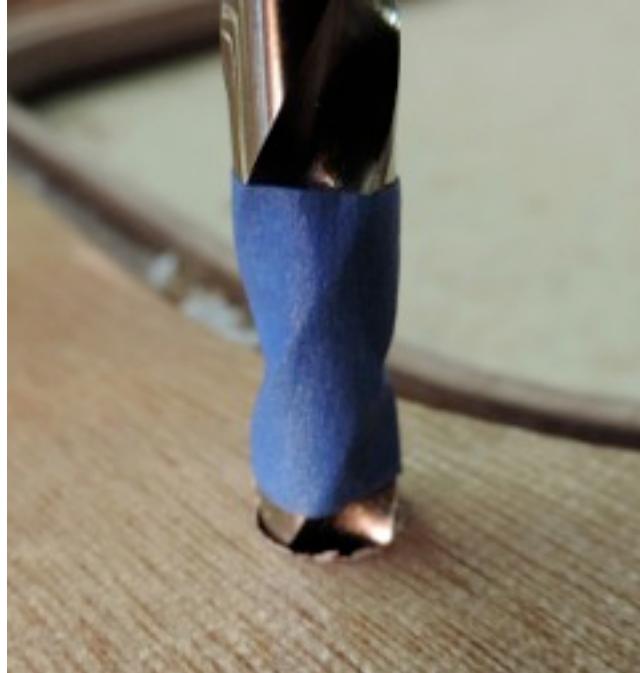


HATCH TURN DOGS

Drill the holes 1/2" away from the hatch cut out edge, to a depth of 5/8"

Mark drill bit as shown for depth.



Coat the walls of the holes with epoxy by dipping the but end of a smaller drill bit as shown below. Wait for this to cure or fill the holes at the end of the day (dropping temperatures) to try to avoid pesky bubbles.



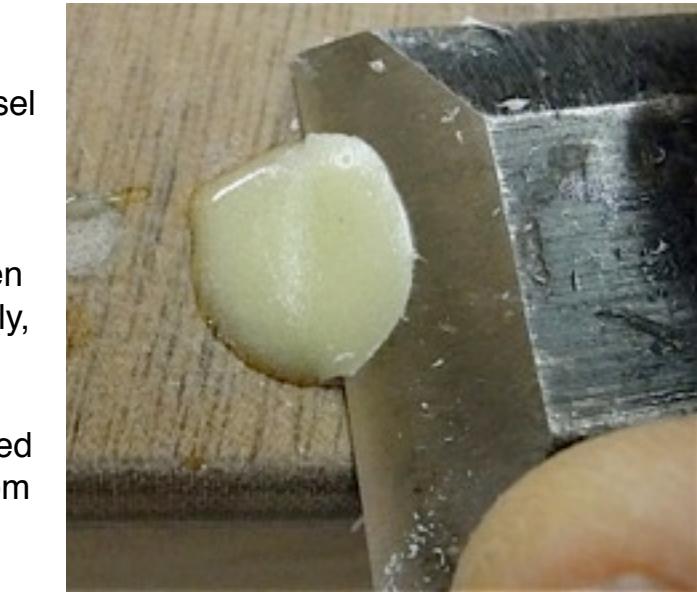
Add a small amount (the mix must pour) of 404 high-density fibers to epoxy to pour into the holes. Pinch the edge of the cup to make a spout. Leave a small mound of epoxy over each hole.



When cured, warm up the mounds of epoxy and slice them off flat with a sharp, wide chisel held flat. Push sideways on the chisel with your thumb to slice off the bumps (a bit at a time) and then lightly block sand to finish.

Note: sometimes filled holes will bubble, even in cooling temperatures. If yours bubble badly, drill them out and fill again.

Use an awl to mark a center in the epoxy filled holes. These marks should be about 1/2" from the edge of the hatch cut-out.



Mark your 5/32" drill bit to the correct depth for the 5/8" #10 screws.



Drill the holes for the screws as square as possible to the surface and use a countersink to lightly bevel the edges of the holes.

Install all the screws & turn dogs. Make sure the screws are square to the surface when starting them. Remove the screws and apply a tiny bit of epoxy to the insides of the holes with a nail or the butt end of a tiny drill bit. Install the screws and turn dogs. Tighten the screws hard and then back off on them until the dogs turn with a medium amount of friction.

