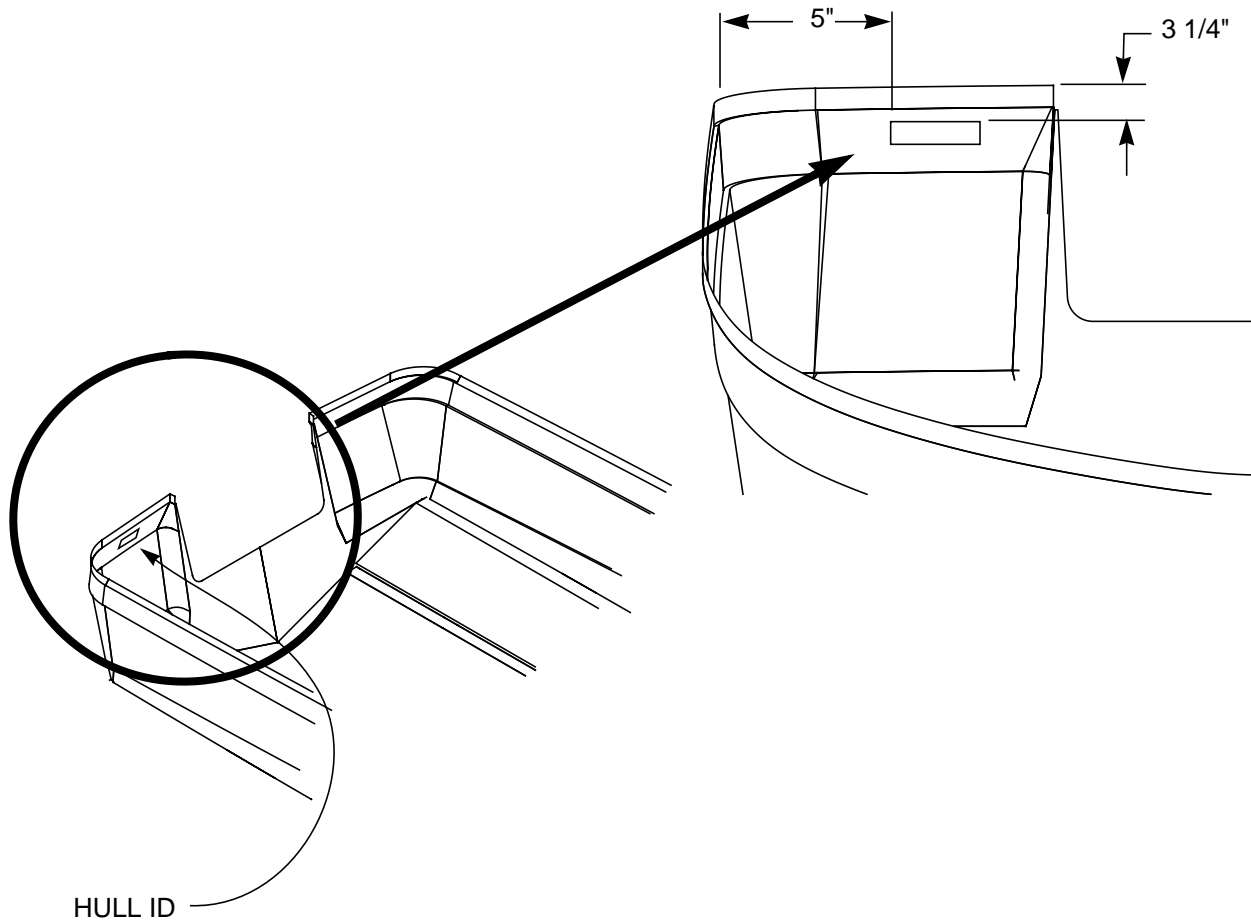


CHAPTER 1: HULL LAMINATION

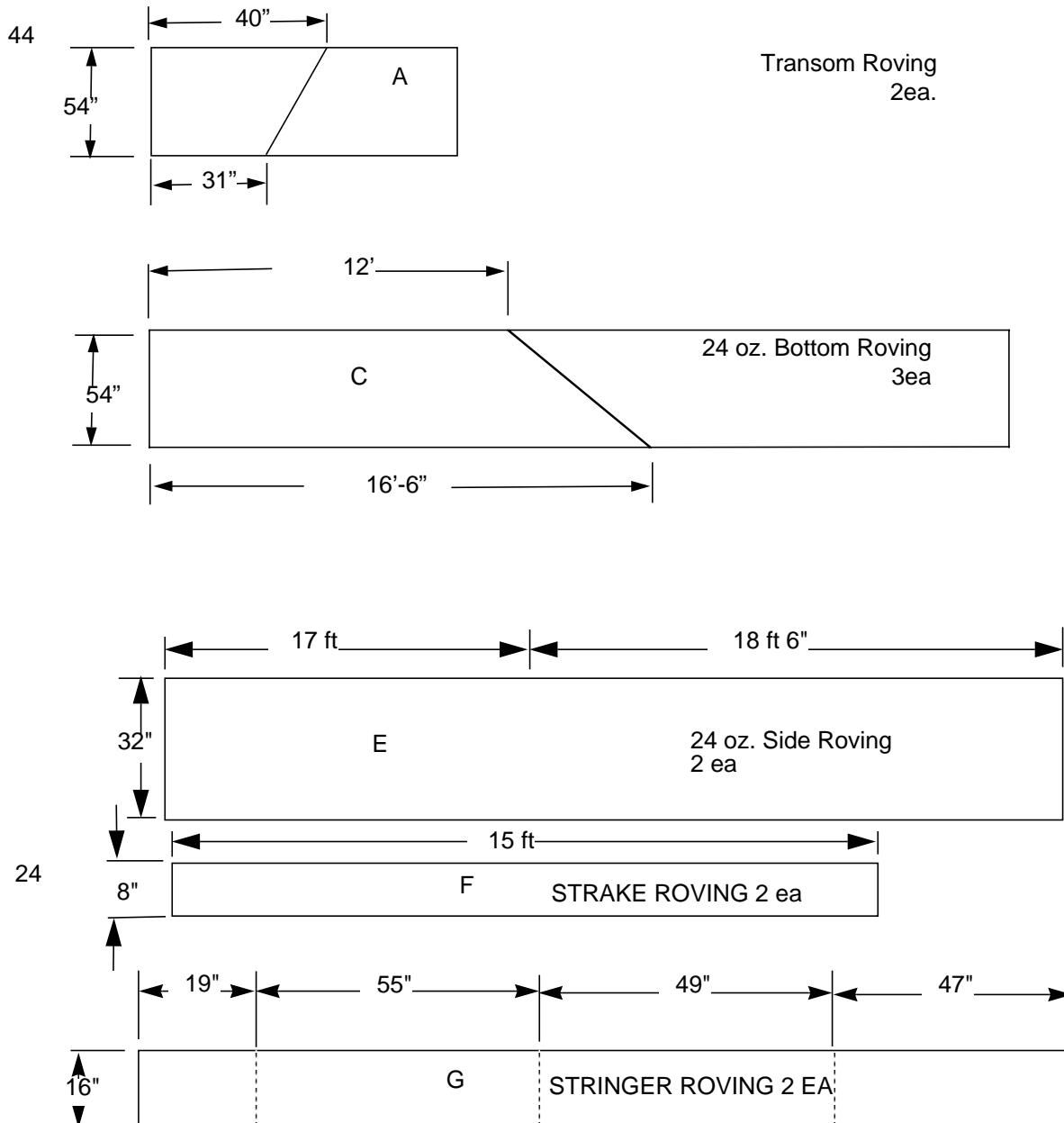
GELCOAT PROCEDURES:

