Response Marine, Inc. **#536, Chesterfield 28x10.3' FBLC**

Entered 180828, as ordered from Pierce ~7/11/16
8/28/17

SHEET/PLATE for NC CUT

QTY	Alloy	Thick	Width	Lngth	approx. lbs/ft^2	lbs
4	5052	0.190	72	240	2.7	1,296
3	5086	0.190	96	288	2.7	1,555
3	5086	0.250	96	288	3.6	2,074
1	5086	0.250	96	240	3.6	576
2	5083	0.250	48	96	3.6	230
					Sub Total	5,731

SHEET/PLATE, uncut stock

(subsequent order from Yarde for misc.)

2	5052	0.125	48	96	1.8	115
1	5052	0.190	48	96	2.7	86
1	5086	0.250	60	120	3.6	180
					Sub Total	382
				Total All Sheet/Plate		6,113

Response #536 Chesterfield
EXTRUSION,

	QTY	Alloy	Item	Lgth (ft)	lbs/ft	lbs
Bottom & Door	5	6061 T6	3" x 1.498x 1.73# Channel	25	1.73	216
Roof	2	6061 T6	2x1x.13 Channel	25	.58	29
Door Slats	12	6061 T6	2x.5" Flat Bar	12	1.179	170
Transom Lip	1	6061 T6	2x.375" Flat Bar	12	.885	11
Door Stiff	4	6061 T6	2.5x.375" Flat Bar	12	1.106	53
Push Knees	2	6061 T6	4x.375" Flat Bar	12	1.77	42
Girder Flange	5	6061 T6	2x.25" Flat Bar	12	.59	35
Frame Int. FL	7	6061 T6	1.5x.25" Flat Bar	12	.4425	37
Deck	8	6061 T6	2" x .250" Sq Tube	24	2.1	403
Spud Tube	1	6061 T6	3.5" OD x .5" Wall Tube	12	5.542	67
Door	1	6061 T6	2" Sch 80 Pipe	20	1.74	35
Rails	5	6063	1.25" sch 40 Pipe	20	.79	79
Conduit	2	6063	2" sch 40 Pipe	20	1.26	50
Tie-Down	4	6063	1" sch 40 Pipe	20	.58	46
	4	6063	3" sch 40 Pipe	20	2.62	210
Rails	4	6063	1.5" sch 40 Pipe	20	.94	75
					Sub Total	1,559

Response Marine, Inc.

Plaz Parts for 28' LC- Chesterfield
File: WoodIsland\Deriv-MiscFB\Chesterfield
revised: 7/7/16

Print Date: 8/22/2019

1/8" 5052 Parts

Part #	Description	Pieces	Bending	Bending Instructions	NOTES:

Total Pieces: 0

3/16" 5052 Parts

Part #	Description	Pieces	Bending	Bending Instructions	NOTES:
PHB	Pilothouse Bulkhead, Aft, Above Deck	1	Y	B-1	
F1	Frame 1	1	Y	B-1	
F1-P	Frame 1, Topside, Port	1			
F1-S	Frame 1, Topside, Stbd	1			
F2	Frame 2	1	Y	B-1	
F2-P	Frame 2, Topside, Port	1	Y	B-1	
F2-S	Frame 2, Topside, Stbd	1	Y	B-1	
F3	Frame 3	1	Y	B-1	
F3-P	Frame 3, Topside, Port	1	Y	B-1	
F3-S	Frame 3, Topside, Stbd	1	Y	B-1	
F4	Frame 4	1	Y	B-1	
F4-P	Frame 4, Topside, Port	1	Y	B-1	
F4-S	Frame 4, Topside, Stbd	1	Y	B-1	
F5	Frame 5	1	Y	B-1	
F5-P	Frame 5, Topside, Port	1	Y	B-1	
F5-S	Frame 5, Topside, Stbd	1	Y	B-1	
F6	Frame 6	1	Y	B-1	
F6-P	Frame 6, Topside, Port	1	Y	B-1	
F6-S	Frame 6, Topside, Stbd	1	Y	B-1	
F7	Frame 7	1	Y	B-1	
F7-P	Frame 7, Topside, Port	1	Y	B-1	
F7-S	Frame 7, Topside, Stbd	1	Y	B-1	
F7-KP	Frame 7, Topside/Sidedeck Knee, Port	1			
F7-KS	Frame 7, Topside/Sidedeck Knee, Stbd	1			
F8	Frame 8, Topside, Port	1	Y	B-1	
F8-P	Frame 8, Topside, Port	1	Y	B-1	
F8-S	Frame 8, Topside, Stbd	1	Y	B-1	
F8-KP	Frame 8, Topside/Sidedeck Knee, Port	1			
F8-KS	Frame 8, Topside/Sidedeck Knee, Stbd	1			
FT-1	Fuel Tank Body	1	Y	On Marks, Match to Ends	

FT-2	Fuel Tank Ends	2		
FT-3	Fuel Tank Transverse Baffle	1		
FT-4	Fuel Tank Longitudinal Baffle	1		
FT-5	Fuel Tank Top	1		
J-PHR	Jig, House Roof	1		
PH-AFT	House Aft Bhd	1		
PH-DH	House Door Header	1	Y	On Marks, Tight Radius
PH-DT	House Door Threshold	1	Y	On Marks, Tight Radius
PH-FT	House Front	1	Y	On Marks, Tight Radius
PHR	House Roof	1	Y	On Marks, Tight Radius
PH-SPA	House Side, Port Fwd	1	Y	On Marks, Tight Radius
PH-SPB	House Side, Port Aft	1	Y	On Marks, Tight Radius
PH-SS	House Side, Stbd	1		
PHVA	House Visor Aft	1		
PHVF	House Visor Fwd	1		
PH-VS1	House Fwd Visor Stiff, IB	2	Y	Flange B-1
PH-VS2	House Fwd Visor Stiff, OB	2	Y	Flange B-1
RS-P	Raised Sole, Aft, Port	1		
RS-S	Raised Sole, Aft, Stbd	1		
SPB	Splashwell Bulkhead	1		

Total Pieces: 53

3/16" 5083/86 Parts

Part #	Description	Pieces	Bending	Bending Instructions	NOTES
BS-2A	Bottom Longitudinal (Girder) 2, Fwd, Stem to F6	2			
BS-2B	Bottom Longitudinal (Girder) 2, Aft, F6 to Tran	2			
FDC-AP	Foredeck Coaming, Fwd, Port	1			
FDC-AS	Foredeck Coaming, Fwd, Stbd	1			
SD-AP	Side Deck, Fwd, Port	1			
SD-AS	Side Deck, Fwd, Stbd	1			
SD-BP	Side Deck, Aft, Port	1			
SD-BS	Side Deck, Aft, Stbd	1			
SDC-AP	Side Deck Coaming, Fwd, Port Jog	1			
SDC-AS	Side Deck Coaming, Fwd, Stbd Jog	1			
SDC-BP	Side Deck Coaming, Aft, Port	1			
SDC-BS	Side Deck Coaming, Aft, Stbd	1			
SPS-P	Splashwell Side, Port	1			
SPS-S	Splashwell Side, Stbd	1			
TS-AP	Topsides, Fwd, Port	1			
TS-AS	Topsides, Fwd, Stbd	1			
TS-BP	Topsides, Aft, Port	1			
TS-BS	Topsides, Aft, Stbd	1			

TSL-AP	Topsides Stringer, Fwd, Port	1	Y	B-1
TSL-AS	Topsides Stringer, Fwd, Stbd	1	Y	B-1
TSL-BP	Topsides Stringer, Mid, Port	1	Y	B-1
TSL-BS	Topsides Stringer, Mid, Stbd	1	Y	B-1
TSL-CP	Topsides Stringer, Aft, Port	1	Y	B-1
TSL-CS	Topsides Stringer, Aft, Stbd	1	Y	B-1
TD	Transom Deck	1		
TDC	Transom Deck Coaming	1	Y	Bend as Marked, 45 Degrees

Total Pieces: 28

1/4" 5083/86 Parts

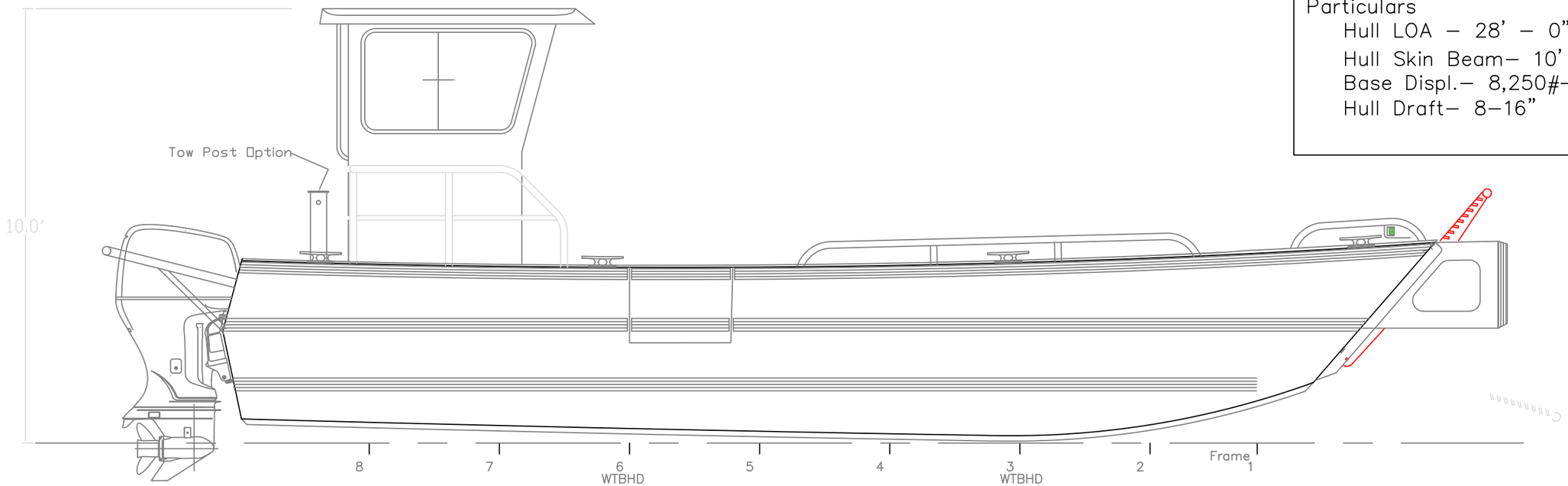
Part #	Description	Pieces	Bending	Bending Instructions
BOT-AP	Bottom Plate, Fwd, Port	1		
BOT-AS	Bottom Plate, Fwd, Stbd	1		
BOT-BP	Bottom Plate, Aft, Port	1		
BOT-BS	Bottom Plate, Aft, Stbd	1		
B-P	Bow Plate, Port	1		
B-S	Bow Plate, Stbd	1		
BS-0A	CL (Keel) Longitudinal, Fwd, Stem to F4/5 Bay	1		
BS-0B	CL (Keel) Longitudinal, Aft, F4/5 Bay to Tran	1		
BS-1A	Bottom Longitudinal 1, Fwd, Stem to F3	2		
BS-1B	Bottom Longitudinal 1, Aft, F3 to Tran	2		
BS-3A	Bottom Longitudinal 3, Fwd, Stem to F3	2		
BS-3B	Bottom Longitudinal 3, Aft, F3 to Tran	2		
BS-4A	Bottom Longitudinal 4, Fwd, Stem to F6	2		
BS-4B	Bottom Longitudinal 4, Aft, F6 to Tran	2		
DDDA	Dive Door Door Face, Fwd			
DDDF	Dive Door Door Frame, Aft		Y	Bend as Marked, 65 Deg. @ B-1A Back Guage Setting
DDHF	Dive Door Hull Frame, Aft		Y	Bend as Marked, 65 Deg. @ B-1A Back Guage Setting
DDHT	Dive Door Hull Threshold		Y	Bend as Marked, 90 Deg. @ B-1A Back Guage Setting PLUS 1"
DDTF	Dive Door Door Bottom		Y	Bend as Marked, 90 Deg. @ B-1A Back Guage Setting
DB-A	Deck Body, Fwd	1		
DB-B	Deck Body, Mid Fwd	1		
DB-C	Deck Body, Mid Aft	1		
DB-D	Deck Body, Aft	1		
DM-AP	Deck Margin, Fwd, Port	1		
DM-AS	Deck Margin, Fwd, Stbd	1		
DM-BP	Deck Margin, Mid, Port	1		
DM-BS	Deck Margin, Mid, Stbd	1		
DM-CP	Deck Margin, Aft, Port	1		
DM-CS	Deck Margin, Aft, Stbd	1		
PK-1	Push Knees			

