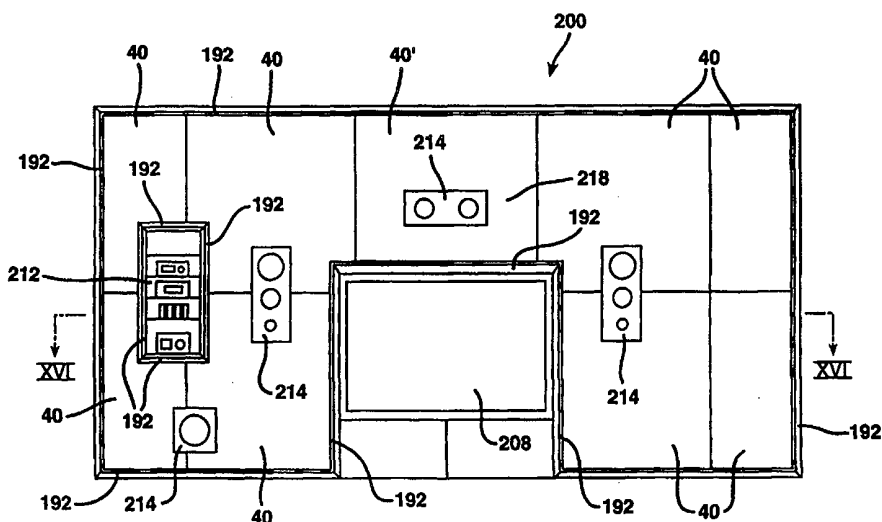




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(21) International Application Number: PCT/US99/16594 (22) International Filing Date: 22 July 1999 (22.07.99) (30) Priority Data: 09/148,519 4 September 1998 (04.09.98) US (71) Applicant (for all designated States except US): OWENS CORNING [US/US]; One Owens Corning Parkway, Toledo, OH 43659 (US). (72) Inventor; and (75) Inventor/Applicant (for US only): MCGRATH, Ralph [CA/US]; 11 Denbigh Drive, Granville, OH 43023 (US). (74) Agents: BARNS, Stephen et al.; Owens Corning Science & Technology Center, 2790 Columbus Road, Building 54, Granville, OH 43023-1200 (US).		(81) Designated States: AE, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, US, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG). Published <i>With international search report.</i> <i>Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i>

(54) Title: ACOUSTICAL SPEAKER HOUSING AND METHODS OF INSTALLATION



(57) Abstract

Acoustical housing (2010, 3010) for supporting and enhancing the performance of speakers (110, 214, 2044, 3090, 4090). A preferred apparatus includes a support well (2012, 2012') that is fabricated from acoustically absorptive material and is adapted to be mounted between wall or ceiling studs (2056, 2058, 3056, 3058, 4056, 4058). A cover (2030, 4030) or a portion of wall board (2052, 2054) may be installed to completely enclose the support well (2012, 2012') within the wall to define a cavity (2060, 3070, 4070) into which a portion of a speaker body (2046) may extend. The speaker or speakers (110, 214, 2044, 3090, 4090) are affixed to the cover (2030, 4030) or wallboard (2052, 2054) in a conventional manner such that the speaker body (2046) extends into the cavity (2060, 3070, 4070) and the sound emitting surface of the speaker (110, 214, 2044, 3090, 4090) is exposed. Methods for installing the acoustical housings (2010, 3010) into existing wall or ceiling structures without compromising the acoustical and structural integrities of such structures are also disclosed.

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ACOUSTICAL SPEAKER HOUSING AND METHODS OF INSTALLATION

TECHNICAL FIELD AND INDUSTRIAL

5 APPLICABILITY OF THE INVENTION

The present invention relates to speakers and, more particularly, is directed to acoustical housing assemblies for supporting speakers in a desired orientation and methods for installing such devices to enhance the acoustical performance of an enclosed space.

10

BACKGROUND OF THE INVENTION

Perhaps ever since Thomas Alva Edison invented the phonograph in 1876, man has attempted to control the transmission of sound to his advantage. Today, the need for sound control can be found in a variety of different environments and settings. For
15 example, office buildings, doctor's offices, recording studios, home theaters, etc. generally employ various types of materials for preventing the unwanted transmission of sound.

Acoustics is defined as the science that deals with the production, control, transmission, reception and effects of sound. When considering the problem of noise control, one must differentiate between sound absorption, sound insulation, sound
20 reflection and sound diffusion. Sound absorption refers to the attenuation of reverberant noise within the same room or area as the noise source. The sound absorption coefficient of a material is a measure of its ability to absorb noise efficiently. For example, a material that absorbs 100% of the sound energy striking it has a sound absorption coefficient of one.

25 Sound insulation refers to the reduction of noise being transmitted from one area into another area. The "Sound Reduction Index" or "Transmission Loss" of building elements are terms which described the resistance of that element to airborne sound transmission. The following table compares the degree of acoustic privacy with the sound reduction index:

SOUND REDUCTION INDEX	HEARING CONDITIONS
35dB or less	Normal speech can be understood quite easily and distinctly through the walls.
35 to 40Db	Loud speech can be understood fairly well. Normal speech can be heard but not easily understood.

SOUND REDUCTION INDEX	HEARING CONDITIONS
40 to 45dB	Loud speech can be heard, but is not easily intelligible. Normal speech can be heard only faintly, if at all.
45 to 50dB	Loud speech can be faintly heard but not understood. Normal speech is inaudible.
55dB or greater	Very loud sounds, such as loud singing, brass musical instruments or a radio at full volume can be heard faintly or not at all.

Sound reflection refers to transmission of sound in another direction by virtue of the sound bouncing off of a non-sound absorbing surface. The sound reflection coefficient of a material is the ratio of the amount of reflected sound energy to that of the incident sound energy striking the material. When tested for sabine absorption in a reverberation room, an absorption coefficient of .20 will generally result in a reflection coefficient of .90.

Sound diffusion is the uniform distribution or scattering of sound by controlled reflection. This is particularly important in home theaters to ensure that “surround sound” effects are not specifically localized thus producing the unwanted perception of “sound from a box”. Thus, to prevent such sound localization, it is desirable to diffuse, or control the reflection of, the sound energy in a range of frequencies.

Over the years, a variety of different materials and apparatuses have been developed for controlling the transmission and absorption of sound based on the foregoing principles. Different forms of acoustical panels have been used in making furniture, room dividers, partitions, wall constructions, ceiling constructions and the like. For example, U.S. Patent No. 2,081,765 to Prudden discloses an acoustical structure that is generally loosely attached to a wall for preventing the transmission of sound therethrough. Such structure, however, can be difficult and time consuming to install. Because such structure is loosely attached to the wall, it offers no structural support to the wall. Furthermore, such structure cannot be provided in complex surface geometries designed for the advantageous absorption and reflection of sound.

Another acoustical panel is disclosed in U.S. Patent No. 3,712,846 to Daniels et al. While the Daniels et al. panel includes a rigid main body, the flexible outer covering includes a plurality of projections and indentations that can trap dirt and debris making it difficult to keep clean. Furthermore, such irregular surface may not be aesthetically desirable. Other embodiments in the Daniels et al. panel employ a woven outer covering

that may also have similar shortcomings. Other panels which have desirable structural characteristics are disclosed in U.S. Patent No. 2,692,219 to Slater et al. However, such panels are not well-adapted to be formed with complex geometric surfaces.

U.S. Patent No. 4,661,392 to Kapstad discloses a sound dampening panel that
5 includes a corrugated center barrier that is sandwiched between fibrous sound dampening material. The sound dampening material is housed within a frame and is covered with a fabric material. Such panel is intended to be used as a partition panel, and thus is not well-suited for attachment to structures such as ceilings, walls, etc.

Another panel structure is disclosed in U.S. Patent No. 5,606,833 to Anderson.
10 The panel comprises a rigid support sheet that has an insulating sheet attached thereto. Anderson teaches that the insulating sheet of each panel is placed inwardly and not exposed.

U.S. Patent No. 4,719,730 to Winkowski discloses a demountable partition wall that includes a sound absorbing tack board including a gypsum baseboard, a mineral fiber
15 core board and a porous decorative sheet of material adhered to the core board. The tack board is hung such that the core board faces toward sound and absorbs it.

Decoustics, a company located in Toronto, Canada, also manufactures assorted types of wall panels and ceiling tiles that provide various acoustical properties. Such panels and tiles, however, are not well-adapted for being formed with a variety of
20 geometric surfaces. Thus, in general, many previously proposed acoustical panel constructions are less desirable because they are either too expensive to produce economically, provide poor performance and/or are difficult to install and maintain.

Yet another panel arrangement is disclosed in U.S. Patent No. 5,606,841 to Carter, Jr. The panels disclosed in that patent comprise interior filled wall panels that include a
25 framed backing member to which an outer sheet material is attached. A filler or padding material that may have desirable thermal or acoustical properties is retained between the backing member and the sheet material. The sheet material is secured through the filler material in a plurality of spaced locations to create a three dimensional surface relief.

U.S. Patent No. 3,721,050 to Perina discloses a modular grid panel retention
30 system that can be used to cover the walls and/or ceiling surfaces of a room. The system includes 4' x 8' grid-like sections which may be fastened to the wall, ceiling or support structure by screws, bolts or hook and loop-type fasteners. Each grid-like section includes a plurality of panel receiving cavities for receiving wall panels, ceiling tiles and the like

therein. The grid-like structures disclosed in this patent can be cumbersome to handle and install. In addition, the numerous exposed frame portions of each grid-like section can provide undesirable sound reflection in rooms requiring enhanced acoustical properties.

Other diffuser panel arrangements are manufactured by RPG Diffusor Systems, Inc. located at 651-C Commerce Drive, Upper Marlboro, MD 20774. For example, RPG manufactures a diffuser panel under the trademark Skyline that consists of a panel that has a plurality of outwardly extending columns which provide two-dimensional diffusion. Such panel is adapted to be affixed to an exterior wall or ceiling surface.

In existing wall arrangements, it is generally desirable to mount acoustical diffuser and absorption panels such that they do not occupy any interior space. Thus, it is advantageous to recess such panels within the existing wall structure. To do so, however, the structural integrity of the wall is usually compromised by cutting the wall board and studding. Also, prior acoustical diffuser panels provide little or no structural support to the wall, requiring the installation of additional support braces and cross-studs in the wall. After the additional bracing has been added and the diffuser panels are installed, a discrete cover member is typically installed to cover the opening in the wall. Because such discrete cover does not cover the entire wall it can detract from the overall aesthetic appearance of the wall.

The above-mentioned panels and arrangements due to their cost, have not been embraced by the residential market. Homeowners desiring to acoustically tune a room to enhance the sound performance of their stereo systems usually are prevented from doing so due to the relatively high costs associated with purchasing and installing such materials and devices.

In addition, various methods have been employed to enhance the performance of speakers. For example, U.S. Patent No. 3,962,544 to Kobayashi discloses a speaker arrangement that includes low and high frequency speakers wherein the high frequency speaker is mounted within its own housing which permits rear cone radiation out of the housing sides. The housing also permits front cone radiation out of the front of the speaker. Kobayashi claims that such arrangement improves radiation efficiency and transient response. The speaker arrangement is designed to be mounted to a buffer board provided in a stand alone enclosure. The speaker arrangement is not particularly well-suited for use in applications wherein it is desirable for the speaker to be completely recessed within a wall cavity.

U.S. Patent No. 4,566,557 to Laemaitre discloses a flat acoustic diffuser assembly that includes a speaker that is located within an area that is bordered by a frame. A cover is employed to enclose the front of the assembly. The cover acts as a direct wave attenuator so that the front side of the speaker is covered, but its rear side is uncovered so
5 that unattenuated sound waves are emitted from the rear of the speaker. Thus, this arrangement is not particularly well suited for use in connection with speakers that are designed to be installed in a wall cavity.

U.S. Patent No. 3,557,901 to Young discloses a sound diffuser unit that comprises a plurality of spaced, radially arranged, spoke-like members which lie in a common plane.
10 The unit is constructed to be supported in front of or mounted directly on the front of a speaker. Such arrangement, however, can detract from the aesthetic appearance of the speaker.

Thus, there is a need for an acoustical housing arrangement for use with a wide variety of speakers.

15 There is a further need for an acoustical housing for speakers that facilitates installation of the speaker(s) into wall or ceiling cavities without causing undesirable impact on the overall acoustical integrity of the room, the wall, the ceiling or the speaker(s).

There is a need for an acoustical housing that can be employed to support one or
20 more speakers and achieve a desired acoustical result therefrom.

There is still another need for an acoustical housing for supporting one or more speakers within an existing or newly constructed wall or ceiling.

Another need exists for acoustical wall and ceiling treatments that have the attributes mentioned above that is customizable in terms of texture and color.

25 Yet another need exists for an acoustical speaker housing that reduces unwanted sound transmission from the speaker(s) to other adjacent rooms and spaces.

Still another need exists for an acoustical speaker housing that can be easily and conveniently installed into a wall or ceiling without compromising its acoustical and structural integrities.

30 Another need exists for aesthetic, acoustical built-in wall systems.

SUMMARY OF THE INVENTION

In accordance with a preferred form of the present invention, there is provided an apparatus for supporting a speaker that has a body portion. The apparatus may comprise a support well and a cover that is arranged in confronting relationship with the support well.

- 5 The cover is attached to the support well to form an enclosed cavity. An opening is provided through the cover to support at least a portion of the speaker within the enclosed cavity. The speaker may be attached to the cover.

- The present invention also comprises an apparatus for supporting a speaker that has a body portion. The apparatus includes a support well fabricated from a first layer of moldable material and a second layer of moldable material with a septum material laminated therebetween. The support well has a first bottom and side walls integrally formed with the first bottom. An attachment flange extends around a perimeter of the support well. This embodiment of the present invention includes a cover arranged in confronting relationship with the support well to form an enclosed cavity. The cover has a second bottom portion and second wall integrally formed with the second bottom portion and a second attachment flange for confronting contact with the first attachment flange of the support well. The cover has an opening therethrough sized such that at least a portion of the speaker body is received within the enclosed cavity.

- Another embodiment of the present invention comprises an apparatus for supporting a speaker that has a body portion. The apparatus includes a support well fabricated from a first layer of moldable material and a second layer of moldable material with a septum material laminated therebetween. The support well has a first bottom and side walls integrally formed with the first bottom. An attachment flange extends around a perimeter of the support well. This embodiment of the present invention includes a cover arranged in confronting relationship with the support well to form an enclosed cavity. The cover comprises a piece of drywall and has an opening therethrough sized such that at least a portion of the speaker body is received within the enclosed cavity. A fiberglass mat material may be bonded to the cover.

- The present invention also includes a method for installing at least one speaker that has a body portion and a sound emitting surface into a wall structure. The wall structure may have two spaced-apart wall boards that are fastened to spaced-apart studs to define an enclosed cavity between the studs and wall boards. The method comprises removing at least a portion of one of the wall boards to expose at least a portion of the

enclosed cavity and providing a support well that includes a first rigid support member formed from an acoustically absorptive material and sized to be received within the exposed portion of the enclosed cavity. The support well also has a bottom and upstanding side walls that are integrally formed with the bottom. The side walls are
5 constructed for attachment to at least one stud. The method further comprises attaching a cover assembly to the support well to form an enclosed cavity between the cover assembly and support well and providing an opening in the cover assembly that is sized to receive at least a portion of the speaker body therein. The method may also include inserting at least a portion of the speaker body assembly through the opening and into the
10 enclosed cavity and affixing the speaker to the cover assembly.

The present invention also comprises a wall structure that includes a wall frame including at least two spaced-apart studs and first and second wall boards that are affixed to the wall frame. The wall frame and the first and second wallboards define at least one cavity between at least two spaced-apart studs. The wall structure also includes at least
15 one support well sized to be received in one cavity and attached to at least one stud. The wall structure also comprises a cover arranged in confronting relationship with the support well to form an enclosed speaker well for receiving a portion of a speaker body therein.

It is a feature of the present invention to provide an apparatus for supporting one or more speakers that is easy to install in a recessed manner within an existing wall or
20 ceiling structure without compromising the structural integrity of the structure and without the use of additional support braces and/or studs.

Another feature of the present invention is to provide a method for installing a diffuser panel and speaker assembly into an existing wall or ceiling structure of a commercial or residential structure or a classroom.

25 Another feature of the present invention is to provide an acoustical built-in wall system for mounting components such as speakers in a wall or ceiling to achieve desired acoustical results within an enclosed space.

Another feature of the present invention is to provide a diffuser apparatus that can enhance the performance of a speaker and reduce the phase effects from boundary walls.

30 Yet another feature of the present invention is to provide an acoustical speaker housing that reduces sound transmission from a speaker into adjoining rooms and spaces.

Still another feature of the present invention is to provide a housing for a speaker or similar component that can be readily installed in new walls or ceilings and in remodeled walls or ceilings.

Accordingly, the present invention can provide solutions to many shortcomings of various methods and apparatuses used to enhance the effectiveness of a speaker. The subject invention is particularly well-suited for acoustically tuning rooms, such as home entertainment rooms, recording studios etc. Those of ordinary skill in the art will further appreciate that the effectiveness of the speaker can be so enhanced that acceptable results can be achieved through the use of speakers that are smaller than the speakers that one would normally use to achieve the same results. These and other details, objects and advantages will become further apparent as the following detailed description of the present preferred embodiments proceeds.

BRIEF DESCRIPTION OF THE DRAWINGS

In the accompanying drawings, there are shown present preferred embodiments of the invention wherein like reference numerals are employed to designate like parts and wherein:

FIG. 1 is a perspective view of a preferred diffuser panel of the subject invention with some of the elements thereof omitted for clarity;

FIG. 2 is an exploded assembly view of the diffuser of FIG. 1;

FIG. 3 is an exploded cross-sectional view of a preferred arrangement of materials for a preferred initial molding step wherein the mold halves are in open positions;

FIG. 4 is a cross-sectional view of the materials of FIG. 3, with the mold halves in closed positions;

FIG. 5 is an exploded cross-sectional view of a preferred arrangement of materials after the initial molding step with the mold halves in open positions;

FIG. 6 is a cross-sectional view of the materials of FIG. 5 with the mold halves in closed positions;

FIG. 7 is a partial perspective view of a preferred panel of the subject invention;

FIG. 8 is a partial perspective view of another preferred panel of the subject invention;

FIG. 9 is a partial perspective view of another preferred panel of the subject invention;

FIG. 10 is a cross-sectional assembly view of a preferred fabric retainer member of the present invention and preferred panels of the present invention attached to an existing wall;

FIG. 11 is a partial perspective view of the preferred fabric retainer members and panels of FIG. 10 attached to the wall of FIG. 10;

FIG. 12 is a partial perspective view of preferred fabric retainer members of the present invention and preferred panels of the present invention attached to an existing wall and wherein a speaker component is received within a cavity in one of the panels;

FIG. 13 is a cross-sectional view of a more preferred fabric retainer member of the present invention.

FIG. 14 is a schematic perspective view of an enclosed area that has preferred panels installed therein in a preferred arrangement of the present invention;

FIG. 15 is a plan view of an acoustical built-in wall system of the present invention, with a fabric thereof removed;

FIG. 16 is a cross-sectional view along line XVI-XVI of FIG. 15, with the fabric in place;

FIG. 17 is a schematic top view of a second embodiment of an acoustical built-in wall system of the present invention;

FIG. 18 is a schematic top view of a third embodiment of an acoustical built-in wall system of the present invention;

FIG. 19 is a partial perspective view of a preferred door construction of the present invention with a portion thereof cut away;

FIG. 20 is a partial cross-sectional view of the preferred door of FIG. 19;

FIG. 21 is a graphical comparison of transmission loss in dB vs. frequency in Hz for two preferred panels of the subject invention;

FIG. 22 is a graphical comparison of transmission loss in dB vs. frequency in Hz for a preferred panel of the subject invention attached to a support surface by screws and the same panel attached to the support surface without screws;

FIG. 23 is a graphical comparison of transmission loss in dB vs. frequency in Hz for a 2 X 4 stud wall, a preferred panel of the subject invention, another preferred panel of the subject invention attached to a support surface with screws and a filler wall;

FIG. 24 is a graphical comparison of sound absorption coefficients and sum of the sound absorption coefficients vs. frequency in Hz. for a preferred panel of the subject

invention wherein the panel was mounted with its backing board facing toward and away from the source of sound;

FIG. 25 is a graphical comparison of the sound absorption coefficients and the sum of sound absorption coefficients vs. frequency in Hz for another preferred panel of the subject invention wherein the panel was mounted with its backing board facing toward
5 and away from the source of the sound;

FIG. 26 is a graphical comparison of the reverberation times vs. frequency in Hz for a particular room before and after incorporation of the preferred system of the present invention;

10 FIG. 27 is a partial perspective view of a preferred diffuser assembly of the present invention;

FIG. 28 is a cross-sectional view of the diffuser assembly of FIG. 27 taken along line XXVIII-XXVIII in FIG. 27;

FIG. 29 is a cross-sectional view of another preferred diffuser assembly installed
15 in a wall structure;

FIG. 30 is a front elevational view of the diffuser assembly of FIG. 29 with the acoustically transparent cover removed therefrom;

FIG. 31 is a partial cross-sectional perspective view of another preferred diffuser assembly of the present invention;

20 FIG. 32 is a cross-sectional view of the diffuser assembly of FIG. 31 installed in a wall structure;

FIG. 33 is a plan view of the diffuser assembly of FIGS. 30 and 31;

FIG. 34 is a graphical depiction of a home entertainment room illustrating a preferred location for diffusers of the present invention;

25 FIG. 35 is a cross-sectional view of a portion of the wall structure of FIG. 34;

FIG. 36 is a plan view of a portion of a suspended ceiling structure having a preferred diffuser assembly of the present invention supported therein;

FIG. 37 is a partial cross-sectional view of the ceiling structure of FIG. 36 taken along line XXXVII-XXXVII of Figure 36;

30 FIG. 38 is a cross-sectional assembly view of an acoustical housing assembly of the present invention installed in a wall structure and supporting a speaker;

FIG. 39 is a plan view of the speaker well of the speaker housing assembly depicted in FIG. 38;

FIG. 40 is a side elevational view of the speaker well of FIG. 39;

FIG. 41 is a cross-sectional view of a portion of the speaker well of FIGS. 39 and 40;

FIG. 42 is a cross-sectional assembly view of another speaker housing assembly of the present invention installed in a wall structure and supporting a speaker therein;

FIG. 43 is a plan view of the speaker well of the speaker housing assembly depicted in FIG. 42;

FIG. 44 is a side elevational view of the speaker well of FIG. 43; and

FIG. 45 is a cross-sectional view of another speaker housing assembly installed in a wall structure and supporting a speaker therein.

DETAILED DESCRIPTION AND

PREFERRED EMBODIMENTS OF THE INVENTION

Referring now to the drawings for the purposes of illustrating the present preferred embodiments of the invention only and not for purposes of limiting the same, FIG. 1 illustrates a preferred acoustic diffuser panel 10 of the present invention. While FIG. 1 depicts a diffuser panel 10 that has a wavy outer surface 12, the skilled artisan will readily appreciate from the discussion to follow that the diffuser panel 10 of the present invention can be provided with a myriad of complex outer surface geometries for advantageously diffusing sound in a desired manner. Those of ordinary skill in the art will also appreciate that such surface geometries are dependent upon the characteristics of the specific environment into which it is to be installed (i.e., room size, room shape, internal and external sounds, etc.). With the appropriate outer surface geometry, sound can be evenly scattered from the outer surface 12. Such effect significantly enhances the sound image quality of an enclosed area and serves to increase the perceived sense of space (i.e., virtual size) of the area. As used herein, "sound diffusion" means the uniform distribution or scattering of sound independent of the direction of the sound from a source (e.g., a speaker).

