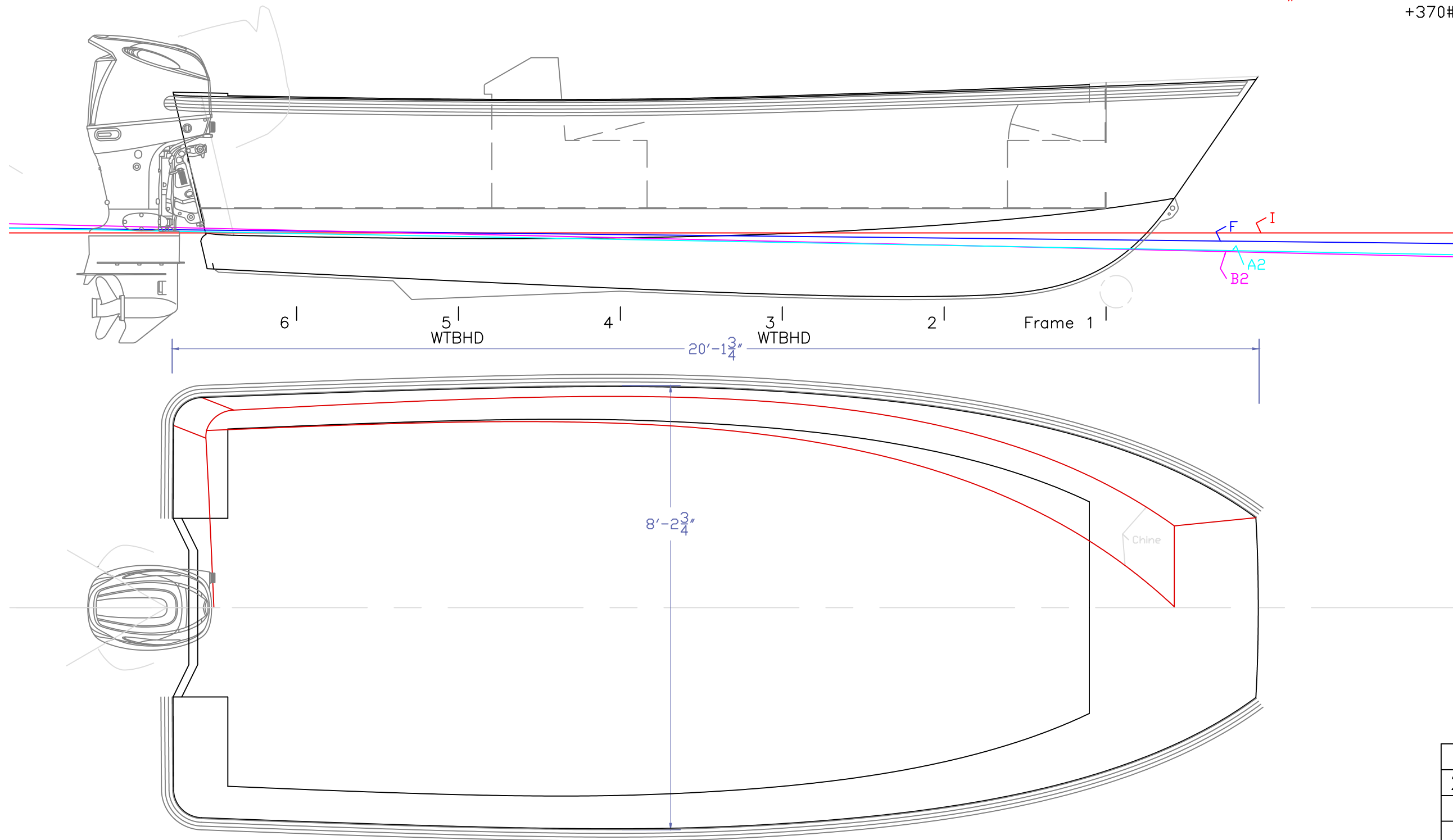


**Waterlines:**  
 A2, 2,724# @X=9.41': Suzuki DF-115A, 25"  
 6 gal fuel at transom  
 Battery in console  
 30# Stow in fwd locker