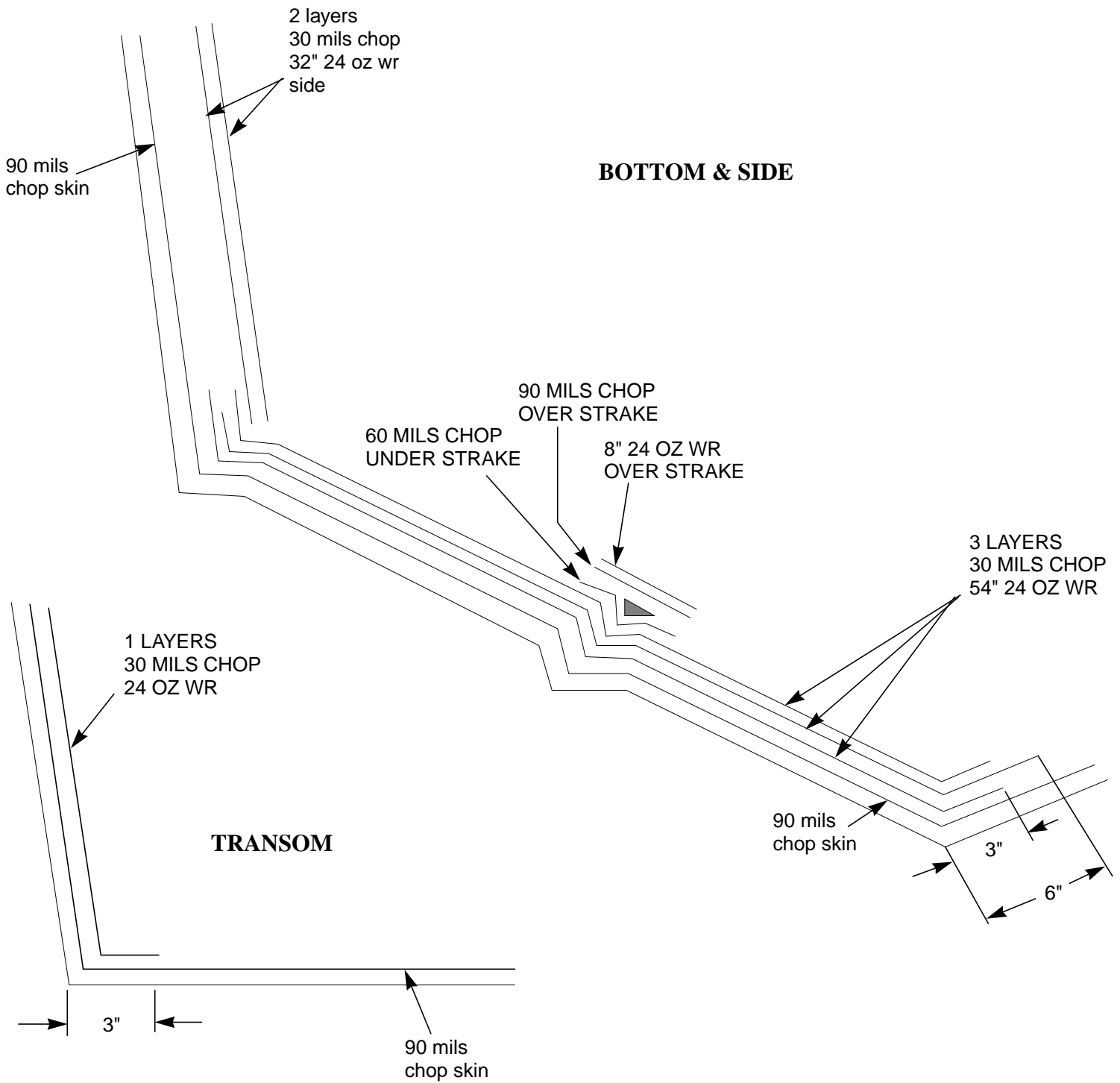


1. Apply 18-20 mils of Gelcoat to entire hull, 6-7 mils of per pass in three even coats.
2. Allow a minimum of 30 seconds between coats.