A preferred panel 10 of the subject invention is preferably fabricated utilizing a molding/lamination method that is described below. FIG. 2 is an exploded view of a preferred diffuser panel construction. As can be seen in that Figure, the panel 10 preferably comprises a composite of materials, one of which is an acoustically transparent surface finishing material 14 that preferably comprises a fabric material. The surface

finishing material 14 is preferably impregnated with an uncured binder such as a thermoset polymer material which preferably has a curing temperature of approximately 400°F (204°C). However, surface finishing material 14 could also comprise other acoustically transparent glass mat or other similar material that is impregnated with a similar binding medium or adhesive medium. As used herein, "acoustically transparent material" is a material whose acoustical properties when applied to a primary product will not affect the acoustical properties exhibited by the primary product .

The next layer of material preferably comprises a first molding media 16. Such molding media preferably comprises a moldable fibrous material impregnated with a binder, such as the fiberglass material manufactured by Owens Corning under the general product description of molding media. It will be appreciated that such fiber glass material provides added advantages of structural strength and rigidity. However, other organic and inorganic materials such as open-celled melamine foam or rockwool could also be successfully employed. The next layer of material preferably comprises a first foil layer 18, such as the foil manufactured by Lamtec of New Jersey under Model No. 3035; however, other material such as aluminum foil fabricated by Reynolds Aluminum may also be used.

The next layer 20 of material functions as a diffuser material and preferably comprises asphalt material having a preferred weight of 1.5 pounds per square foot and a preferred softening point of approximately 150-180°F (64-82°C). Although the acoustical characteristics of any laminate depend upon the arrangement, thicknesses and masses of the component layers, layer 20 is termed a diffuser material because its high density makes it the primary contributor to the acoustically reflective properties of the panel 10 that enable diffusion of sound. The next layer 22 of material preferably comprises a second layer of foil of the type described above. Layer 24 preferably comprises a second molding media such as the moldable fiberglass of the type described above. The last layer 26 of the panel 10 preferably comprises a preformed fibrous backing material such as a medium density fiberglass material or an open-celled melamine. It will be apparent to the skilled artisan that by incorporating various layers of different densities over a controlled radius profile, the present diffuser creates a diffuse sound field that scatters sound in a wide range of frequencies to avoid undesirable sound image localization.

A panel 10 is preferably fabricated utilizing commercially available molding equipment and is preferably molded as described below and depicted in FIGS. 3-6. As

can be seen in FIG. 3, the molding equipment is provided with a first mold half 30 that is configured to provide the panel 10 with the desired outer surface geometry. The mold also includes a second mold half 32. The mold equipment is designed to heat the mold halves (30, 32) and to clamp the desired composite of materials to be molded

5 therebetween under various predetermined temperatures and amounts of pressure for various predetermined time periods.

To begin a preferred molding process, the mold halves (30, 32) are moved to their opened positions as shown in FIG. 3. Thereafter, the materials (14, 16, 18, 22, 24, 26) are inserted between the mold halves (30, 32) in the arrangement shown. After the layers of
10 preferred materials (14, 16, 18, 22, 24, 26) are inserted between the mold halves (30, 32), the mold halves are moved to their closed positions as shown in FIG. 4. After the mold halves (30, 32) have been closed, they preferably heat the materials to approximately 400-450°F (204-232°C) under a preferred pressure of 10-30 psi for a preferred first dwell time period of 45-150 seconds.

15 During this initial molding operation, the binder material on the molding media 16, 24 cures causing the first foil layer 18 to adhere to the first molding media 16 and the second foil layer 22 to adhere to the second molding media 24. Because the confronting sides of the first and second foil layers (18, 22) are not provided with a binder material, the first molding media 16 can be separated from the second molding media 24 after the
20 mold halves (30, 32) have been opened as shown in FIG. 5. After the mold halves (30, 32) have been opened, the layer of asphalt material 20 is inserted between the first molding media 16 and the second molding media 24. In preferred practice, the time required to open the mold halves (30, 32) and insert the asphalt layer 20 between the first and second molding medias (16, 24) takes approximately 10-20 seconds. During such
25 time period, the mold halves (30, 32) cool to approximately 250° F (121°C) which enables the asphalt layer 20 to be molded when the mold halves (30, 32) are closed as shown in FIG. 6. Preferably, the mold halves (30, 32) are closed for a period of 10-20 seconds to apply a pressure of approximately 0-1 psi to the panel to the composite of materials. After such time period expires, the mold halves (30, 32) are opened and the
30 molded panel 10 is removed. The skilled artisan will appreciate that the foil layers (18, 22) prevent the asphalt layer 20 from bleeding through into the layers (16, 24). Also, the use of such foil layers (18, 22) enhances the fire resistant attributes of the panel 10.

The panels 10 of the present invention solve many problems commonly associated with prior panels. In particular, the subject panel 10 is relatively lightweight and exhibits structural qualities that enable the panel 10 to be fabricated in relatively large sizes [e.g., 4ft x 8ft (1.2 x 2.4m) cross-section] which enable it to be used in a variety of different settings. In addition, the preformed backing 26 provides a uniform attachment surface for easy installation by, for example, commercially available adhesive or other mechanical fastening means such as screws, nails, etc. Also, the overall panel thickness can be economically varied by utilizing thicker or thinner preformed backing material 26.

Another preferred embodiment of the present invention for acoustically tuning an enclosed space such as a room is shown in FIG. 7. As can be seen in that Figure, a preferred panel 40 has a first surface 42 that is acoustically absorptive and a second surface 44 that is acoustically reflective. As used herein, the term "acoustically reflective" means the ability of a material to reflect sound energy at a certain frequency. A material's degree of acoustical reflectivity is represented by its reflection coefficient, which is the ratio of the amount of reflected sound energy to the total incident sound energy striking the material. The term "acoustically absorptive" means a soft porous surface which absorbs sound energy. A material's degree of acoustical absorbtivity is represented by its sound absorption coefficient which is the ratio of sound energy absorbed by a material to the total incident sound energy striking the material. In a preferred embodiment, panel 40 comprises a rigid backing board 46 that has a fibrous material 48 laminated thereto. Preferably, the backing board 46 comprises commercially available gypsum wall board which can be installed utilizing commercially available adhesive and/or by mechanical fasteners, such as screws, nails, etc. We prefer to employ wall board having a thickness of 1/4" (.6 cm) which serves to provide a desirable amount of durability during handling and installation. It has been discovered that such wall board provides a basis weight of one pound per square foot which provides adequate acoustic reflectivity. However, other material of differing thicknesses and densities could also be employed.

In one preferred embodiment, the fibrous material 48 comprises fiberglass board having a density of at least 3 pounds per cubic foot. Exemplary board of this type is manufactured by Owens Corning as an acoustical board product (700 Series Board); however, other suitable material such as mineral wool and the like could be successfully employed. To facilitate the use of such light density fiberglass or mineral wool material, a commercially available glass mat 50 is preferably laminated to the outer surface of the

fibrous material 48. In a preferred embodiment, a glass mat 50 with a nominal basis weight of approximately 25 pounds per one thousand square feet is employed to enable the panel 40 to be installed utilizing conventional drywall screws without the screw heads tearing loose. The skilled artisan will also appreciate that the mat 50 serves as a load distributor which serves to increase the compressive strength of the fibrous material substrate. If desired, depending upon the installation orientation of the panel 40, the finish provided by the glass mat 50 can serve as the final wall finish. It will be further appreciated, however, that the panel 40 can also be successfully employed without the glass mat 50.

The fibrous material 48 can be fabricated utilizing a variety of known methods. For example, the glass mat 50 could be directly applied to the fiberglass or mineral wool during the initial board production process. That "faced" board could then be applied to the rigid backing board 46 utilizing suitable commercially available adhesive.

Another preferred embodiment of the present invention is depicted in FIG. 8. In this embodiment, the panel 60, preferably has a rigid backing board 62 of the type described above. Attached to the backing board 62 is a commercially available open-cell melamine foam 64, preferably of the type manufactured by BASF of Germany under the registered trademark BASOTECH. Preferably, this foam has a density of 0.7 pounds per cubic feet. As with the previously described preferred embodiment, a glass mat 66 is preferably laminated onto the foam 64. However, the panel 60 could be employed in the various manners discussed below without the use of the glass mat 66.

FIG. 9 depicts yet another preferred embodiment of the present invention. In this embodiment, the panel 70 preferably has a rigid backing board 72 of the type described above. Attached to each side of the backing board 72 are fibrous materials 74, preferably of the type manufactured by Owens Corning as an acoustical board. As with the previously described preferred embodiments, a glass mat 76 is preferably laminated onto the fibrous material 74 that will face the interior of the room. However, the panel 70 could be employed in the various manners discussed below without the use of the glass mat 76.

FIGS. 10 and 11 depict a preferred method for installing panels (40, 60) adjacent an existing wall 90. The reader will appreciate that the same method could also be employed to install panels 70. In a preferred embodiment, fabric retainer members 92 are employed. As shown in FIG. 10, a preferred fabric retainer 92 comprises an elongated

rectangular-shaped support member 94 that can be fabricated from a myriad of different materials such as wood, plastic, etc. Attached to the support member 94, preferably by stapling or gluing, is a moldable strip 95 of the type disclosed in U.S. Patent No.

5,117,598 to Livingston, the disclosure of which is herein incorporated by reference.

5 While the fabric retainer 92 depicted in FIG. 10, is of two-piece construction, the skilled artisan will appreciate that such member could be extruded as a single unitary piece utilizing known extrusion techniques. The skilled artisan will also appreciate that such retainer 92 could be provided in the form of a "T" or be shaped to accommodate inside and outside corners. In addition, other of methods for supporting a fabric sheet or similar
10 material on a surface could also be successfully employed.

In a preferred embodiment, to facilitate attachment of the fabric retainer 92 to the wall 90 in a desired manner, the support member 94 is provided with a plurality of countersunk bores 99 for receiving attachment screws (not shown) therethrough.

However, other methods of attaching the fabric retainer member 92 to the support wall 90
15 may also be employed. The retainer member 92 is formed with a fabric gripping portion 96 that comprises two confronting members (97, 98) that are arranged to permit a piece of fabric material 100 or other acoustically transparent medium to be inserted therebetween.

As can be seen in FIG. 11, the fabric retainer members are attached to the support wall 90 at spaced intervals that enable a series of like-constructed preferred panels (i.e.,
20 panels 10, 40, 60 and/or 70) to be installed therebetween. The panels are attached to the support wall 90 by adhesive or mechanical fasteners such as screws, nails, etc. For all of the panels disclosed herein, the preferred method of attachment is by coarse thread screws into a drywall support wall 90, such that the panels are acoustically decoupled from the underlying wall studs. After the panels have been attached between the fabric retainers
25 92, the fabric 100 is then stretched over the panels and attached to the retainers 92 such that the fabric 100 covers the panels and retainers 92. While the foregoing installation method was directed to wall coverings, the skilled artisan will appreciate that such method may be successfully used on a variety of different surfaces such as ceilings, doors, floors, etc.

30 The reader will further appreciate that the foregoing installation method is well-adapted for concealing wall or ceiling mounted components such as speakers, etc. For example, as shown in FIG. 12, when it is desirable to conceal a wall mounted speaker 110, a receiving cavity 112 is cut into a corresponding panel member 40. In this

embodiment, the panel 40 is preferably at least as thick as the speaker, such that when the speaker is mounted (utilizing known attachment methods) within the cavity 112, preferably none of the speaker 110 protrudes therefrom. See FIG. 12. Also, by providing the backing board 46 with a flat black color, the panel can function as a screen for
5 projection devices by mounting the black side so that it faces the projection device. The skilled artisan will also appreciate that the diffuser panels 10 described above may also be employed to provide a desired amount of acoustical diffusion within a room. The diffuser panels 10 would be installed in the same manner as the panels 40 or 70.

FIG. 13 is a cross-sectional view of a more preferred embodiment of the fabric
10 retainer of the present invention. The fabric retainer 192 would normally be formed as an elongated channel having the cross-section shown, and includes a base 193 that would normally be fastened against a wall or other supporting structure, a retaining portion 194 for grasping and retaining fabric, and an extension arm 195. The extension arm 195 includes a plurality of holes 196 (only one shown) therethrough to allow a screw or other
15 fastening device to be driven through the base 193. The extension arm further includes an upper locating arm 197 and a side locating arm 198. The upper locating arm 197 is designed to have an outer surface coextensive with the outer surfaces of adjacent panels, such that the fabric held by the retainer 192 extends across the panels and the upper locating arm 197 in a smooth, aesthetic manner. The side locating arm 198 enables the
20 retainer 192 to be positively located against an adjacent panel 40 even when the backing board 46 faces outwardly and is thus spaced from a supporting wall and the base 193 of the retainer. An extension 199 of the base 193 enables the retaining portion 194 to be spaced from an adjacent surface (such as an adjoining wall in a corner of a room) by a small amount, enabling insertion of fabric into the retaining portion 194 to be
25 accomplished more easily.

Those of ordinary skill in the art will also appreciate that the panels (40, 60, 70) can be used to advantageously acoustically tune an enclosed space such as a room. That is, the preferred design parameters of the panels (40, 60, 70) provide a flexible and relatively inexpensive means for controlling the sound absorption characteristics
30 occurring within a room or enclosed space. Properly balanced sound absorption, in e.g., a home theater environment, can dramatically decrease sound image localization. The material properties of these panels and their orientation to the source of the sound determine the amount of sound absorption occurring relative to the desired frequency

range of the sound to be attenuated. For example, a human's experience of sound is often analyzed in terms of a low range of frequencies, i.e., less than 300 Hz, a mid-range of frequencies, i.e., 500 to 4000 Hz, and a high range of frequencies, i.e., 4000 to 20,000 Hz, with the mid-range of frequencies generally being considered most important for

5 applications such as home theater. In the case of low range frequency absorption (less than 300 hertz), an absorption coefficient of 0.20 or greater is desired, especially in a room to be used as a home theater, and can be approximated by having the backing board exposed to the sound source(s). Those panels that are installed with their fibrous material facing the sound source(s) have sound absorption coefficients between about 0.65 and
10 0.90 for mid-range frequencies (frequencies ranging from 1000-4000 hertz). For mid-range frequencies, sound absorption coefficients above .75, for example in a room to be used as a home theater, are desirable and are approximated well when the preferred panels of the subject invention are used.

Further, reflection coefficients of 0.90 and above are expected for many low-range
15 frequencies when the panels' fibrous material is exposed to the sound source, and are expected for most mid-range frequencies with the backing board so exposed. These properties allow sound reflection characteristics in a room to be designed to provide such acoustical characteristics as sound presence, or sense of spaciousness, and definition or clarity of the sound stage.

20 FIG. 14 depicts an enclosed space 120 that has an interior 122 that is subjected to a source of sound (not shown). The enclosed space 120 also has four walls (124, 126, 128, 130). As can be seen in FIG. 14, wall 124 opposes wall 128 and wall 126 opposes wall 130. In this example, the enclosed space 120 also has four corners (132, 134, 136, 138), a door 150 and a stairway 160. Those of ordinary skill in the art will also
25 appreciate that the preferred installation arrangement of the present invention can be installed in a variety of differently shaped rooms without departing from the spirit and scope of the present invention.

As is evident from the test results shown below, it has been discovered that an enclosed space can be acoustically tuned (i.e., to provide studio-like performance) by
30 advantageously mounting panels at each corner with their acoustically absorptive side facing the interior of the space and then alternately mounting panels along the walls such that every other panel is mounted with its acoustically absorptive side facing the interior space and such that panels on opposing walls are mounted in opposite orientations. Those

panels that are installed with their acoustically absorbent side facing the interior 122 of the enclosed space 120 are designated as 40 and those panels that are installed with their acoustically reflective side facing the interior 122 of the enclosed space 120 are designated as 40'.

5 The walls (124, 126, 128, 130) each have a height "H". In the example shown in FIG. 14, the end walls (124, 128) have a length "L" that is shorter than the lengths "L" of walls (126, 130). In such room configuration, panels 40 are preferably installed at each corner (132, 134, 136, 138) and on each end wall (124, 126). It will be appreciated, however, that the panels attached to the end walls (124, 128) could also be arranged in an
10 alternating fashion as described below. The walls (126, 130) are covered with alternating panels (40, 40') such that panels on an opposing wall have a different orientation. For example, except in the corners, a panel 40 on wall 126 will have a panel 40' directly opposite it on wall 130. See FIG. 14.

 The enclosed space 120 depicted in FIG. 14 includes a stairway 160. Preferably,
15 the panels (40, 40') are installed such that they alternate along the exposed side of the stairway as shown in that Figure. Also, the skilled artisan will readily appreciate that the panels (40, 40') of the present invention can be attached to the existing door 150 and window structures (not shown). In the alternative, the door 140 may be constructed utilizing framing material and the panels of the subject invention. Conventional door
20 attachment hinges, slides, etc. could also be used.

 It should be understood that, while the panels 40, 60, 70 are generally shown as being large panels, such as 4 ft by 8 ft (1.2 m by 2.4 m) panels, in a more preferred embodiment of the invention the panels may be different, smaller sizes. Such smaller sizes, such as 4 ft by 4 ft (1.2 m by 1.2 m) panels or even 2 ft by 4 ft (.6 m by 2.4 m)
25 panels, can have the advantage that they can enable a room to be more precisely tuned, or to handle rooms where a uniform treatment from floor to ceiling along a particular portion of a wall proves to be acoustically undesirable. For example, in such a case an acoustically absorptive panel may be located along a lower portion of the wall and an acoustically reflective panel may be located along an upper portion of the wall, or vice
30 versa. It should be understood that in the normal course of installation an installer may have to cut standard panels to fit into particular portions of particular rooms, and such cutting of panels to smaller sizes during installation is considered to be a normal part of installation.

It should further be understood that, while FIG. 14 illustrates an enclosed space 120 as having acoustical panels 40, 40' installed on all four walls 124, 126, 128, 130 of the space, this arrangement is only a most preferred embodiment of the invention. It is fully contemplated by this disclosure that a preferred embodiment of the present invention
5 may include only panels 40, 40' on a wall in or to which various stereo or home theater components are mounted or adjacent, such as wall 124, or may include only panels installed in the corners of the space 120. Further, a more preferred embodiment of the invention may include panels 40, 40' installed only on two adjacent walls, such as walls 124, 130, or on two opposing walls, such as walls 126, 130. In such preferred and more
10 preferred embodiments, various advantages of the present invention may be still be achieved.

It is contemplated herein that the fabric retainers of the present invention may be spaced between each panel, to stretch and retain standard width pieces of fabric across each individual panel. In a preferred embodiment of the present invention, however, a
15 sewn-seam stretch fabric, as is known in the art, may be utilized to cover large portions or all of each wall 124, 126, 128, 130. In such a case, the fabric retainers would need only to be placed around the edges of a wall, and around any objects over which the fabric would not extend, such as doors, windows, television screens, etc., and the sewn-seam fabric could be stretched to cover the rest of the wall. The advantage of this type of installation
20 is that it would require less length of fabric retainer and thus would be less expensive, and also that it could form an unbroken, more acoustically pleasing wall surface. In addition, such an installation would allow the smaller size panels referenced above to be used, and thus a more precisely-tuned space to be achieved, without detracting from the aesthetics of the installation with numerous, irregularly-sized fabric squares.

While the use of sewn-seam fabric in an installation is currently preferred, it
25 should be understood that its use over an entire wall is disclosed herein only to satisfy any potential best mode requirements. The concept is the invention of an inventive entity different from the inventive entity of the instant application, and was disclosed to the instant inventive entity by the other inventive entity. The instant inventive entity claims
30 no rights in the concept, other than those rights available to the general public.

FIGS. 15 and 16 illustrate a first embodiment 200 of an acoustical built-in wall system of the present invention, with a fabric thereof removed. More specifically, the built-in wall system 200 includes a supporting wall structure such as a partition wall 202

constructed across one end of an existing enclosed space or room 203, such as defined by masonry wall 204 of FIG. 16, into which are mounted various audio and/or video components of, for example, a standard home theater system. The wall 202 is preferably formed of wood studs 206, although steel studs or any other non-load bearing wall construction technique may be used, to which are attached various panels 40, 40' (or 10, 60 or 70) arranged to provide a desired acoustical treatment system. For example, FIG. 15 shows an acoustically reflective panel 40' mounted in the center of the system 200 above a big screen television 208 to enliven what could otherwise be a dead response area of the system 200, and acoustically absorptive panels 40 mounted towards the sides of the system 200 to reduce sound image localization generated in part by interference patterns in corner areas of space 203. It should be understood that although the panel 40' is referred to as acoustically reflective, the desired acoustical effect in a particular area of the system 200 may include diffusion, i.e., controlled reflection of sound, thus the acoustically reflective panel 40' could be a diffuser panel such as the panel 10 so that the panel would be acoustically reflective in a controlled manner or to form a desired reflection pattern.

Cutouts 210 are formed in the panels 40, 40' upon installation to allow for items such as an audio and video component rack 212 to be visibly exposed and accessible, or to allow the speakers 214 to be acoustically exposed to the enclosed space 203. As shown, the audio and video component rack 212 and the speakers 214 may be mounted directly to the wood studs 206 to suspend them in appropriate locations in the system 200. The television 208 is preferably slid into an opening 216 in the system 200 designed for it, so that the opening 216 may act also as entryway to the rear of the system 200 when service or maintenance of the various components are required.

Fabric retainers 192 are located along and frame the top, bottom, and side edges of the system 200, and also frame out any components, such as the television 208 and the component rack 212, that must be visible or accessible from the enclosed space 203. The fabric retainers 192 would normally stretch and retain a fabric across the area 218 surrounded by the retainers 192. Notably, this area 218 would include areas covering the cutouts 210 that acoustically expose the speakers 214. This is possible as long as the fabric is generally acoustically transparent. The net effect is thus that a very simple, aesthetically pleasing wall surface is presented, visibly broken only in one or two areas, to visibly expose the television 208 and the component rack 212. Many elements of a

standard home theater system, such as the speakers, wiring and most surfaces of the remaining components, can thus be hidden by the built-in wall system 200, to present a very professional, aesthetic installation.

It is contemplated that the built-in wall system 200 can be used alone without any further acoustical treatment systems in the space 203, and the acoustical and aesthetic characteristics of the space 203 can be advantageously effected. However, more preferably, additional treatment systems may be applied to adjacent exposed walls of the space 203, or even more preferably to all of the exposed walls of the space 203, and further advantageous effect may be had upon the acoustical and aesthetic characteristics of the space. It is also contemplated that acoustical wall treatments could be applied to the existing walls of space 203 behind the system 200, such as highly acoustically absorptive panels. It is further contemplated that, given the existing dimensions of a space 203 and a preferred seating location, that existing calculations known in the art could be used to optimize the location of the system 200 in the space, and thus the acoustics in the area of the preferred seating location.

FIG. 17 is a schematic top view of a second embodiment 300 of an acoustical built-in wall system of the present invention. In the embodiment of system 300, the partition wall 302 includes on either end thereof a wall portion 320 that is acutely angled with respect to a main portion 319 of the wall 302. Accordingly, the acoustical panels mounted on the wall portions 320 are acutely angled with respect to the acoustical panels mounted on the main portion 319 of the wall 302. This system 300 may be useful in spaces 303 in which no further acoustical wall treatment systems will be installed, such that the wall portions 320 eliminate two 90 degree corners of the space 303. Ninety degree corners having one or more untreated wall surfaces have been found to be particularly prone to distort sound image localizations due to interference patterns produced by sound wave reflections.

FIG. 18 is a schematic top view of a third embodiment 400 of an acoustical built-in wall system of the present invention. In system 400, the partition wall 402 does not extend completely across an end of the enclosed space 403. Instead, the wall 402 terminates short of the existing wall, such as masonry wall 204, and an end wall 422 extends behind the partition wall 402 to the end of the existing wall. The system 400 can thus be used where there is an object such as a door 205 or an electrical panel 207 that must normally be readily accessible in day-to-day or emergency situations. In addition, if

desired the end wall 422 may be formed as a movable or at least partially removable wall, such as by mounting the wall 422 on hinges or by fastening acoustical panels thereof to the wall 422 by some easily removable means, such as bolts or Velcro(tm). It can be advantageous for the wall 422 to be removable especially if a television 408 to be used with the system 400 is not a standalone model, such that it must be mounted to the partition wall 402 off of the floor.

