

# Making the Launcher Throat



The first thing you'll need is the foam blank and saddles shown on the left (you get these and finished launcher throats from Greg Ryan)



Cut two 2x6's into a 16" radius as show above. These will be the side forms.



Cut two pieces of  $\frac{1}{4}$  plywood 10" wide and 30" long across the grain of the plywood as shown. Staple or nail one piece of plywood on the forms allowing it to hand over each form 1" (not as shown—but better)

# Launcher throat lay-up

Cut 2 pieces of hybrid 18" x 34" with the carbon running the long way. Cut a piece of s-glass the same size as well as a piece of peel ply and a piece of 2 mill (or thinner) plastic. Cut an old piece of cotton cloth the same size (ask her first before you take it from her sewing stuff). This will be used to soak up excess resin that come through the peel ply.

Cut the bottom foam saddle off at 31", the wing section at 31 ½" and the top at 32" (the length difference is to deal with the bigger radius as the pieces get further from the form).

Lay your piece of plastic down first followed by the piece of cotton cloth followed by the piece of peel ply. Lay you piece of s-glass on as the next layer and wet it out. Follow up with each layer of Carbon—wetting each one out and squeegeeing the air out in the process. Wet out the foam wing section and lay the trailing edge about 1" inside of the edge of the wetted material with an inch hanging over each end. Wrap the entire lay-up over the wind and pull on the plastic to bring it tight around the wings' leading edge. Place the wind in the lower saddle (the short one) and put the top piece on as well. Set the foam saddles with the wing inside on top of the form and the other piece of plywood on top of that. Clamp the assembly down to the lip of the form plywood starting in the center and working toward both ends. Carefully pull the carbon, the s-glass, and the peel ply and cotton tight from the ends and the trailing edge while keeping it forward in the saddles.

The epoxy will cure rapidly as the foam holds in the curing heat.



The overhanging lip on the form will eliminate the need for the big clamps shown above, Your clamps will only need a 2 ½ maximum jaw. (sorry for the poor picture)

# Finishing the launcher throat



When the part has cured, remove it from the form and remove the peel ply. Sand and fill any imperfections, cover the filler with peel ply and leave it until you bond it to the boat. When you finish your deck you can finish the launcher throat at the same time



After the launcher is installed on the boat, you will install these brass inserts for the jib blocks. The holes should be drilled oversize ( $3/8$ " for  $1/4$ " OD inserts) and the inserts bedded completely in epoxy. Drill the depth until you feel your bit hit the bottom skin of the launcher. Do not install these block until you have the spinnaker sock ready to install.

The finished launcher throat weighs 1 lb.

