SL2-A1-02A SLINO Build Sequence

Markla 11.11.10

This boat was designed for a very fast build. As such below you will see a number of phases with concurrent tasks. You can jump between these concurrent tasks while waiting for resin to cure etc, or if you are lucky enough to have friends or slaves they can be working on the concurrent tasks. Generally you will need to complete all tasks within a phase before moving on to the next one.

Where possible, don't let resin cure where you need to overlaminate it later. For example on the inner seams on the hull, aim to cove seam, tape seam, drop in frames, cove frames and tape frames all before the initial cove has cured. Slow hardner and an extra set of hands helps. If you can achieve this, no sanding is required prior to the fairing procedure which is nice.

I am publishing this information as a personal reference only. If you chose to replicate it, it is at your own risk.
This information carries no warranty and has not been thoroughly thought through or engineered.
Building and sailing a moth to this design could seriously hurt you.

If you do attempt to replicate derivate from this information please send me an email – I am always interested to see where this design leads.

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Phase	***Concurrent Tasks***			
0	Order cut parts Order materials Order consumables Order wing tubes	Get tools Clean/setup work space	Laminate some solid laminate, 300x300x4.5mm should be ample. Include plenty of E glass in this laminate (80%) as it is harder wearing than carbon.	Read all notes Review all drawings Review all photos
1	Assemble Hull Jig See Drawing SL2-H1-01 Assemble Deck Jig See Drawing SL2-H1-02 Assemble Foredeck Jig See Drawing SL2-H1-02	Remove peel ply from: • Hull inside • Deck outside • Foredeck exterior seams[i] Mark bulkhead locations on hull panels. See Drawing SL2-I3-01 Mark wand push rod penetrations on hull, deck and bulkhead parts. See Drawing SL2-I3-03	Decore hull and deck panels around centreboard case. See Drawing SL2-E2-01 Decore centreboard case as required. See Drawing SL2-E2-01 Cut push rod and wand axle penetrations into hull, deck and bulkhead. See Drawing SL2-I3-03	Build centreboard case. See Drawing SL2-E2-01 Insert solid laminate into stem piece and add Unis. See Drawing SL2-E3-01 Insert solid and add unis to into transom lugs. See Drawing SL2-E3-01

Phase	*Concurrent Tasks*			
2	Insert hull panels into jig and hot glue to frames. See Drawing SL2-E1-02 Test fit bulkheads and frames Laminate internal hull seams and stem piece. See Drawing SL2-E1-01 Immediately install and laminate: • Frames • Bulkheads • centreboard case • Transom • Transom lug. • Mast king post	Hot glue deck pieces to jig. Laminate external deck seams See Drawing SL2-E1-02	Hot glue foredeck to jig Laminate external seams See Drawing SL2-E1-02	Build wings See Drawing SL2-F1-01
3	Remove hull from jig Trim peel ply 50mm from seams Laminate external seams.	Remove deck from jig Laminate internal seams	Remove foredeck from jig Laminate internal seams Add mast ram reinforcing inside foredeck. See Drawing SL2-E4-01	Using transverse wing tube as a plug, mould up a 500mm long half tube in E glass (if alloy wings) or carbon for carbon wings.
4	Dremel perimeter of hull panels. Dremel perimeter of foredeck. Dremel across each frame. Cut bung hole into transom, decore and back fill.	Glue deck on and laminate to hull. See Drawing SL2-E1-02 Concurrently build wing foundations[ii] See Drawing SL2-E4-01 Laminate deck to centreboard case.		Cut wing half tubes into lengths for wing mounts and washer plates. See Drawing SL2-E4-01
5	Insert wand axle and push rod conduit.	Glue foredeck on and laminate to hull and bulkhead.	Drop wings on and laminate wing mounts. See Drawing SL2-E4-01	
6	Drill lacing holes for tramps. Decore and back fill. Wipe fairing compound over all seams	Insert solid into gantry lugs and apply unis. See Drawing SL2-F2-01	Assemble cradle See Drawing SL2-F5-01	Build external mast ram. See Drawing SL2-E4-01
7	Redrill lacing holes. Fair all seams. Patch fill with fairing compound	Laminate gantry external seams See Drawing SL2-F2-01	Insert solid into spreaders and apply unis See Drawing SL2-F3-01	Get tramps made.
8	Final fair seams. Apply undercoat	Remove gantry from jig and laminate internal seams See Drawing SL2-F2-01	Undercoat spreaders[iii]	
9	Fit centreboard to hull[iv] Assemble push rod system. See Drawing SL2-G1-01	Apply clear coat	Top coat spreaders	

Phase	*Concurrent Tasks*	
10	Apply top coat	Get shrouds made.
11	Pimp the boat with pulleys, ropes mast sail etc. See Drawing SL2-F4-01	Pull on lots of rig tension, downhaul, vang and mainsheet and hope nothing breaks. Fix it if it does.
12	Up for a sail?	

Foot Notes:

[i] Only remove the peel ply from where the seam is going to go. Use a knife to score the peel ply 50mm away from the seam. Then only remove this 50mm strip of peel ply. This will preserve the carbon finish for painting/clear coating later. If you are really smart you can make a little machine that holds a knife blade 50mm away from a guide that follows the edge of the panel. This keeps a consistant 50mm.

[ii] Take special care and review this drawing. You need to wet out half of the uni and apply it to the inside of the hull before dropping the deck on. After immediately after dropping the deck on it needs to be folded over on top of the deck. This is a very delicate procedure and crucial for a good load transmission from the wings.

[iii] Don't bother painting the gantry. Its going to break anyway.

[iv] I just added high density bog to my centreboard. Others have built cassettes that make up the difference. The choice is up to you.