As can be seen in FIGS. 19 and 20, the method and apparatus of the present invention is well-suited for retrofitting existing hollow doors. More specifically, many hollow interior doors comprise a frame member 152 that extends around the perimeter of the door 150. Attached to each side of the frame 152 are skin members 154. To incorporate the present method and apparatus into such a door to further enhance the acoustic characteristics of the enclosed space, one of the skins 154 is cut away along the inside perimeter of the frame 152. After one of the skins 154 is removed, a filler strip 156, preferably a common filler strip, is preferably attached to the inside of the frame 152 as shown. In a preferred embodiment, filler strip 156 is preferably attached to the inner surface of the skin 154 by a commercially available adhesive.

After the filler strip 156 has been installed, sections of fabric retainer 92 are attached around the inner perimeter of the frame 152. In a preferred embodiment, retainer 92 is attached to corresponding filler strips 156 by screws (not shown). After the fabric retainer 92 has been attached around the inner perimeter of the door frame 152, a panel (or panels) 40 is installed as shown in FIGS. 19 and 20. Preferably, the backing board 46 of the panel is attached to the intact skin 154 by commercially available adhesive. In a preferred embodiment, the acoustically absorptive surface 42 of the panel is arranged to face the interior of the room. Those of ordinary skill in the art will appreciate that other panels of the present invention may also be employed in the door 150 to provide a desired acoustical effect. After the panel(s) 40 have been installed, an acoustically transparent material, preferably fabric 158, is used to cover the panel(s) 40 and is attached to the fabric retainers 92 in the manner described above.

As is readily apparent from the foregoing description, the method and apparatus is well-suited for use with existing hollow doors or access panels for a room. However, the method and apparatus may also be advantageously used to fabricate new doors and access panels.

As evidenced by the test results in the following tables, the above-mentioned preferred method of installation provides a broad spectrum of acoustic absorption. The panels 40 that are arranged with their fibrous material facing the source of the sound effectively absorb higher frequency sound, while the panels with their backing boards facing the sound source absorb the lower frequency sounds. Thus, resulting in an arrangement which provides a broad range of absorption characteristics.

FIG. 21 is a chart that compares the transmission loss, a measure of acoustical absorption, of a panel 40 to the transmission loss of a panel 60. The results depicted in FIG. 21, were obtained by approved test methods in a certified acoustical test laboratory.

As can be seen from FIG. 21, the transmission loss for panels (40, 60) are relatively similar. FIG. 22, is a chart that compares the transmission loss of a panel 70 that is attached to a structure wall or ceiling with screws to the transmission loss that is experienced when the panel 70 is attached to a wall or ceiling structure utilizing adhesive.

FIG. 23 is a chart that compares the transmission losses of various wall components, including panels (40, 70).

To further evidence the random incidence sound absorption of a panel 40 with the fibrous material 48 facing the source of the sound, a test was performed in an empty room having an area of seventy-two square feet (6.689 square meters). The room was empty and had a temperature of 22.5°C and a relative humidity of 50.94%. Another test was conducted in a full room of the same area having a temperature of 22.67°C and a relative humidity of 50.35%. The results of those tests are as follows:

Frequency (Hz)	Full Room Absorption (Metric Sabines)	Percent Uncertainty	Empty Room Absorption (Metric Sabines)	Percent Uncertainty	Absorption Coefficients
100	5.683	6.137	5.385	4.391	0.04
125	6.115	5.380	5.663	3.088	0.07
160	6.438	4.990	5.868	2.251	0.09
200	6.176	4.471	5.266	2.550	0.14
250	6.500	4.507	5.124	2.134	0.21
315	7.466	4.368	5.125	1.675	0.35
400	8.854	4.454	5.553	1.274	0.49
500	9.941	4.466	5.780	1.418	0.62
630	11.245	4.384	6.005	1.116	0.78
800	12.103	4.245	6.645	1.044	0.82
1000	13.074	4.223	6.960	0.928	0.91
1250	14.042	4.255	7.619	0.890	0.96
1600	15.521	4.212	8.912	0.770	0.99

Frequency (Hz)	Full Room Absorption (Metric Sabines)	Percent Uncertainty	Empty Room Absorption (Metric Sabines)	Percent Uncertainty	Absorption Coefficients
2000	16.804	4.263	10.019	0.770	1.01
2500	17.660	4.245	11.228	0.960	0.96
3150	19.009	4.186	12.952	0.665	0.91
4000	21.173	4.169	15.623	0.604	0.83
5000	23.050	4.184	18.061	0.700	0.75
				Exact NRC	0.688
				NRC =	0.70
				Exact SAA	0.687
				SAA =	0.70

In another test, the rigid backing board 46 of a panel 40 was oriented to face the sound field in the above-mentioned room wherein the temperatures and humidities were as follows: empty room (22.56°C, 50.94%), full room (22.46°C, 50.35%). The results of

5 such test are as follows:

Frequency (Hz)	Full Room Absorption (Metric Sabines)	Percent Uncertainty	Empty Room Absorption (Metric Sabines)	Percent Uncertainty	Absorption Coefficients
100	6.921	7.253	5.385	4.391	0.23
125	8.481	6.211	5.663	3.088	0.42
160	8.561	5.191	5.868	2.251	0.40
200	6.282	4.770	5.266	2.550	0.15
250	5.969	4.594	5.124	2.134	0.13
315	5.744	4.351	5.125	1.675	0.09
400	5.824	4.277	5.553	1.274	0.04
500	6.080	4.309	5.780	1.418	0.04
630	6.287	4.199	6.005	1.116	0.04
800	6.905	4.293	6.645	1.044	0.04
1000	7.228	4.166	6.960	0.928	0.04
1250	7.806	4.232	7.619	0.890	0.03
1600	9.177	4.174	8.912	0.770	0.04
2000	10.190	4.169	10.019	0.770	0.03
2500	11.287	4.229	11.228	0.960	0.01
3150	12.909	4.188	12.952	0.665	0.00
4000	15.700	4.160	15.623	0.604	0.01
5000	18.266	4.171	18.061	0.700	0.03
				Exact NRC	0.060
				NRC =	0.05
				Exact SAA	0.057
				SAA =	0.05

Another test was conducted in the above-mentioned room wherein the foam material 64 of a preferred panel 60 faced the sound field. The temperatures and humidities were as follows: empty room (22.56°C, 50.94%), full room (22.66 °C, 50.35%). The results of such test are as follows:

Frequency (Hz)	Full Room Absorption (Metric Sabines)	Percent Uncertainty	Empty Room Absorption (Metric Sabines)	Percent Uncertainty	Absorption Coefficients
100	5.668	3.741	5.385	4.391	0.04
125	5.880	3.385	5.663	3.088	0.03
160	6.497	2.679	5.868	2.251	0.09
200	6.344	2.492	5.266	2.550	0.16
250	6.529	2.110	5.124	2.134	0.21
315	7.236	1.618	5.125	1.675	0.32
400	8.344	1.538	5.553	1.274	0.42
500	9.728	1.599	5.780	1.418	0.59
630	10.908	1.569	6.005	1.116	0.73
800	12.058	1.508	6.645	1.044	0.81
1000	12.686	1.090	6.960	0.928	0.86
1250	13.598	1.202	7.619	0.890	0.89
1600	14.731	0.982	8.912	0.770	0.87
2000	15.978	0.918	10.019	0.770	0.89
2500	17.257	0.923	11.228	0.960	0.90
3150	18.908	0.888	12.952	0.665	0.89
4000	21.625	0.841	15.623	0.604	0.90
5000	24.042	0.648	18.061	0.700	0.89
Exact NRC					0.638
NRC =					0.65
Exact SAA					0.638
SAA =					0.65

- 5 In another test, the rigid backing board 62 of the panel 60 was oriented to face the sound field in the above-mentioned room wherein the temperatures and humidities were as follows: empty room (22.56°C, 50.94%), full room (22.48°C, 50.35%). The results of such test are as follows:

Frequency (Hz)	Full Room Absorption (Metric Sabines)	Percent Uncertainty	Empty Room Absorption (Metric Sabines)	Percent Uncertainty	Absorption Coefficients
100	6.406	5.802	5.385	4.391	0.15
125	8.840	3.583	5.663	3.088	0.47
160	9.638	3.050	5.868	2.251	0.56
200	6.509	2.744	5.266	2.550	0.19
250	5.805	1.875	5.124	2.134	0.10
315	5.547	1.385	5.125	1.675	0.06

Frequency (Hz)	Full Room Absorption (Metric Sabines)	Percent Uncertainty	Empty Room Absorption (Metric Sabines)	Percent Uncertainty	Absorption Coefficients
400	5.946	1.269	5.553	1.274	0.06
500	6.138	1.196	5.780	1.418	0.05
630	6.529	1.076	6.005	1.116	0.08
800	7.116	1.195	6.645	1.044	0.07
1000	7.499	0.880	6.960	0.928	0.08
1250	8.042	1.193	7.619	0.890	0.06
1600	9.242	0.806	8.912	0.770	0.05
2000	10.327	0.814	10.019	0.770	0.05
2500	11.464	0.950	11.228	0.960	0.04
3150	13.171	0.743	12.952	0.665	0.03
4000	16.035	0.746	15.623	0.604	0.06
5000	18.610	0.692	18.061	0.700	0.08
Exact NRC					0.070
NRC =					0.05
Exact SAA					0.074
SAA =					0.05

As can be appreciated from the foregoing test results, the panels (40, 60) of the present invention have both acoustically reflective and acoustically absorptive characteristics that can be used in preferred methods of the present invention to acoustically tune or sound proof an enclosed area.

FIG. 24 is a chart that sets forth sound absorption coefficients of preferred panel 40 that is exposed to a source of sound at various frequencies. That chart includes the absorption coefficients for a panel that has its backing board facing the sound source and a panel that has its fibrous material facing the sound source. As can be seen from FIG. 24, with the fibrous material facing the sound source, the panel 40 exhibits good acoustical absorbency over the mid-range frequencies of between about 1000 and 4000 Hz. In the low range of frequencies, i.e., below about 300 Hz, the panel 40 is generally acoustically reflective with the fibrous material facing the sound source. Conversely, with the backing board facing the sound source, the panel 40 exhibits good acoustical absorbency over a range of the low range of frequencies, and is generally acoustically reflective over a range of the mid-range of frequencies. Accordingly, desired levels of acoustical absorbency and acoustical reflectivity over a wide range of frequencies can be designed into an acoustical room using the panels 40 in various arrangements of interior-facing surfaces.

FIG. 25 provides the same data for a preferred panel 60. The information provided in FIGS. 24 and 25 is also provided in the following tables:

Absorption Coefficients for a preferred panel 40

Frequency (Hz)	Backing board facing sound	Fibrous material facing sound
100	0.23	0.05
125	0.42	0.08
160	0.40	0.10
200	0.15	0.16
250	0.13	0.23
315	0.09	0.38
400	0.04	0.52
500	0.04	0.65
630	0.04	0.82
800	0.04	0.86
1000	0.04	0.96
1250	0.03	1.01
1600	0.04	1.04
2000	0.03	1.07
2500	0.01	1.02
3150	0.00	0.96
4000	0.01	0.89
5000	0.03	0.82

5

Absorption Coefficients for a Preferred Panel 60

Frequency (Hz)	Backing Board facing sound	Foam facing sound
100	0.15	0.04
125	0.47	0.03
160	0.56	0.09
200	0.19	0.16
250	0.10	0.21
315	0.06	0.32
400	0.06	0.42
500	0.05	0.59
630	0.08	0.73
800	0.07	0.81
1000	0.08	0.86
1250	0.06	0.89
1600	0.05	0.87
2000	0.05	0.89
2500	0.04	0.90
3150	0.03	0.89
4000	0.06	0.90
5000	0.08	0.89

FIG. 26 is a graph of the reverberation time in seconds vs. frequency in Hz before and after a particular room was treated with the acoustical wall treatment system shown in FIG. 14. The room had a volume of 3100 ft³ (88 m³), and is believed to have been at generally ambient conditions, i.e., about 70 degrees F (21 degrees C) and about 40-50 percent relative humidity. Before the acoustical wall treatment system of FIG. 14 was applied to the room, the walls of the room were finished, with all four walls having a painted drywall finish. As can be seen from FIG. 26, the reverberation times for many frequencies, especially frequencies in the mid-range of normal human hearing, i.e., 500 to 4000 Hz, were well outside the recommended decay range O. The recommended decay range O for the room was extrapolated from standard curves, such as disclosed by K.B. Ginn, MSc., in Architectural Acoustics, 2d edition, 1978, based upon the room volume and the desired type of test acoustics, which included human speech, music and movie special effects. In contrast, as shown in FIG. 26, the reverberation times for the room after the treatment system shown in FIG. 14 was installed were almost uniformly within the recommended decay range O for the mid-range frequencies. It should be noted that the extrapolation becomes less accurate for the lower low-range frequencies, i.e., less than about 150 Hz, for the particular room tested.

Figures 27 and 28 depict a preferred acoustical diffuser assembly 510 adapted for installation into a wall structure generally designated as 550. In a preferred embodiment, a diffuser assembly 510 comprises a support member 512 that has a bottom 514 and upstanding side walls 516. Support member 510 is preferably fabricated from a relatively rigid acoustically absorptive material such as fiberglass or open-celled melamine foam utilizing known vacuum forming or injection molding techniques. In this embodiment, a layer or septum of asphaltic material 520 is encapsulated within the acoustically absorptive material as shown in Figure 28. Those of ordinary skill in the art will appreciate that the layer 520 serves to add mass to the construction such that the assembly will more effectively obstruct the passage of sound through the wall. Preferably, the side walls 516 are formed at an angle (angle "X" in Figure 28) with respect to the bottom 514 that is greater than or equal to ninety degrees and preferably 120 degrees. Side walls 516 are integrally formed together to define a well, generally designated as 522. In addition, an attachment flange 526 is formed around the upper perimeter 524 of the support

member 510 to facilitate attachment to the existing wall structure 550 in a preferred manner discussed below.

In this embodiment, a diffuser panel 540, fabricated from acrylonitrile-butadiene-styrene resin or polyvinyl chloride, utilizing known vacuum forming or thermoforming techniques is sized to be received within the well 522 as shown in Figure 28. Diffuser panel 540, preferably has a planar bottom surface 542 and a plurality of upstanding columns 544 integrally formed with and extending from the planar bottom surface 542. Most preferably, a plurality of columns 544 with a random assortment of heights disposed relative to each other in a random fashion are provided. Preferably, at least one column 544 extends a distance above the bottom surface 542 that differs from the distance that at least one other column 544 extends from the planar bottom surface 542. In this embodiment, however, none of the columns 544 extends above the attachment flange 526 of the support member 510 when the bottom 542 is received on the bottom 514 of the support member 510 as shown in Figure 28. Preferably, each column 544 has a rectangular-shaped cross-section and a pyramidal shaped upper end 545. However, columns 544 could be provided in a variety of like or different cross-sectional shapes such as circles, squares, ovals, triangles, etc. and have flat, conical, etc. upper ends 545. In addition, those diffusers manufactured by RPG Diffusor Systems, Inc. of 651-C Commerce Drive, Upper Marlboro, MD 20774 under the trademarks Skyline, Abflector, HT DiffRACTal and Flutterfree could also be employed. The bottom 542 of the diffuser panel 540 is preferably attached to the bottom 514 of the support member 510 by means of a suitable commercially available adhesive such as a hot melt ethylene-vinyl acetate type of material. An acoustically transparent material 546 of the type described hereinabove is attached to the attachment flange 526 of the support member 510 preferably by a suitable commercially available sprayable contact adhesive such that it covers the diffuser panel 540.

Those of ordinary skill in the art will readily appreciate that the unique design of the diffuser assembly 510 enables it to be quickly and easily installed into a variety of structures and different settings. However, the diffuser assembly 510 is particularly well-suited for recessed installation in an existing wall or ceiling structure. The word "wall" as used herein refers to a variety of different similarly constructed structures including ceilings, portable partitions, etc. By way of example, wall structure 550 comprises a frame structure 552 fabricated from wood (or steel) studs 554 that are arranged in a

spaced-apart relationship as shown in Figure 28. The frame structure 552 has a pair of wall board-receiving sides 556 that have pieces of wall board (558, 560) attached thereto. The studs 554 and wall boards (558, 560) serve to define an enclosed cavity 562.

The diffuser panel assembly 510 is preferably installed in the wall structure 550 as follows. An opening is cut into wall board 558 which, for the purposes of this example, faces the direction of a source of sound (not shown). Support member 510 is sized such that it extends into the now exposed enclosed cavity 562 and portions of the attachment flange 526 of the support member 510 engage the studs 554. To create a flush installation, the attachment flange 526 preferably has a cross-sectional thickness that corresponds to the thickness of the wall boards (558, 560). The portions of the attachment flange 526 that contact the studs 554 are affixed thereto by commercially available drywall screws. However, other fasteners could also be successfully employed to affix the diffuser assembly 510 to the wall structure 550.

Figures 29 and 30 depict another preferred diffuser assembly 610 of the present invention installed in the wall structure 550. In this embodiment, diffuser assembly 610 is substantially identical to diffuser assembly 510 described above except for the following differences. In particular, as shown in Figure 29, at least one of the columns 644 of diffuser 640 extend above the top of the attachment flange 626 of the support member 612. Also, in this embodiment, reversible panels 40 (or 60) of the type and construction defined above are affixed to the wall boards (558, 560) in the manner described above such that they preferably overlap the attachment flange 626 of the support member 612, but do not cover the diffuser as shown in Figure 29. An acoustically transparent cover 646 of the type described above is stretched across the panels 40 and the diffuser assembly and affixed in position in a preferred manner described above.

Figures 31-33 depict another preferred diffuser assembly 710 of the present invention. As can be seen in those Figures, the diffuser assembly 710 includes a support member 712 that is preferably fabricated from an acoustically absorbent material such as fiberglass or open-celled melamine foam utilizing known molding or thermoforming techniques. Support member 712 has a bottom 714 and upstanding side walls 715 that are integrally formed therewith. In a preferred embodiment, the side walls 715 are formed at an angle with respect to the bottom 714 (represented by "Y" in Figure 32) that is greater than or equal to ninety degrees (preferably 120 degrees). An attachment flange 718 is formed around the upper perimeter 716 of the support member 712. The reader will

appreciate that the support member has a length "Z" and a width "Z'" at least one of which enables the support member 712 to be installed in an existing support wall 550 between studs 554. See Figure. 33.

In this preferred embodiment, a diffuser panel 730 is provided. Diffuser panel 730 is preferably fabricated from a thermoplastic material such as acrylonitrile-butadiene-styrene resin or polyvinyl chloride utilizing known vacuum forming or similar thermoforming techniques with a plurality of elongated columns 732 that extend for the length Z (or width Z') of the support member 712. As can be seen in Figure 32, each column has an upper surface 734 that is formed from two intersecting angled surfaces (736, 738). Preferably, when the diffuser panel 730 is received within the support member 712, at least one column 732 extends a distance T above the bottom of the support member 712 that differs from the distance T" between another column 732 and the bottom 714 of the support member 712. Preferably, the diffuser panel 710 is affixed within the support member 712 by a layer of asphaltic material 740. See Figure 31. As can be seen in Figure 32, the diffuser assembly 710 is well adapted to be installed into a wall structure 550 in the manner described hereinabove.

Figures 34 and 35 depict an exemplary arrangement of preferred diffuser assemblies (610 or 710) of the present invention installed in a portion of a residential entertainment room 900 that contains for example a television 902 and a viewing area 904. The reader will appreciate that the "viewing area" refers to an area where the individuals are typically located. As can be seen in those Figures, the diffuser assemblies of the present invention can be advantageously installed in opposing walls 906 in areas 908 adjacent the viewing area 904. However, a myriad of other installation arrangements can be successfully employed without departing from the spirit and scope of the present invention.

For example, Figures 36 and 37 depict the use of preferred diffuser assemblies (610 or 710) in a conventional suspended ceiling arrangement 920. The skilled artisan will appreciate that a conventional the suspended ceiling 920 comprises a plurality of support channels 922 that are suspended from an overhead structure (e.g., rafters, ceiling joists, etc.) 924 to define a space 930 therebetween and form a ceiling grid 926 that serves to support a plurality of commercially available ceiling or acoustical tiles 928 ceiling grid 926 serves to define a plurality of opening 932 which are adapted to receive a ceiling tile therein. Those of ordinary skill in the art will appreciate that the diffuser assemblies (610

or 710) can be employed in place of such tiles and advantageously located in the ceiling. See Figure 37. The assemblies can be covered with acoustically transparent fabric in the manner described above, or they can be installed without such material. It will also be appreciated that the diffuser assemblies (610 or 710) can be easily removed for cleaning
5 purposes. Furthermore, the acoustical wells of the assemblies serve to maintain the overall acoustical absorption properties of the ceiling system. The subject invention is particularly useful in applications where ceiling height is limited.

Those of ordinary skill in the art will appreciate that the rigid nature of the support members disclosed herein enable the present diffuser assemblies to be recessed into an
10 existing wall structure by removing a portion of a wall board without compromising the wall's structural integrity. The skilled artisan will also readily appreciate that the apparatuses and methods of the present invention can be successfully employed to create free standing portable wall panels that can be used to create an enclosed area that has desired acoustical characteristics.

15 Another preferred embodiment of the present invention is depicted in Figures 38-41. As can be seen in those Figures, a speaker housing 2010 of the present invention preferably comprises a support well 2012 that has a bottom 2014 and upstanding side walls 2016. Support well 2012 is preferably fabricated from a relatively rigid acoustically absorptive material such as high density fiberglass or open-celled melamine foam
20 utilizing appropriate known press molding, thermoforming or injection molding techniques. In this embodiment, a layer or septum 2018 is laminated between two layers (2015, 2017) of fiberglass or melamine foam as shown in Figure 41. The layers (2015, 2017) may each be approximately 0.25 inch thick. In a preferred embodiment, the septum 2018 comprises asphaltic material having a preferred thickness of 0.125 inch. However,
25 other materials such as butyl rubber or other readily thermoformed material, (including filled polymeric materials) may also be successfully employed. Also in this preferred embodiment, the location of the septum 2018 is preferably mid point between the layers 2015 and 2017. However, the location of the septum 2018 between the layers 2015 and 2017 may provided at other positions depending upon the specific acoustic application.
30 Those of ordinary skill in the art will appreciate that the layer 2018 serves to add mass to the construction such that the support well 2012 will more effectively obstruct the passage of sound through the rear wallboard. Preferably, the side walls 2016 are formed at an angle (X" in Figure 38) with respect to the bottom 2014 that is greater than or equal to

90° degrees and preferably 120°. Side walls 2016 are preferably integrally formed with the bottom 2014 to define a first well 2020. In addition, an attachment flange 2022 is preferably formed around the upper perimeter of the first support member 2012 to facilitate attachment to the existing wall structure as discussed below.

5 Also in this embodiment, a cover 2030 is employed as shown in Figure 38. Cover 2030 is preferably fabricated of the same materials that comprise the support member 2012. In particular, the cover 2030 has a planar support surface 2032 and integrally formed side walls 2034. A mounting flange 2035 is preferably formed around the upper perimeter of the side walls 2034. Cover 2030 may also be fabricated from a relatively
10 rigid acoustically absorptive material such as high density fiberglass or open-celled melamine foam utilizing known thermoforming, press molding or injection molding techniques. In this embodiment, a septum 2036 is molded between two layers (2037, 2039) of high density fiberglass or open-celled melamine foam. Septum 2036 may comprise an asphaltic material, butyl rubber or other readily thermoformed material. The
15 depth of the cover 2030 (represented by “Y” in Figure 38) can be made such that when the assembly 2010 is installed as shown in Figure 38, the cover 2030 is substantially flush with the surrounding wallboards.

