

Mounting the Moulds & Frames

The moulds have been designed in such a way that you should be able to get these almost perfectly in position with little trouble, using interlocking battens.

When mounting and securing the moulds, remember that when the time comes to turn over the hull, you will need to be able to remove ALL of the moulds and stem curves before lifting the hull. Make sure that the screws holding the pieces in place can be removed when the planking is in place!

1. Align the bottom of the triangular skims on Mould 1 to the top of the datum crossbeam, clamp, then screw it into position from the inside of the frame.
2. Screw the spalls to the bottom edge of the moulds. Screw from the plywood through to the timber. The spalls help keep the moulds straight and support the weight on the rails.
3. Use the spacer bars to get the correct spacing between the moulds. Note that the spacers are numbered against the moulds. The spalls should be on the inward side of the moulds - on Moulds 2 & 3 they are aft of the mould and on 4, 5, & 6 they are fwd.
4. Make your best effort to get the moulds lined up correctly, then temporarily clamp them to the rails.
5. Add the stem guides to Moulds 1 and 6 as shown. The flat of the triangular skim aligns with outside of the mould. The support brackets can be a very tight fit - use some sandpaper if necessary (the thickness of the ply used for these can vary by more than 1mm).
6. Clamp a piece of timber to the bottom of the stem supports to give it some support on the floor, and ensure that the brackets are horizontal using a spirit level. Check also that the stem supports are square to the moulds, and secure, again making sure that any screws can be removed when the planking is complete.
7. Run a piece of fine string from the holes in the stem supports through the holes cut in the moulds. There are two holes cut in each mould - use one side or the other - the two holes are there simply so that you can run the string down either side of the stem supports.
8. Stretch the string as tight as you can and align the moulds by centring the string in the holes, vertically and horizontally.

Horizontally, you are looking for accuracy $\pm 1\text{mm}$, vertically $\pm 2\text{mm}$.

9. If you have a dead straight keelson, this is more effective for aligning the moulds.
10. When you are finished with aligning the moulds, secure all with screws, ensuring that the moulds are perpendicular to the rails.
11. Finally in this stage, clamp the frames to the moulds in the correct position - on moulds 2 & 3 they are fwd of the moulds, on 4 & 5 they are aft of the moulds.

