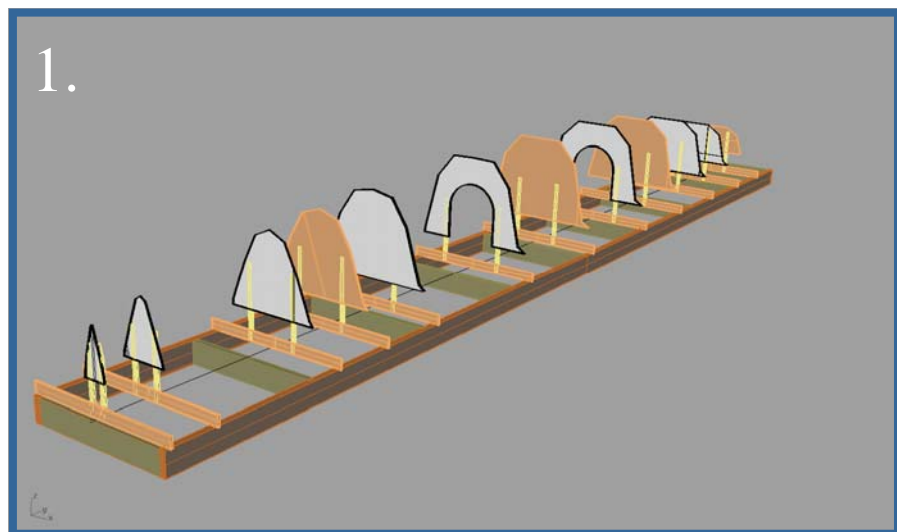
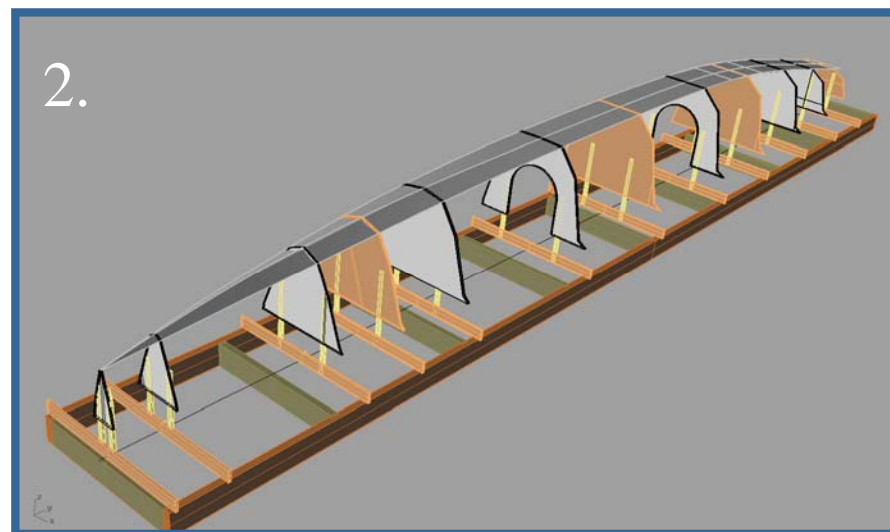


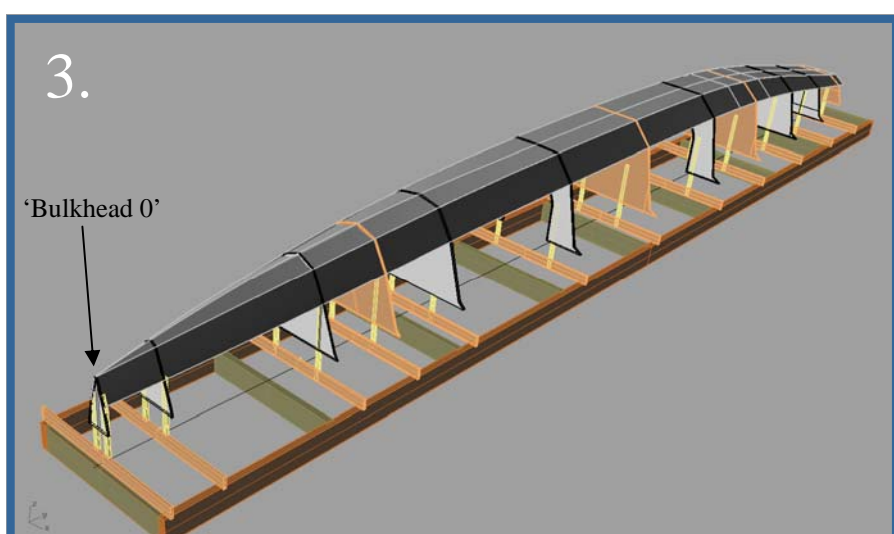
# Wilderness X Series Construction Sequence