 The cover 2030 may be attached to the support well 2012 preferably by use of a construction type adhesive (e.g., the type of adhesive sold under the trademark Liquid
20 Nails) and those members cooperate to form an enclosed cavity, generally designated as 2040. Molded fiberglass may also be attached with the adhesive to the cover assembly 2030 to facilitate improved attachment of the cover 2030 to the support well 2012 by the commercially available adhesive. An opening 2042, sized to accommodate at least a portion of the body 2046 of a speaker 2044, is provided through the cover 2030 as shown
25 in Figure 38. The speaker 2044 has a sound emitting surface 2048 and may be affixed to the cover 2030 in a conventional manner (i.e., screws, etc.).

 The housing 2010 can be installed in an existing wall or ceiling structure 2050 that consists of wallboards (2052, 2054) that are attached to wooden studs (2056, 2058) in a conventional manner. In the embodiment illustrated in Figure 38, the wallboard 2052
30 comprises a reversible panel 70 of the type and construction described above in connection with a piece of conventional drywall 2053. Wallboard 2054 may comprise, for example a conventional piece of drywall. Wallboards, (2052, 2054) cooperate with studs (2056, 2058) to define an enclosed cavity 2060 therebetween. To install the housing

assembly 2010 into such a wall or ceiling, a portion of the interior wall board 2054 is removed to permit the diffuser assembly 2010 to be inserted into the cavity 2060 between studs (2056, 2058). The well member 2012 then be inserted into the cavity 2060 such that portions of the flange 2022 are received on the studs (2056, 2058). The flange 2022 may then be affixed to the studs (2056, 2058), by conventional fasteners such as screws, nails etc. The skilled artisan will appreciate that the wires 2048 for supplying power to the speaker, may, if desired, extend through corresponding holes in the support well member 2012 such that they are completely concealed within the wall or ceiling 2050. It will be further appreciated that the outer surface of the wall 2050 that has the opening therein may be provided with an acoustically transparent member (not shown) to match the room's particular decor. Also, the outer facing surfaces of the well member 2012 and the cover 2030 may be covered with a commercially available glass mat facing material 2031 that has a preferred color. For example, that glass mat manufactured by Lydall Manning of Troy, New York under Model No. 1217 may be successfully attached to the outer surfaces of the well member 2012 and the cover member 2030 during the molding stage, using the available resinous material found in the molding media itself.

Another preferred housing assembly 3010 is depicted in Figures 42-44 and includes a support well member 2012' of a preferred construction described above. The support well 2012' has a bottom 2014' and upstanding sides 2016' integrally formed therewith; however the support well 2012' does not have an attachment flange formed around its upper perimeter. The support well 2012' may be advantageously incorporated into the wall 3050 that may comprise drywall boards (3052, 3054) that are attached to spaced-apart studs (3056, 3058). Boards (3052, 3054) and the studs (3056, 3058) cooperate to define a cavity 3070 therebetween. In this instance, the support well 2012' is installed prior to the installation of the drywall board 3052. The skilled artisan will appreciate that this type of installation would particularly suite new or remodeled construction projects where the entire wall structures are being assembled. The support well 2012' may be retained in position by use of construction adhesives, or mechanical fastening to the studs. To install a conventional speaker 3090, a hole 3080 corresponding to each speaker to be installed is cut in the drywall piece 3052 to permit a body portion 3092 of the speaker 3090 to be inserted therein as shown in Figure 42. The speaker 3090 is then attached to the drywall piece 3052 utilizing conventional techniques. The speaker wires 3094 may extend through corresponding apertures in the support well 2012'.

Another embodiment is disclosed in Figure 45. As can be seen in that Figure, a support well 2012 of the construction described above is employed. Those of ordinary skill in the art will appreciate that such arrangement is particularly well suited for installation into an existing wall or ceiling 4050 that have wallboards (4052, 4054) (i.e., drywall or the like) that are attached to a plurality of studs (4056, 4058). To install the support well 2012, a portion of the wallboard 4052 extending between studs (4056, 4058) is removed such that approximately one half of each stud 4056 and 4058 is exposed. The reader will appreciate that the size of the wallboard piece that is removed corresponds to the size of the support well 2012. Thereafter, the support well 2012 is inserted into the cavity 4070 between the studs (4056, 4058). The attachment flange 2022 of the support well 2012 is attached to the studs (4056, 4058) in the above discussed manner. A cover assembly 4030, preferably fabricated from a piece of conventional drywall 4032 that has a molded fiberglass layer 4034 bonded thereto is used to enclose the support well 2012 in the cavity 4070. In a preferred embodiment, the molded fiberglass layer manufactured using similar techniques to those described earlier may be employed. The molded fiberglass 4034 may be attached to the drywall piece 4032 by, for example, use of construction adhesive such as Liquid Nails. The fiberglass and adhesive serve to facilitate attachment of the cover assembly 4030 to the support member 2012. The cover assembly 4030 may also be retained in position by conventional drywall screws that extend into the studs (4056, 4058) and which may be concealed in a known manner. After the cover assembly 4030 has been attached to the studs (4056, 4058), a hole 4080 is cut in the cover assembly 4030 to receive a portion of a conventional speaker body 4092 therein. The speaker 4090 is attached to the cover assembly 4030 utilizing conventional mounting techniques such that the speaker body portion 4092 is received within the cavity 4082 defined by the well member 2012 and the cover assembly 4030.

As such, the present invention provides numerous advantages over other acoustical housings that have been adapted for use with speakers. In particular, the present acoustical housing assemblies can be constructed to support a wide variety and number of speakers. Also, the housing assemblies can be molded utilizing conventional forming techniques to accommodate a myriad of different speaker configurations. The subject invention also avoids the resonance issues that often arise when a conventional speaker is simply mounted in a wall. The skilled artisan will also appreciate that the septum employed in the speaker wells of the present invention substantially overcomes

the loss of sound transmission that might otherwise occur due to removal a portion of the wallboard. Furthermore, the unique and novel design of the present invention makes it well-suited for use in connection with wood or steel stud cavity type walls or ceilings.

5 The present methods of supporting speakers in walls and ceilings enable a speaker or speakers to be preassembled before installation to ensure a precise fit. Also, the housing assemblies of the present invention can be manufactured for installation into existing wall and/or ceiling structures without compromising the structural integrity of such structures and without use of additional structural supports or braces. The present invention is equally well-suited for use in new and remodeled construction in residential
10 and commercial applications. While the subject invention represents an improvement over prior methods and apparatuses for supporting speakers and similar components, etc., it will be understood, however, that various changes in the details, materials and arrangements of parts which have been herein described and illustrated in order to explain the nature of the invention may be made by those skilled in the art within the principle
15 and scope of the invention as expressed in the appended claims.

WHAT IS CLAIMED IS:

1. Apparatus for supporting a speaker having a body portion, said apparatus comprising:

a support well; and

a cover arranged in confronting relationship with said support well to form an enclosed cavity, said cover having an opening therethrough sized such that at least a portion of the speaker body is received within said enclosed cavity.

2. The apparatus of claim 1 wherein said support well is fabricated from a moldable material selected from the group consisting essentially of fiberglass and open-celled melamine foam.

3. The apparatus of claim 2 wherein said support well comprises:

a first moldable layer of material;

a second moldable layer of material; and

a septum laminated between said first and second layers of material.

4. The apparatus of claim 3 wherein said septum comprises a material selected from the group consisting essentially of asphalt, butyl rubber, and filled polymeric material.

5. The apparatus of claim 1 wherein said support well has a first bottom and first side walls integrally formed with said first bottom.

6. The apparatus of claim 5 wherein said side walls are each formed at an angle greater than or equal to ninety degrees with respect to said first bottom.

7. The apparatus of claim 1 further comprising a first attachment flange formed around a perimeter of said support well.

8. The apparatus of claim 1 wherein said cover is fabricated from a moldable material selected from the group consisting essentially of fiberglass and open-celled melamine foam.
9. The apparatus of claim 1 wherein said cover is non-planar.
10. The apparatus of claim 9 wherein said cover comprises a second bottom portion and second walls integrally formed with said second bottom portion, said second walls and said second bottom portion of said diffuser assembly cooperating with said first walls and said first bottom of said support well to form said enclosed cavity for receiving at least a portion of the speaker body therein.
11. The apparatus of claim 7 wherein said cover has a second attachment flange around a perimeter thereof for confronting contact with said first attachment flange of said support well.
12. The apparatus of claim 1 further comprising a fiberglass mat material affixed to at least a portion of an exposed side of said cover.
13. The apparatus of claim 1 wherein said support well is sized to be received between at least two wall studs.
14. Apparatus for supporting a speaker having a body portion, said apparatus comprising:
 - a support well; and
 - a planar cover arranged in confronting relationship with said support well to form an enclosed cavity therebetween, said cover having an opening therethrough sized such that at least a portion of the speaker body is received within said enclosed cavity.
15. The apparatus of claim 14 wherein said support well is fabricated from a moldable material selected from the group consisting essentially of fiberglass and open-celled melamine foam.

16. The apparatus of claim 15 wherein said support well comprises:
a first moldable layer of material;
a second moldable layer of material; and
a septum laminated between said first and second layers of material.

17. The apparatus of claim 16 wherein said septum comprises a material selected from the group consisting essentially of: asphalt, butyl rubber, and filled polymeric material.

18. The apparatus of claim 14 wherein said support well has a first bottom and first side walls integrally formed with said first bottom.

19. The apparatus of claim 18 wherein said side walls are each formed at an angle greater than or equal to ninety degrees with respect to said first bottom.

20. The apparatus of claim 14 wherein said cover comprises a piece of drywall board.

21. The apparatus of claim 20 wherein said drywall board has a piece of molded fiberglass skin bonded thereto.

22. Apparatus for supporting a speaker having a body portion, said apparatus comprising:

a support well fabricated from a first layer of moldable material and a second layer of moldable material with a septum material laminated therebetween, said support well having a first bottom and side walls integrally formed with said first bottom and an attachment flanged extending around a perimeter thereof; and

a cover arranged in confronting relationship with said support well to form an enclosed cavity, said cover having a second bottom portion and second wall integrally formed with the second bottom portion and a second attachment flange for confronting contact with said first attachment flange of said support well and said cover having an

opening therethrough sized such that at least a portion of the speaker body is received within said enclosed cavity.

23. Apparatus for supporting a speaker having a body portion, said apparatus comprising:

a support well fabricated from a first layer of moldable material and a second layer of moldable material with a septum material laminated therebetween, said support well having a first bottom and side walls integrally formed with said first bottom and an attachment flanged extending around a perimeter thereof; and

a cover arranged in confronting relationship with said support well to form an enclosed cavity, said cover comprising a drywall board and having an opening therethrough sized such that at least a portion of the speaker body extends through said opening into said cavity.

24. Apparatus for supporting a speaker having a body portion, said apparatus comprising:

a support well fabricated from a first layer of moldable material and a second layer of moldable material with a septum material laminated therebetween, said support well having a first bottom and side walls integrally formed with said first bottom and an attachment flanged extending around a perimeter thereof; and

a cover arranged in confronting relationship with said support well to form an enclosed cavity, said cover comprising a drywall board having a fiberglass skin bonded thereto and having an opening therethrough sized such that at least a portion of the speaker body extends through the opening into said cavity.

25. A method for installing at least one speaker having a body portion and a sound emitting surface into a wall structure having two spaced-apart wall boards and fastened to a stud assembly located between the wall boards to define an enclosed cavity therebetween, said method comprising:

removing at least a portion of one of said wall boards to expose at least a portion of said enclosed cavity;

inserting a support well formed from an acoustically absorptive material into said exposed portion of said enclosed cavity;
affixing said support well to at least one stud;
covering said support well with a cover to form a speaker well therebetween;
providing an opening in said cover sized to receive at least a portion of the speaker body therein; and
inserting said at least a portion of said speaker body through said opening and into said speaker well.

26. A wall structure, comprising:
a wall frame including at least two spaced-apart studs;
first and second wall boards affixed to said wall frame such that said first and second wallboards define at least one cavity between at least two said spaced-apart studs;
at least one support well sized to be received in a corresponding said cavity and attached to at least one said stud; and
a cover arranged in confronting relationship with each said support well to form an enclosed speaker well for receiving a portion of a speaker body therein.

27. The wall structure of claim 26 wherein at least one support well is fabricated from a moldable material selected from the group consisting essentially of fiberglass and open-celled melamine foam.

28. The wall structure of claim 27 wherein at least one said support well comprises:
a first moldable layer of material;
a second moldable layer of material; and
a septum laminated between said first and second layers of material.

29. The wall structure of claim 28 wherein said septum comprises a material selected from the group consisting essentially of: asphalt, butyl rubber, and filled polymeric material.

30. The wall structure of claim 26 wherein at least one said support well has a first bottom and first side walls integrally formed with said first bottom.

31. The wall structure of claim 30 wherein said side walls of at least one said support well are each formed at an angle greater than or equal to ninety degrees with respect to said first bottom of said support well.

32. The wall structure of claim 26 further comprising a first attachment flange formed around a perimeter of at least one said support well.

33. The wall structure of claim 26 wherein at least one said cover is fabricated from a moldable material selected from the group consisting essentially of fiberglass and open-celled melamine foam.

34. The wall structure of claim 26 wherein at least one said cover is non-planar.

35. The wall structure of claim 32 wherein at least one said cover has a second attachment flange around a perimeter thereof for confronting engagement with said first attachment flange of said support well.

36. The wall structure of claim 26 further comprising a fiberglass mat material affixed to at least a portion of an exposed side of at least one said cover.

37. The wall structure of claim 26 wherein at least one said cover comprises a piece of drywall.

38. The wall structure of claim 37 further comprising a piece of fiberglass mat bonded to said piece of drywall.

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FIG. 1

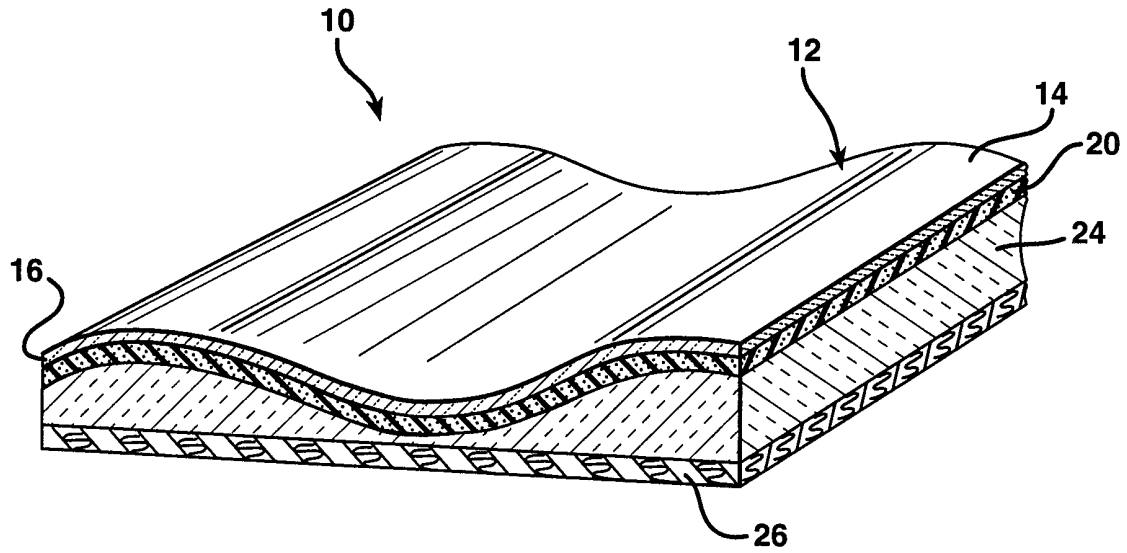
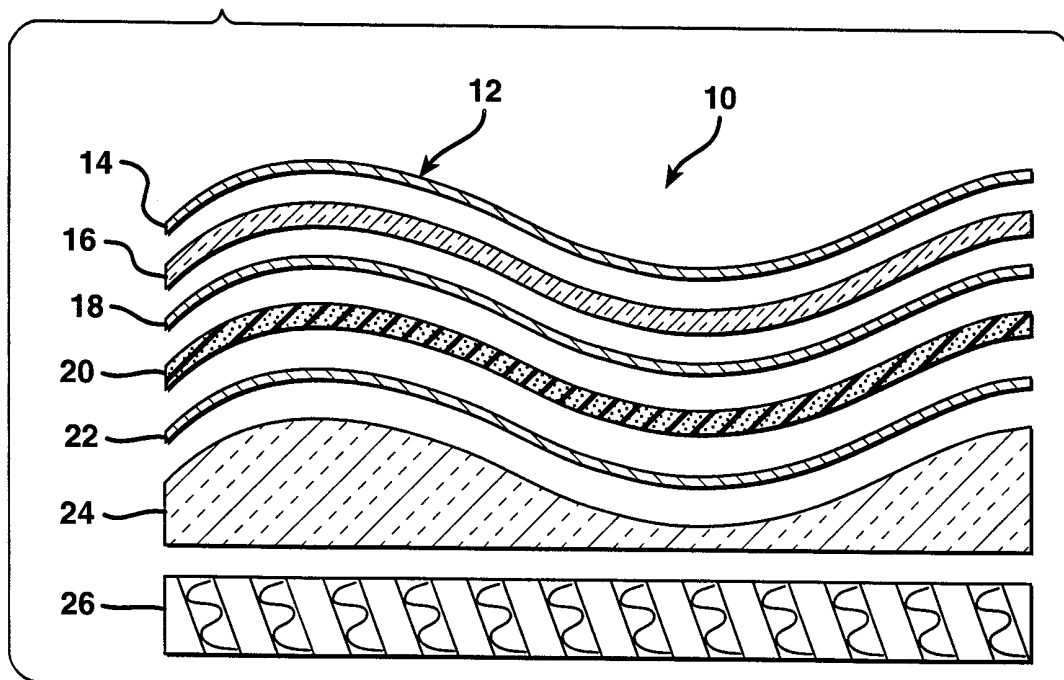


FIG. 2



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FIG. 3

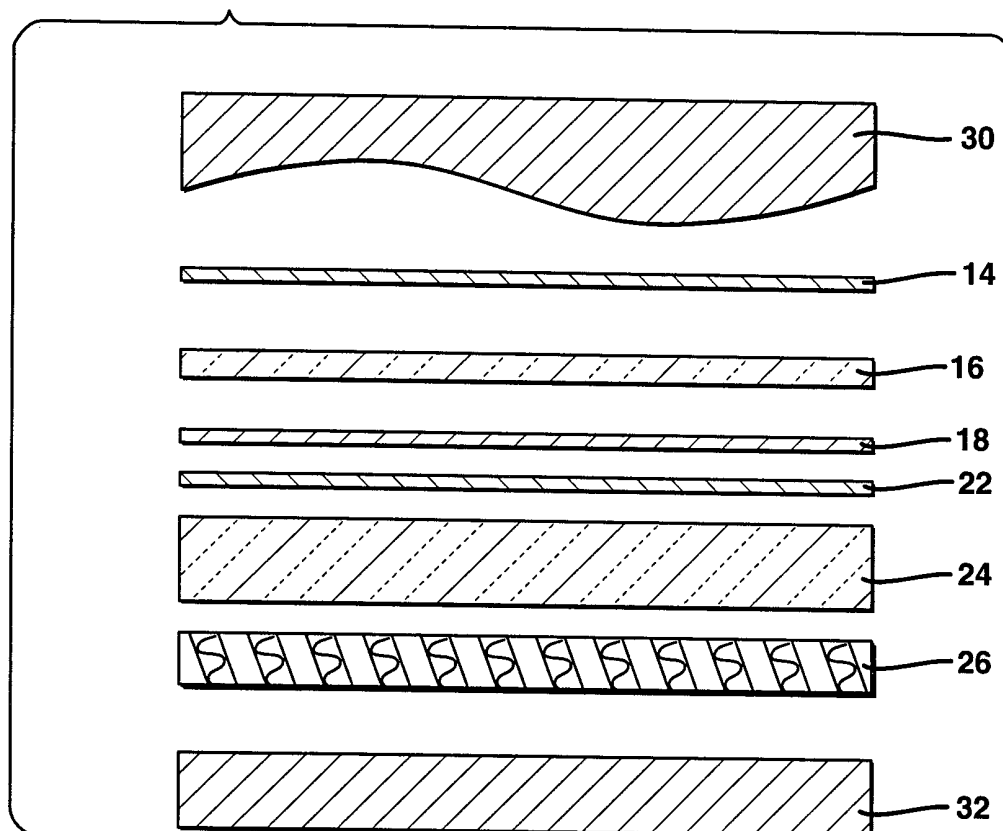
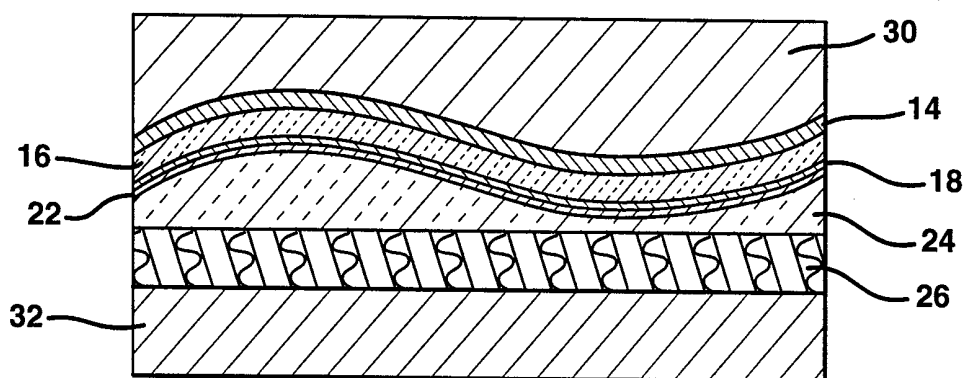


FIG. 4



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FIG. 5

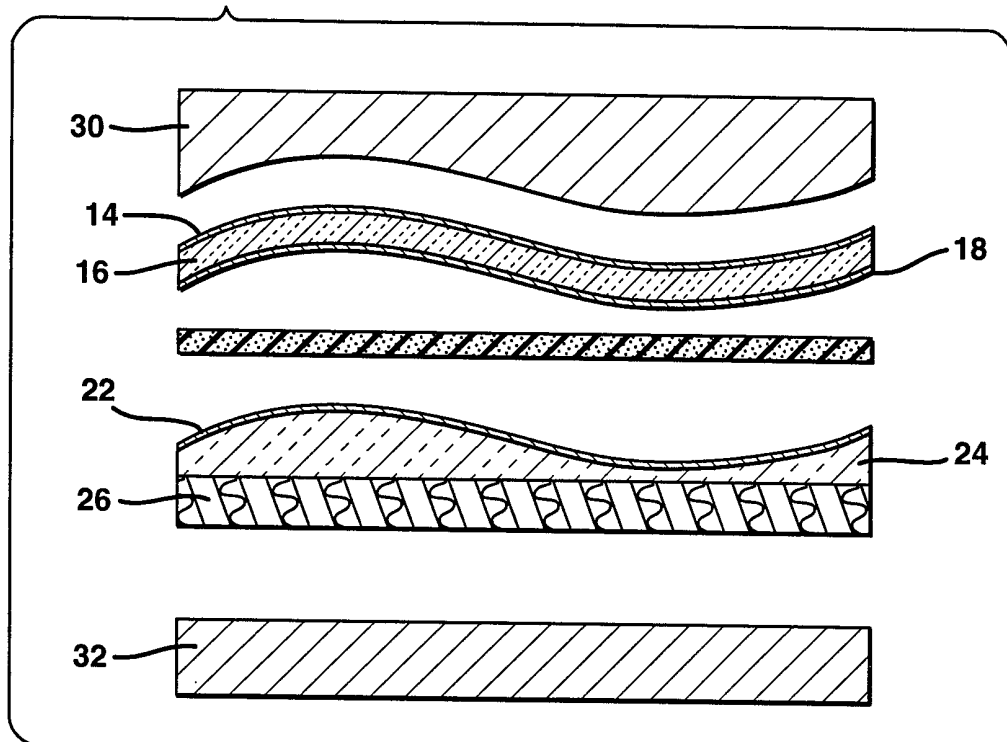
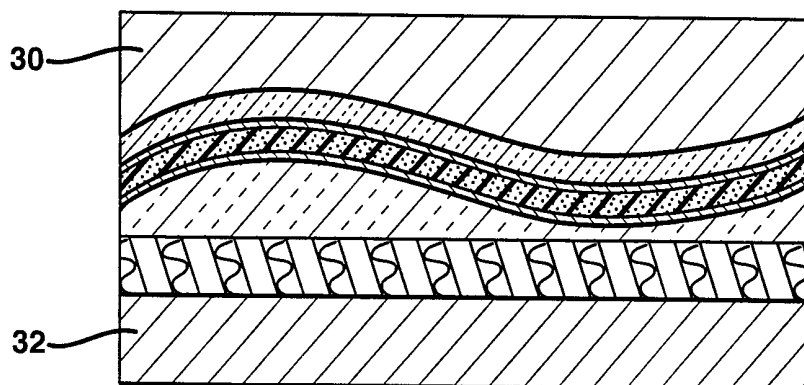