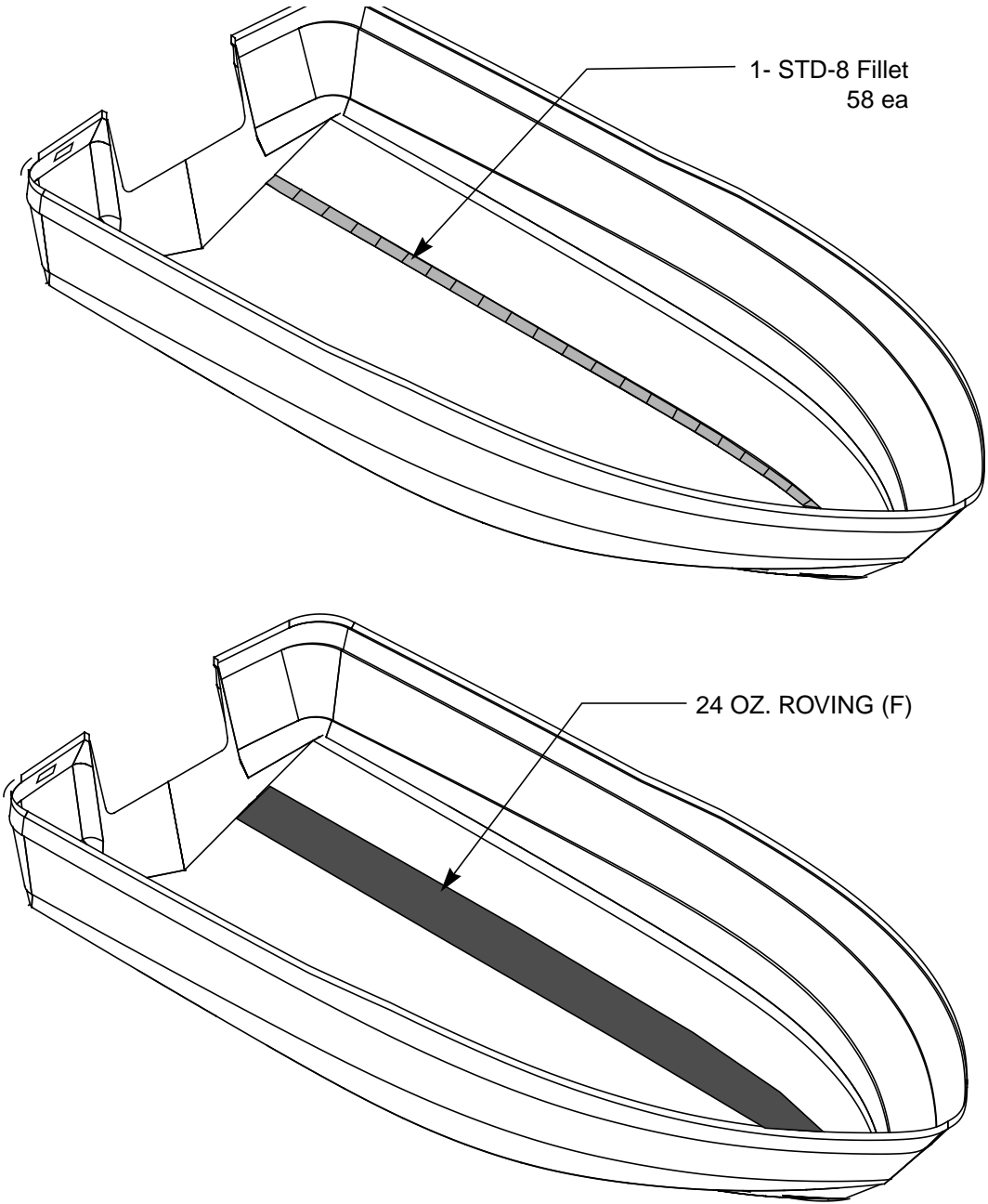
Note: Use 43 lbs. of Dream White Gelcoat (PN 39853).