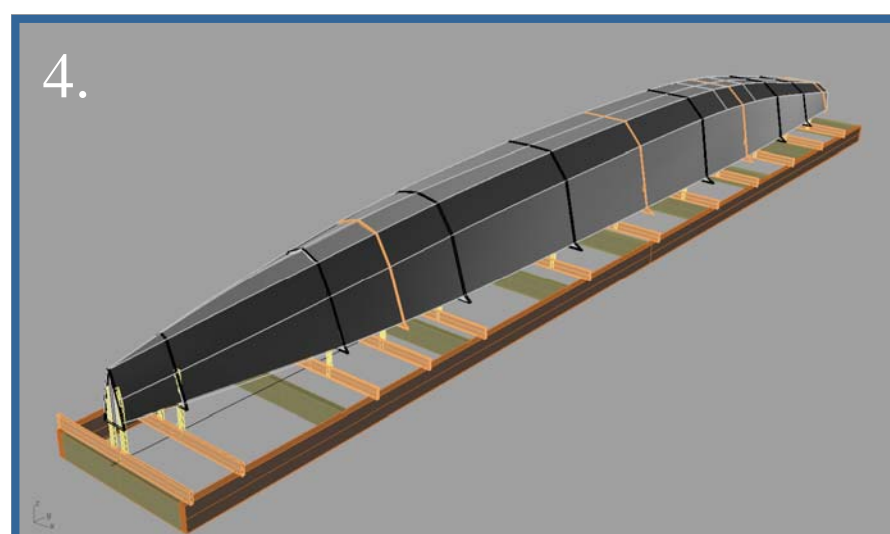
1. Identify shoe parts of permanent and MDF bulkheads, transfer reference lines from plots and set up on strongback (Sh7) according to the spacings shown on Sht10. All bulkheads are split at DWL plus 400mm. Brace BH0 transversely.



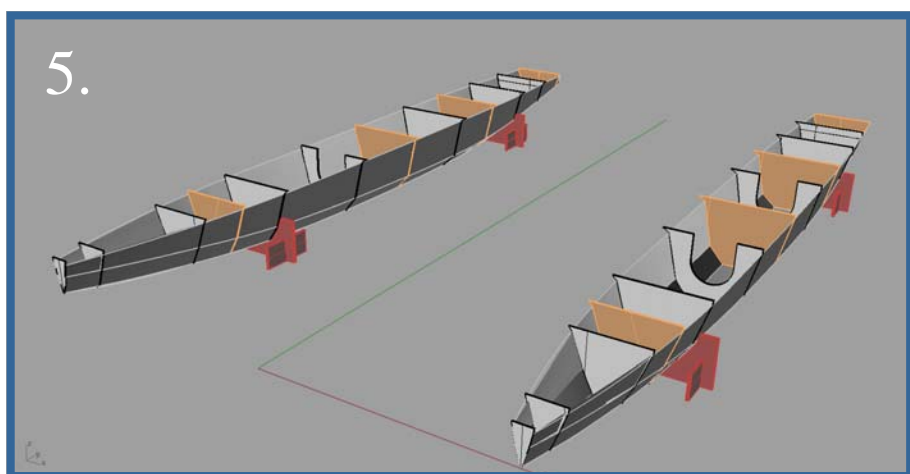
2. Begin with the bottom panels and add panels evenly one side then the other lining fwd ends up with BH0 fwd face. Panels can be just partly unscrewed, glue applied then repeat for the other end. Depth align the hull panel faces, brush epoxy into V joints then overfill them with 411 mix.