FIG. 6



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FIG. 7

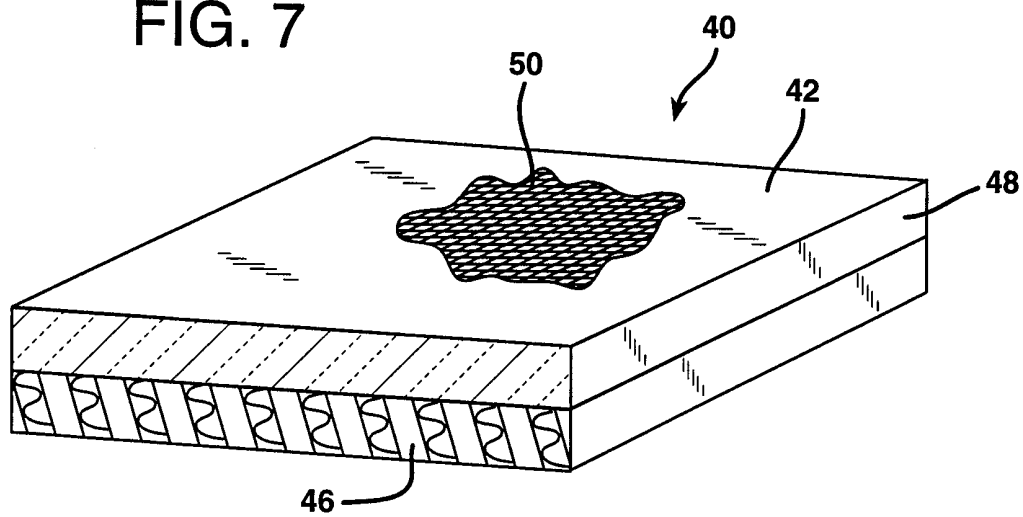
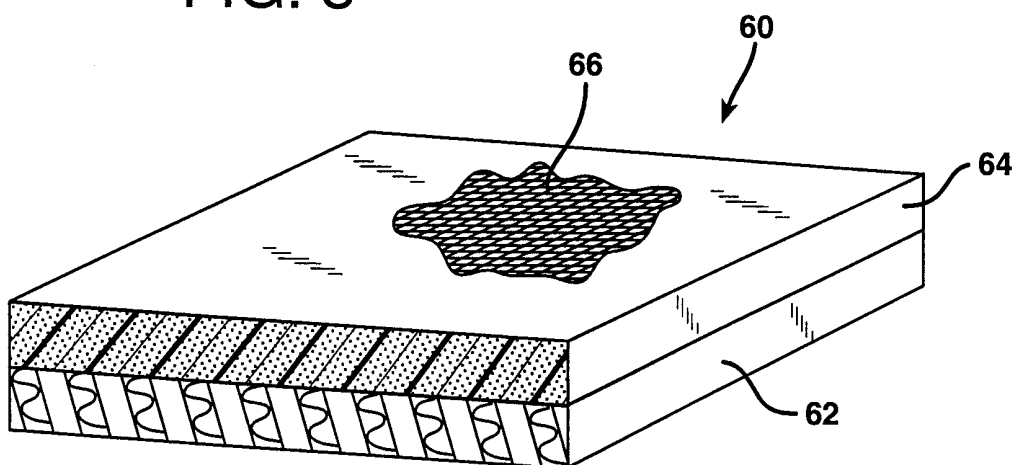


FIG. 8



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FIG. 9

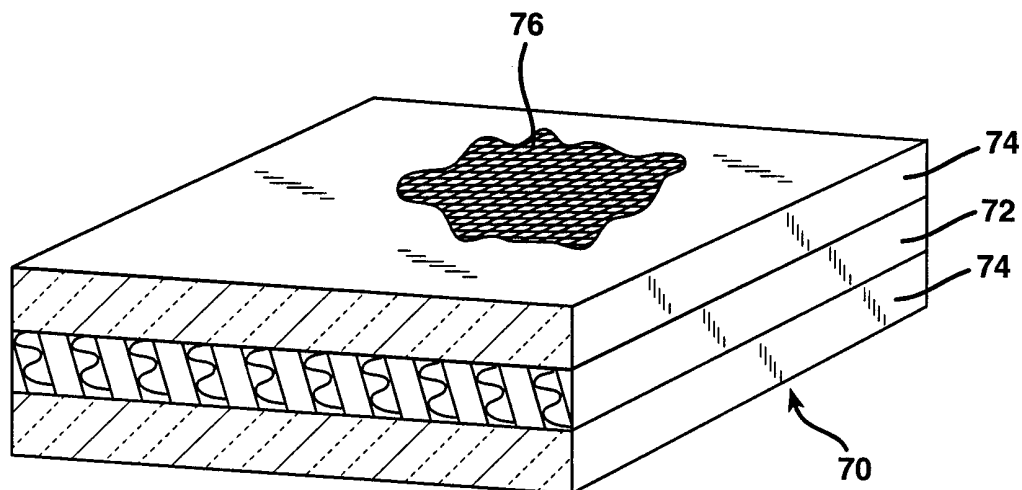


FIG. 10

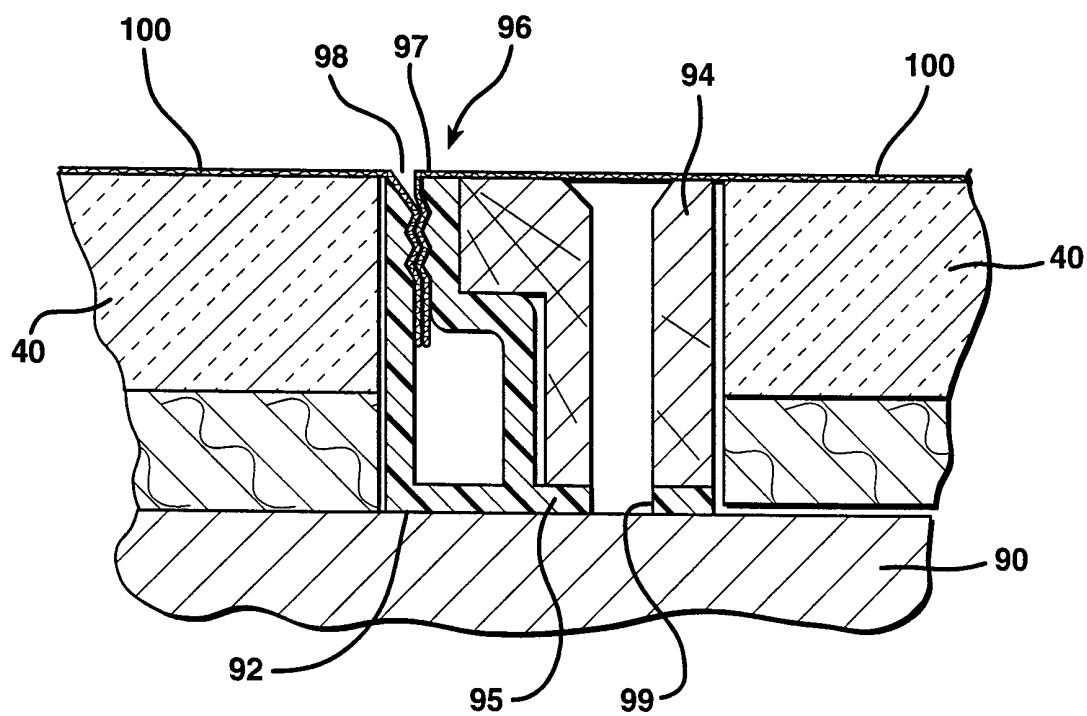


FIG. 11

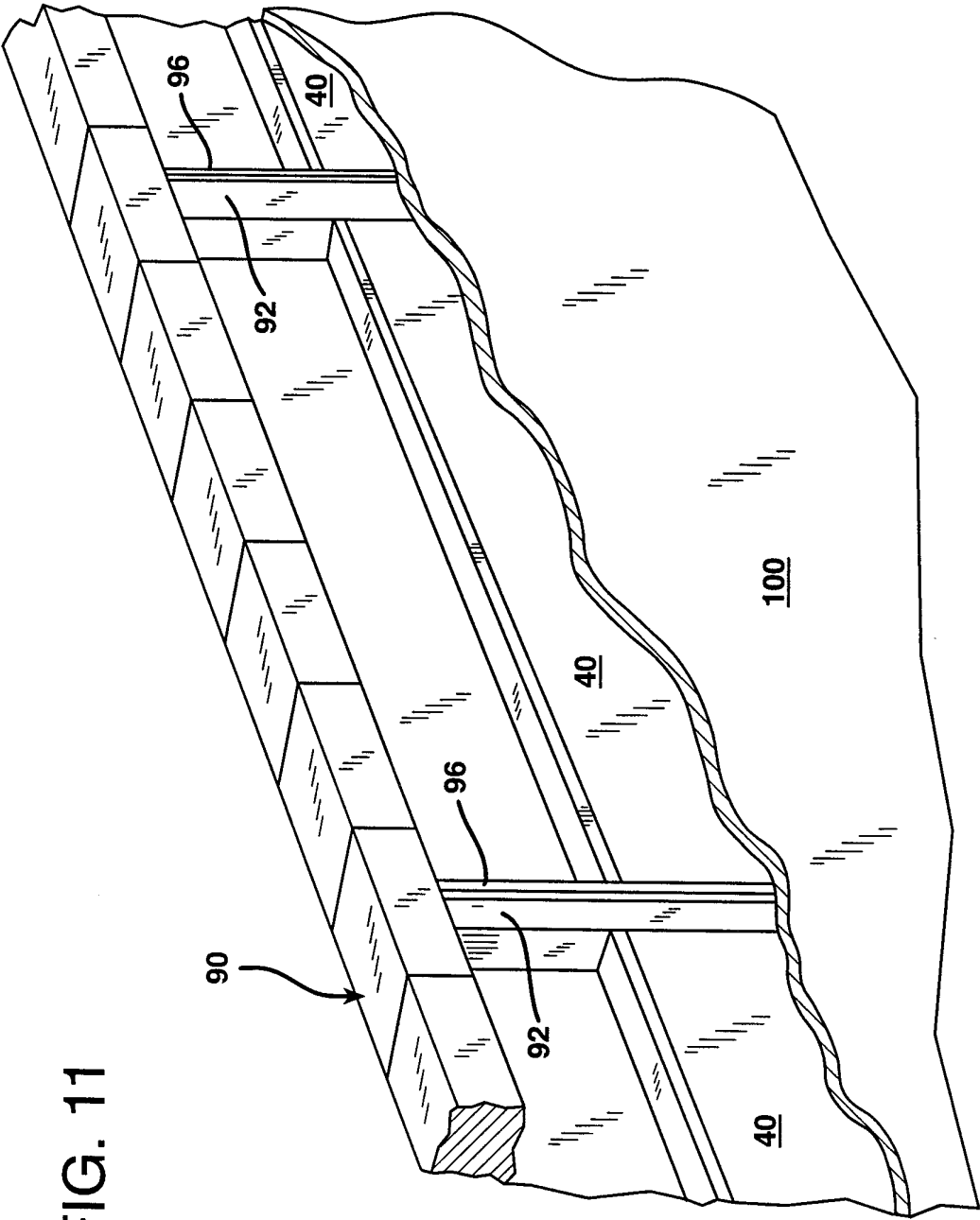
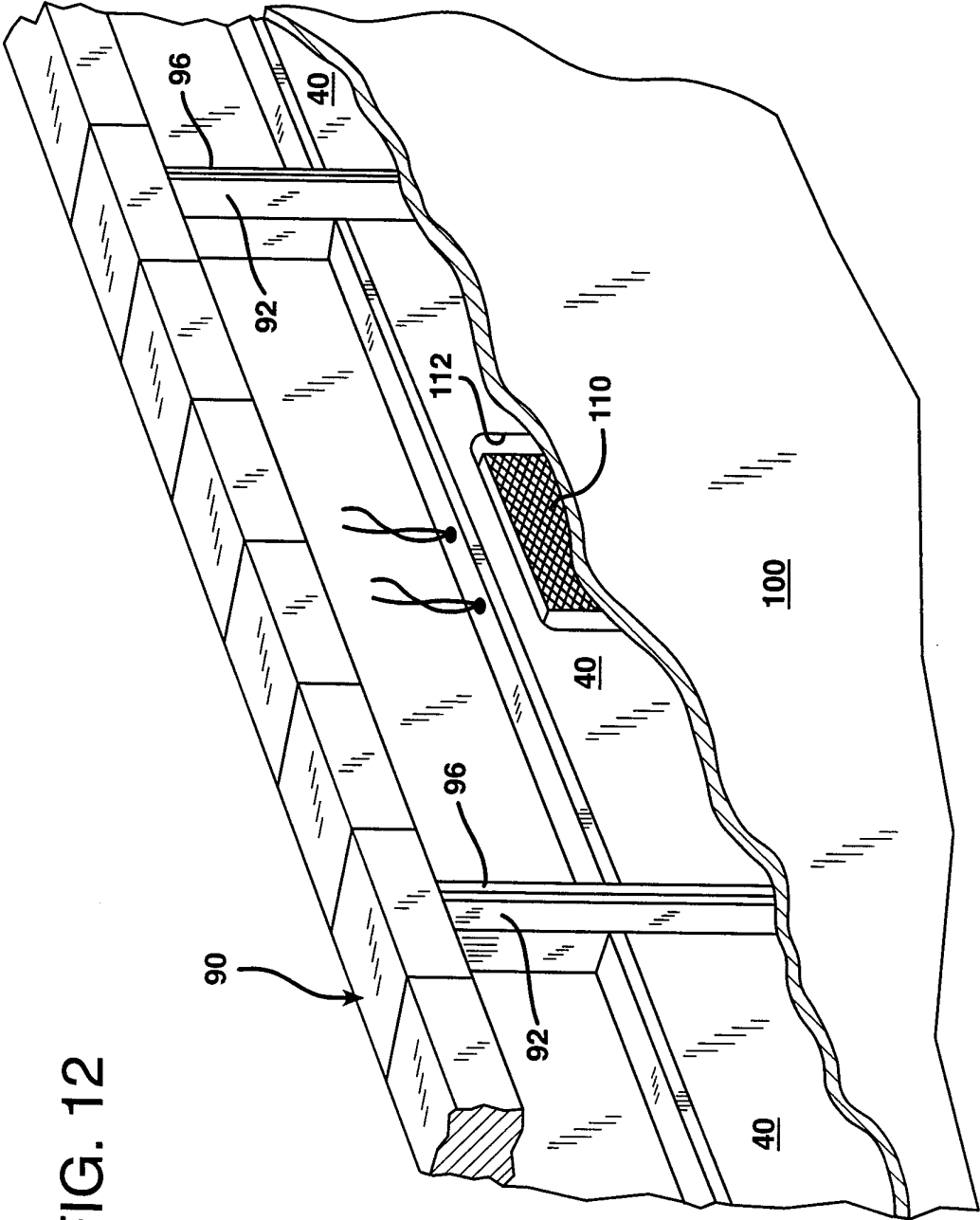
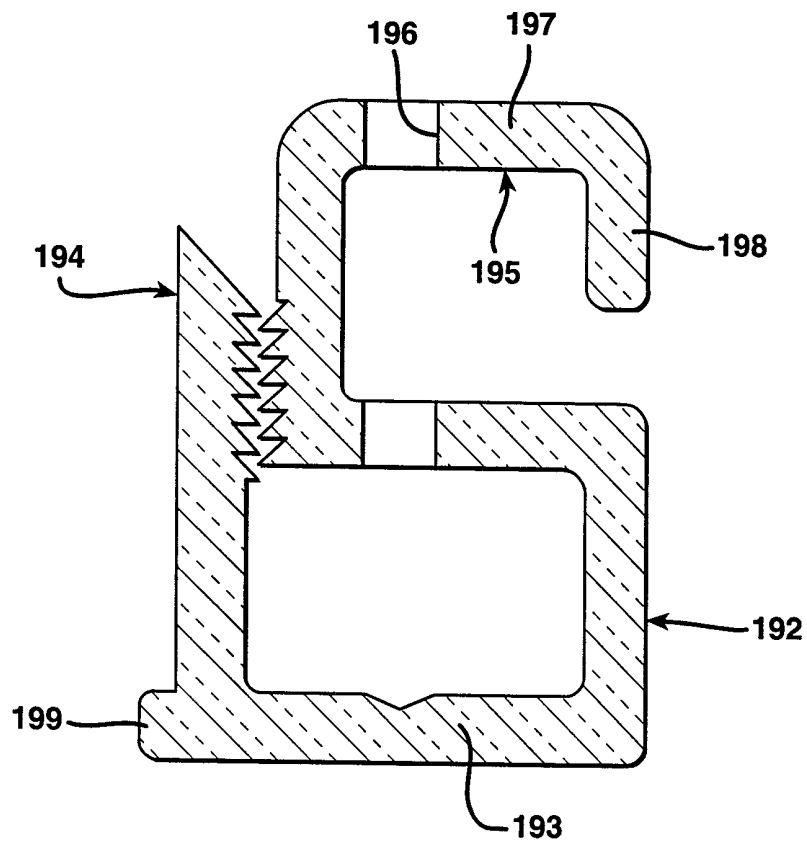


