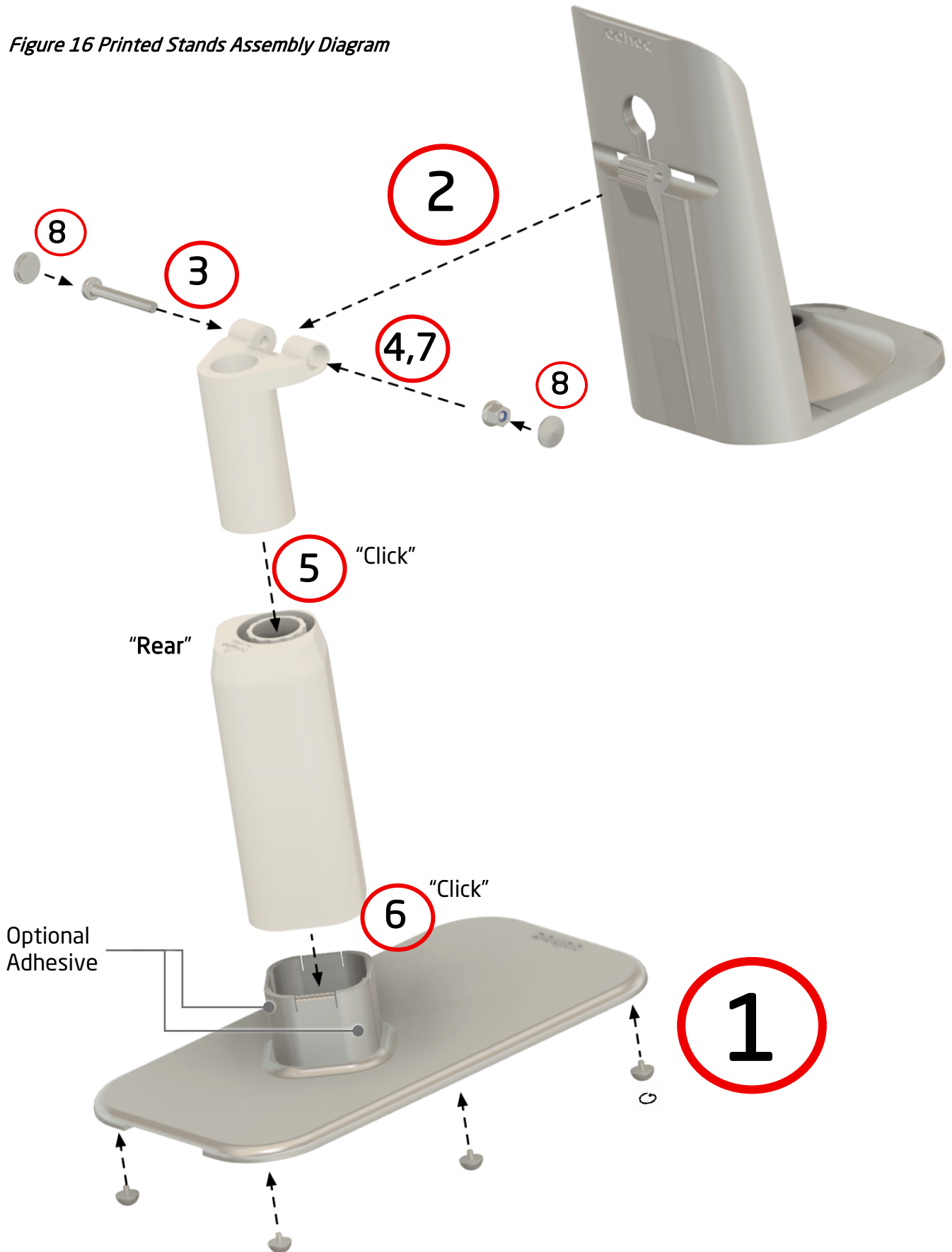
Step 7: Tighten the pivot nut.

Tighten the nut only until the cradle holds its indexed tilt positions while still being adjustable by hand. Do not overtighten; the cradle should not bind.