ROVING CUTS

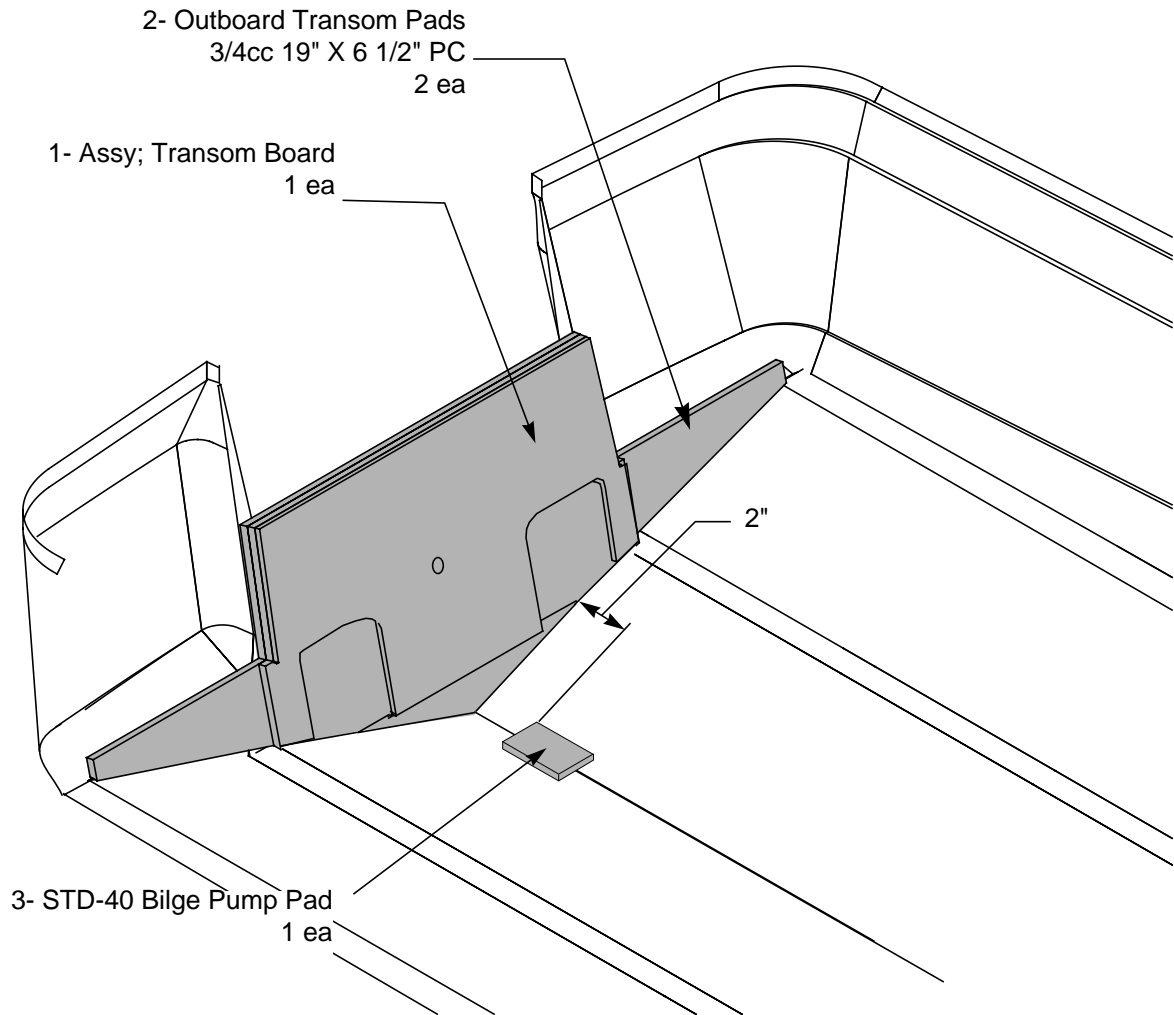




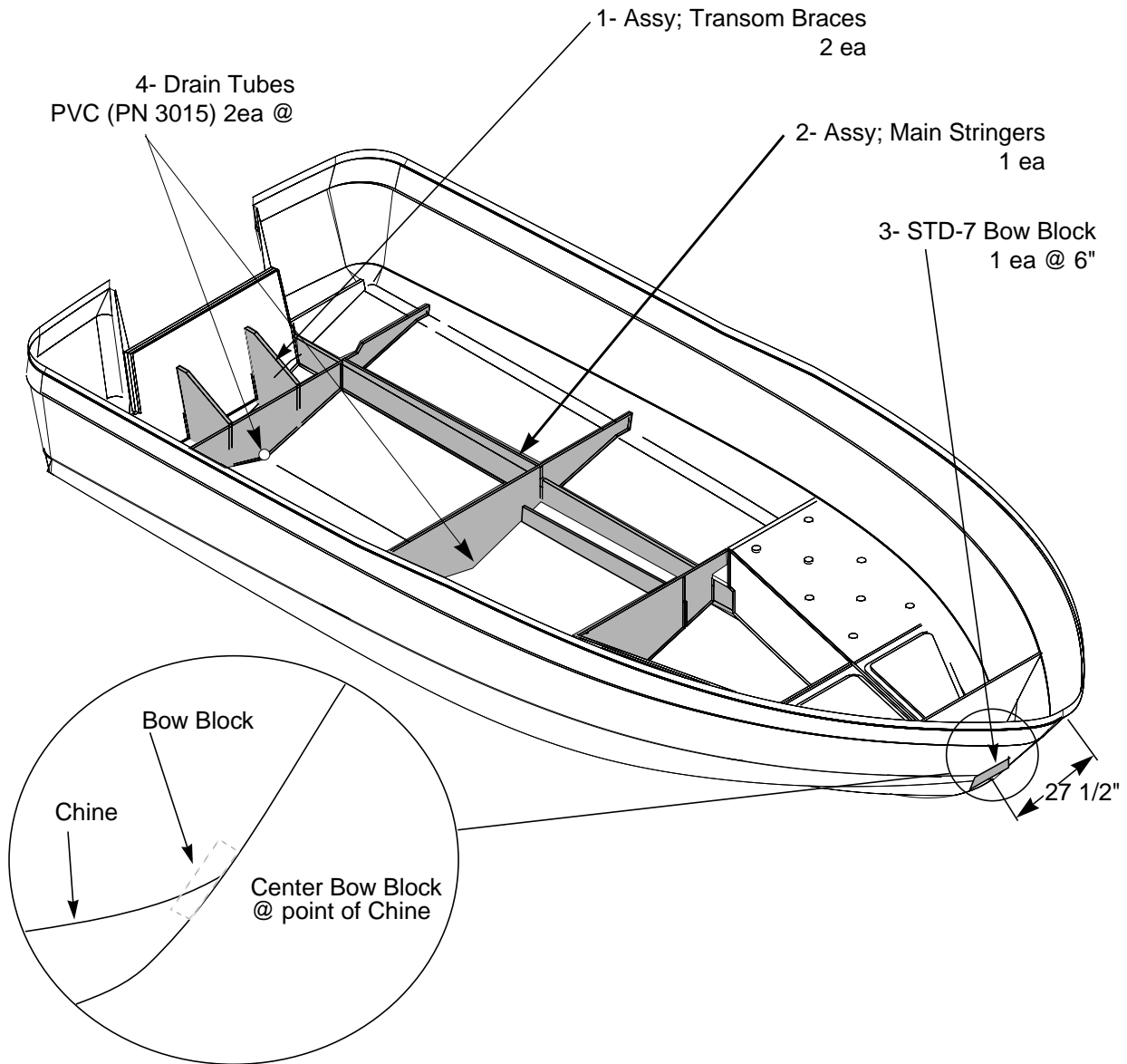
STRAKE INSTALLATION:



TRANSOM WOOD INSTALLATION:



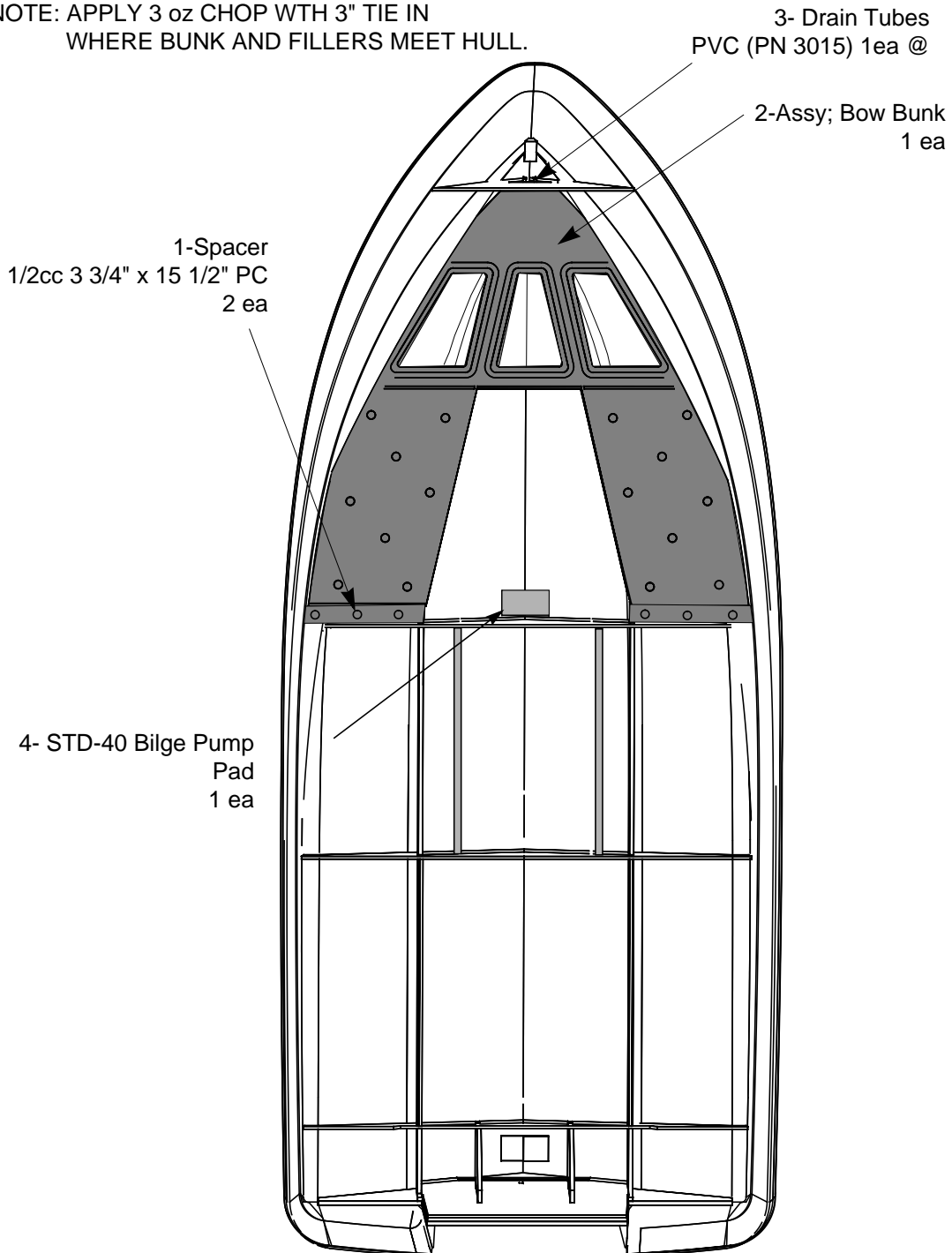
1. Refer to Product Standards Manual for Transom Board lamination specification.

STRINGER / BULKHEAD INSTALLATION:

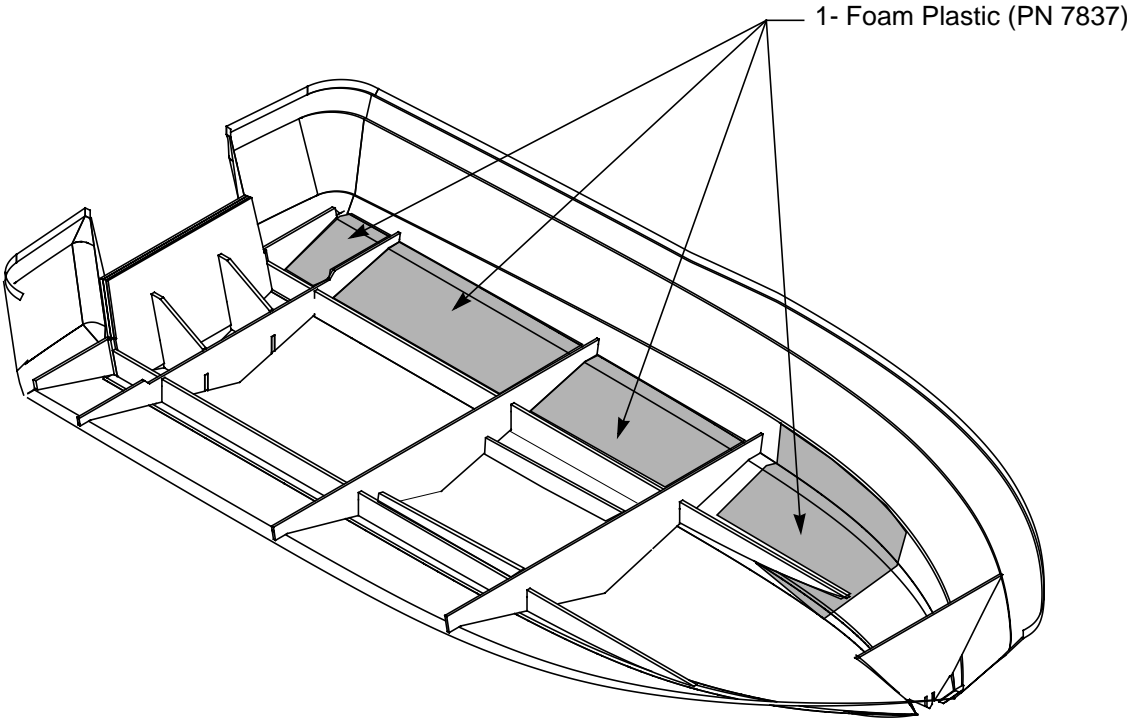
1. Place Stringer Assy in wet chop.
2. Set Bow Bunk in for Stringer placement port to starboard, lift out Bow Bunk.
3. Apply 90 mils Chop over part 1, 3 and stringers.
4. Apply 24 oz roving over MAIN OUT BOARD STRINGERS ONLY.
5. Apply 90 mils chop over INBOARD STRINGERS.
6. Apply 90 mils chop to bulkheads at floor and intersections with a 3" overlap.
7. Wet out remaining bulkhead wood.