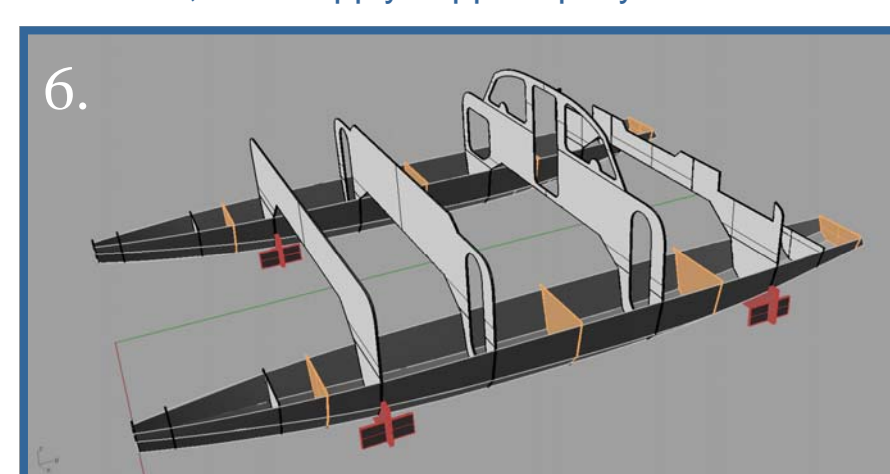
3. Depth and length alignment of the hull panels is important. Depth maintains the accuracy of the chines, inaccurate chine alignment makes more fairing work. Length alignment dictates the position of the precut transom and cockpit parts added later.



4. Sand chine joins carefully. Apply full layers of F/glass cloth (Glassing Details Sht). Screed a thin layer (2mm app) of 410 M/light mix over the entire shoe leaving a 120mm clear area on bottom and end edges. Machine sand smooth, apply 3 sealer coats of epoxy lightly sanding between then apply hi build u/coat, sand. Apply copper epoxy now if desired.



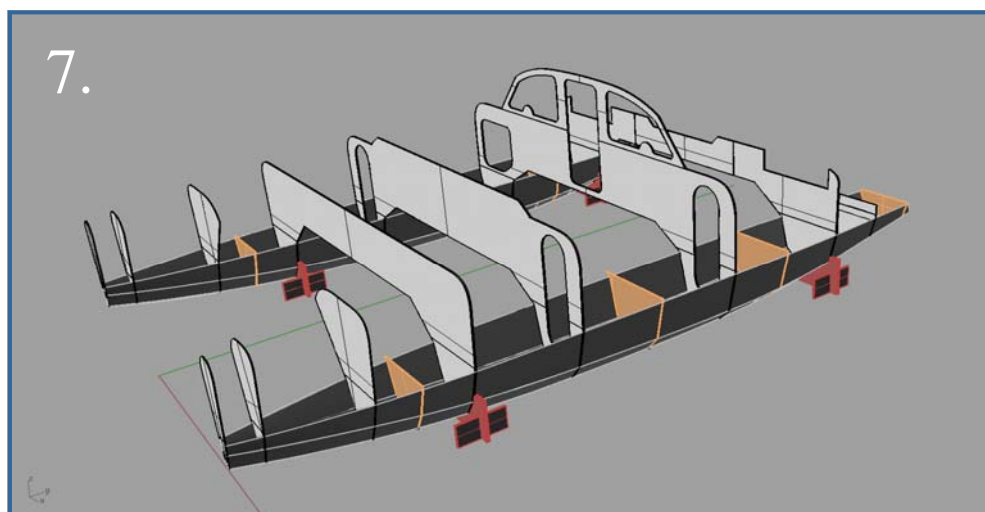
5. Turn the shoe and repeat steps 1-4 for shoe no 2 reusing the strongback. With shoes in cradles tape internal hull and bhd joins (Glassing details sht). Align the shoes (see Boat Building Manual). Locate and assemble the other Bhd precut parts and install uni troughs in tops and doorways etc (Bhd Details Sht) while Bhds are loose and flat. Install keelsons at this stage.