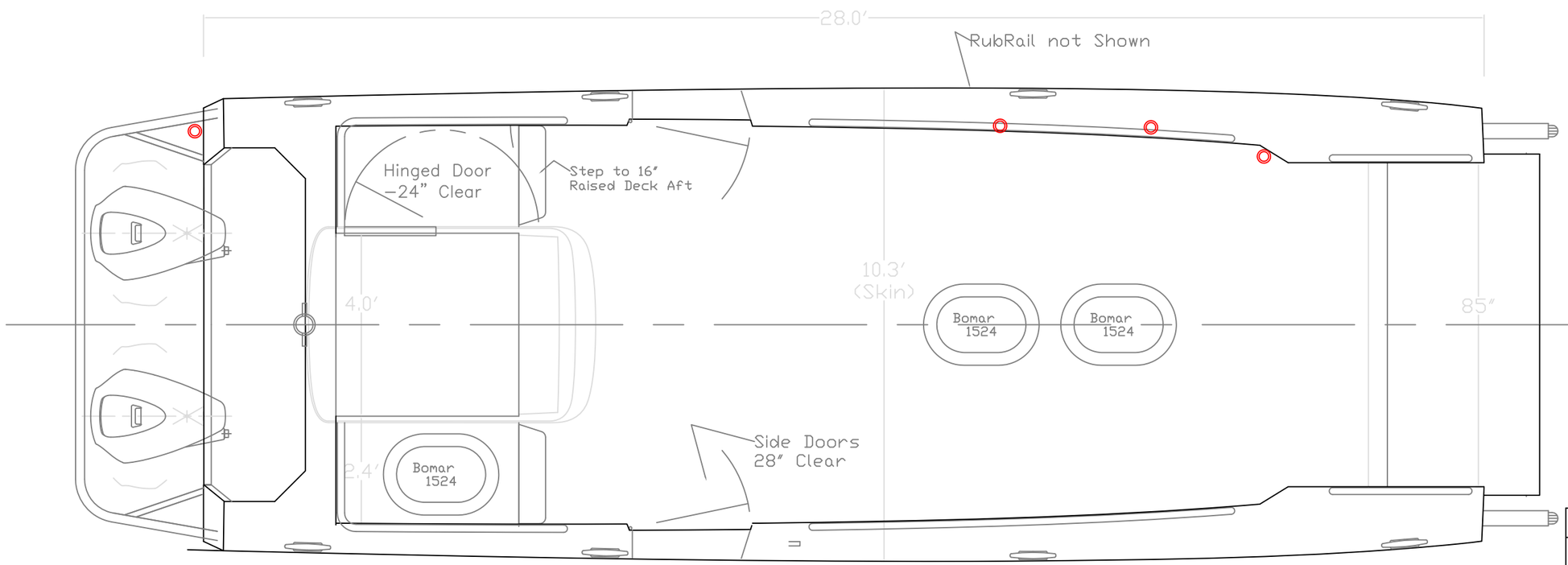
PK-2	Push Knee Top Plate		
PK-3	Push Knee Fwd Plate		
PK-4	Push Knee Bot Plate		
TK	Transom Knees		5
TR	Transom		1
		Total Pieces:	36

1/4" 5083

Part #	Description	Pieces	Bending	Bending Instructions
BDP	Bow Door Plate	1		
BDS	Bow Door Stiffeners	5		
BDS-P	Bow Door Stiffener, Port	1		
BDS-S	Bow Door Stiffener, Stbd	1		
		Total Pieces:	8	
	Total Cut Parts	**125**		

Particulars
Hull LOA – 28' – 0"
Hull Skin Beam– 10' 3½"
Base Displ.– 8,250#– 2 pax, 1/2 fuel
Hull Draft– 8–16"





OUTBOARD VIEWS

REV.	DESCRIPTION

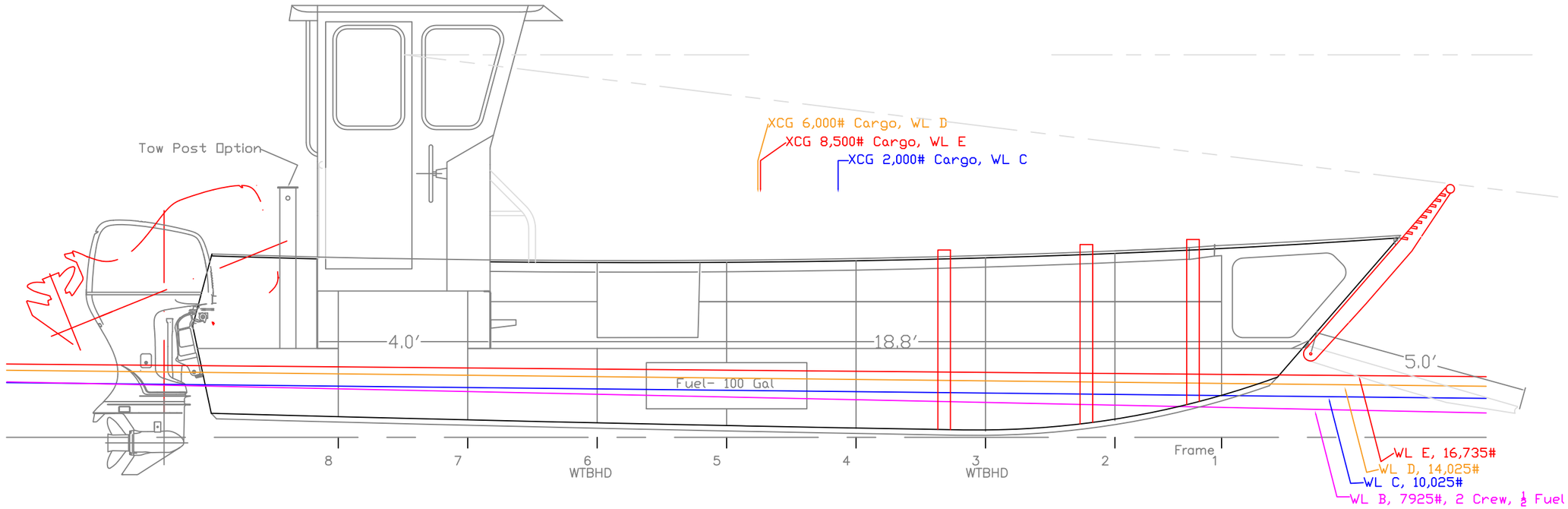
28' LANDING CRAFT
For: Chesterfield

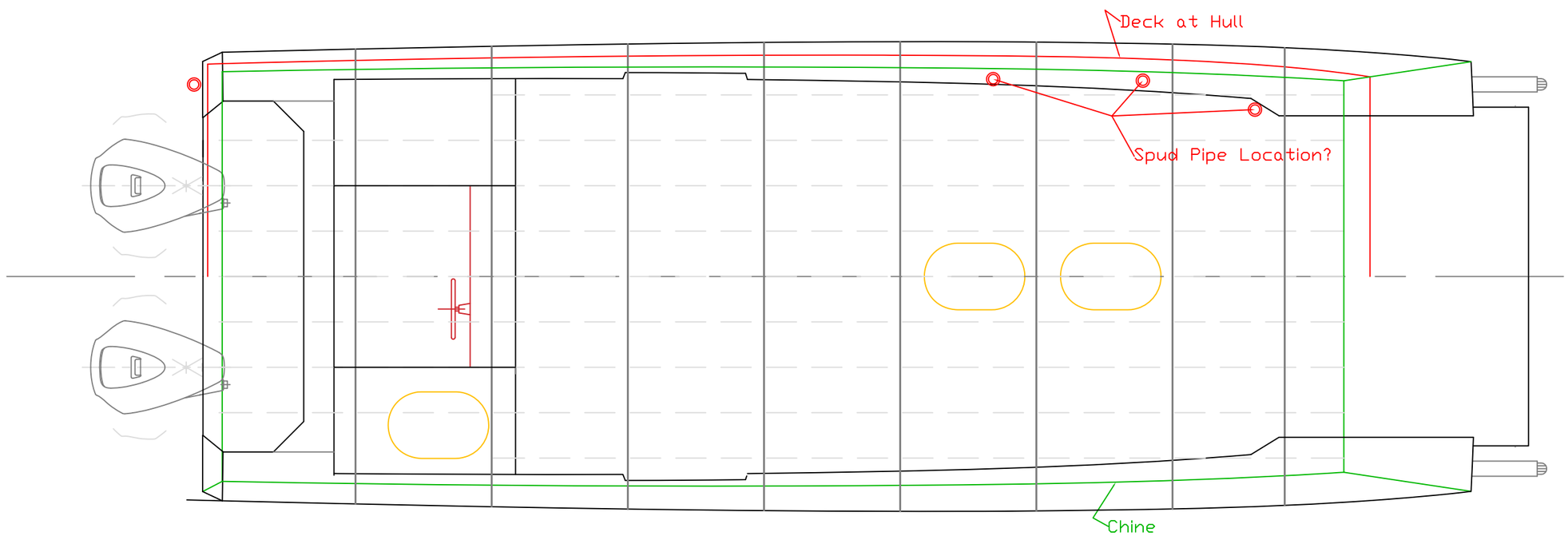
SCALE	DES/DWN	DATE
3/8" = 1'	WAL/JCC	8/10/16