BOW BUNK AND BUNK SPACER INSTALLATION:

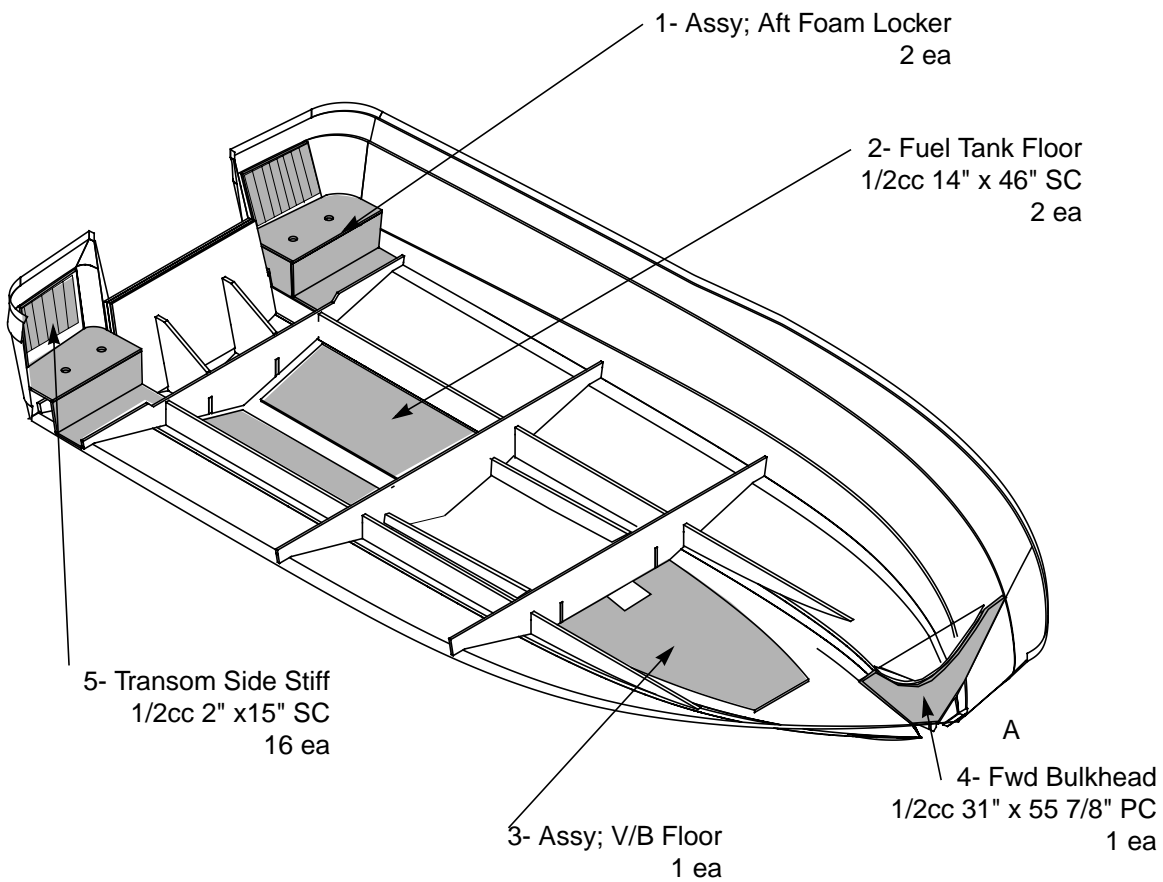
NOTE: APPLY 3 oz CHOP WTH 3" TIE IN
WHERE BUNK AND FILLERS MEET HULL.



FOAM PLASTIC INSTALLATION:

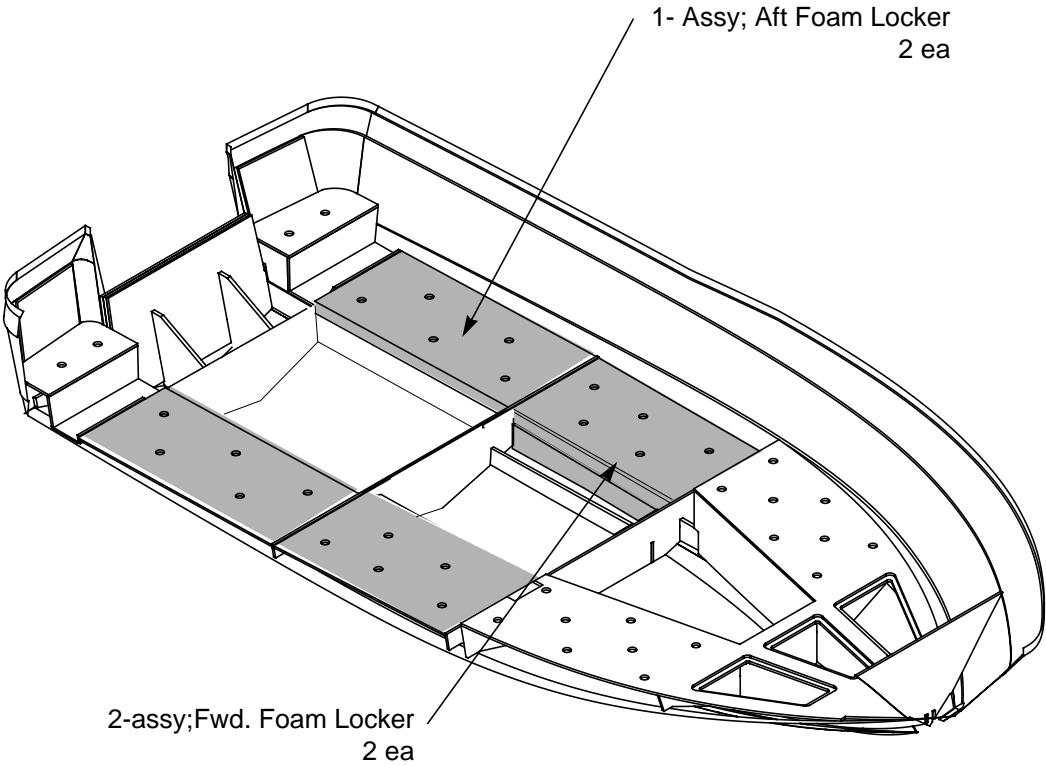


- 1. Bow bunk is left out for clarity.
- 2. Cut Plastic to fit each locker area.

