

## Torpedo Bill of Materials

**MATERIAL - 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 grade cores may have voids not apparent to the eye, use cores made from woods not as suitable for marine applications, and be less than the specified thickness. 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. 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, Port Orford cedar, or Douglas-fir (DF).

**HULL MATERIAL LISTING:** The following material listing is an estimate of the materials required to build the basic hull. The 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. Lumber listed as 1" is to be "four quarters" stock milled; this usually results in a 3/4" thickness. **DO NOT BUY 1" NET LUMBER.** Lumber listed as 5/8" in thickness may be ripped from 1" stock. All widths are net and lengths allow for fitting. All 2" lumber is to be "lumberyard size" in both thickness and width. Thus a 2" x 6" will probably net 1-1/2" x 5-1/2".

ITEM	MATERIAL	NO. of PIECES	SIZE
<b>LUMBER COMPONENTS</b>			
<b>Transom #0:</b>			
Uprights	Mahog.	1	1" x 4" x 18" (makes two)
Floor Timber	DF or Mahog.	1	2" x 4" x 26"
Bottom	Mahog.	4	1" x 4" x 32"
Horizontal Shelf	Mahog.	1	1" x 4" x 68"
Side Frame	Mahog.	1	1" x 4" x 18" (makes both)
<b>Frame #1:</b>			
Sides	Mahog.	1	1" x 3" x 6" (makes two)
Bottom	Mahog.	2	1" x 3" x 32"
<b>Frame #2:</b>			
Sides	Mahog.	2	1" x 3" x 33"
Bottom	Mahog.	2	1" x 5" x 25"
<b>Frame #3:</b>			
Sides	Mahog.	2	1" x 3" x 26"
Bottom	Mahog.	1	1" x 3" x 60" (makes two)
Deck Beam	Mahog.	1	1" x 8" x 7" (makes #3 & #6)
<b>Frame #4:</b>			
Sides	Mahog.	1	1" x 3" x 54" (makes two)
Bottom	Mahog.	2	1" x 4" x 38" (makes two)

Deck Beam	Mahog.	1	1" x 7" x 6' 8"
<b>Frame #5:</b>			
Sides	Mahog.	2	1" x 4½" x 28"
Bottom	Mahog.	2	1" x 5" x 34"
Deck Beam	Mahog.	1	1" x 6" x 6'
<b>Frame #6:</b>			
Sides	Mahog.	2	1" x 4" x 30"
Bottom	Mahog.	2	1" x 5" x 30"
Deck Beam	Mahog.	1	1" x 9" x 7'
<b>Frame #7:</b>			
Sides & Bottom	Mahog.	2	1" x 4" x 51"
Deck Beam	Mahog.	1	1" x 7" x 6'3"
<b>Frame #8:</b>			
Sides & Bottom	Mahog.	2	1" x 5" x 38"
Deck Beam	Mahog.	1	1" x 6" x 51"
<b>Foredeck:</b>			
Strongback	Mahog.	1	1" x 2" x 9'
Battens	Mahog.	4	5/8" x 1¼" x 7'
Battens	Mahog.	2	5/8" x 1¼" x 6'
<b>Aft Deck:</b>			
Battens	Mahog.	2	5/8" x 1¼" x 7'
Battens	Mahog.	2	5/8" x 1¼" x 8'
<b>Other Lumber Components:</b>			
Keel	Mahog.	2	1" x 4" x 17'
Chine	Mahog.	4	1" x 2" x 20'
Sheer	Mahog.	2	1" x 1¼" x 8'
Bottom Battens	Mahog.	2 2 2	1" x 1¼" x 18' 1" x 1½" x 17' 1" x 1¼" x 17'
Side Battens	Mahog.	2 4	5/8" x 1¼" x 20' 5/8" x 1¼" x 16'
Motor Stringers	DF	2	2" x 6" x 14'
Motor Stringer Extension	DF	2	2" x 4" x 3'
Motor Stringer Clips	DF or Mahog.	1	2" x 2" x 10' (makes 12)
Hatch (Vertical Members)	Mahog.	4	1" x 3" x 4' 6"
Carlings	Mahog.	1	1" x 4" x 6'

**PLANKING:**

TORPEDO instructions give several options for planking, thus the following quantities are given in square footage of area to be covered. If three laminations are used, multiply the area to be covered by three to obtain the total square footage required. Cold-molded construction results in considerable waste; add 20% to the square footage of veneer to obtain the total required. If a natural finish is desired Mahogany (dark red Philippine or Honduras) is advised for the outer lams.

- Total area for both sides = 72 sq. ft.
- Total bottom area = 90 sq. ft.

**PLYWOOD:**

Minimum plywood grades are listed. Exterior (ext.) grade plywood is specified, however a full marine panel is preferable. The letters "AB" designate the quality of the exterior veneers, however "AA" panels are better. Douglas-fir (DF) veneers are acceptable, but mahogany or similar veneer surfaces are desirable for a natural finish and some imports are of higher quality than U.S. specifications.

Gussets, harpin, lower deck & #0	DF Ext AB	2	3/8" x 4' x 8'
Deck underlayment	DF Ext AB	4	1/4" x 4' x 8'
Floor timbers, stem, knee & breasthook	DF Ext AB	1	3/4" x 4' x 8'

**FASTENINGS:****NAILS:**

Bronze ring type boat nails.

- 3/4" #14 - 1 lb.
- 1" #12 - 4 lbs.
- 1 1/4" #12 - 1 lb.

**SCREWS:**

Flat head wood screws, silicon bronze.

- 1 1/4" #8 - 200
- 1 1/2" #8 - 400
- 2" #10 - 20
- 3" #14 - 25

**Carriage Bolts:**

Hot dipped galvanized or bronze with nut and washer; lengths to be taken from the work.

- 3/8" - 2 required at stem/keel junction.
- 1/4" - 52 required for clips.
- 1/4" - 16 required for frames to deck beams.

**ADHESIVES:** Epoxy adhesives are advised throughout the construction, either an epoxy glue or epoxy resin. Epoxy resins should be used with thickeners (wood flour, microspheres and silica or equal) per the instructions with the resin and/or thickening agent. Wood flour with epoxy will dry to a brown color and is preferable for bedding final mahogany laminates in place.

Due to the noted options and the probable waste the amount required is difficult to estimate. Start with a five gallon container of epoxy and after use you will be better able to estimate the total amount required.