SHEET

Response Marine, Inc.
Newburyport, MA, www.responsemarine.com

DWG NO. 536–1, R1





INBOARD VIEWS

REV.	DESCRIPTION

28' LANDING CRAFT

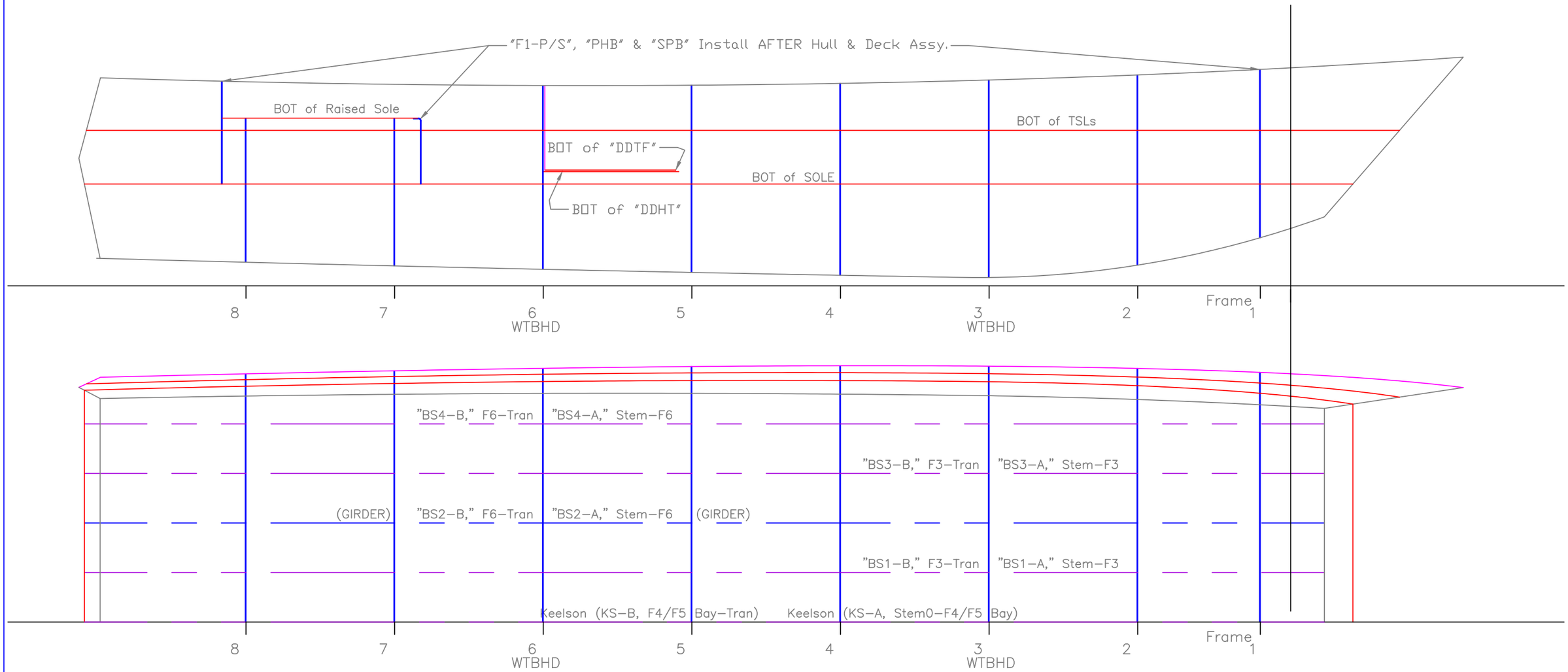
For: Chesterfield

SCALE	DES/DWN	DATE
3/8" = 1'	WAL/JCC	8/10/16

SHEET

DWG NO. 536-2, R1

Response Marine, Inc.
Newburyport, MA, www.responsemarine.com



BOTTOM & TOPSIDES LAYOUTS

REV.	DESCRIPTION

28' LANDING CRAFT

For: Chesterfield

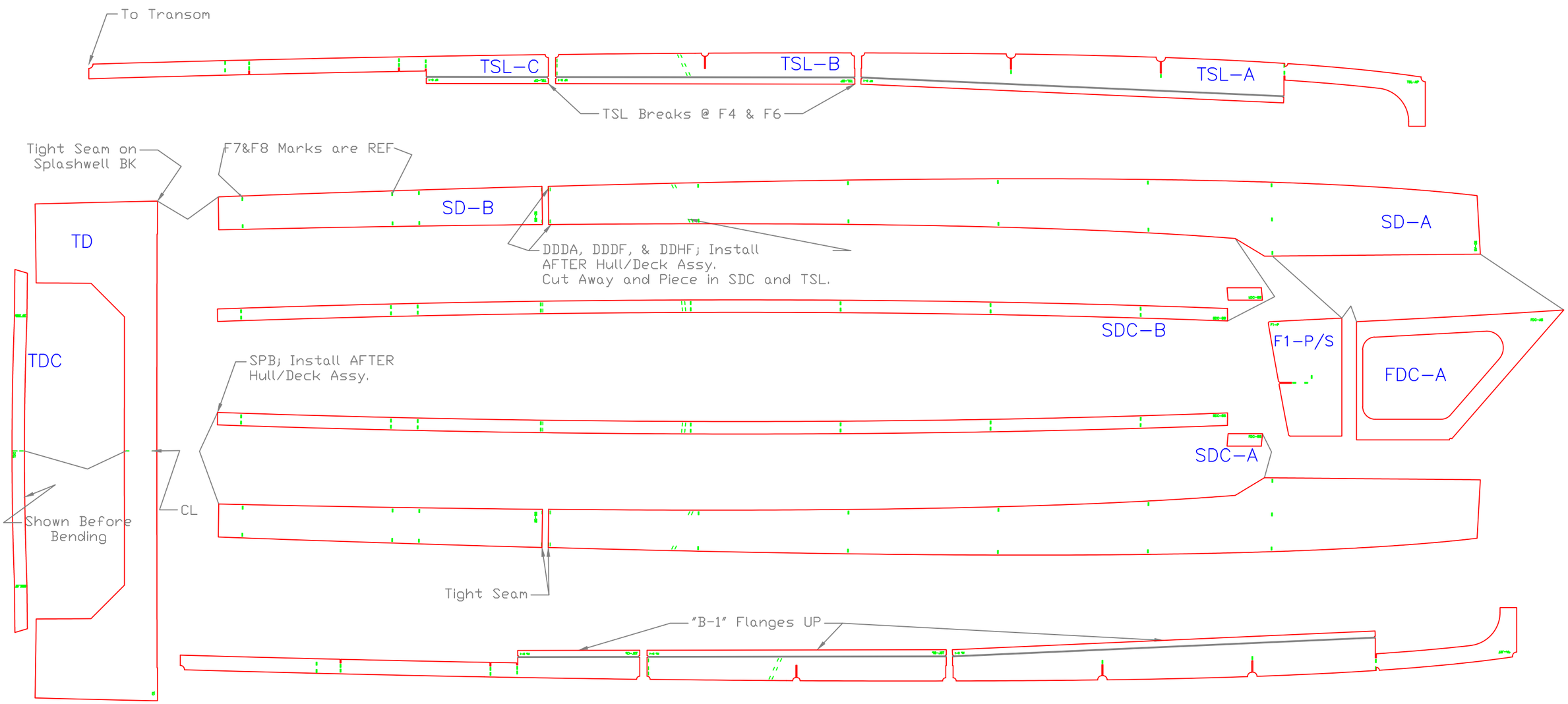
SCALE	DES/DWN	DATE
1/2" = 1'	WAL/JCC	7/19/16

Response Marine, Inc.