B2, 2,924# @X=9.62': A2 + 200# helmsman

F, 3,264# @X=9.22': B2 + 185# pax at console seat &  
 185# pax at fwd stow bench

I: 3,464# @ X=8.86': A2 + 370# at Helm  
 +370# at Fwd Bench



PROFILE & PLAN		
20' x 8'3" VBB		
SCALE 1/2" = 1'	DES/DWN WAL	DATE 9/8/19
Response Marine, Inc.		SHEET
Newburyport, MA, www.responsemarine.com		DWG. NO. 592-1

Response Marine, Inc.  
Drawing List

<b>Design</b>	<b>Dwg</b>	<b>Description</b>	<b>Date</b>
<b><u>#592- 20' x 8'3" V, Blunt Bow w/ Radiused Transom Corners</u></b>			
592	-1	Profile & Plan	9/8/19
	2-1	Keel Layout	9/8/19
	2-2	Girder Layout	9/8/19
	2-3	Bottom Layout	9/8/19
	2-4	Topsides Layout	9/8/19
	2-5	Transom	9/8/19
	2-6	Bow	9/8/19
	2-7	Cockpit Deck	9/8/19
	2-8	Side Decks	9/8/19
	2-9	Fwd Bench	9/8/19
	4-1	Console	9/8/19
	B-1	Flange B-1	9/8/19
	C-1	Typical Skin Joints	9/8/19
	F-R	Frame Dimensions	9/8/19
	F1	Frame 1	9/8/19
	F2	Frame 2	9/8/19
	F3	Frame 3, WTBHD	9/8/19
	F4	Frame 4	9/8/19
	F5	Frame 5, WTBHD	9/8/19
	F6	Frame 6	9/8/19

\*\*\*\*\* NC Cut Parts \*\*\*\*\*

Response Marine, Inc.

Boat: 592, 20' VBB for Miller Marine  
 -Radiused Transom Corners,  
 - 1/2" Keel  
 -Console from # 502A

File: \Des\Sound\Bullshark\Derivatives\592

Rev. Date: 9/8/19

Print Date: 9/8/19

Cut Files are:

#592 All Parts

**1/8" Parts- 5052 Stock**

<u>Part #</u>	<u>Pieces</u>	<u>Description</u>	<u>Bend</u>
C-1P	1	Console Sides	
C-1S	1	Console Sides	
C-2	1	Console Top/Front Face	Y, 1/4" Inside radius
C-3	1	Console Back	Y, 1/4" Inside radius
C-4	1	Console Seat	Y, 1/4" Inside radius
C-5	1	Console Seat Lid	Y, 1/4" Inside radius
	6	Sub Total 1/8" 5052 parts	

**3/16" Parts- 5052**

<u>Part #</u>	<u>Pieces</u>	<u>Description</u>	<u>Bend</u>
BNCH	1	Forward Bench, Horizontal & Vertical	Y, 1/4" Inside radius
HC-S	2	Hatch Cover Stiffeners (at step deck)	
HC	1	Hatch Cover (at step deck)	Y, 1/4" Inside radius
	4	Sub Total 3/16" 5086 parts	

**3/16" Parts- 5086 Marine**

<u>Part #</u>	<u>Pieces</u>	<u>Description</u>	<u>Bend</u>
ALB	1	Anchor Locker Bottom	
BOW	1	Bow	
BG-P	1	Bottom Girder, Port	Flange B-1
BG-S	1	Bottom Girder, Stbd	Flange B-1
DB-AP	1	Deck Body, Fwd of F3, Port	
DB-AS	1	Deck Body, Fwd of F3, Stbd	
DB-B	1	Deck Body, F3-F5	