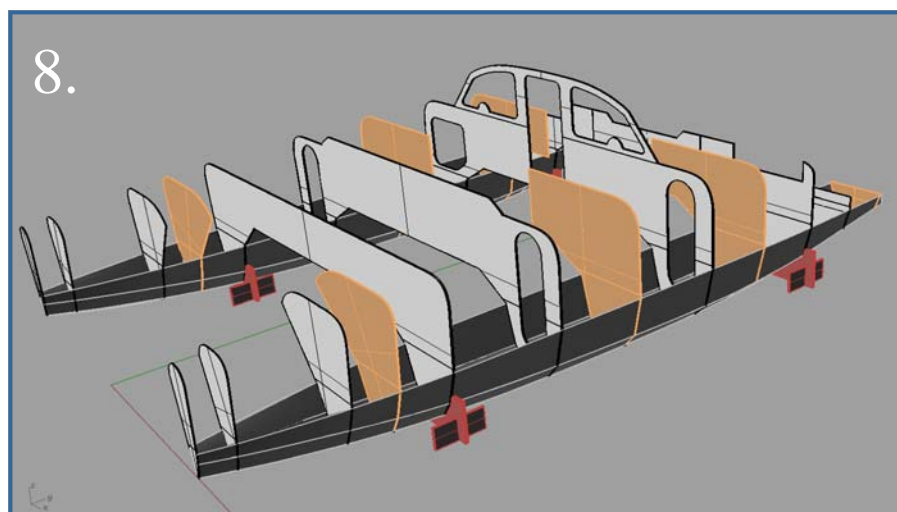
6. Use ply tabs screwed to shoe Bhd faces at joins, drop Bhd tops in position and fasten to ply tabs when centered and aligned. Check top parts are level by sighting top and bottom edges to each other.

NOTE: A typical Wilderness X Series kit is shown, this may not reflect your kit exactly.

