

Biscayne 18 Bill of Materials

LUMBER & PLYWOOD: All plywood must be intended for marine or exterior use; interior grades are not acceptable. The marine grade panel features higher grade inner ply cores, while the exterior plywood grade cores may have voids not apparent to the eye, and may also use cores made from woods not as suitable for marine applications. In most cases, the glues used in both the marine and exterior panels are the same waterproof type, however, the decision to use exterior panels in lieu of marine panels must lie with the builder, considering the particular use of the panel in the boat and the expected service. The letters A, B and C designate the grade of the exterior veneers with A grade the best, etc. Douglas-fir plywood is acceptable for all plywood, although mahogany or other attractive veneers are preferable in many instances as described in these instructions.

All lumber used should be first grade, free from knots, shakes, checks, or other defects. All *widths are actual size except for lumber 2" in thickness where widths are also nominal*. All thicknesses are standard finished sizes, with *1" lumber being four quarters material, usually finished to about 3/4"*. Grouping lumber and purchasing "random-random" material to resaw to the required size will result in considerable savings. All lumber sizes should be checked to the work before purchasing wherever possible. Lumber typical to the locale and proven in use in boats of similar type can be used as long as the weight, strengths, and characteristics are similar. Suitable boatbuilding woods include white oak, mahogany (Mahog.- Philippine dark red, American, or African types commonly used in boats), Sitka spruce (SSP), Alaskan cedar, Port Orford cedar, Douglas-fir (DF), longleaf yellow pine, apitong, and teak.

HULL MATERIAL LISTING: The following material listing is an estimate of the materials required to build the basic hull. The material listing is intended to serve as a general guide only and should not be used to purchase materials until the various options and alternatives have been checked to the plans, to the work, and to the materials which may be available in the area in which the hull will be built. The listing may vary due to the amount of waste and other variables that cannot be controlled.

ITEM	MATERIAL	SIZE	NO. PCS.
LUMBER:			
Sizes given as net thickness and width; lengths allow extra for trimming and/or multiple members.			
Framing/beams/transom	Mahog, DF, SSP	1" Nominal random-random stock (3/4" Net), 100 bd. ft. with some widths to 8"	
Keel	Mahog, DF	1/2" x 4" x 15'	2
Chine logs	Mahog, DF, SSP	3/4" x 1-3/4" x 19'	2
Motor stringers	Mahog, DF	1-1/2" x 3-1/2" x 13'	2
Motor stringer blocking	Mahog, DF	1-1/2" x 3-1/2" x 8'	2
Battens	Mahog, DF, SSP	3/4" x 3/4"	340'
Sheer clamps	Mahog, DF, SSP	5/8" x 1-1/8"	100'
Deck clamps	Mahog, DF, SSP Mahog	5/8" x 3/4" 3/4" x 1-1/4"(*)	120' 40'
Spray rail	Mahog	5/8" x 1-1/2" x 19'	2
Deck strongback	Mahog, DF, SSP	3/4" x 4" x 18'	1
Deck battens	Mahog, DF, SSP Mahog, DF, SSP Mahog, DF, SSP	3/4" x 1-1/2" x 18' 3/4" x 1-1/2" x 17' 3/4" x 1-1/2" x 11'	2 2 2
Carlings	Mahog, DF, SSP	3/4" x 3" x 11'	2
Hatch framing	Mahog, DF, SSP Mahog, DF, SSP	3/4" x 3" x 8' 3/4" x 2" x 8'	2 2
Covering board	Mahog	1/2" x 4"(*)	45'
Hull/deck planking Mahog veneer and/or plywood, 1/8" thick random-random stock, approx. 950 sq. ft.			
(*) Requires wider stock initially for sawing to required shape - check to work.			
PLYWOOD:			
ITEM	MATERIAL	SIZE	NO. PCS.
Stem, breasthook,	DF Ext AB	3/4" x 4" x 8'	2

floor timbers			
Gussets	A-B Ext.	3/8" x 4' x 8'	1
Sub-deck	A-B Ext.	1/4" x 4' x 8'	5
Seats, floorboards, Transom	A-B Ext.	1/2" x 4' x 8'	4

FASTENINGS:

- **Screws:** Flathead wood type, bronze or hot dipped galvanized
- 1" #8 = 500 (4 gross)
- 1 1/4" #8 = 500 (4 gross)
- 1 1/2" #8 = 800 (6 gross)
- 2" #10 = 200 (2 gross)
- 3" #14 = 20 (2 doz.)

Nails: Ring type boat nails, bronze or Monel

- 1" #12 = 2 lbs.
- 1-1/4" #12 = 1 lb.

Carriage Bolts: Bronze or hot dipped galvanized complete with nuts and washers. Size per schedule; take lengths directly from work.

Adhesives: Epoxy adhesives are advised throughout the construction. These may be an epoxy adhesive or epoxy resin. Epoxy resins should be used with thickeners (silica or equal) per the instructions with the resin and/or thickening agent. Due to the noted options, the amount required is difficult to estimate. Start with a gallon container of epoxy and after use you will be better able to estimate the total amount required.