Newburyport, MA, www.responsemarine.com

SHEET

DWG NO. 536-01



NOTE: Parts are VIEWED FROM BOTTOM

SIDEDECKS & TS STRUCTURE

REV.	DESCRIPTION

28' LANDING CRAFT

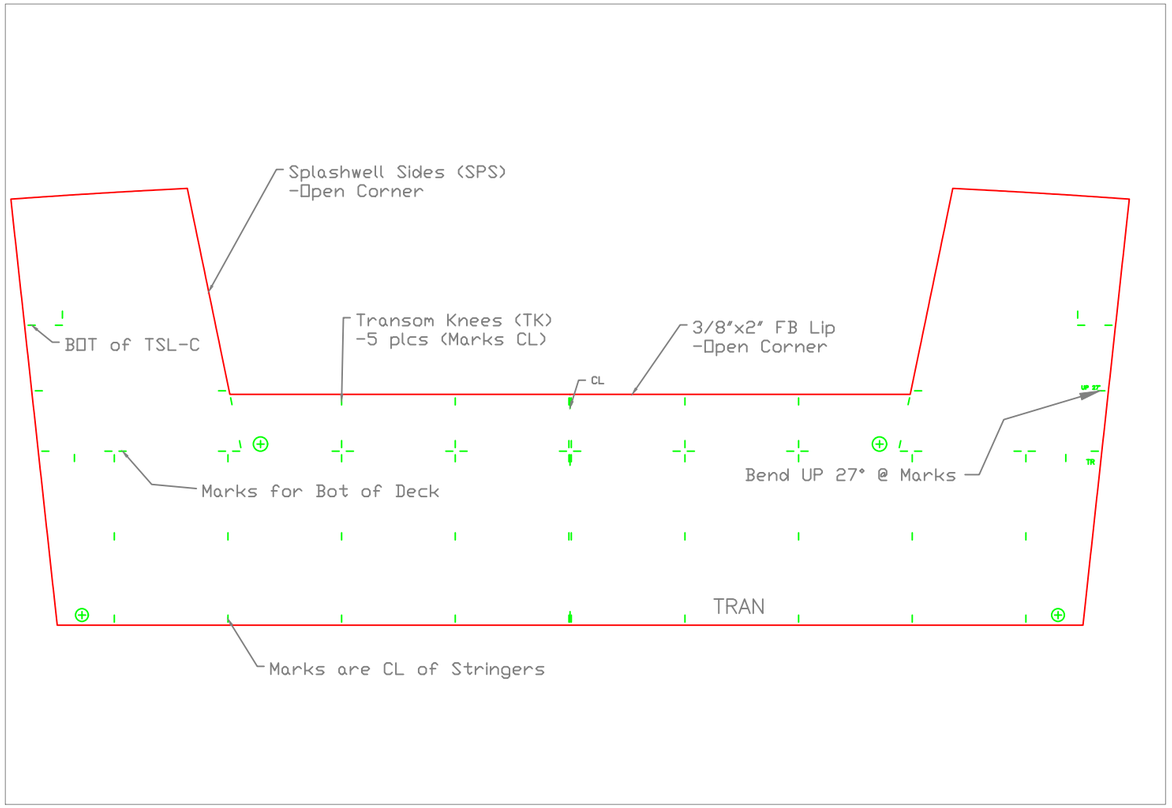
For: Chesterfield

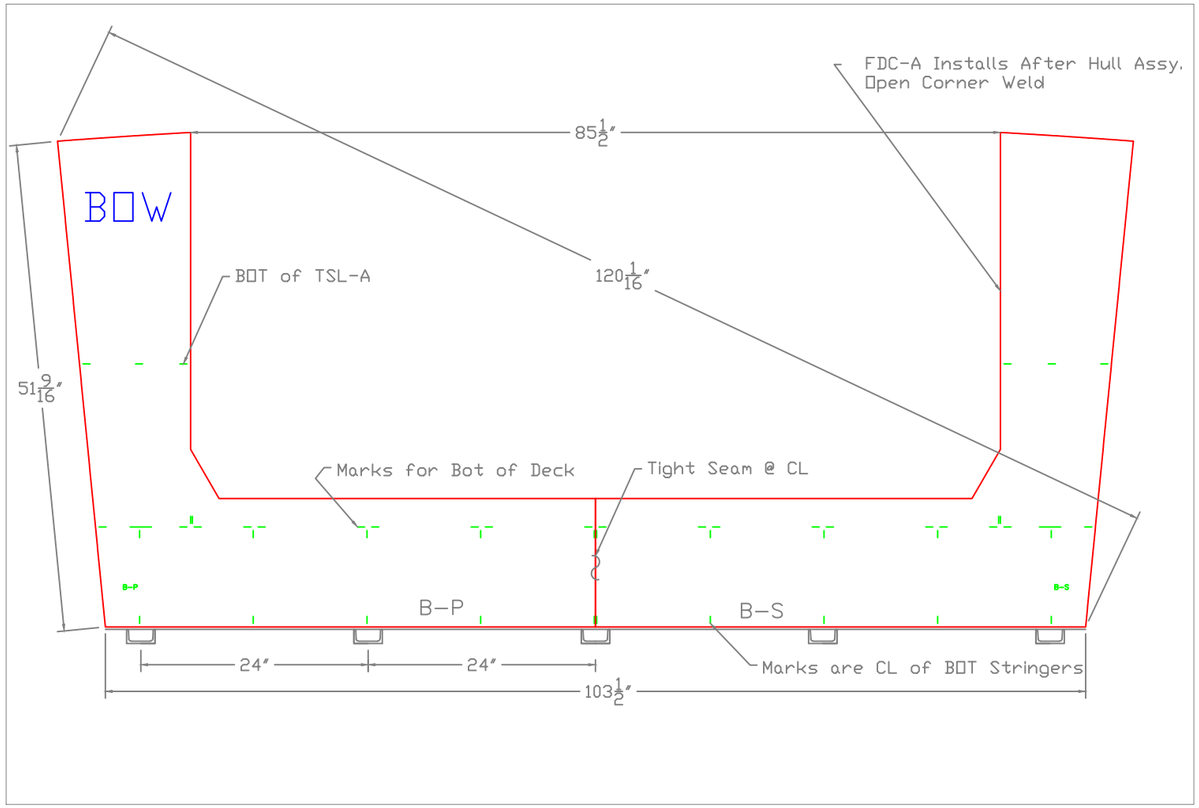
SCALE	DES/DWN	DATE
1/2" = 1'	WAL/JCC	7/19/16

Response Marine, Inc.
Newburyport, MA, www.responsemarine.com

SHEET

DWG NO. 536-02





TRANSOM & BOW

REV.	DESCRIPTION

28' LANDING CRAFT

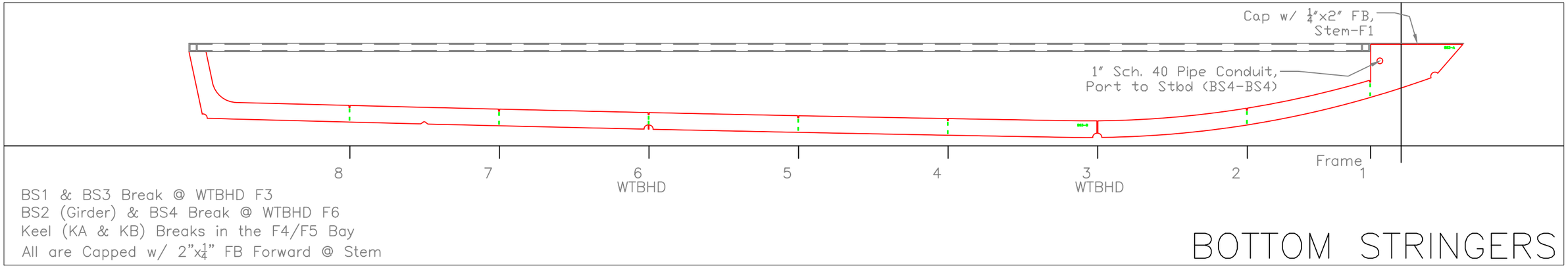
For: Chesterfield

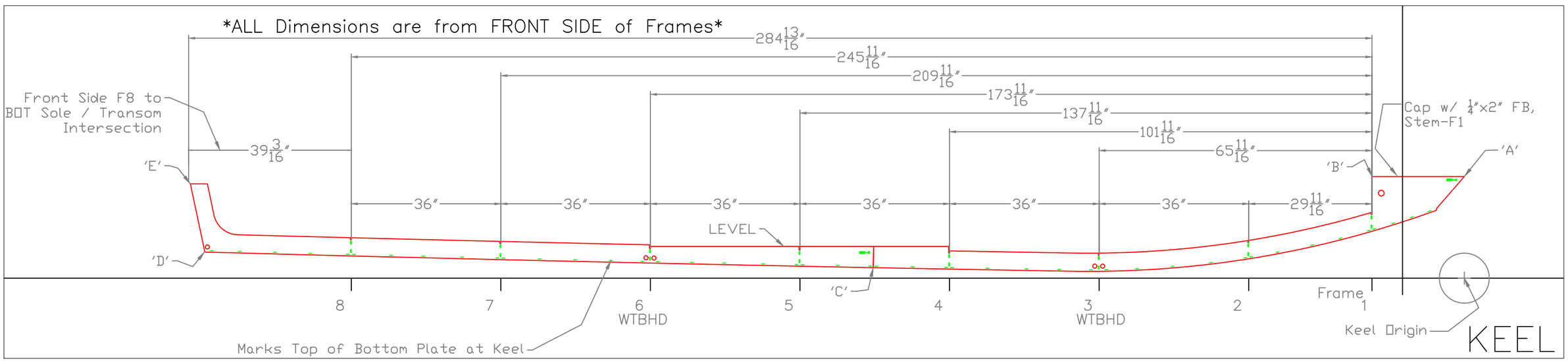
SCALE	DES/DWN	DATE
3/4" = 1'	WAL/JCC	7/19/16

Response Marine, Inc.
Newburyport, MA, www.responsemarine.com

SHEET

DWG NO. 536-03





Response Marine, Inc.
Chesterfield 7/19/16
Keel Points

	Inches- sixteenths				Feet	
	Horizontal	Vertical			Horizontal	Vertical
A to Origin						
B to Origin						
C to Origin						
D to Origin						
E to Origin						
A to						
B to						
C to						
D to						
E to						

KEEL LAYOUT & BS DETAILS

REV.	DESCRIPTION

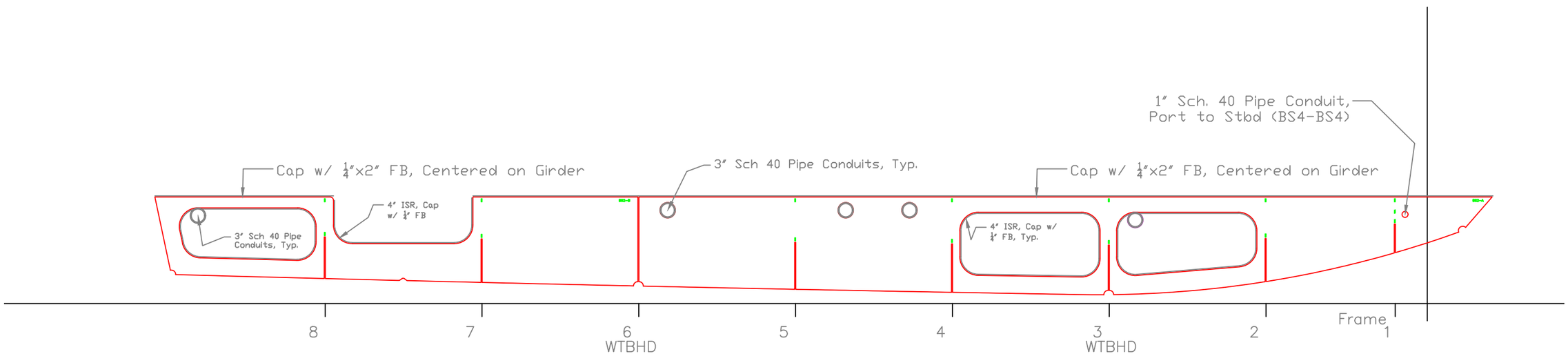
28' LANDING CRAFT
For: Chesterfield

SCALE	DES/DWN	DATE
1/2"=1'	WAL/JCC	7/19/16

SHEET

Response Marine, Inc.
Newburyport, MA, www.responsemarine.com

DWG NO. 536-2-1



GIRDER LAYOUT

REV.	DESCRIPTION

28' LANDING CRAFT

For: Chesterfield

SCALE	DES/DWN	DATE
1/2"=1'	WAL/JCC	7/19/16
		SHEET
		DWG NO. 536-2-2

Response Marine, Inc.

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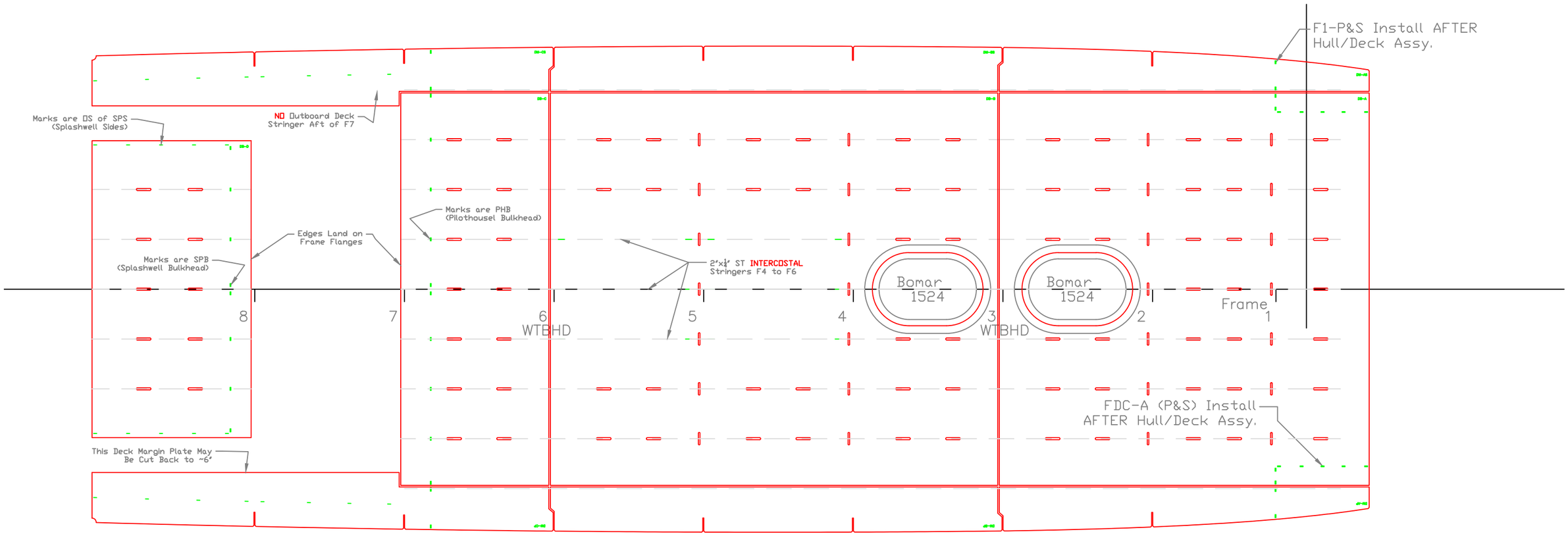


