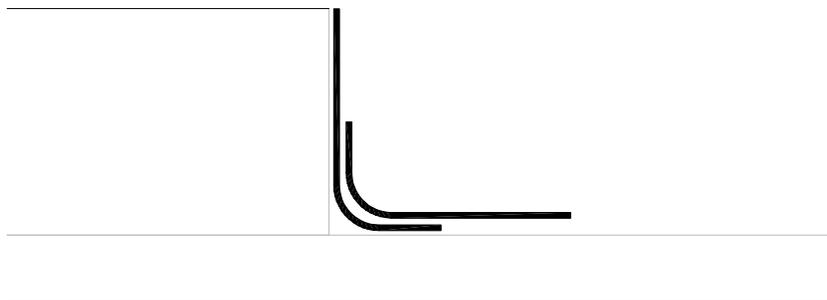




1. Draw the 24" (61 cm) reference lines.
2. Draw the offset dimensions for panel drawings provided. Create curves. Double check your work before you cut! Be sure to draw the frame/bulkhead reference lines. For Top Panels, draw the reference lines ON BOTH SIDES OF THE PANELS.
3. Cut out one each of the top panel half, side panel half, bottom panel half, end bulkheads, and mid frame.
4. The pontoons are symmetrical. Use the items you cut out as templates for the remaining parts.
5. Butt block the short panels to form long panels. Use wooden butt blocks 10" (25 cm) wide. Be sure to bevel the edges of you butt blocks so the pontoons assemble correctly.
6. Stitch the floor and side panels together. Stitch the frames and bulkheads to the reference lines drawn. Measure diagonals to ensure the pontoon is assembled square.
7. Apply masking tape to exterior pontoon seams.
8. Coat wood within 3" (7.6 cm) of all seams with resin.
9. Tack-weld the panels, frames, and bulkheads into place.
10. Remove stitches. Remask exterior seams as needed.
11. Fillet and apply fiberglass tape to seams. Spread excess resin from glass onto interior bare wood. Ensure all interior wood has 2 coats of resin total.
12. Cut ½" (1.3 cm) strips for tops of frames and bulkheads to form Tcleats. Glue cleats into place on top of frames and bulkheads.
13. Flip pontoons. Remove masking tape. Grind/sand a radius on exterior seams. A more rounded seam will be easier to apply fiberglass tape to.
14. Fill in any cavities or voids.
15. Coat wood within 3" (7.6 cm) of all seams with resin.
16. Apply fiberglass tape to seams. Spread excess resin onto bare wood. Ensure all wood has 2 coats of resin.

17. Flip pontoons upright. Grind a 45-degree bevel to the top of the side panels and underside of top panels to form a 90-degree channel for seam filleting material. Recoat any bare wood with resin.
18. Optional: Fill pontoons with buoyancy foam.
19. Apply a heavy bead of thick glue material to top of T-cleats made earlier. Place top panels and weigh down ensuring contact between top panels and their respective three (3) T-cleats.
20. Apply filleting material in channels formed earlier. Let cure. Grind/sand a radius as before. Recoat any bare wood with resin. Fiberglass tape seams.
21. Draw a line from tip to tip on top panels of pontoons.
22. Cut three (3) 2x4s, 4' (1.22 m) long. Ensure the lumber for beams is straight and void/knot free. Coat beams with resin. Alternative: Create beams by glueing strips of leftover plywood together.
23. On level surface, align pontoons parallel to each other, 4' (1.22 m) apart on center. Measure tip to tip to ensure proper spacing. Measure diagonal tip to tip between pontoons to ensure squareness.
24. Glue lumber in place. Align to reference lines and placed to the edge of the center lines. Lumber will form a “frame” to mount a 4'x8' sheet of plywood for the deck.
25. Fillet and tape all seams formed by beams and pontoons with a double overlapping layer of tape as shown:



26. Ensure beams are coated with two (2) coats of resin.



27. Glue the deck to the beams. Fillet and fiberglass seams. Alternative: Use wood screws every 4" (10 cm). Glue beams to deck even if using wood screws. Seal all screws with resin. Round deck edges, add modifications as desired. Ensure deck wood is coated with 2 coats of resin.

28. Note: The pontoons are shaped for displacement, not planing. Anything more than an electric trolling motor will only drive the pontoons deeper into the water and not move you any faster. Install oar-locks and oars even if you plan on using a electric trolling motor. Those batteries don't last forever! A push poll for shallow waters would also work as a nice propulsion back-up.

29. Sand, fair, paint (we recommend using anti skid for top of the deck and top of pontoons).

**30. Send pictures!**