

Hand lay up Procedure for $\frac{3}{8}$ " Separable Mold Skins.

1. Pass pattern for fairness.
2. Apply 2 coats Ceara mold release wax.
3. Apply 1 dust free coat of Ram P.V.A.
mold # to flash portion of transom followed by
4. Apply $\frac{30}{100}$ Ram black tooling gel coat. Pot mix - 30 min. gel time
(approx. 1% cat.)
5. Layup 1 layer of 9oz. boat cloth immediately after gel of
gel coat. Allow 24 hr. cure.* (Lay-up resin - Advance #3270 w/cobalt
to give 2 hr. gel time.)
6. Inspect and remove any entrapped air.
7. Pre-cut 1 layer of cloth and 1 mat (2 oz.) allowing about $\frac{1}{8}$ " ~~minimum~~ overlap at joints.
8. Lay-up 1 mat and 1 cloth together in that order. Work out
all air with metal roller and remove extra resin from
surface with squeegee. Allow to cure for 24 hr.
9. Repeat step #8 allow 24 hr. cure.
10. Paint out all male and female corners using white gel coat.
Apply 1" wide.
11. Layup 1 cloth and 1 mat on "panel" areas only. Stay off white.
12. Repeat step #11 and allow 24 hr. cure.
13. ~~Fill all female corners with plaster.~~ OMIT
14. Repeat step #8 (mat and cloth - even all over including white painted
Allow 24 hr. cure. areas.)
15. Repeat step ~~#14~~ 14

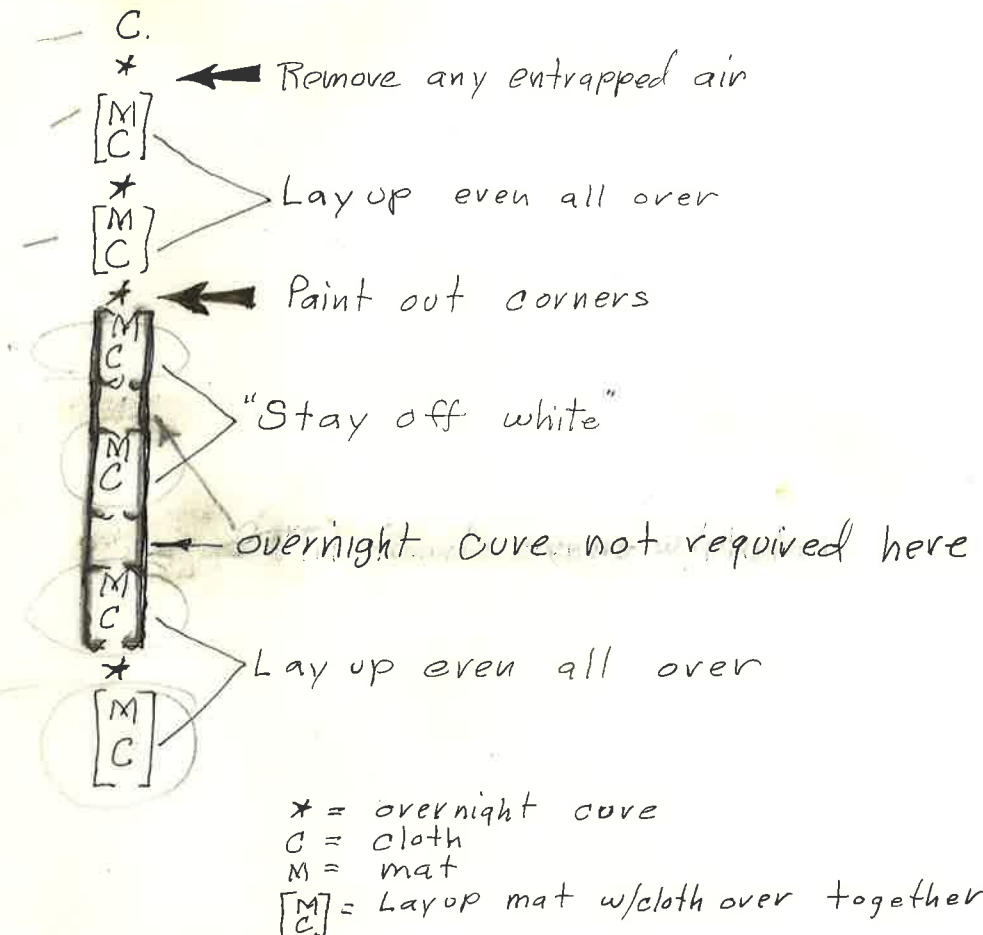
NOTE: See "final foaming dwg. #18-78-2 for last gun layup.
This must be done last thing prior to foaming for
lamination.

* (or overnight)

See Dwg. # 18-78-1 for 13' top mold inserts.

OBSOLETE

Layup Sequence



DECIMAL TOLERANCES $\pm$
ANGULAR TOLERANCES $\pm$
FRACTIONAL TOLERANCES $\pm$

EXCEPT AS NOTED
EXCEPT AS NOTED
EXCEPT AS NOTED

DWG
NO. 18-78

ENGINEERING DEPARTMENT

FISHER-PIERCE
COMPANY, INC.

1149 Hingham St., Rockland, Mass.

TITLE 13' mold (separable)
Hand Layup plan

SCALE	DATE	DRAWN	CH'K'D	APP'D
	1/5/66	RJD	RTA	JVS

MATERIAL
Gel coat - Ram black tooling
Back up Resin - Advance 3270
Cloth - 9oz.
Mat - 2oz.

TREATMENT OR FINISH

DISTRIBUTION CODE

REVISION

CODE	DESCRIPTION	DATE	BY	APP'D
A	add in step 4, "mold # to flash portion of transom followed by"	3/7/66	JVS	

DWG.
NO. 18-78