Step 8: Install the bolt caps.

Press the bolt caps into place on both sides of the swivel.

Figure 16 Printed Stands Assembly Diagram



Repeat the steps above to assemble a second stand.

Install a Flow/1 Speaker

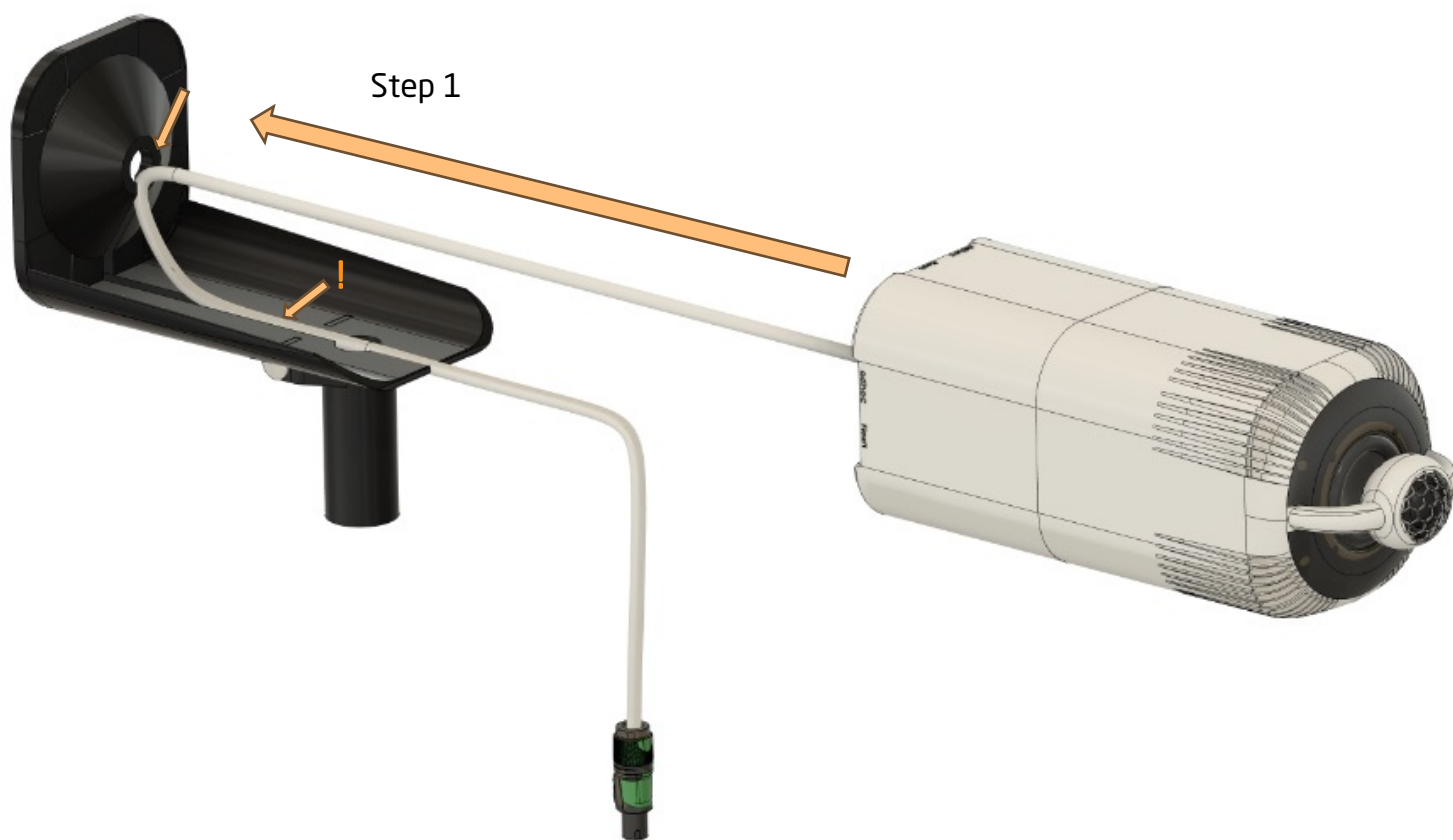
Your speaker stand assembly is complete. It is time to insert a Flow/1 speaker into the stand.