FIG. 12



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FIG. 13



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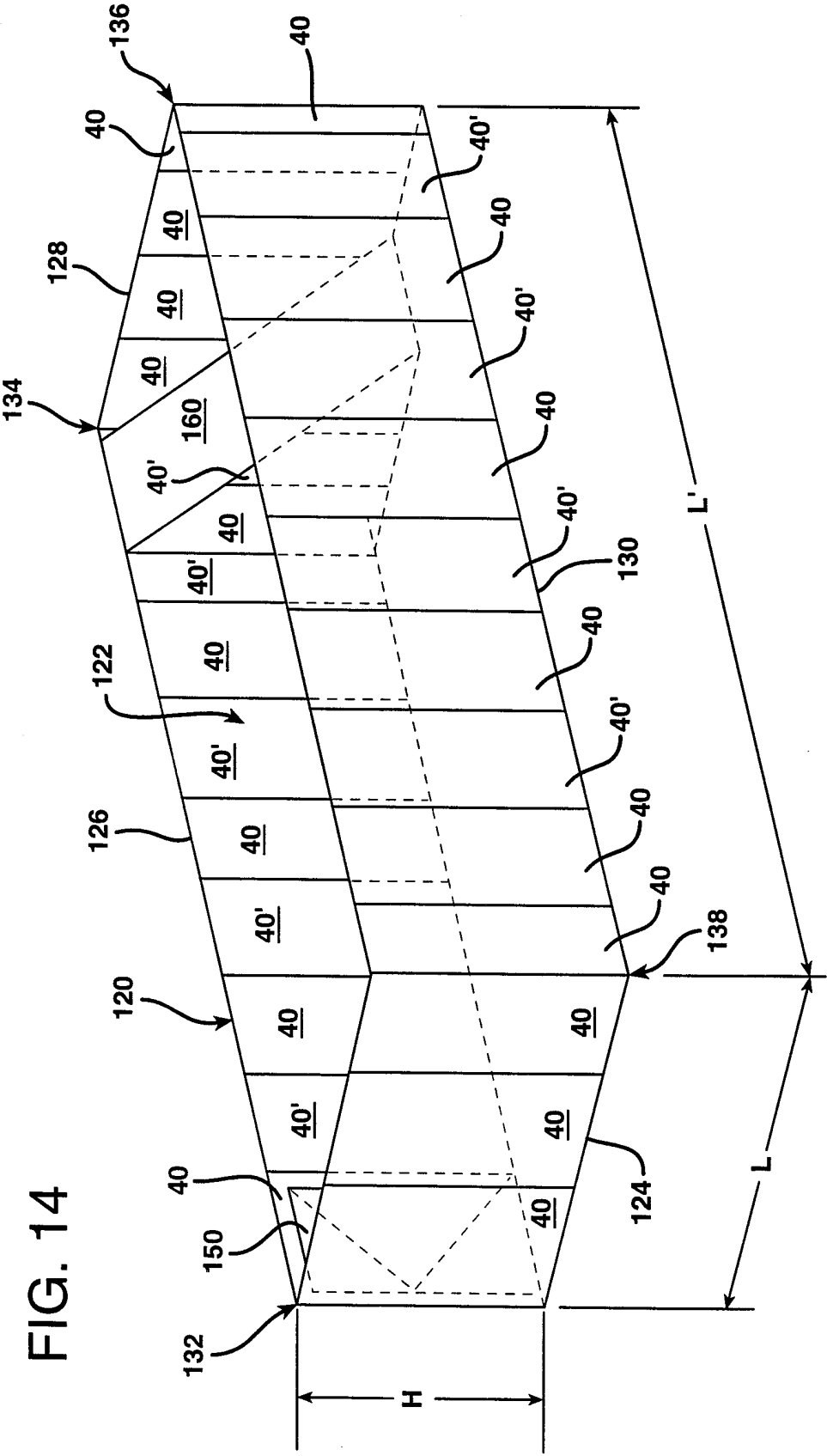
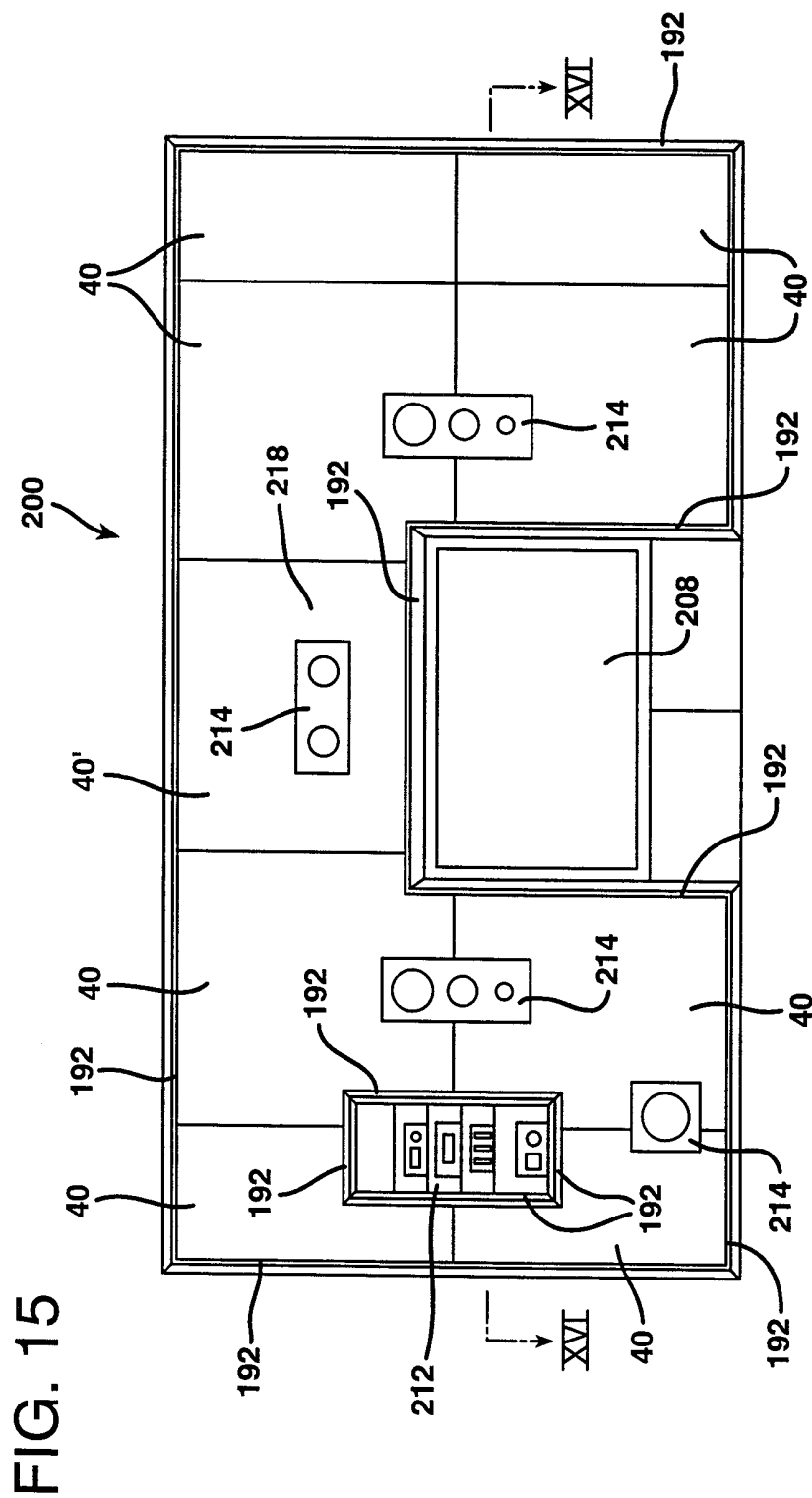
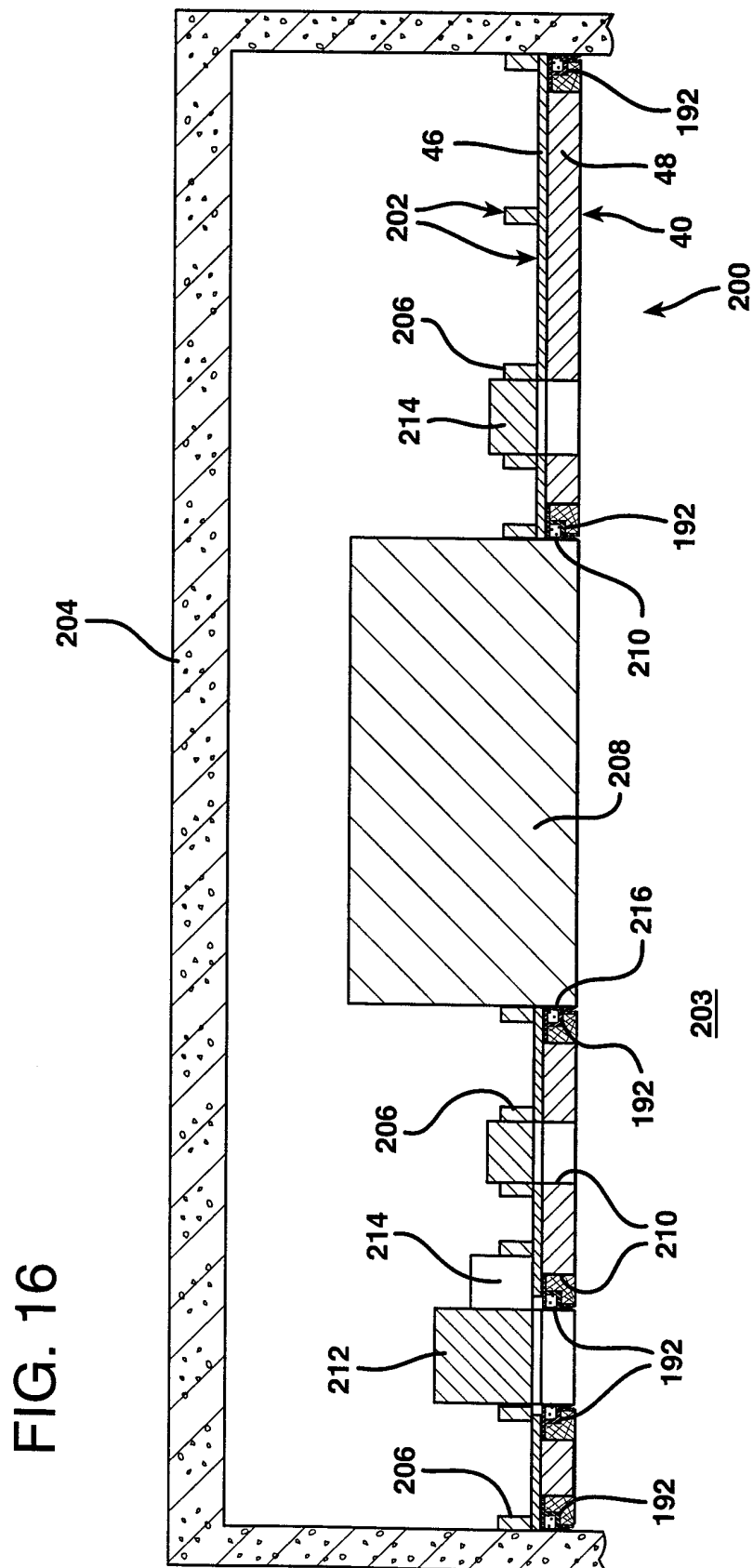


FIG. 14

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FIG. 17

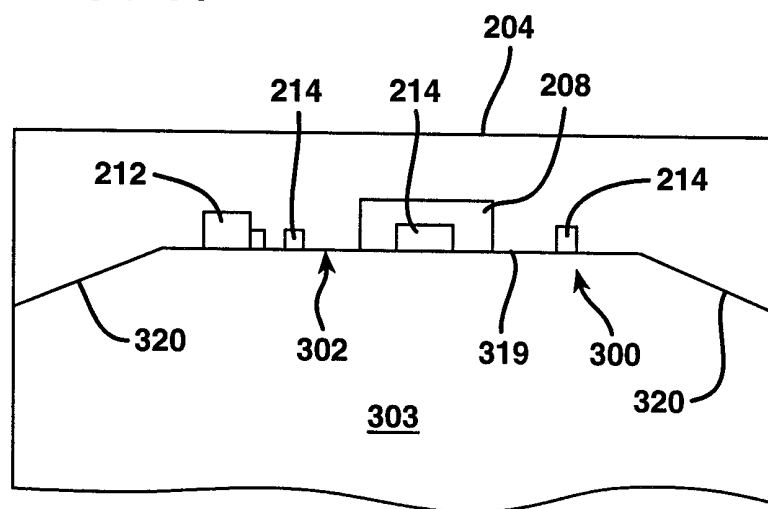
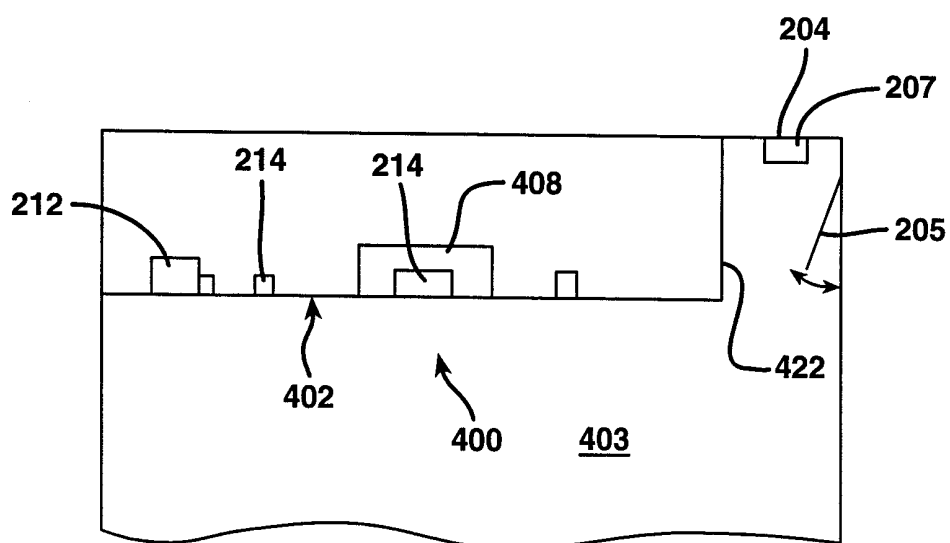


FIG. 18



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FIG. 19

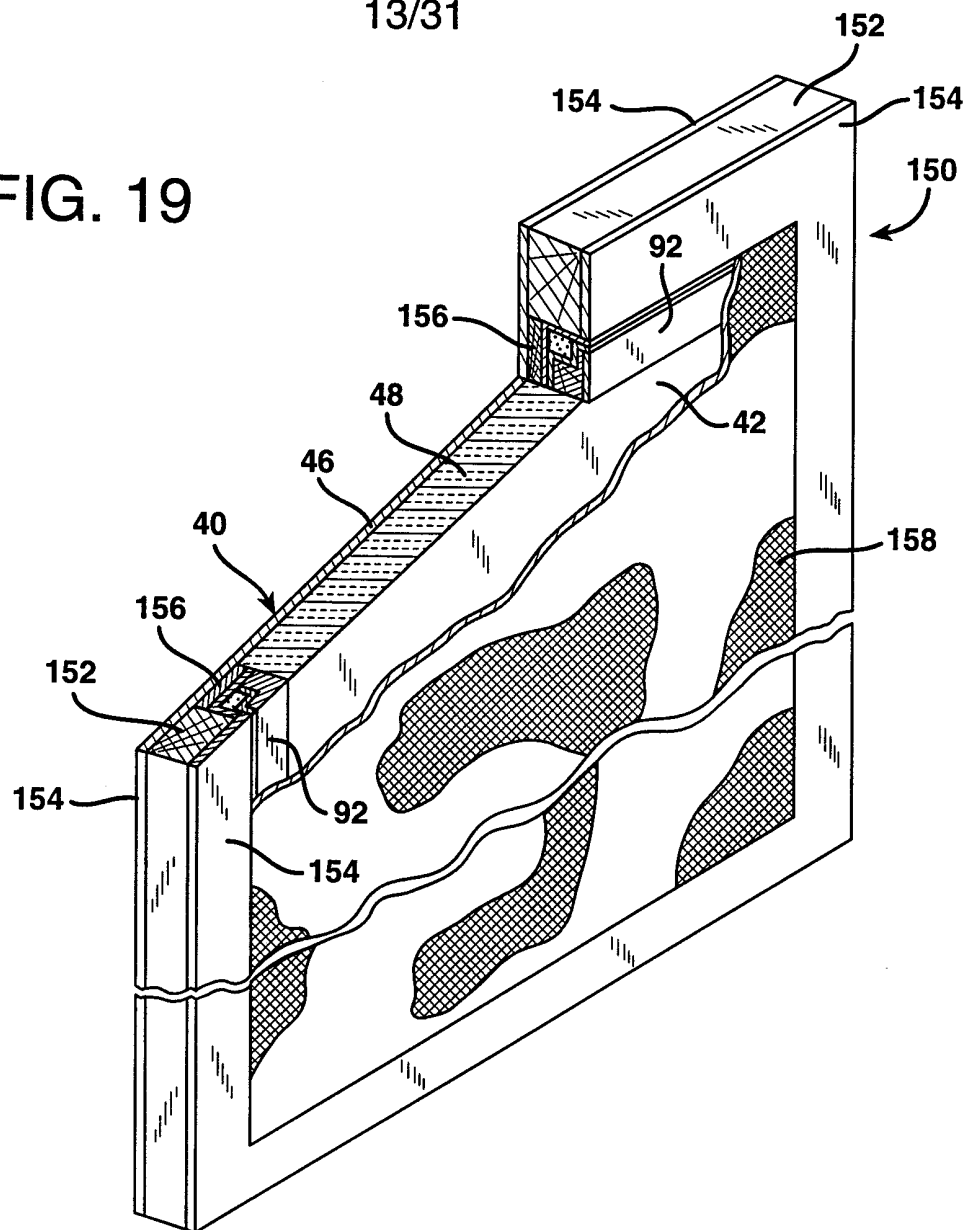
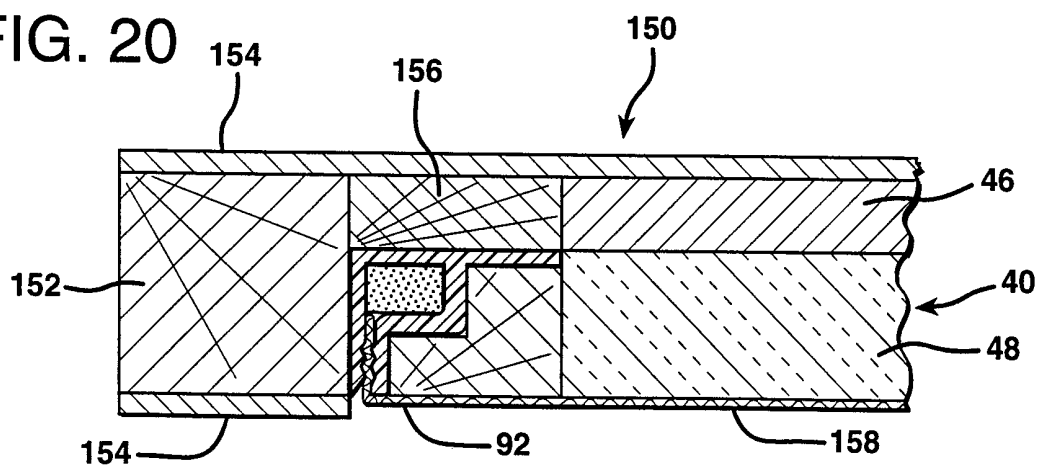
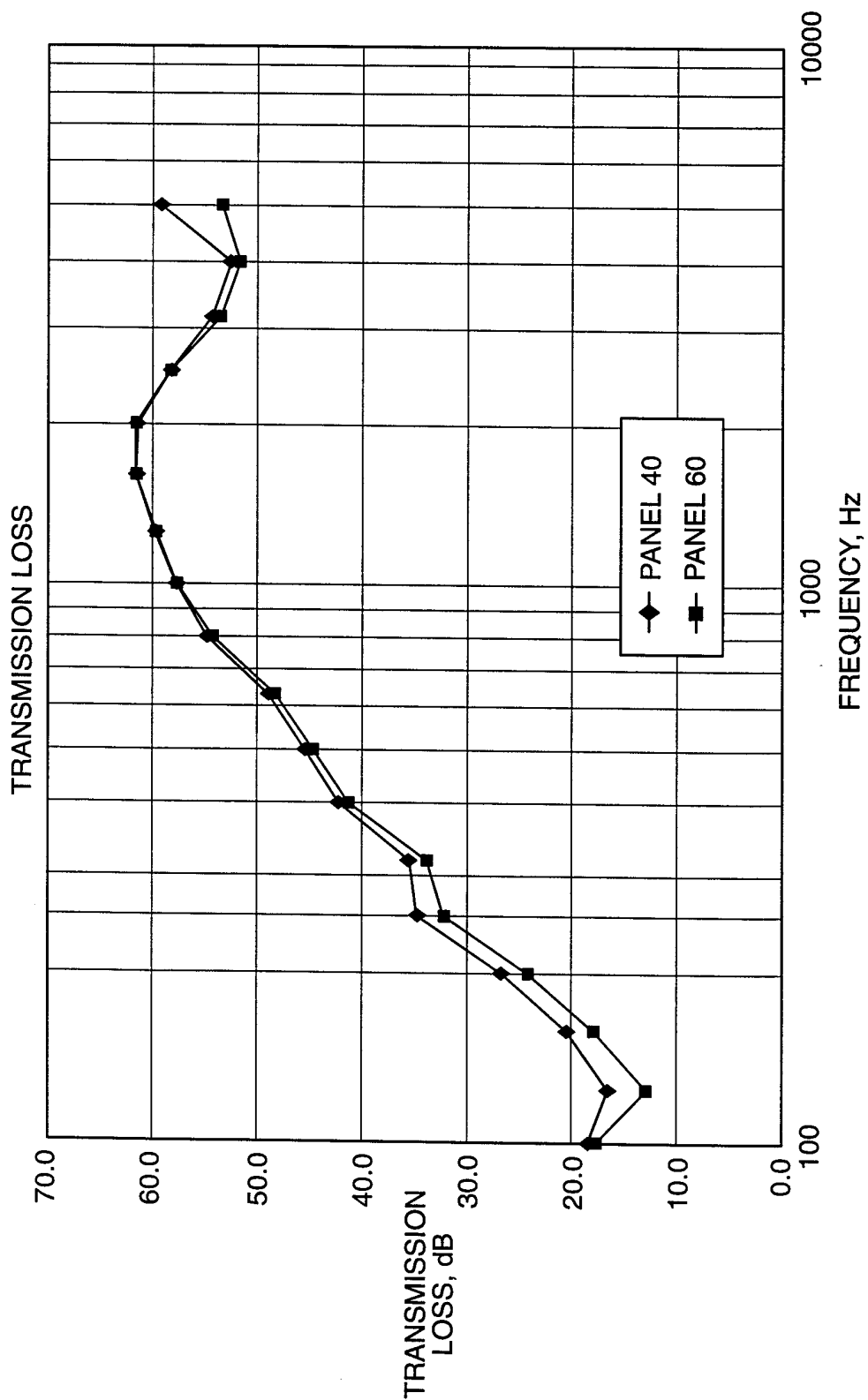


FIG. 20

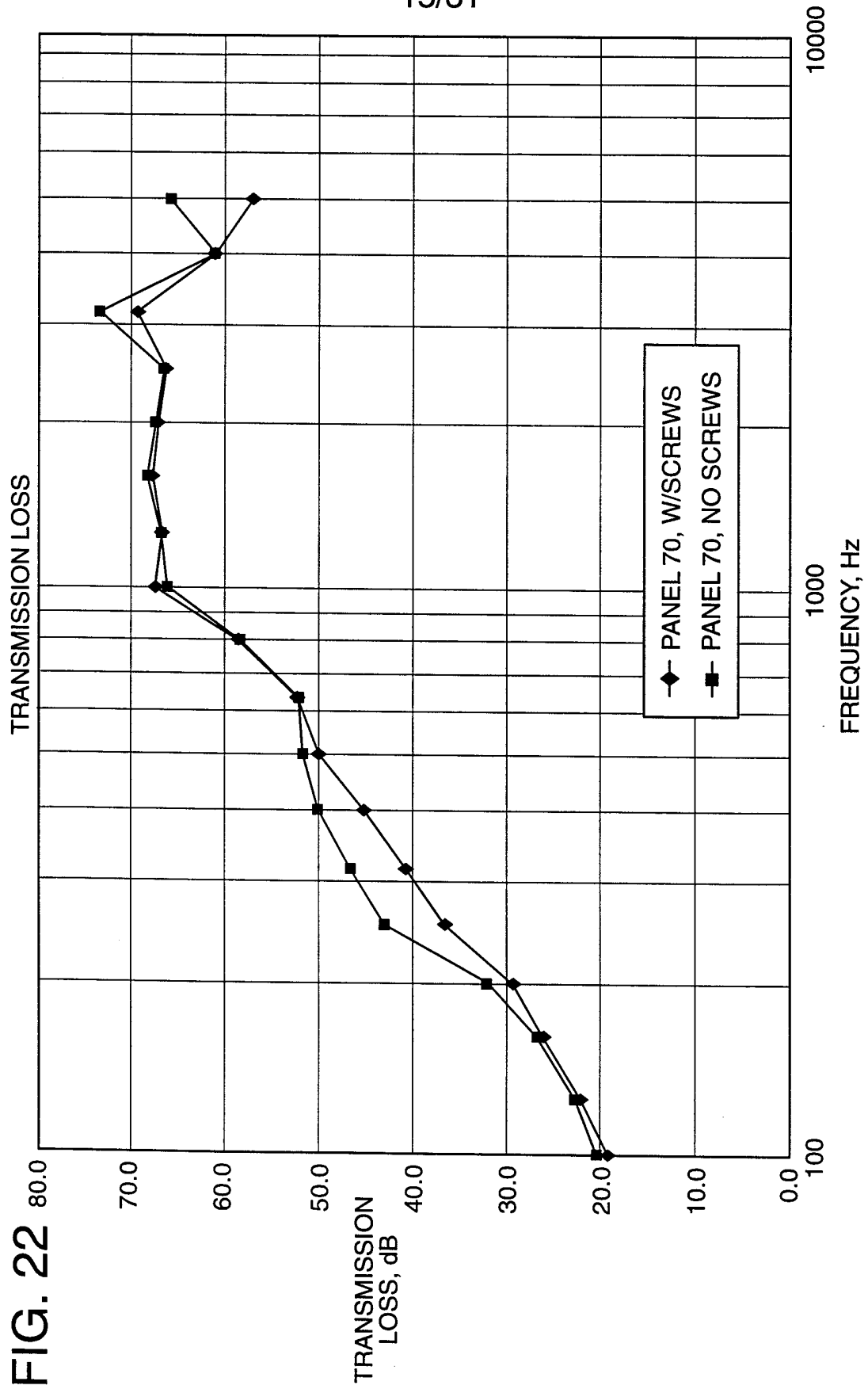


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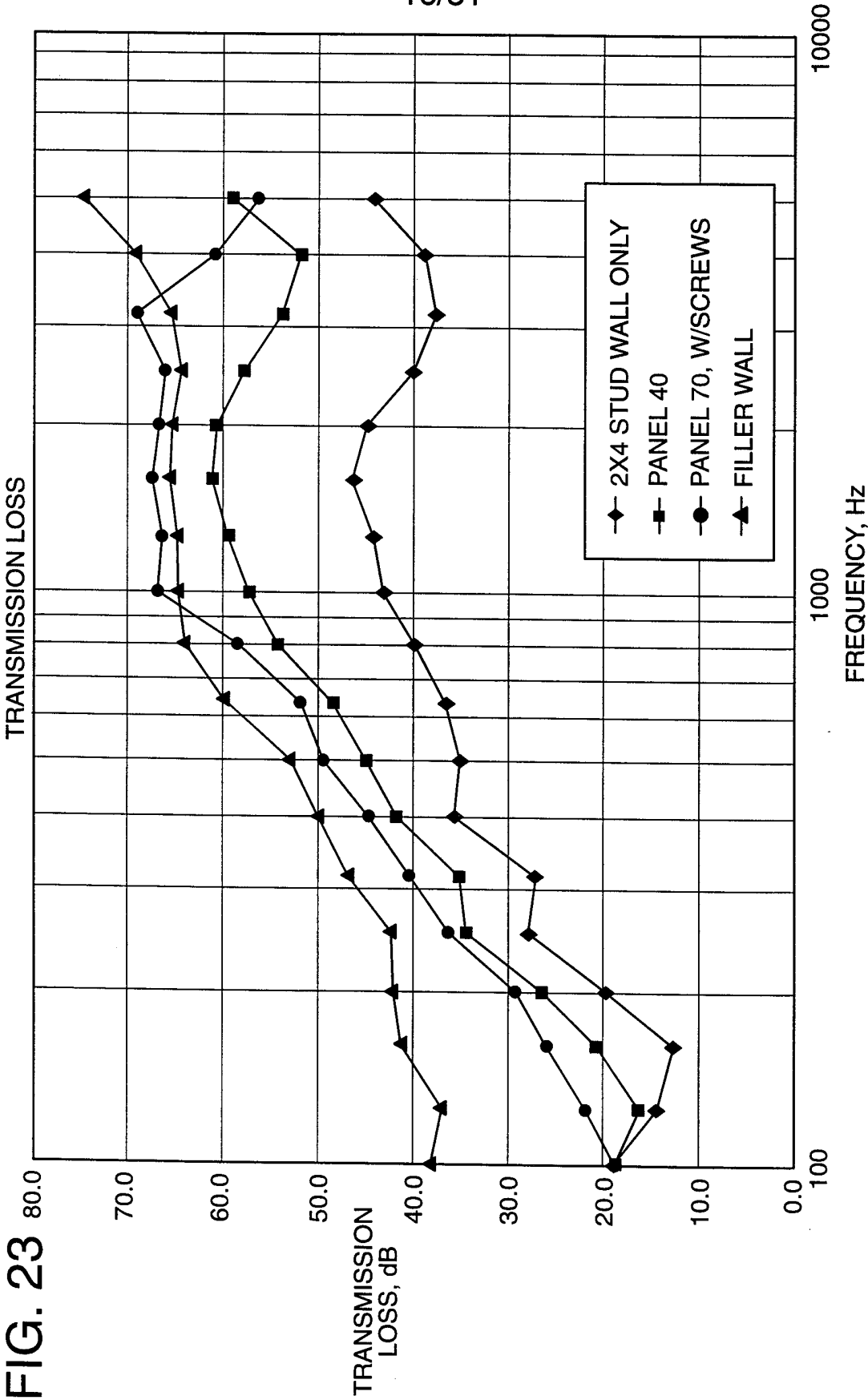
FIG. 21