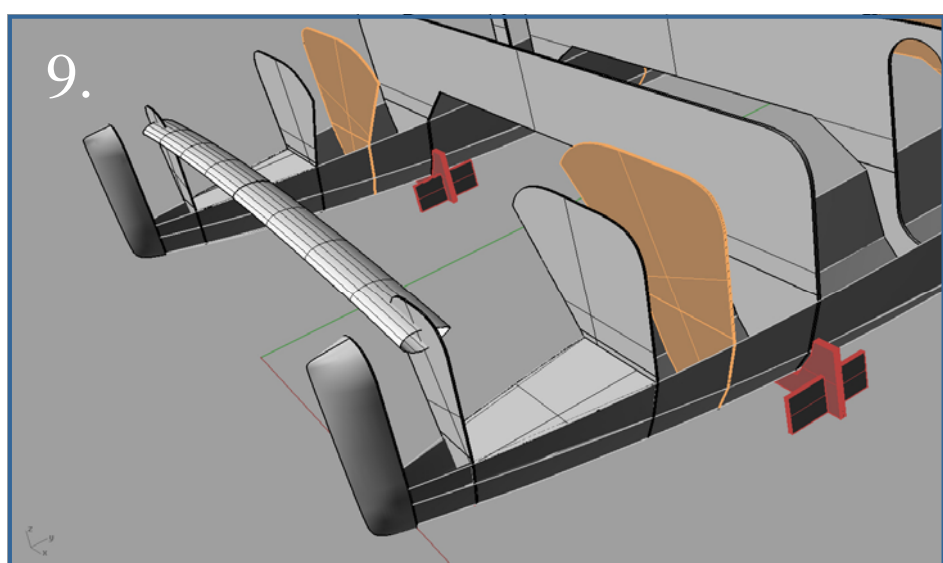




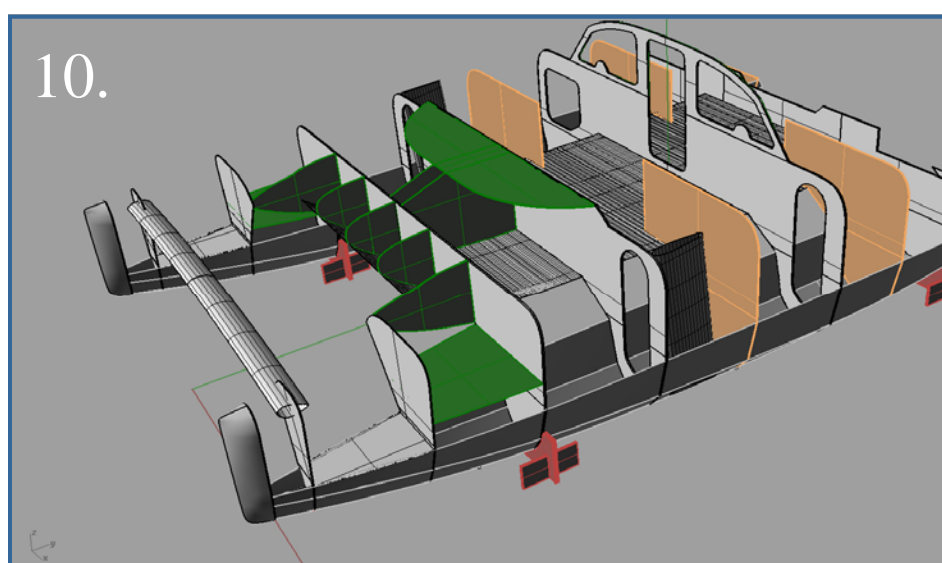
7. Tape across the Bhd joins (Bhd Details Sht), check Bhd's are flat transversely.



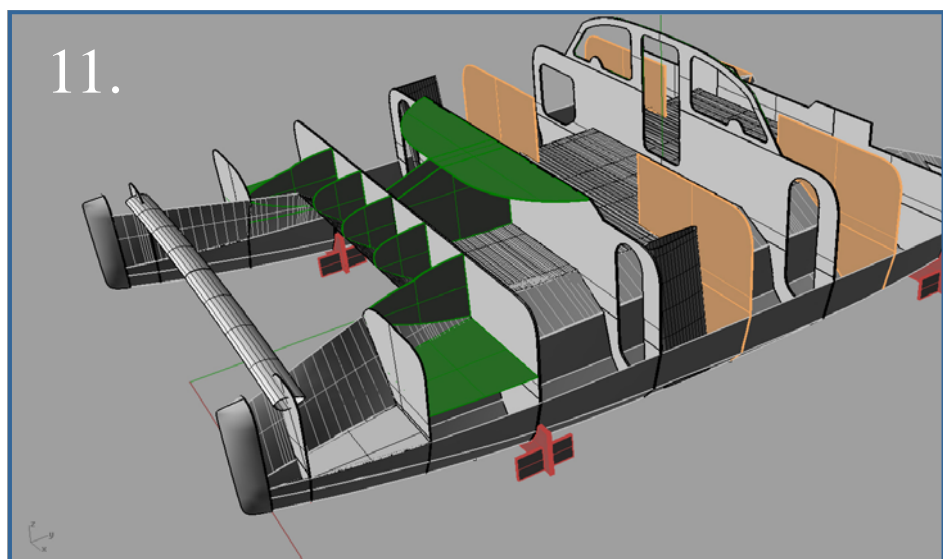
8. Top parts of the MDF bulkheads are attached in preparation for the chamfer panel installation.