The stand is designed to hide the wire to provide a finished look. The holes are sized for a speakON connector, but any smaller connector will work. The feet are sized to accommodate a wire up to one-half inch in diameter.

Follow these steps to attach a Flow/1 to a small stand.

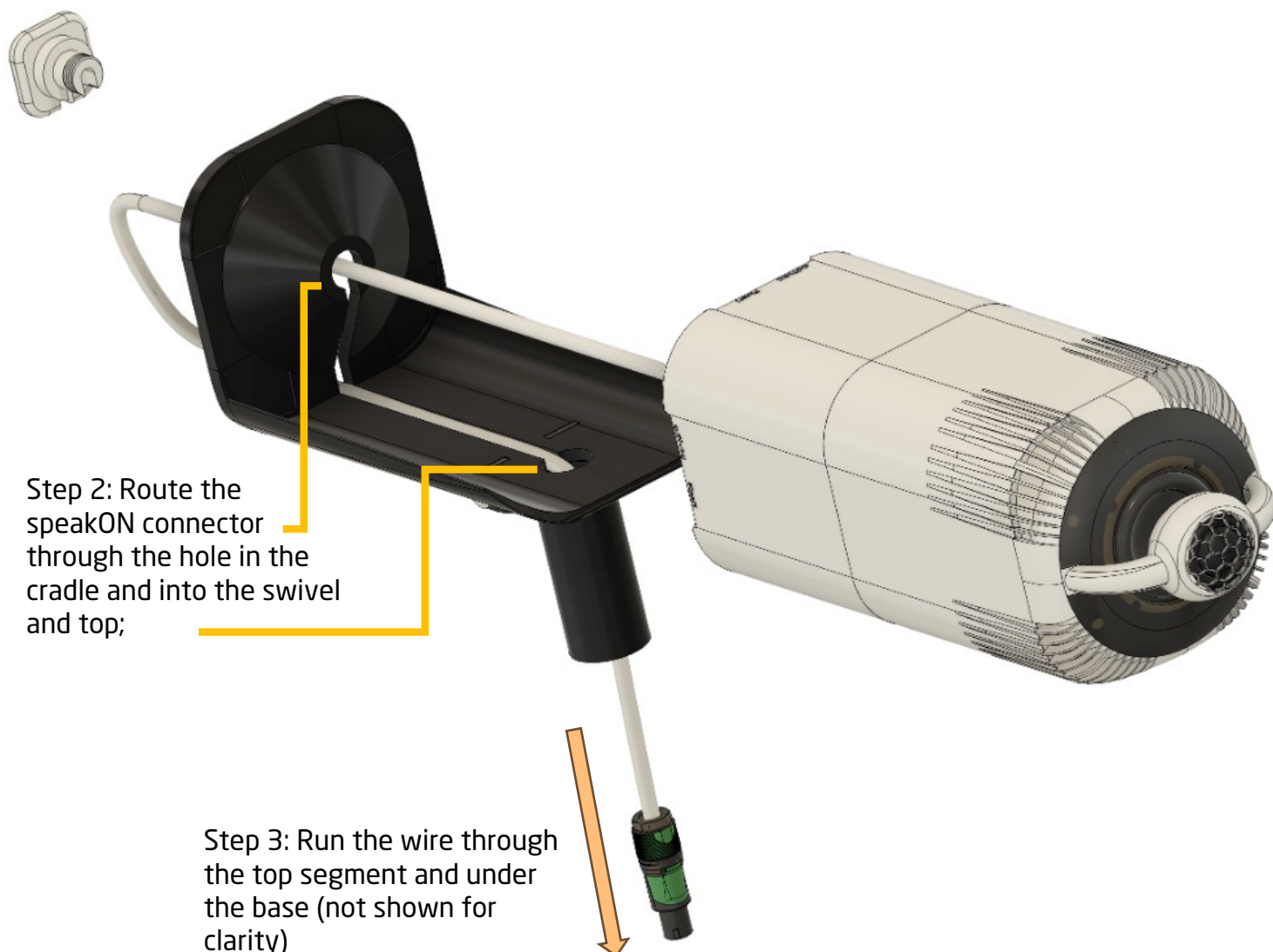
The Flow/1 stand is designed to dress the wire within its body. A unique knob containing a slot for the wire securely attaches the speaker to the cradle by slipping it over the wire and turning the knob to bring the speaker tight against the cradle. Note: the stand top has been removed for visual clarity.