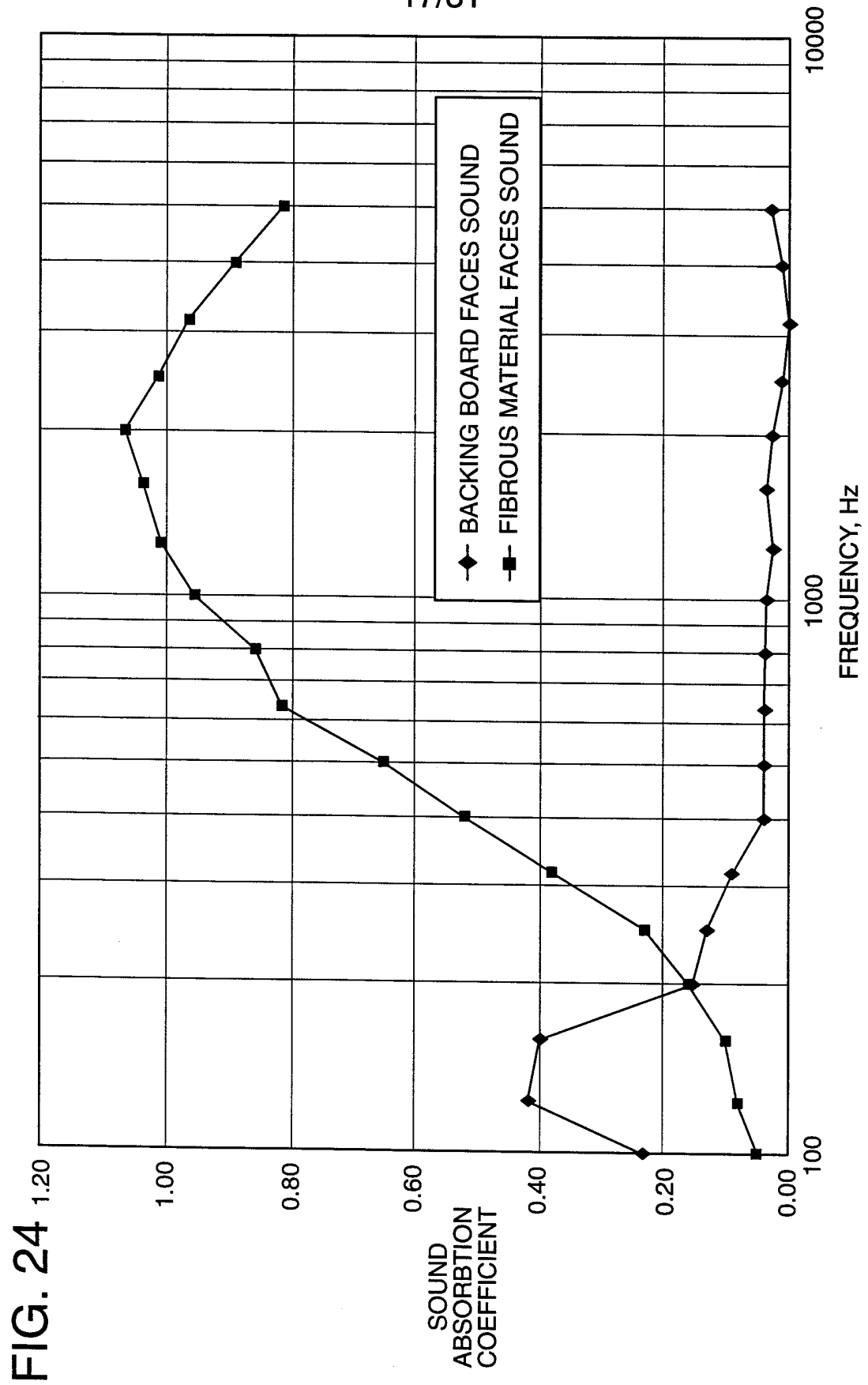
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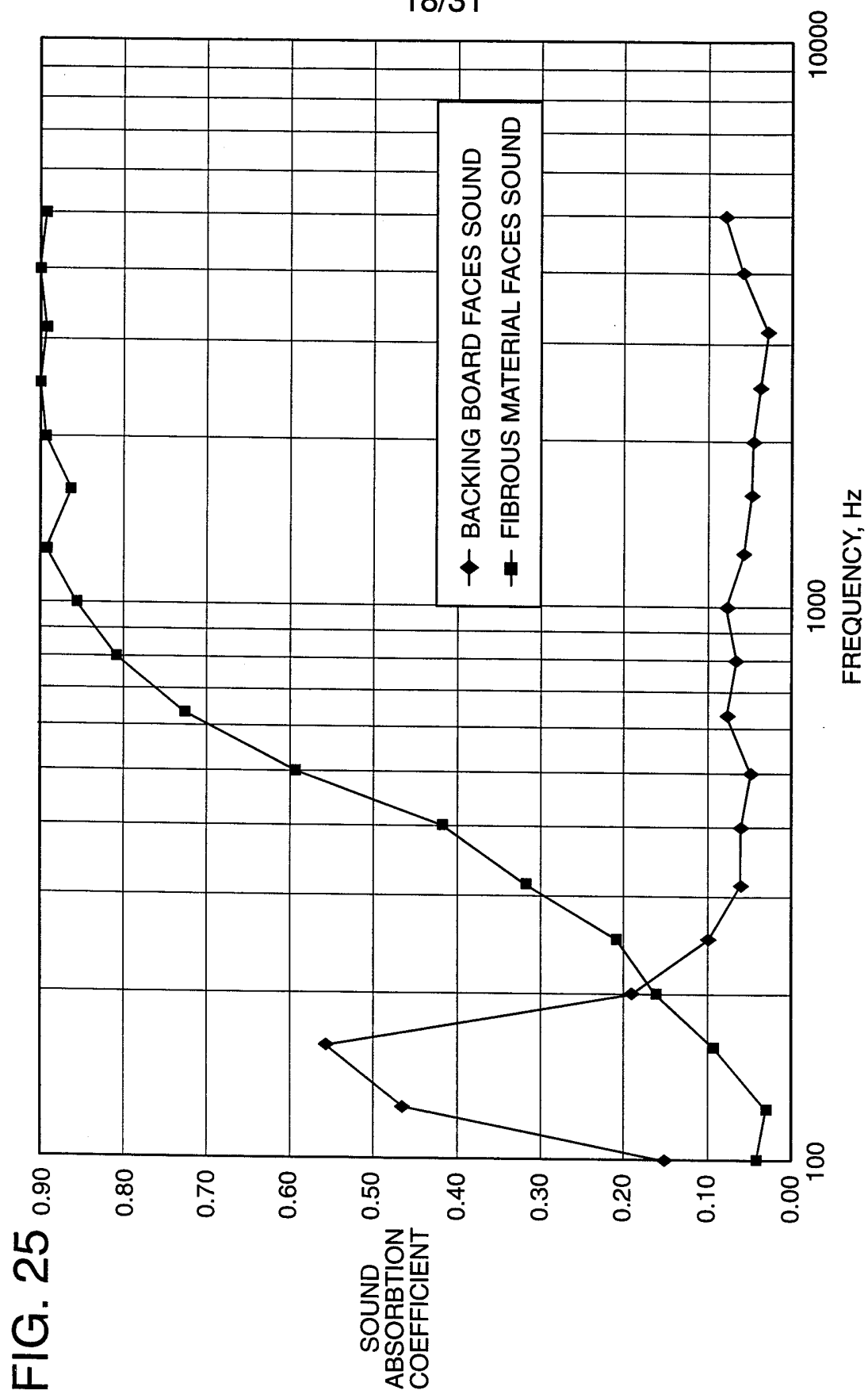
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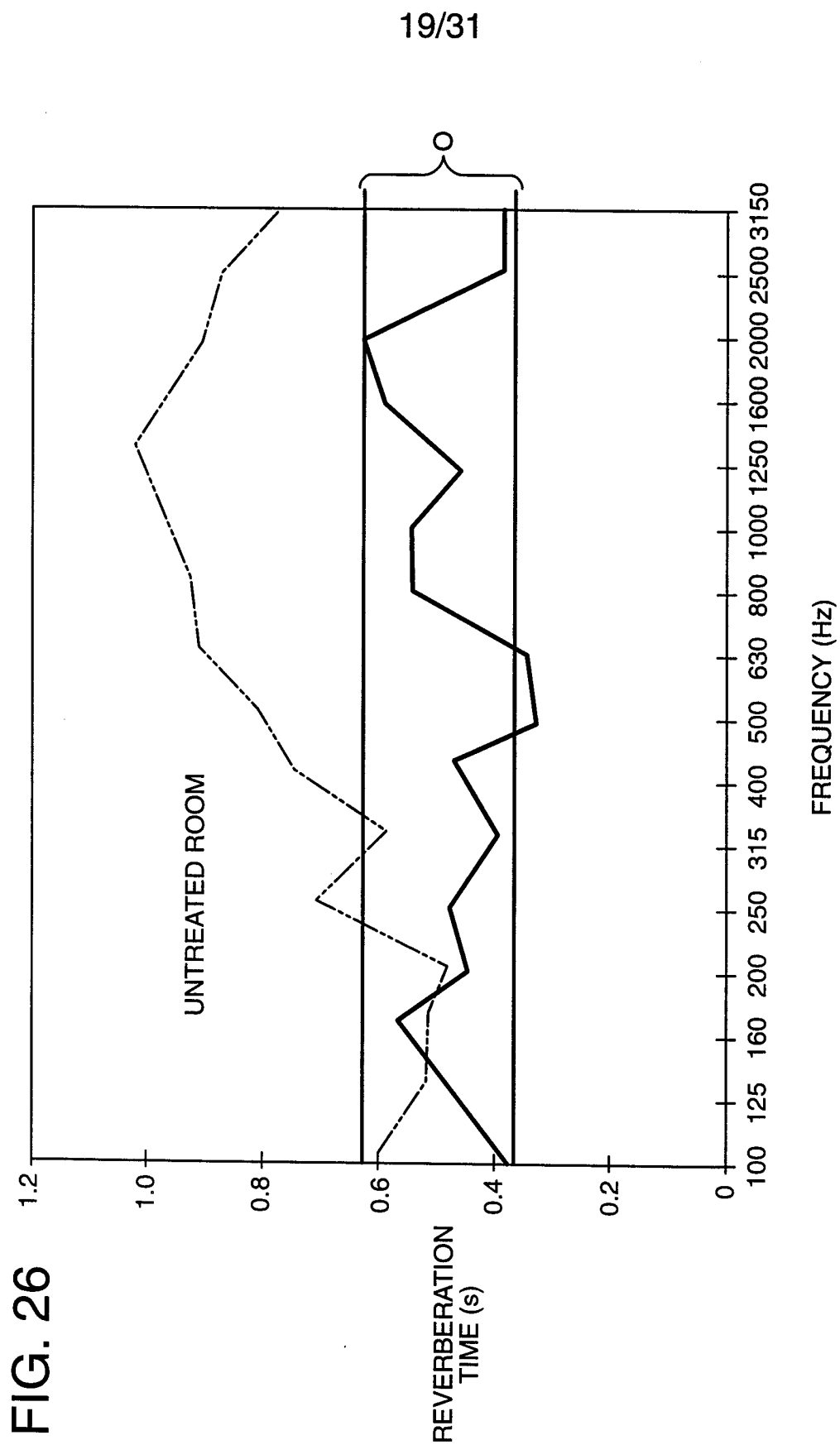


FIG. 27

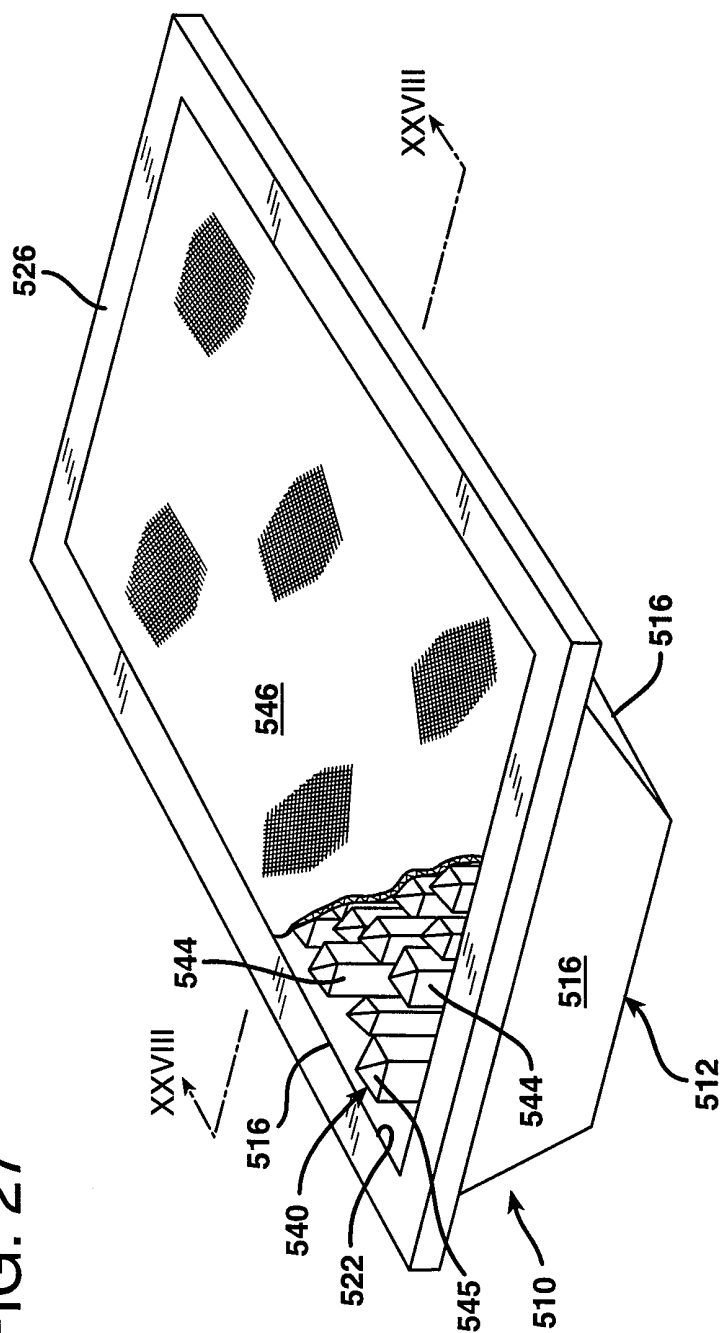
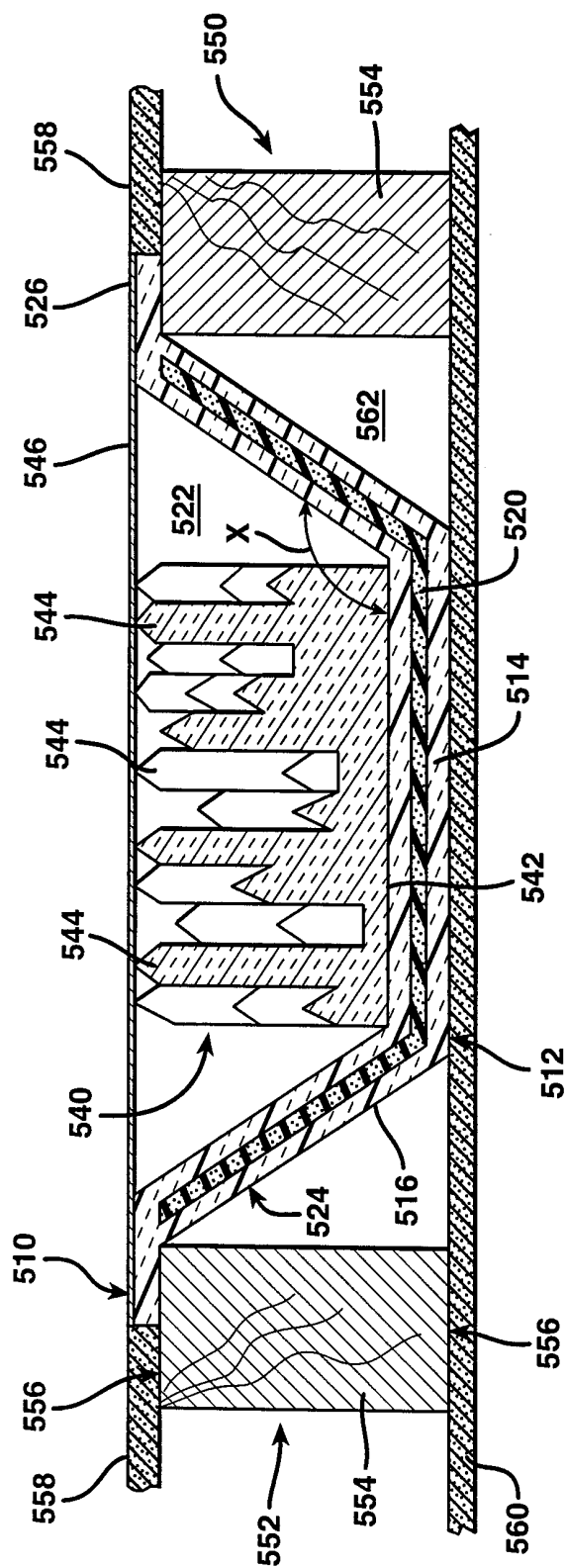