HULL FLOORS INSTALLATION:

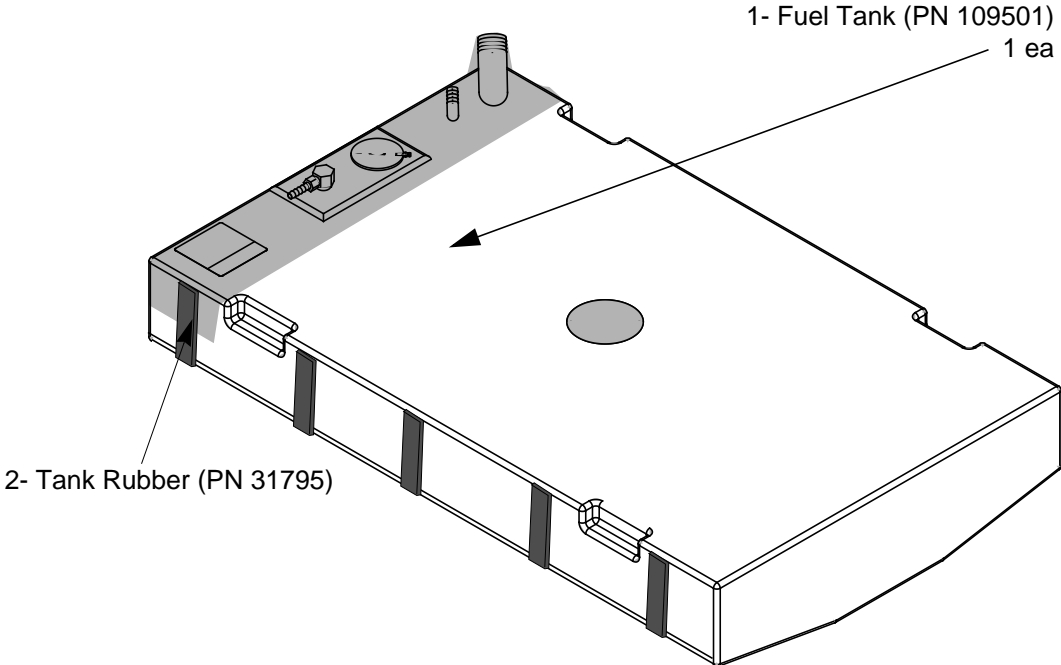
1. Bow Bunk Left out For Clarity.
2. Center Part 2 between aft and middle bulkheads, butt against stringer.
3. Apply floors in wet chop.
4. Apply 3 oz chop to edges of all parts with a 3" tie in and roll out.
5. Wet out remaining bare wood.

FOAM FLOOR INSTALLATION:

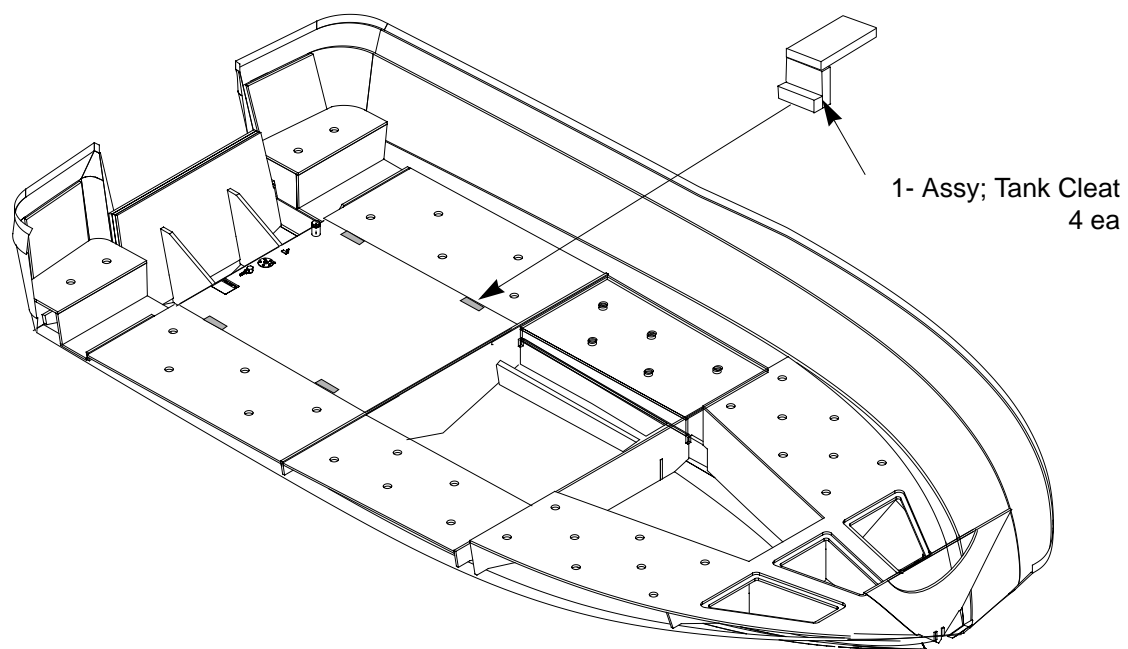


- 1. Apply 3 oz chop to all edges with a 3" tie in.