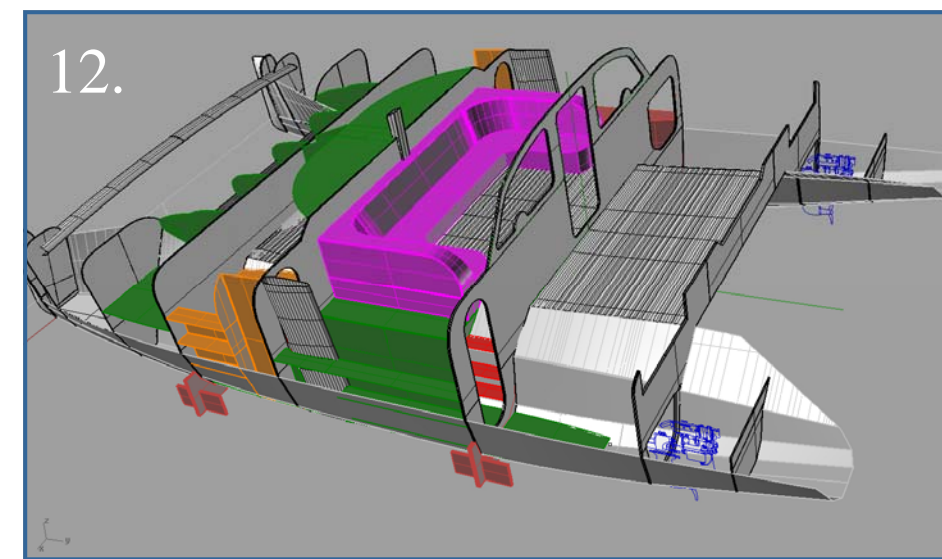
9. The composite forebeam is installed to provide stability to the bows, horizontal collision webs are more easily installed now. Min two epoxy coats are required on surfaces inside a buoyancy chamber inc Duflex. Striker can be installed before this stage.



10. Install fwd webs and dash (dark green), assemble bridge deck (bb manual) and install under Bhd's. Tape Bhd joins and webs, dash, forebeam etc.

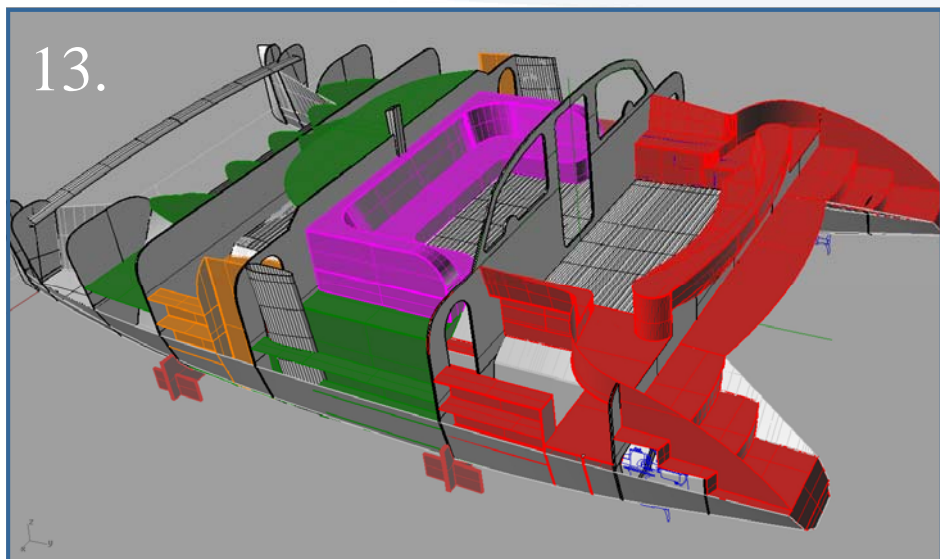


11. Install chamfer panels, there is usually high twisting stress in this panel around Bhd 2-3, any Z scarfs in this area are suggested to have a 100mm tape applied to outside face. A Spanish windlass or ratchet straps are usually required to pull the top edge of the panel in to BH0. Tape Chamfer & Bhd joins. Many of the internal structures can now follow.