FIG. 28



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FIG. 30

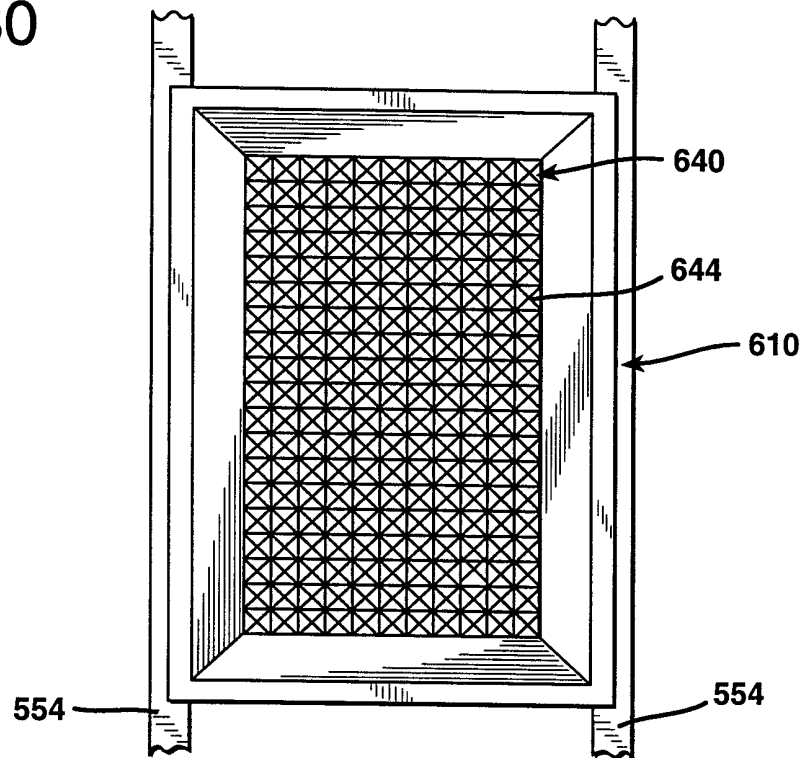


FIG. 31

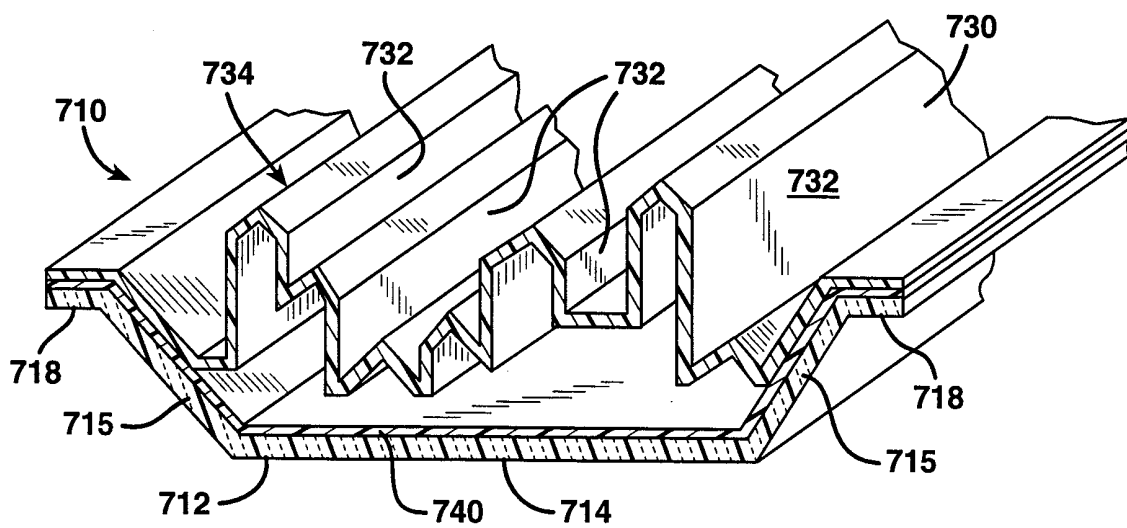


FIG. 32

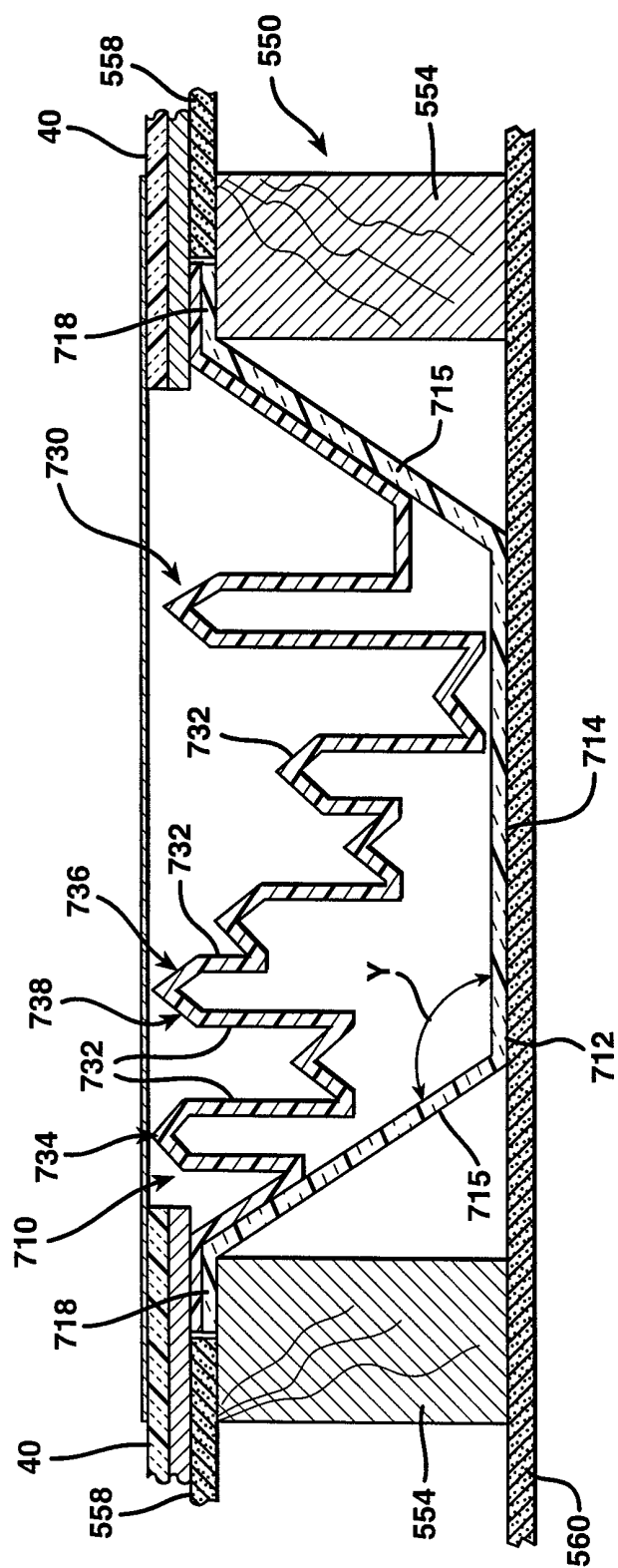


FIG. 33

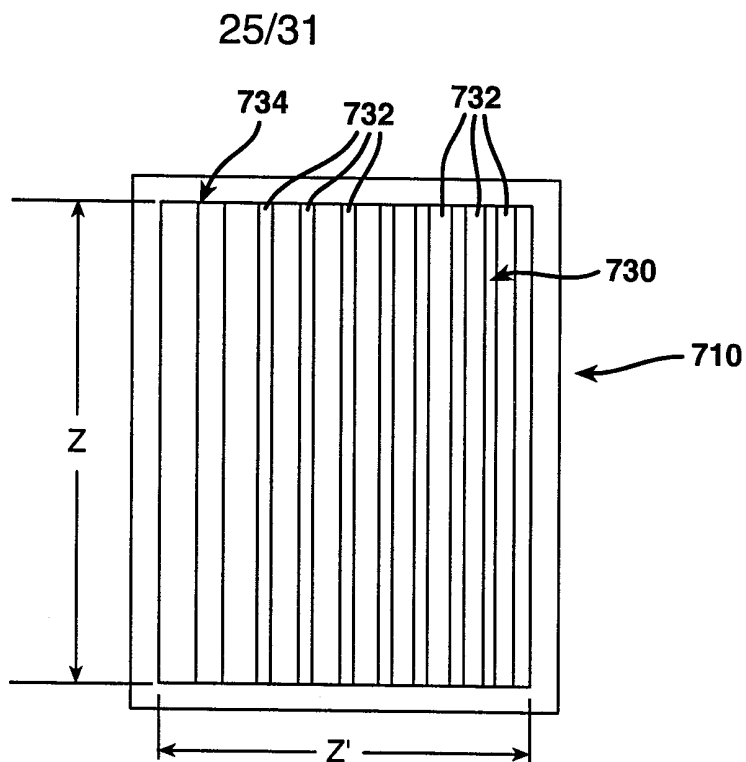


FIG. 34

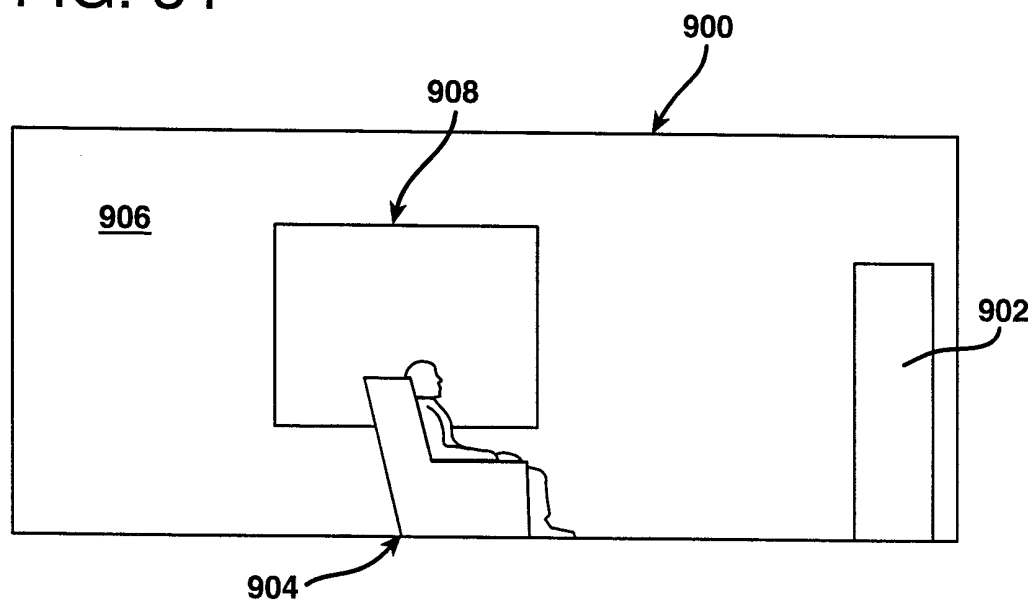
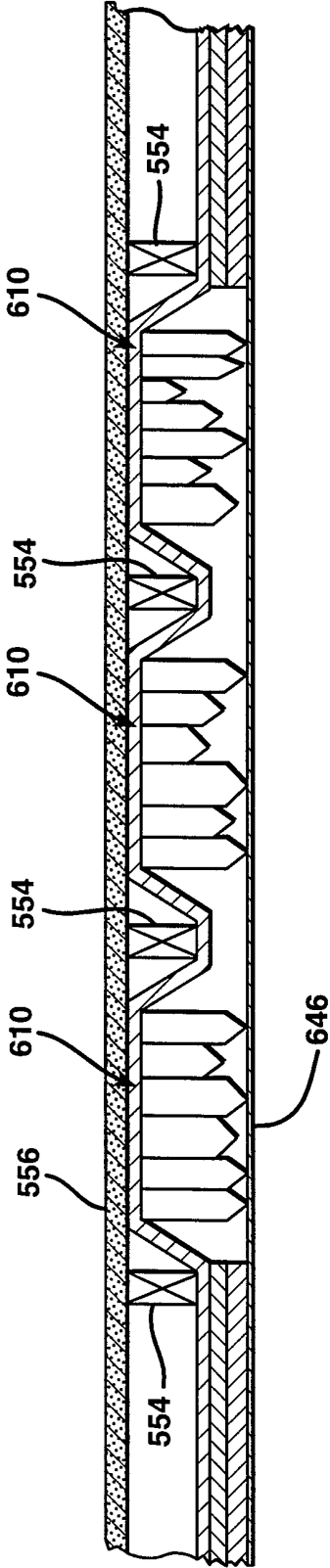


FIG. 35



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FIG. 36

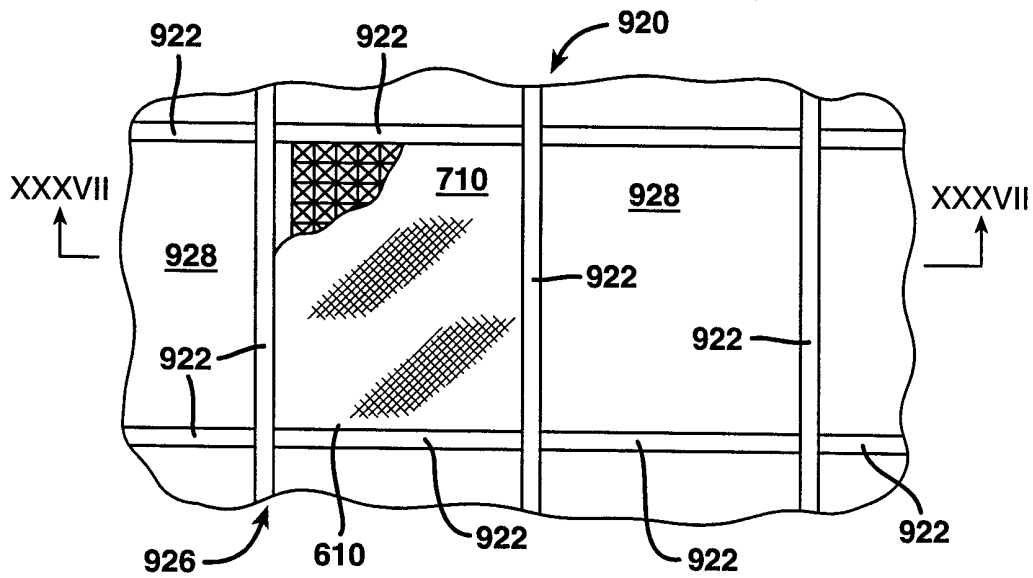


FIG. 37

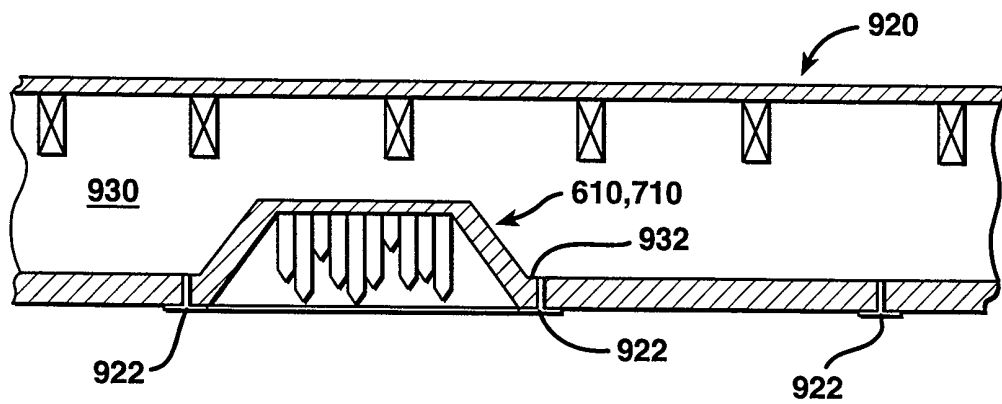
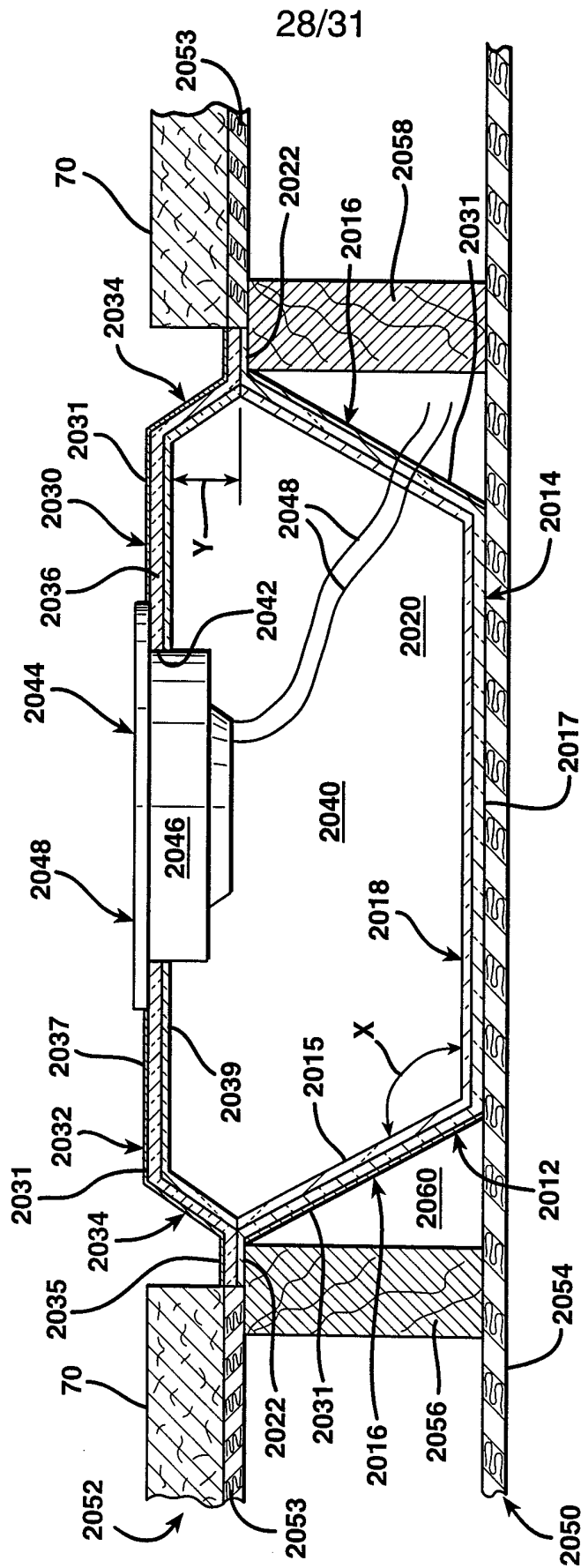


FIG. 38



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FIG. 39

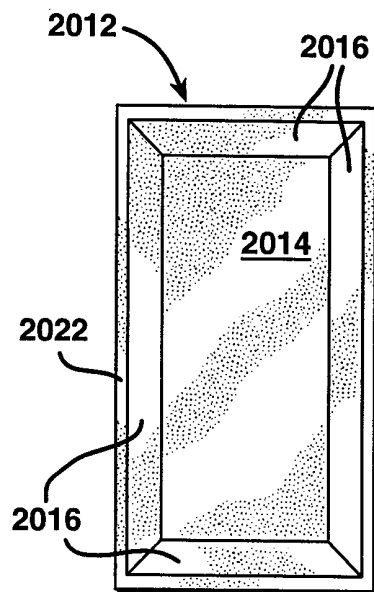


FIG. 40

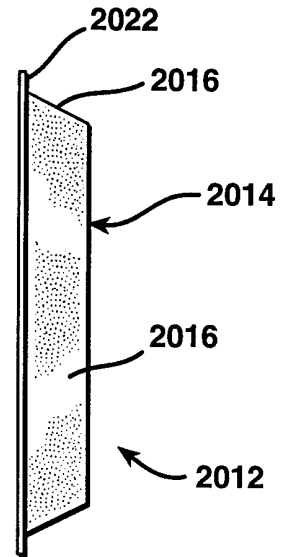


FIG. 43

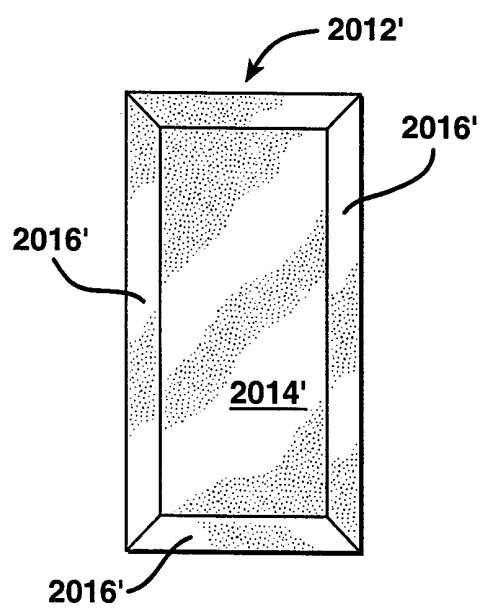


FIG. 44

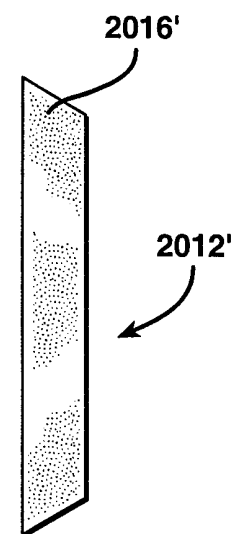


FIG. 41

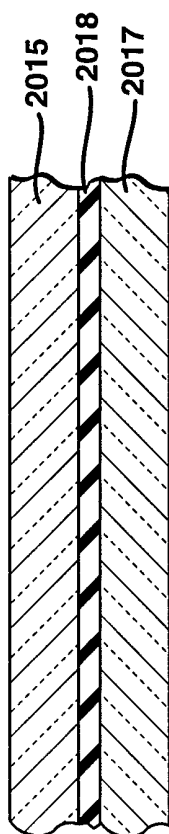


FIG. 45

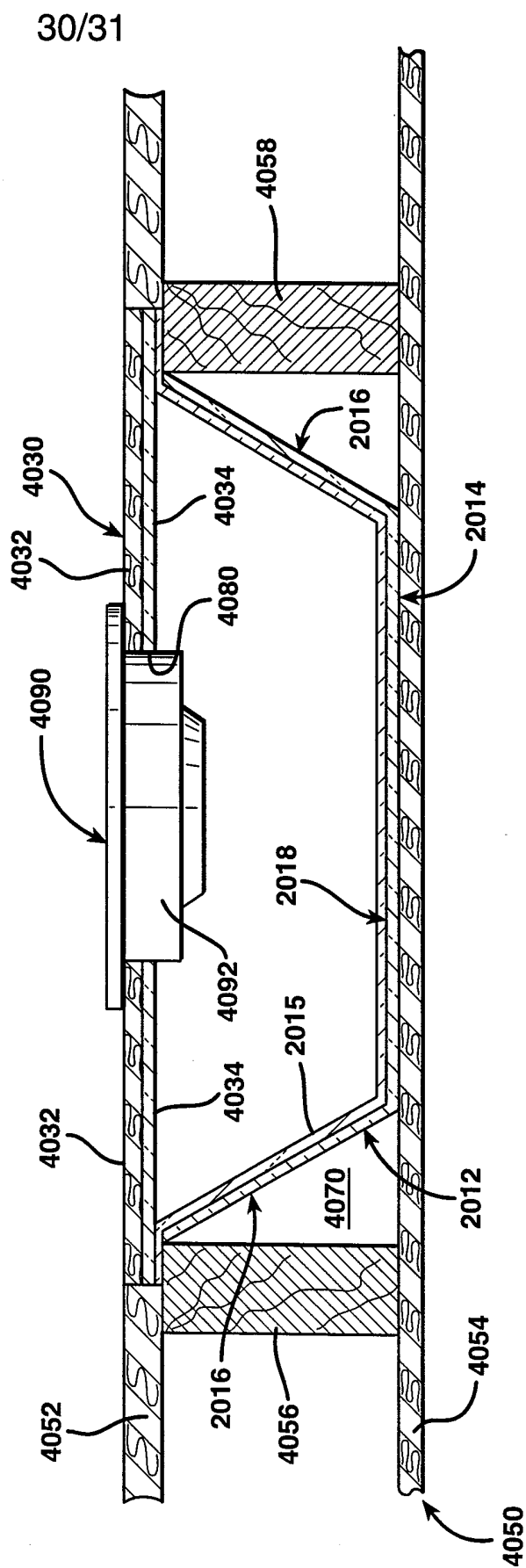
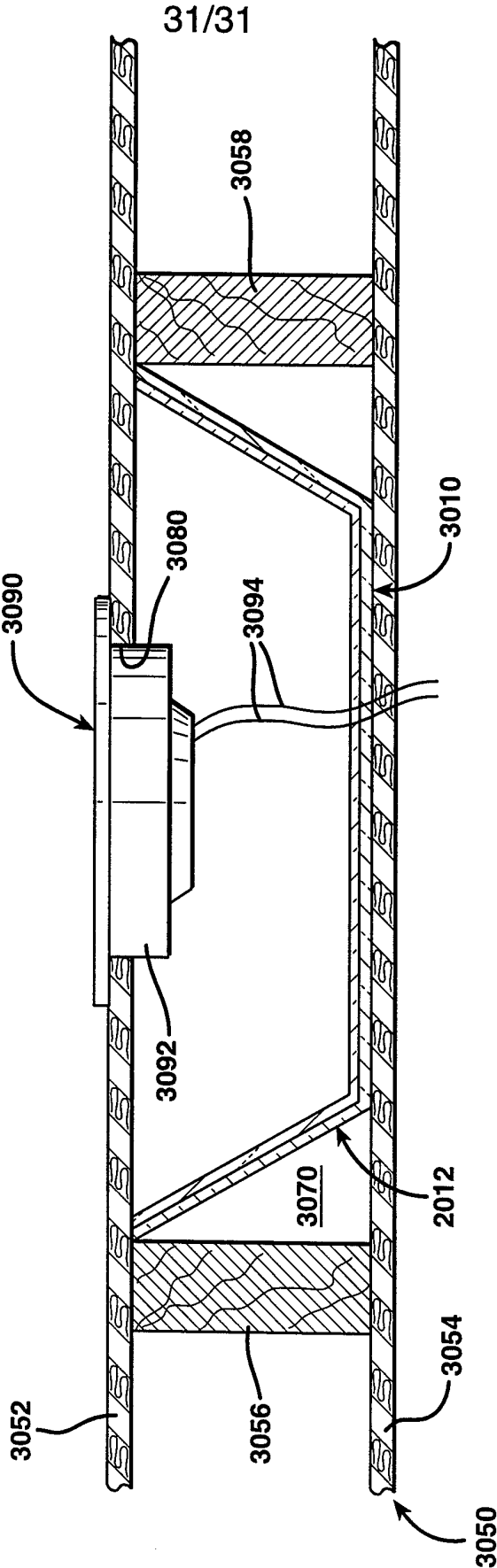


FIG. 42



INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 99/16594

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 H04R5/02 H04R27/00 E04B1/82

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 H04R E04B C08G G10K E04C A47G B32B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
----------	--	-----------------------

X	PATENT ABSTRACTS OF JAPAN vol. 1995, no. 8, 29 September 1995 (1995-09-29) & JP 07 129182 A (NIPPON COLUMBIA), 19 September 1995 (1995-09-19) abstract	1, 13, 14
Y		2, 15
A		5-7, 9-11, 18, 19, 22-26, 30-32, 34, 35

-/--



Further documents are listed in the continuation of box C.



Patent family members are listed in annex.

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Date of the actual completion of the international search

13 January 2000

Date of mailing of the international search report

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INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 99/16594

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 3 488 310 A (MC COMBS) 6 January 1970 (1970-01-06) column 1, line 34-38	2,15
A	column 2, line 15-45 column 2, line 62 -column 3, line 2 column 7, line 62 -column 8, line 31 ----	8,27,33
A	US 4 213 516 A (SULEWSKY) 22 July 1980 (1980-07-22) column 1, line 67 -column 2, line 20 column 3, line 57 -column 5, line 29 column 6, line 15-28 ----	3,4,8, 12,16, 17, 21-24, 28,29, 36,38
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A	US 4 397 123 A (PARKER) 9 August 1983 (1983-08-09) column 2, line 6-33 column 3, line 35 -column 4, line 19 column 4, line 28 -column 5, line 13 column 5, line 28-43 ----	14,20, 21,23, 24,26, 37,38
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information on patent family members

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PCT/US 99/16594

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