Soft Patches @ Fuel & Hose Conduits TBD

DECK LAYOUT

REV.	DESCRIPTION

28' LANDING CRAFT

For: Chesterfield

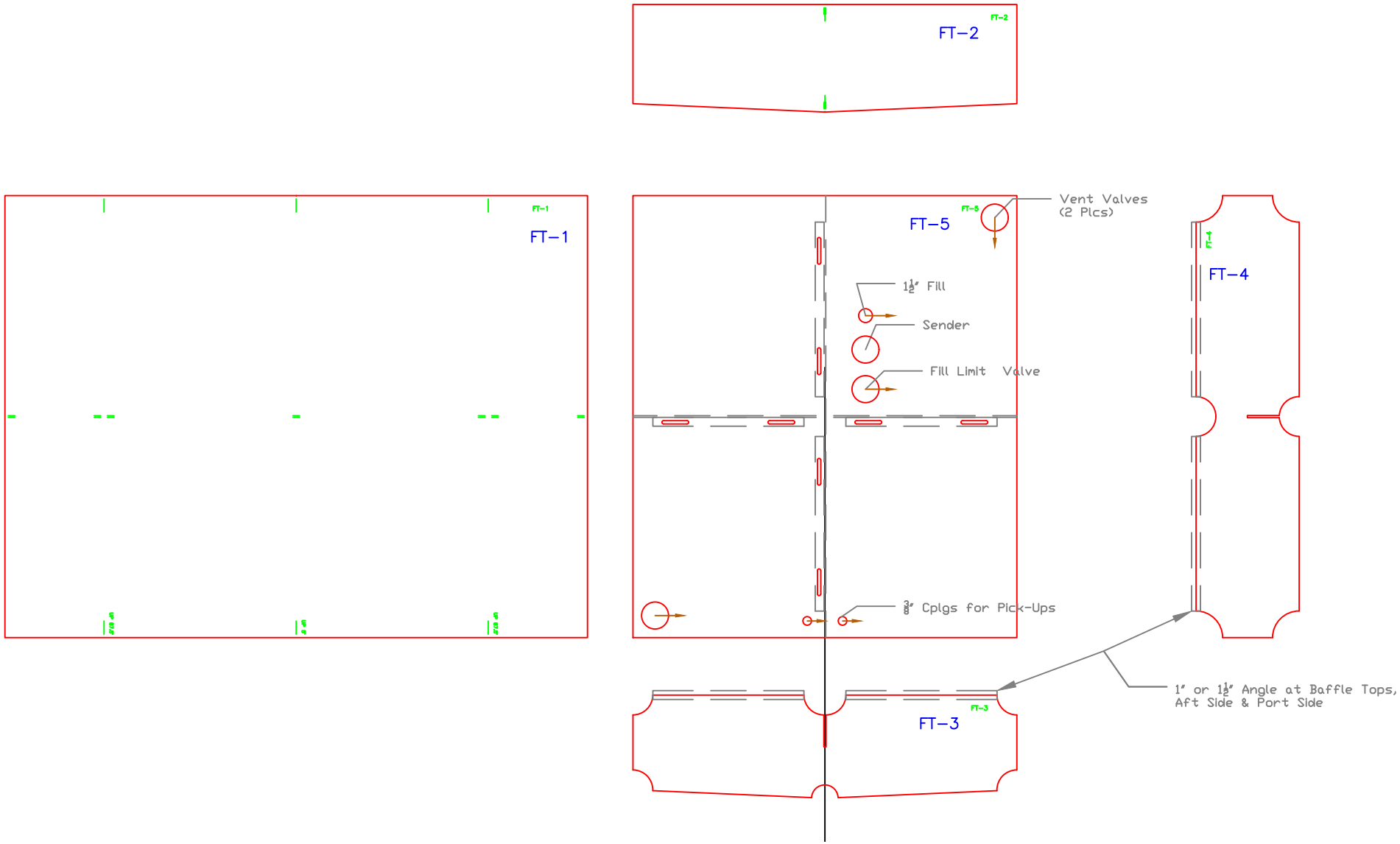
SCALE	DES/DWN	DATE
1/2"=1'	WAL/JCC	7/19/16

Response Marine, Inc.

Newburyport, MA, www.responsemarine.com

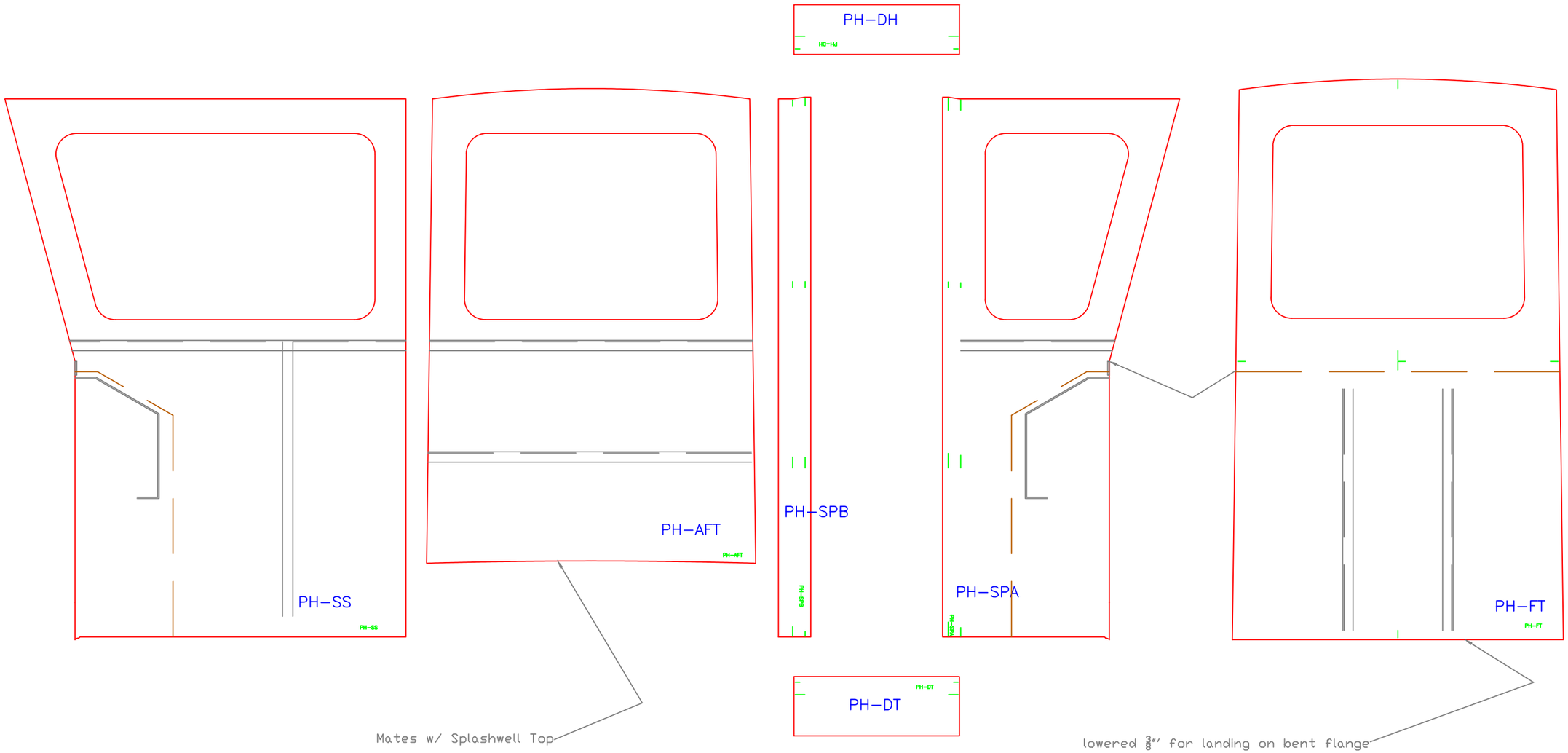
SHEET

DWG NO. 536-2-3



Fuel Tank– 110 gal (Gross)		
For: Chesterfield, 28' LC		
SCALE NONE	DES/DWN WAL/JCC	DATE 8/1/16
Response Marine, Inc. Newburyport, MA, www.responsemarine.com		SHEET
		DWG NO. 536–3–1