Step 1: Align the wire to route through the hole and slot on the back of the cradle and slide the wire through the hole and slot, ensuring the wire sits in the wire guide at the base of the cradle.

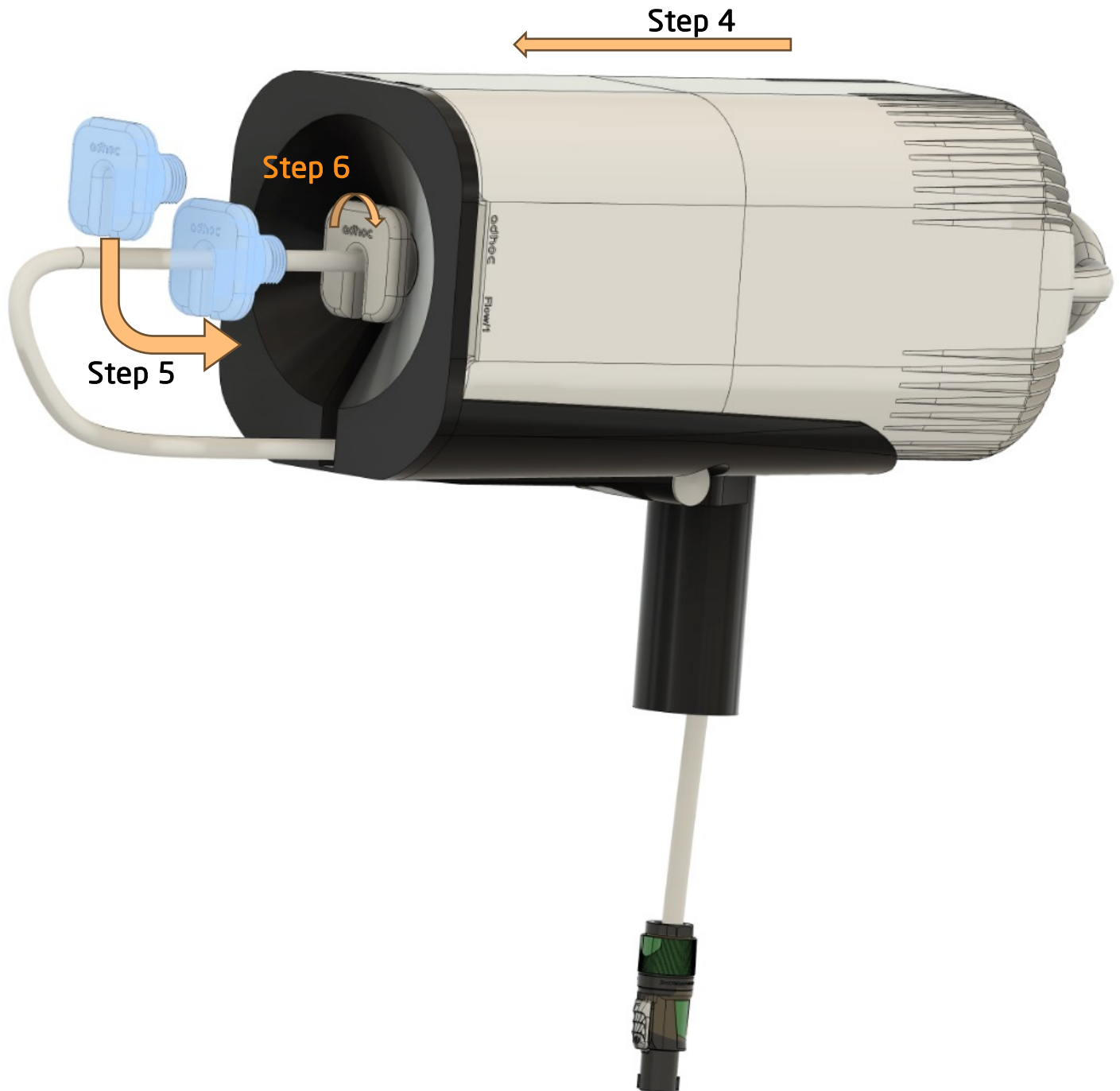


Step 2: Route the speakON connector down through the hole in the top of the swivel.

Step 3: Run the wire beneath the base (not shown) and out of the way.



- Step 4: Push the speaker up against the back of the cradle until it stops, ensuring the wire emerges straight out of the center of the hole in the cradle.
- Step 5: Slide the knob onto the wire through the slot in the knob, and insert the knob into the back of the cradle.
- Step 6: Screw the knob clockwise to attach the speaker to the cradle. Continue tightening the knob until it stops; the slot should be oriented downward and aligned with the slot in the cradle.



- Step 7: Orient the speaker horizontally or vertically depending upon your intended use.
- Step 8: Tighten the swivel nut and attach the bolt caps.

Adjust the swivel bolt tightness after the speaker is attached. The amount of tightness will vary depending upon the material used to print the speakers. Speakers printed in resin will be significantly heavier than PETG or ABS, so the swivel bolt will need to be tighter to hold the speaker in position. Figure 17 shows the completed assembly from various perspectives (shown with printed bases). Dress the wire to fit snugly against the back of the enclosure, fitting into the slot in the rear of the cradle.