DB-C	1	Deck Body, F5-Tran	
DM-P	1	Sole Margin, Port	
DM-S	1	Sole Margin, Stbd	
F1	1	Frame 1	
F2	1	Frame 2	Flange B-1
F2P	1	Frame 2, port	Flange B-1
F2S	1	Frame 2, stbd	Flange B-1
F3	1	Frame 3	Flange B-1
F3-P	1	Frame 3, port	Flange B-1
F3-S	1	Frame 3, stbd	Flange B-1
F4	1	Frame 4	Flange B-1
F4-P	1	Frame 4, port	Flange B-1
F4-S	1	Frame 4, stbd	Flange B-1
F5	1	Frame 5	Flange B-1
F5-P	1	Frame 5, port	Flange B-1
F5-S	1	Frame 5, stbd	Flange B-1
F6-S	1	Frame 6	Flange B-1
FDC	1	Foredeck Coaming	
SD-P	1	Side & Foredeck, Port	
SD-S	1	Side & Foredeck, Stbd	
SDC-P	1	Side Deck Coaming, Port	
SDC-S	1	Side Deck Coaming, Stbd	
TDC-P	1	Transom Deck Coaming, Port	
TDC-S	1	Transom Deck Coaming, Stbd	
TR-CP	1	Transom Corner Radius, Port	Y, Bump per Dwg 592-5
TR-CS	1	Transom Corner Radius, Stbd	Y, Bump per Dwg 592-5
TS-P	1	Topsides, Port	
TS-S	1	Topsides, Stbd	
TSS-BP	1	Topsides Stringer Shelf, F2-F4, Port	Flange B-1
TSS-BS	1	Topsides Stringer Shelf, F2-F4, Stbd	Flange B-1
TSS-CP	1	Topsides Stringer Shelf, F4-Tran, Port	Flange B-1
TSS-CS	1	Topsides Stringer Shelf, F4-Tran, Stbd	Flange B-1
39		Sub Total 3/16" 5086 parts	

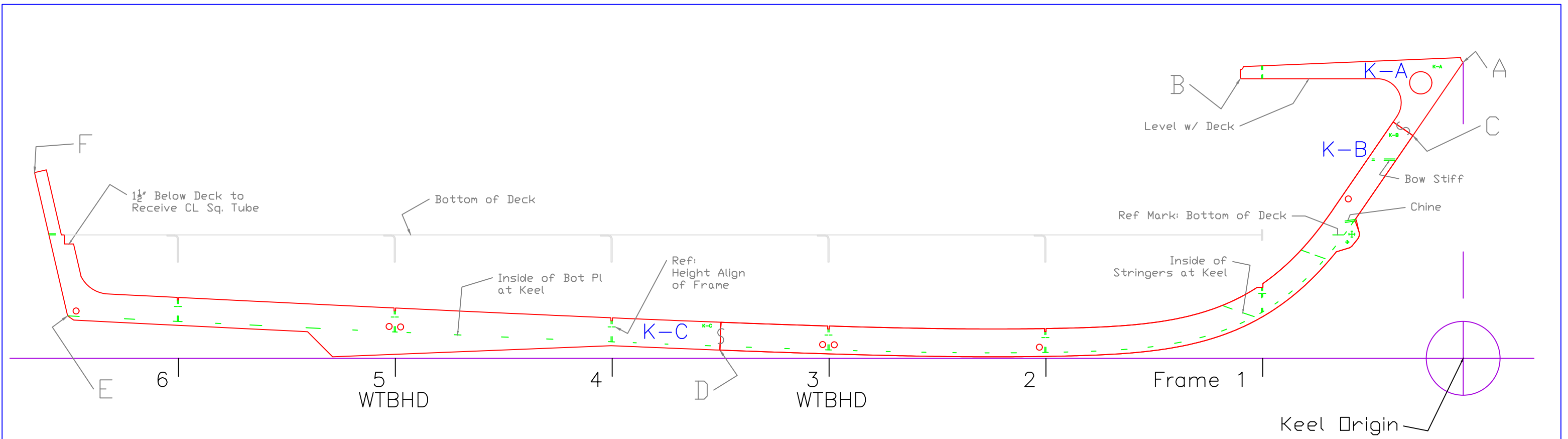
### **1/4" Parts- 5086 H116 Marine**

B-P	1	Bottom, Port	
B-S	1	Bottom, Stbd	
BS	2	Bow Stiffener, Vertical	
BS-1P	1	E	
BS-1S	1	Bottom Stringer 1, Stbd	
BS2-P	1	Bottom Stringer 2, fwd, Port	
BS2-S	1	Bottom Stringer 2, fwd, Stbd	
BS-3P	1	Bottom Stringer 3, Port	
BS-3S	1	Bottom Stringer 3, Stbd	
CS	2	Chine Stiffener F1 to Stem	
C-P	1	Chine Port	
C-S	1	Chine Starboard	
TR	1	Transom	
TR-L	1	Transom Lip	