REV.	DESCRIPTION



HOUSE SKINS

REV.	DESCRIPTION

28' LANDING CRAFT

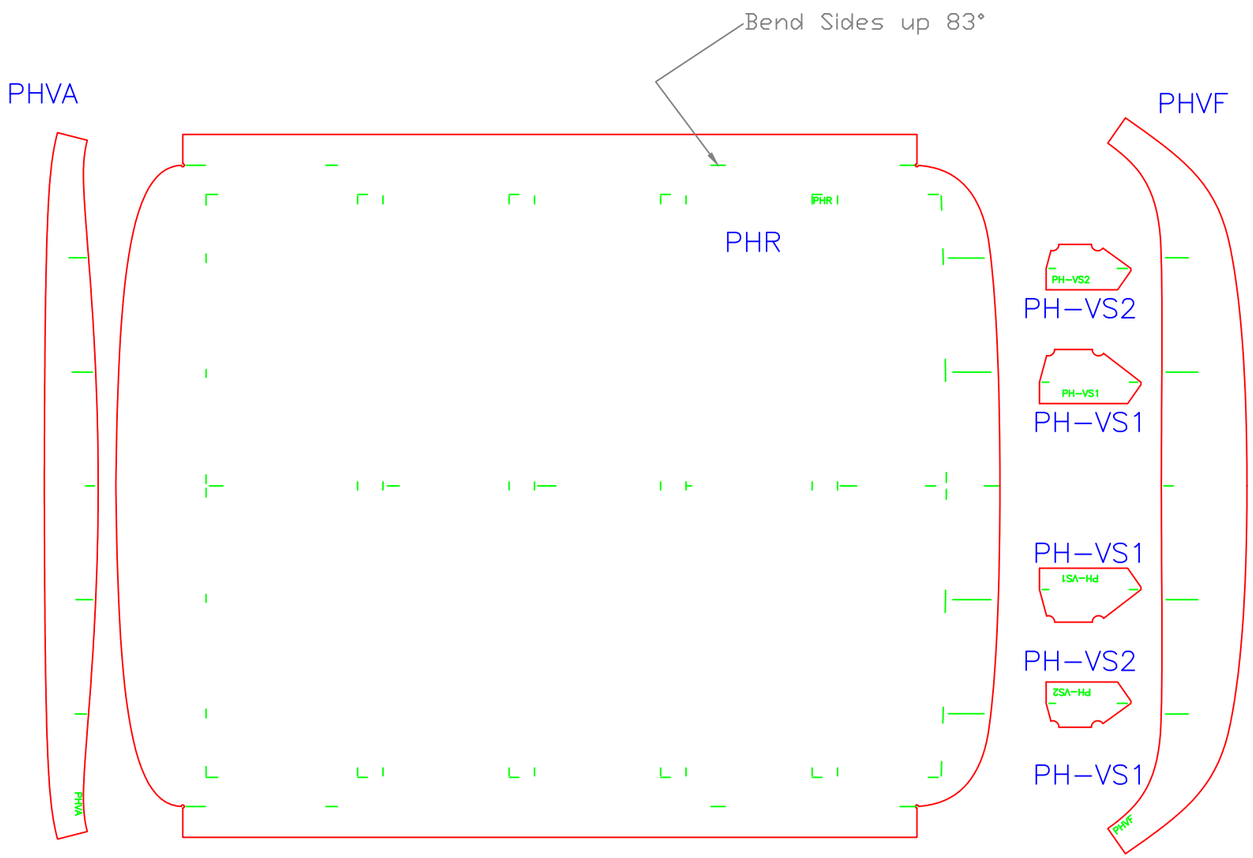
For: Chesterfield

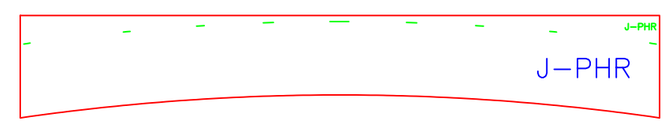
SCALE	DES/DWN	DATE
3/4"=1'	WAL/JCC	8/15/16

Response Marine, Inc.
Newburyport, MA, www.responsemarine.com

SHEET

DWG NO. 536-4-1





HOUSE ROOF

REV.	DESCRIPTION

28' LANDING CRAFT

For: Chesterfield

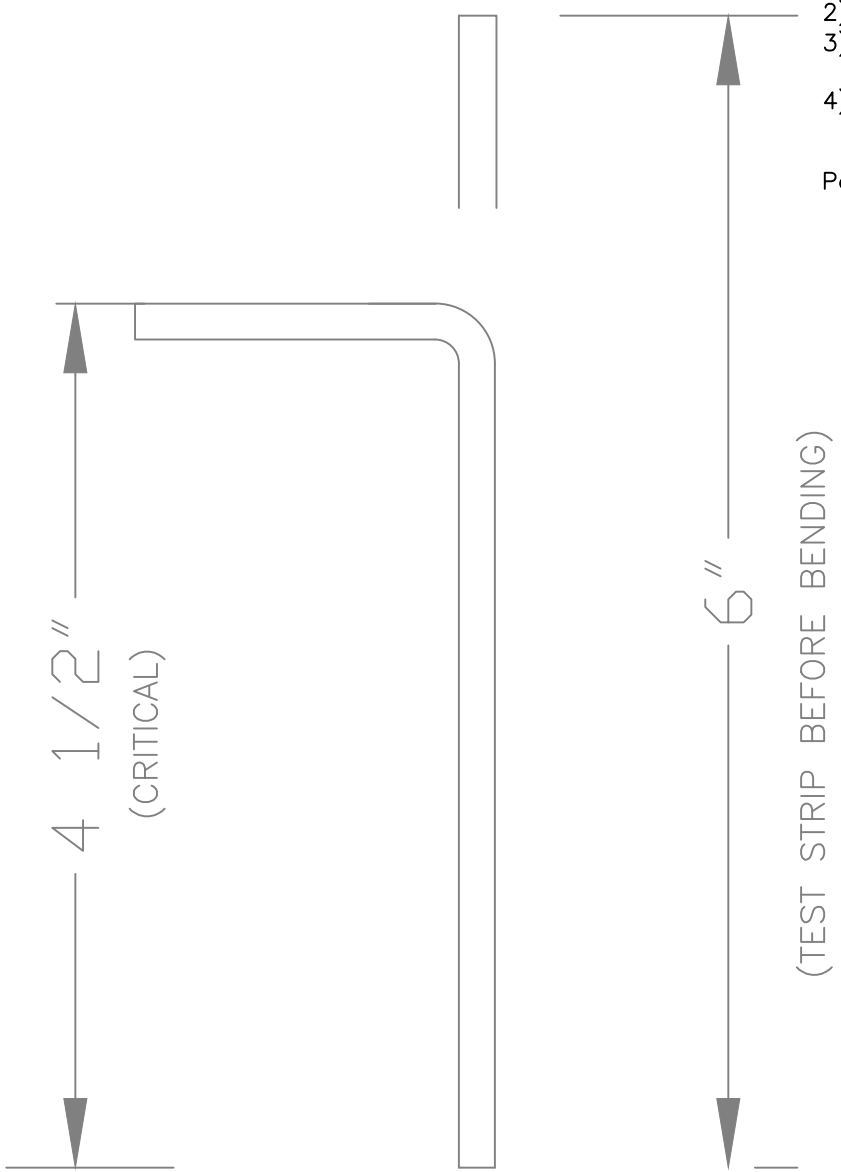
SCALE	DES/DWN	DATE
1"=1'	WAL/JCC	8/15/16

Response Marine, Inc.

Newburyport, MA, www.responsemarine.com

SHEET

DWG NO. 536-4-1



STANDARD FLANGE BENDING: 3/16" 5052 Stock

1) Confirm results for dimensions and cracking with test strips before bending frames.
2) Expected Die Radius is APPROX 1/8""
3) Flanges are designed for outside major flange length of 1½" less than flat stock length as shown.
4) Expected Back Gauge setting is 1 11/16", but confirm and adjust, based on test strip.

Parts to be flanged per this same set-up are listed below.

3/16" 5052 Parts

Part #	Description	Pieces	Bending	Bending Instructions
PHB	Pilothouse Bulkhead, Aft, Above Deck	1	Y	B-1, Tight Radius
F1	Frame 1	1	Y	B-1, Tight Radius
F2	Frame 2	1	Y	B-1, Tight Radius
F2-P	Frame 2, Topside, Port	1	Y	B-1, Tight Radius
F2-S	Frame 2, Topside, Stbd	1	Y	B-1, Tight Radius
F3	Frame 3	1	Y	B-1, Tight Radius
F3-P	Frame 3, Topside, Port	1	Y	B-1, Tight Radius
F3-S	Frame 3, Topside, Stbd	1	Y	B-1, Tight Radius
F4	Frame 4	1	Y	B-1, Tight Radius
F4-P	Frame 4, Topside, Port	1	Y	B-1, Tight Radius
F4-S	Frame 4, Topside, Stbd	1	Y	B-1, Tight Radius
F5	Frame 5	1	Y	B-1, Tight Radius
F5-P	Frame 5, Topside, Port	1	Y	B-1, Tight Radius
F5-S	Frame 5, Topside, Stbd	1	Y	B-1, Tight Radius
F6	Frame 6	1	Y	B-1, Tight Radius
F6-P	Frame 6, Topside, Port	1	Y	B-1, Tight Radius
F6-S	Frame 6, Topside, Stbd	1	Y	B-1, Tight Radius
F7	Frame 7	1	Y	B-1, Tight Radius
F7-P	Frame 7, Topside, Port	1	Y	B-1, Tight Radius
F7-S	Frame 7, Topside, Stbd	1	Y	B-1, Tight Radius
F8	Frame 8, Topside, Port	1	Y	B-1, Tight Radius
F8-P	Frame 8, Topside, Port	1	Y	B-1, Tight Radius
F8-S	Frame 8, Topside, Stbd	1	Y	B-1, Tight Radius
PH-VS1	House Fwd Visor Stiff, IB	2	Y	B-1, Tight Radius
PH-VS2	House Fwd Visor Stiff, OB	2	Y	B-1, Tight Radius
	Total Pieces:	27		

REV.	DESCRIPTION

28' LANDING CRAFT

For: Chesterfield

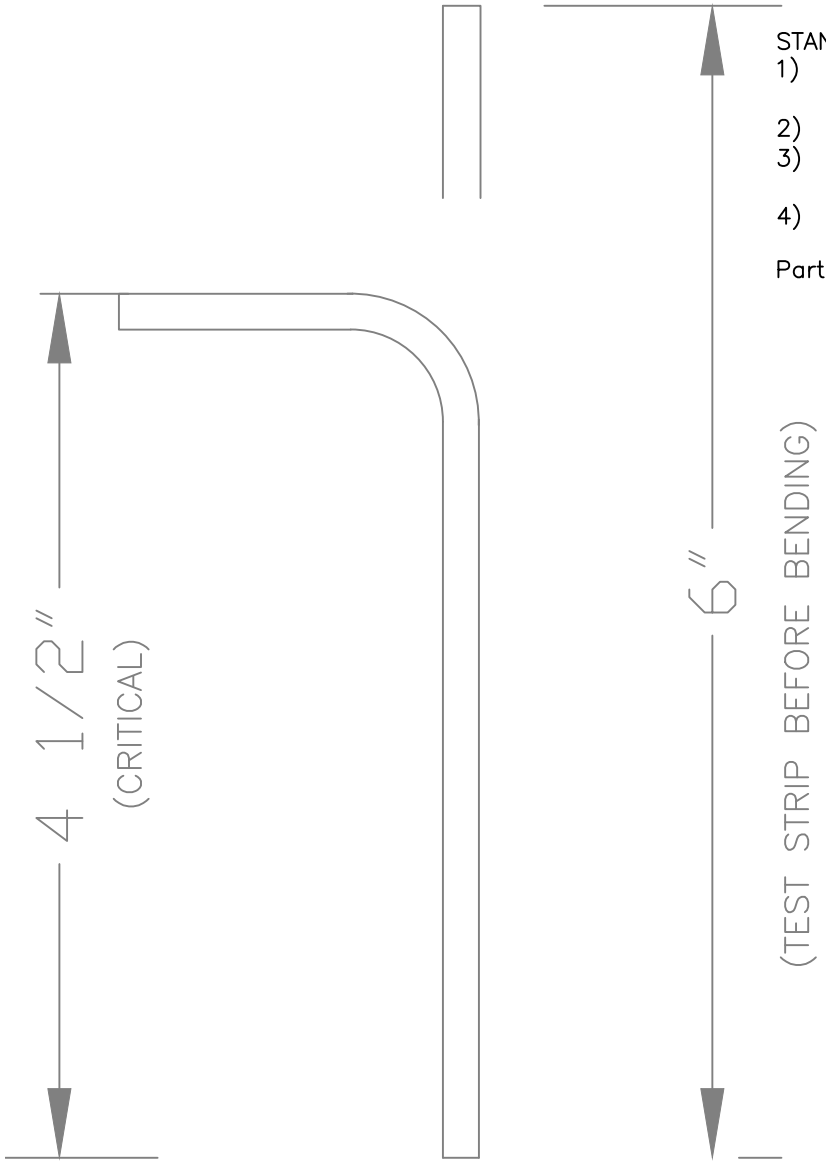
SCALE	DES/DWN	DATE
FULL	WAL/JCC	7/19/16

Response Marine, Inc.