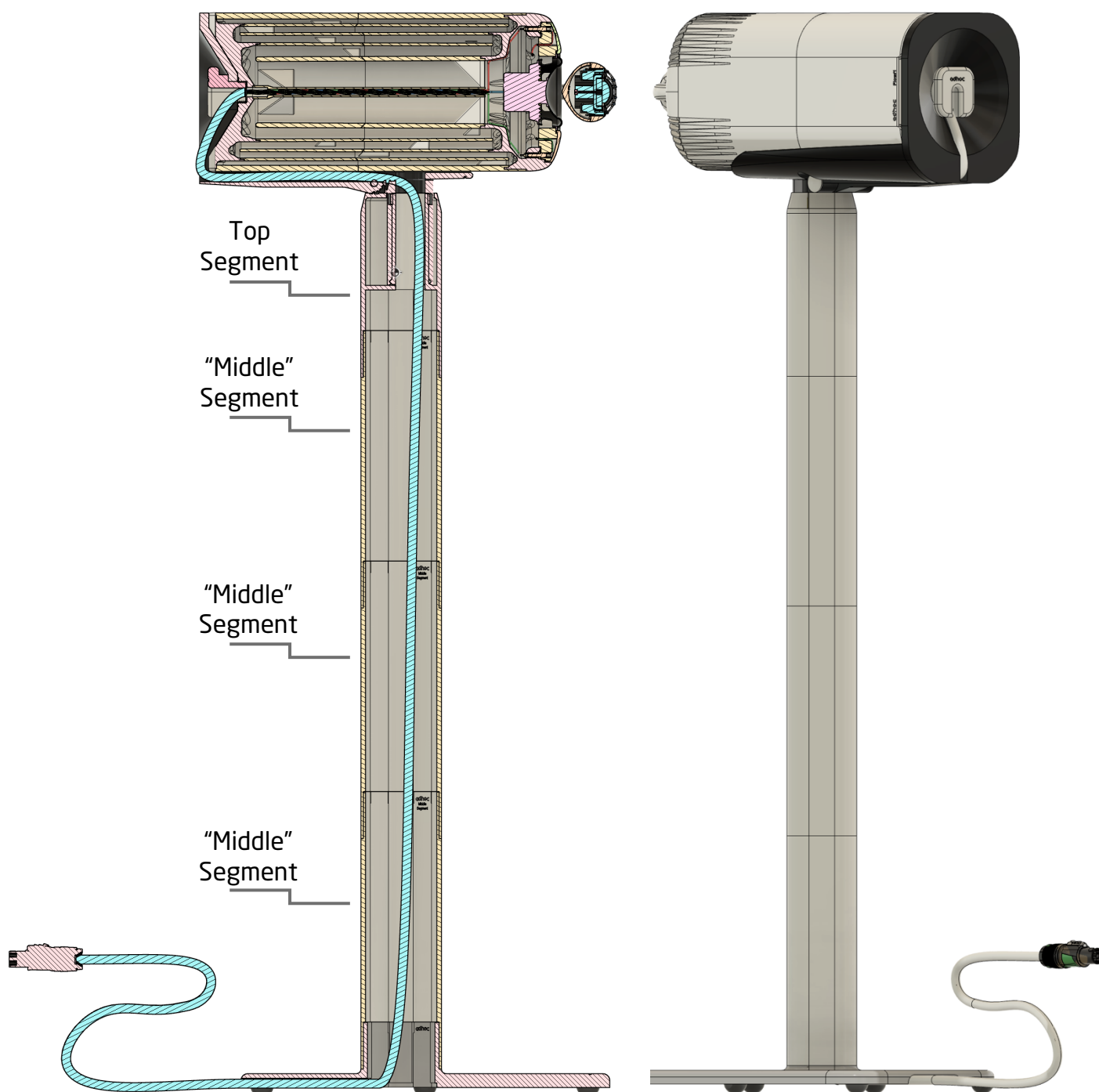
Figure 17 Composite Views of Assembled Speaker on Small Stand



Large Stand Assembly

Large stand assembly follows the same sequence as above, but with middle segments added between the top segment and the base to increase the height of the speaker. Figure 18 shows section and angle views of large stand wiring. The “Middle” Segment can be printed in two sizes to accommodate smaller printers: 200 mm and 250 mm. Middle segments are snapped together to construct taller and taller stands. The Flow/1 is designed to be built with a two-meter pigtail wire, which leaves about a half-meter of wire out of the base of the speaker.

Figure 18 Large Stand Wiring Views



Final Thoughts

These stands are meant to give Flow/1 more placement options without making the build more complicated than it needs to be. Use the small stand for a desk, shelf, or close-field setup; add middle segments when you want floor-standing height; or build a wooden base if that better fits your room or your resources.

Before putting the speakers into regular use, rotate the swivel through its full range, check the cradle tilt, make sure the speaker stays where you set it, and dress the wire so it exits cleanly without pulling on the connector.

Once everything is adjusted, the stand should do its job quietly: hold the speaker securely, aim it accurately, and then disappear into the listening space.

Public Guide and Subscriber Resources

This Stand Assembly Guide is provided publicly as an introduction to the Flow/1 stand options and assembly process. Access to the Flow/1 stand design files, future design updates, alternate configurations, and subscriber discussion resources is provided separately through adhocspeakers.com.

Disclaimer

This document is provided for informational and educational purposes only. The builder is solely responsible for safe use of tools, materials, adhesives, printed parts, purchased hardware, wooden bases, loudspeaker components, and finished assemblies, and for verifying the suitability, stability, fit, finish, and performance of all parts and processes. Build results are not guaranteed; materials, printers, tolerances, hardware availability, and design details may change. adhocspeakers.com assumes no liability for injury, damage, loss, instability, fit problems, unsatisfactory results, or other issues arising from the use of this guide or from the construction or use of the finished stand assemblies.

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