FUEL TANK PREPARATION:



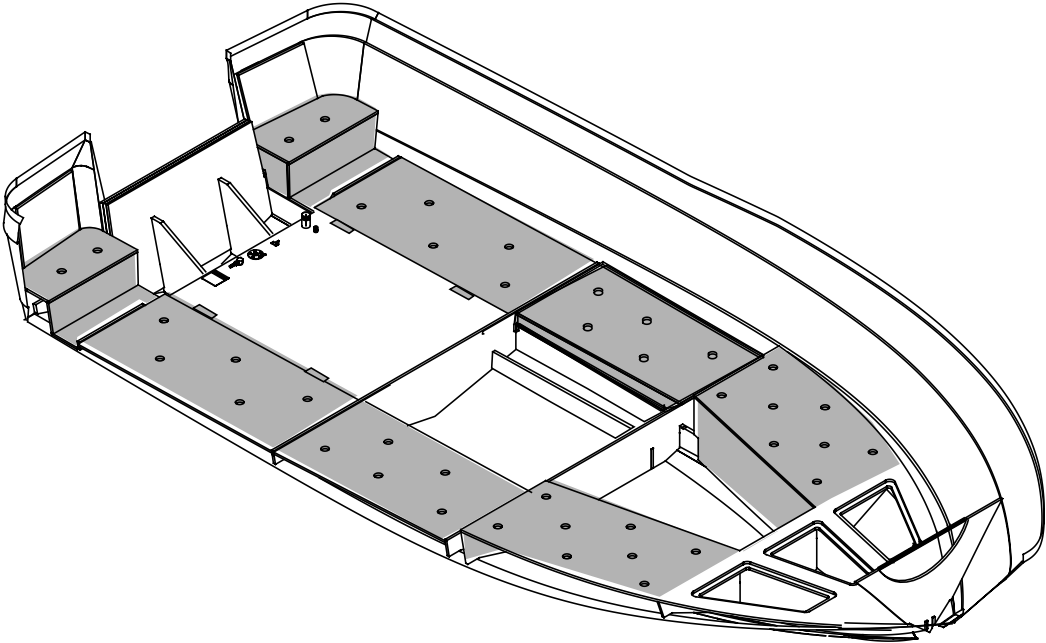
- 1. Apply 12" wide 8 mil Shrink Wrap (PN 7837) over fittings on Tank.

PLASTIC FUEL TANK INSTALLATION:

1. Refer to Fuel Tank Installation Standard.(Refernce ECN.#A-202-94).
2. Install Fuel Tank Hold Down Cleats and staple to stringer and floor.
3. Apply 2 oz of chop over cleats.

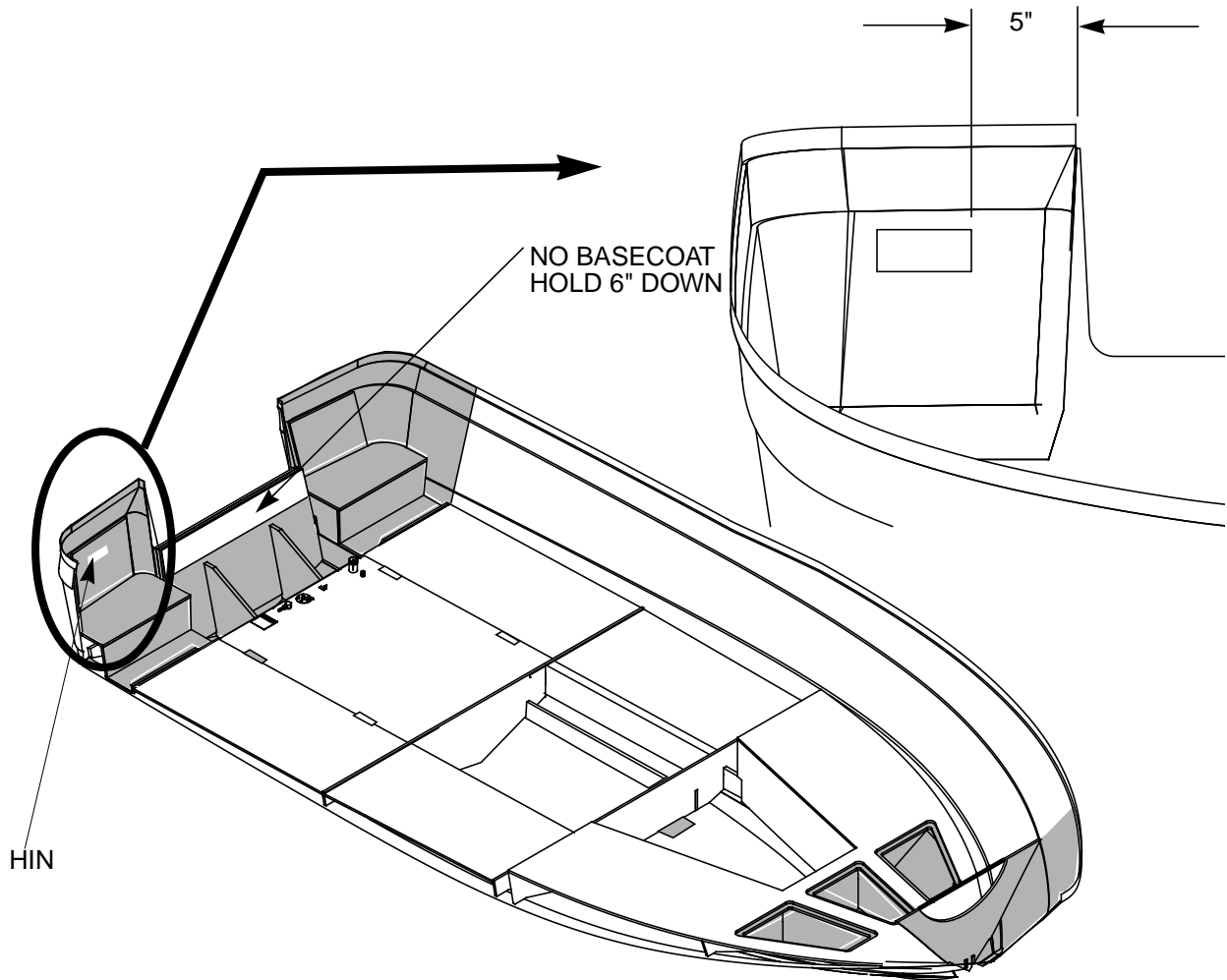
FLOATATION FOAM LOCATION:

NOTE: Use Floation Foam in shaded areas
(Refer to Standards Manual)



- 1. Total Flotation Foam usage ----- 40 lb part A
- 2. -----40 lb part B

BASECOAT:



BASECOAT (PN 7220) 19.04 lbs
WEBBING (PN 62812)