Newburyport, MA, www.responsemarine.com

SHEET

DWG NO. 536-B1



STANDARD FLANGE BENDING: 3/16" 5086 H116 Stock

1) Confirm results for dimensions and cracking with test strips before bending frames.
2) Expected Die Radius is 1/2"
3) Flanges are designed for outside major flange length of 1 1/2" less than flat stock length as shown.
4) Expected Back Gauge setting is 1 13/16", but confirm and adjust, based on test strip.

Parts to be flanged per this same set-up are as follows:

3/16" 5083/86 Parts

Part #	Description	Pieces	Bending	Bending Instructions
TSL-AP	Topsides Stringer, Fwd, Port	1	Y	B-1, LARGE RADIUS
TSL-AS	Topsides Stringer, Fwd, Stbd	1	Y	B-1, LARGE RADIUS
TSL-BP	Topsides Stringer, Mid, Port	1	Y	B-1, LARGE RADIUS
TSL-BS	Topsides Stringer, Mid, Stbd	1	Y	B-1, LARGE RADIUS
TSL-CP	Topsides Stringer, Aft, Port	1	Y	B-1, LARGE RADIUS
TSL-CS	Topsides Stringer, Aft, Stbd	1	Y	B-1, LARGE RADIUS
	Total Pieces:	6		

LARGE RADIUS DIE

REV.	DESCRIPTION

28' LANDING CRAFT

For: Chesterfield

SCALE	DES/DWN	DATE
FULL	WAL/JCC	7/19/16

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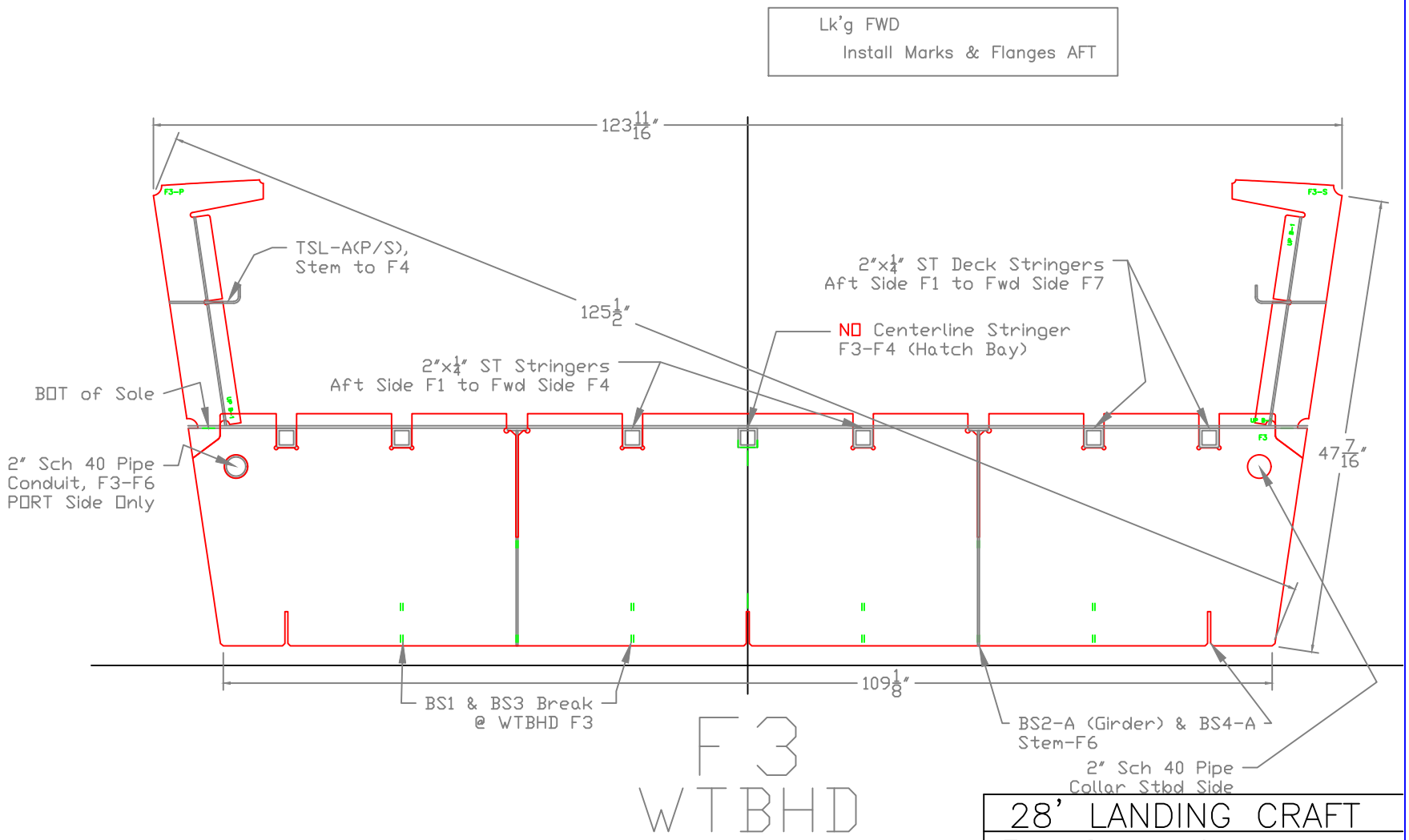
SHEET

DWG NO. 536-B1-1



REV.	DESCRIPTION

28' LANDING CRAFT

For: Chesterfield

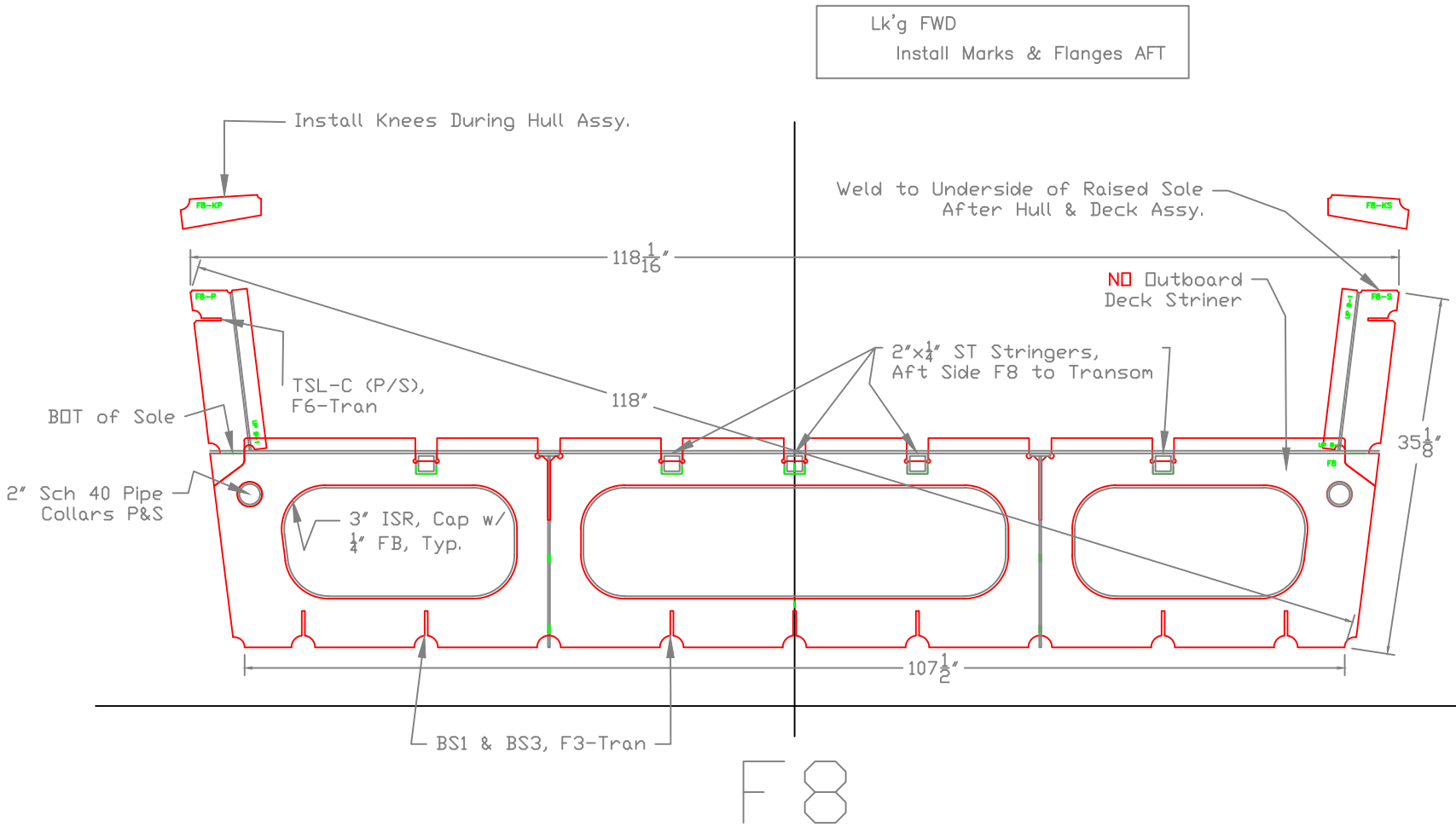
SCALE	DES/DWN	DATE
3/4" = 1'	WAL/JCC	7/19/16

Response Marine, Inc.