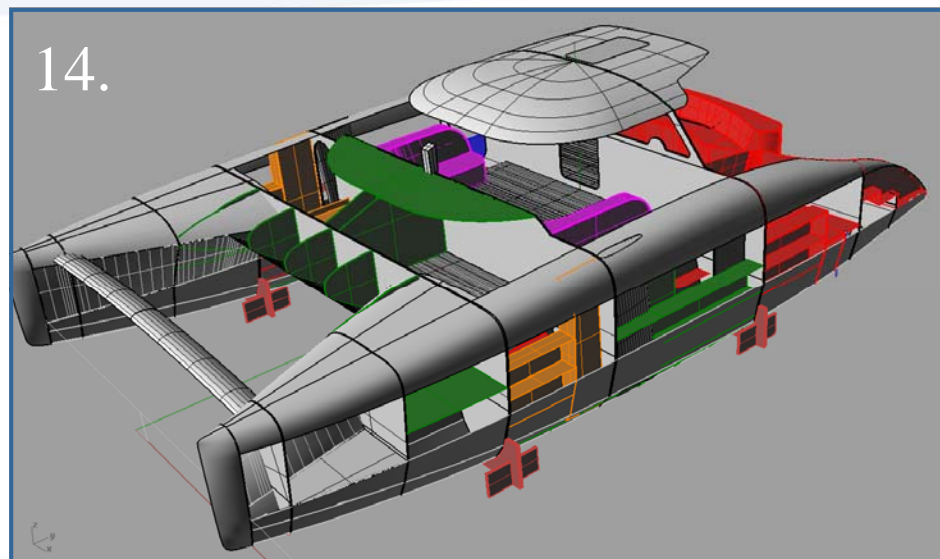


12. Install furniture, cabin soles, dagger board cases, rudder tubes and inboard engines. Tape inside fwd buoyancy chambers and apply epoxy sealer coats at this stage. Install as much as possible in the engine rooms before closing the area off. Tape the outboard parts of the dagger cases before installing hull topside panel.

