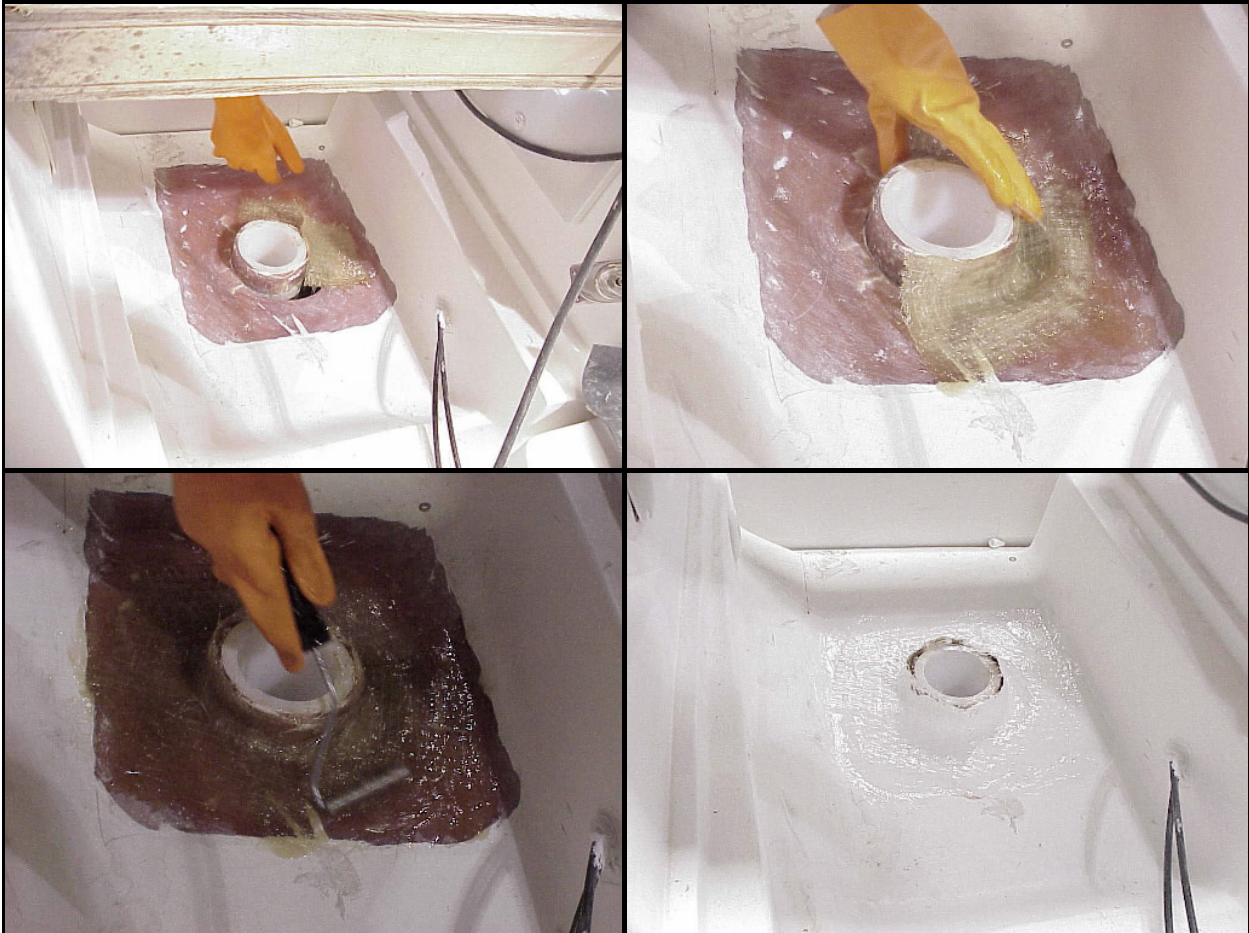
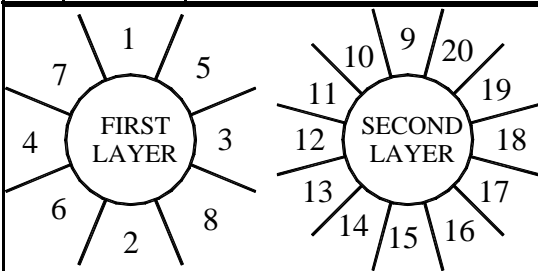


356 SOP RUDDER POST BONDING



#	#Ea.	Description	Size	Part #
1	20	Fabmat # 2415	4" x 6"	150970
2	1 pt.	Gelcoat White Interior	AB WG-AB11X-6008	102383



1. The rudder post is located in the cockpit walk through.
2. Grind the rudder post, using a 3" - 40 grit sanding disc.
3. Clean rudder post and deck area using alcohol.
4. Wet out 20 bonds, 4" x 6" each, using 1 pint of resin and 1 shot of red MEKP.
5. Use paper to carry the bonds to the boat.
6. Lay the bonds over lapping each other (see drawing for order to lay bonds). All 20 bonds will be used. Roll the bonds well to remove all air.

7. Place the helmsmen seat cover in place to ensure that no one steps on the bonds while they are curing.
8. After the bonds have cured, regrind and paint the rudder post area with white gelcoat.
9. Place the helmsman seat back in place to ensure that no one steps on the gelcoat before it dries.

Revision Dates: _____ Expected Time: 20 min.