Newburyport, MA, www.responsemarine.com

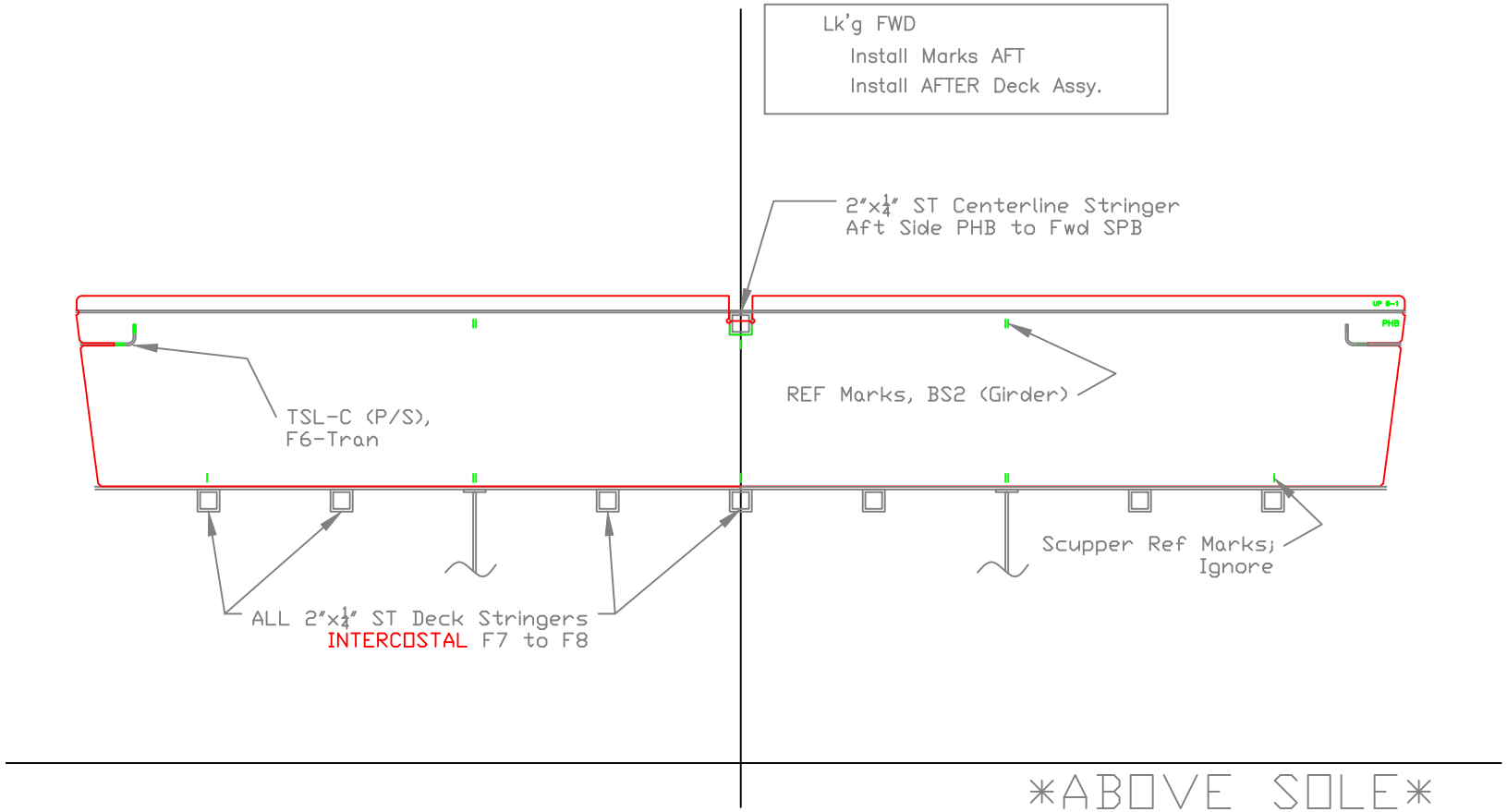
SHEET

DWG NO. 536-F3



28' LANDING CRAFT		
For: Chesterfield		
SCALE 3/4" = 1'	DES/DWN WAL/JCC	DATE 7/19/16
Response Marine, Inc. Newburyport, MA, www.responsemarine.com		SHEET
		DWG NO. 536-F8

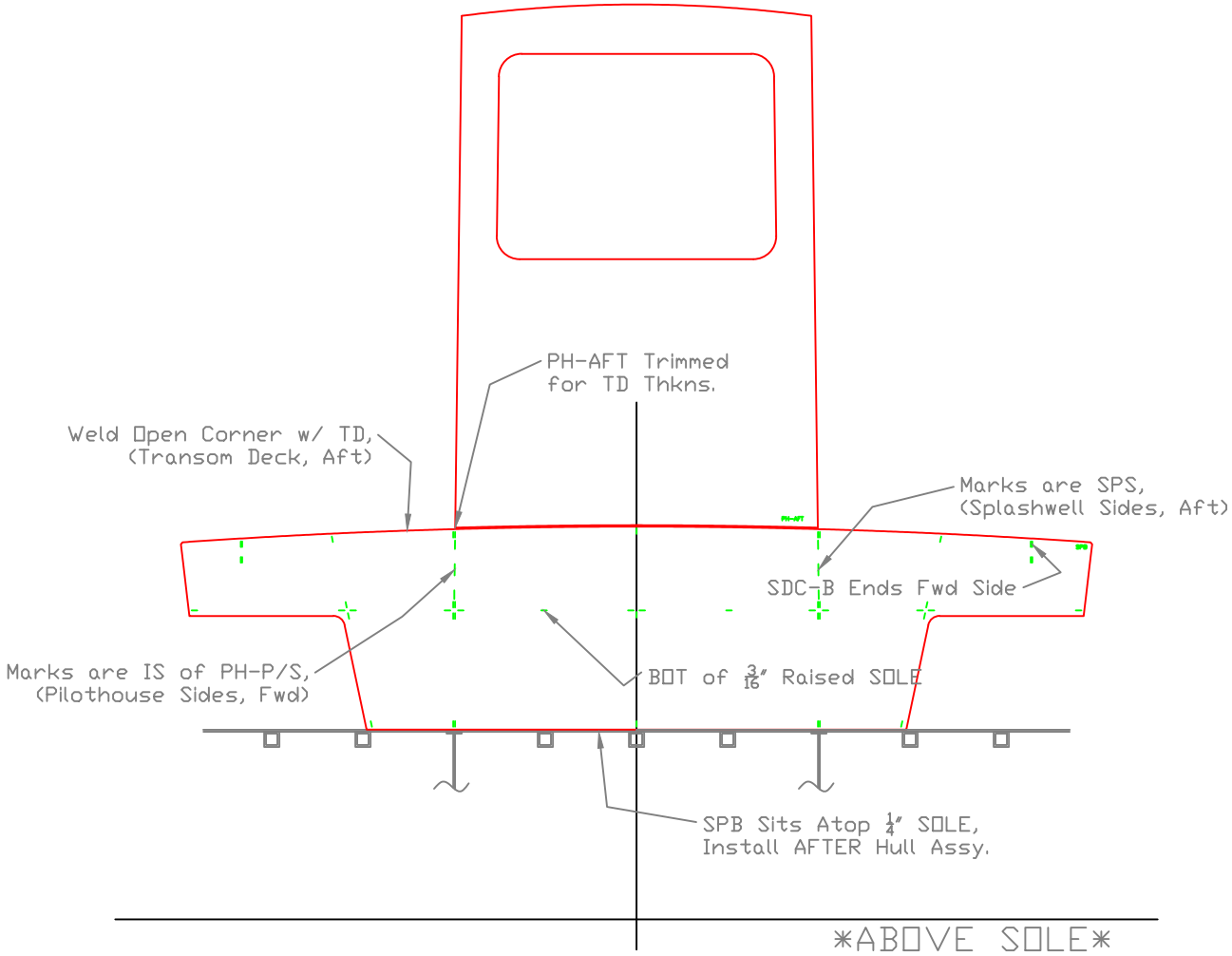
REV.	DESCRIPTION



PHB
Pilothouse Bulkhead

28' LANDING CRAFT			
For: Chesterfield			
SCALE 3/4" = 1'	DES/DWN WAL/JCC	DATE 7/19/16	
Response Marine, Inc. Newburyport, MA, www.responsemarine.com		SHEET	
		DWG NO. 536-PHB	

REV.	DESCRIPTION

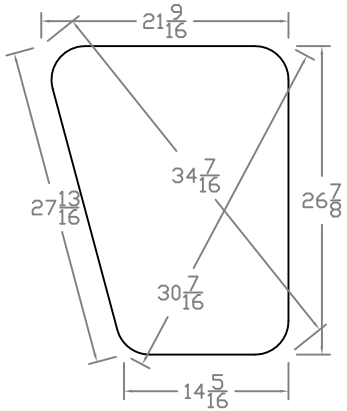


SPB
Splashwell Bulkhead

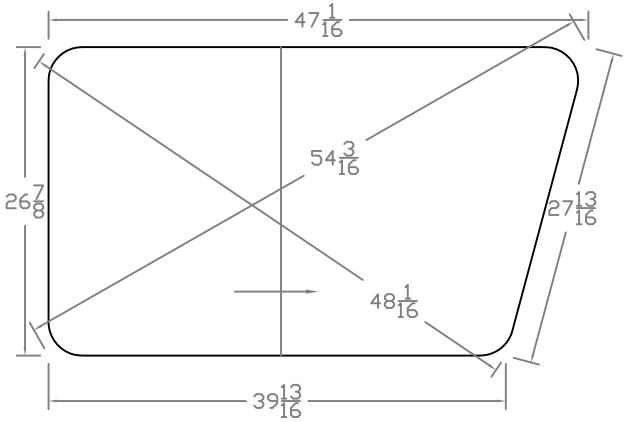
28' LANDING CRAFT			
For: Chesterfield			
SCALE 1/2" = 1'	DES/DWN WAL/JCC	DATE 7/19/16	
Response Marine, Inc. Newburyport, MA, www.responsemarine.com		SHEET	
		DWG NO. 536-SPB	

REV.	DESCRIPTION

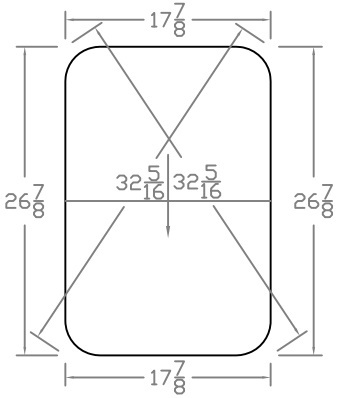
Port
Fixed

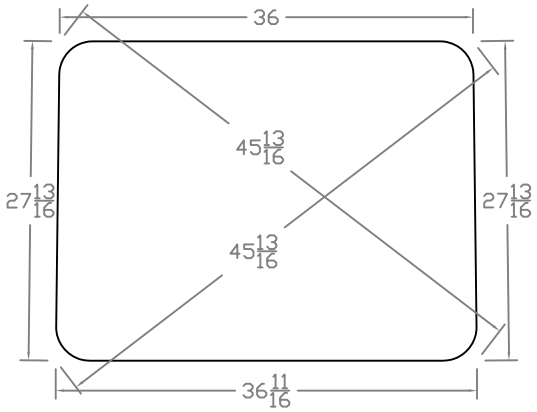


Stbd
Horizontal Slider
Aft Panel Slides Fwd

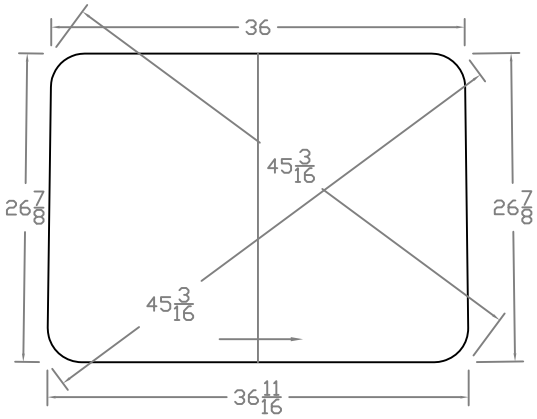


Door
Drop Down





Fwd
Full Swing Out



Aft, Slider
Left Panel Slides Right

Notes–
1.) Views are from OUTSIDE
2.) Dimensions are actual cutout (inches) less .06" per side
3.) Corner Cutout radius is 3"
4.) Clamp Ring is for 3/16" material thickness
5.) Glass is 1/4" Safety Glass, LIGHT TINT

REV.	DESCRIPTION

5 Window Set
For: Chesterfield, 28' LC

SCALE	DES/DWN	DATE
NONE	WAL/JCC	8/1/16

SHEET

Response Marine, Inc.
Newburyport, MA, www.responsemarine.com

DWG NO. 536–7–1, R1