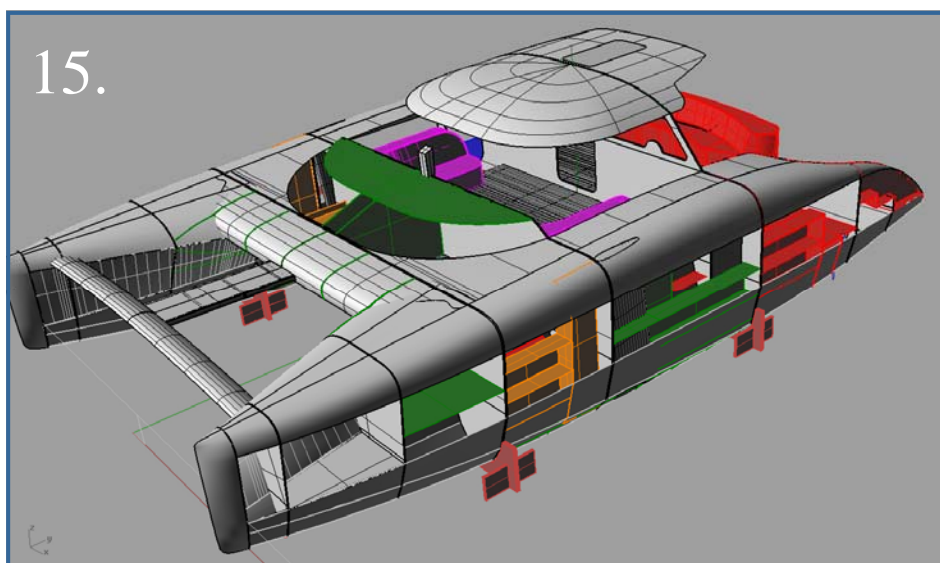




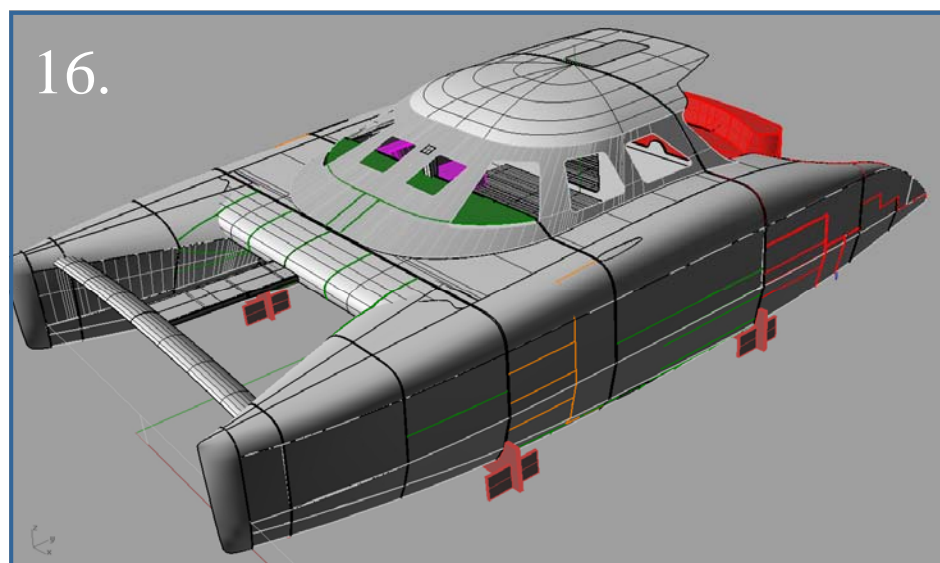
Furniture almost finished, install transom, duckboard and cockpit parts, build any integral engine room hatches and guttering before finally installing step pieces. Striker bridle attachment fittings, chainplates and prodder anchor blocks have to be installed before planked decks are completed.



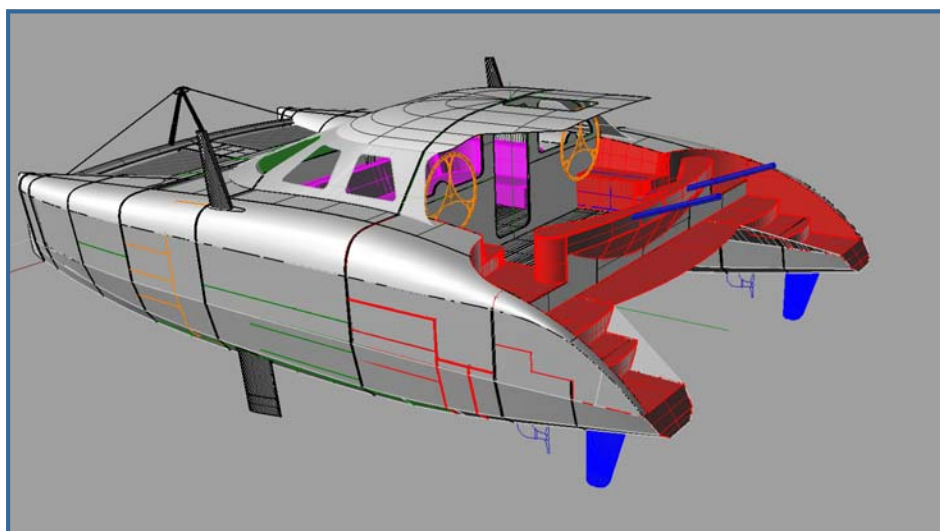
Saloon top is built separately (Saloon top A3 Sht & Plots), finish underside as much as possible before installing, consider any wiring pathways required. Plank, glass and glue on decks, install any integral hatches or guttering before final fixing. These strip planked parts are available for purchase through Schionning Marine.



Precut flat decks and catwalk in place, support edges of flat deck so it can be walked on to install the saloon front and side panels.



The pre-cut saloon sides and front installed. The large hull side panel is put in place once all lockers are finished internally and any taping completed.



Steering, striker and stop, davits and final placement of deck equipment takes place, followed by final finishing and painting.