TSS-AP	1	Topsides Stringer, F2 to Bow, Port
TSS-AS	1	Topsides Stringer, F2 to Bow, Stbd
	18	Sub Total 1/4" Parts

**1/2" Parts 5086 H116 Marine**

<u>Part #</u>	<u>Pieces</u>	<u>Description</u>
K-A	1	Keel, Stem Tip/Foredeck
K-B	1	Keel, Fwd
K-C	1	Keel, Aft
	3	Total 1/2" parts
	70	Total Parts



Response Marine, Inc.  
#592  
Keel Points

9/8/19

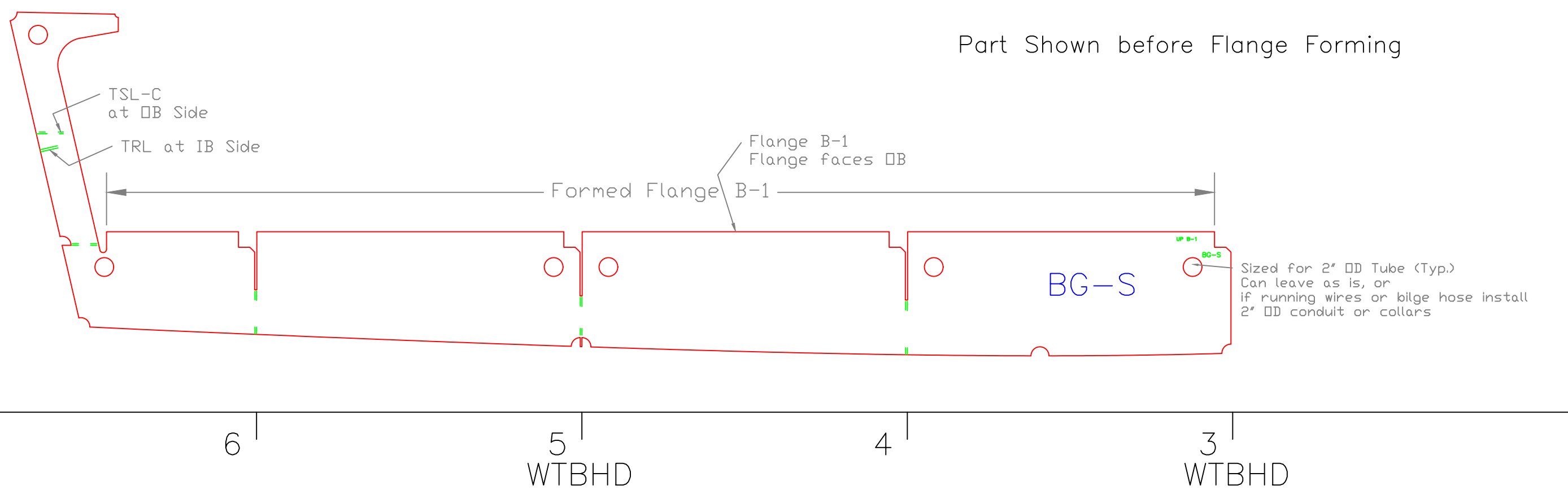
Inches- sixteenths		Feet	
Horizontal	Vertical	Horizontal	Vertical
A to Origin	0	49	2/16
B to Origin			
C to Origin			
D to Origin			
E to Origin			
F to Origin			

A to Origin  
B to Origin  
C to Origin  
D to Origin  
E to Origin  
F to Origin

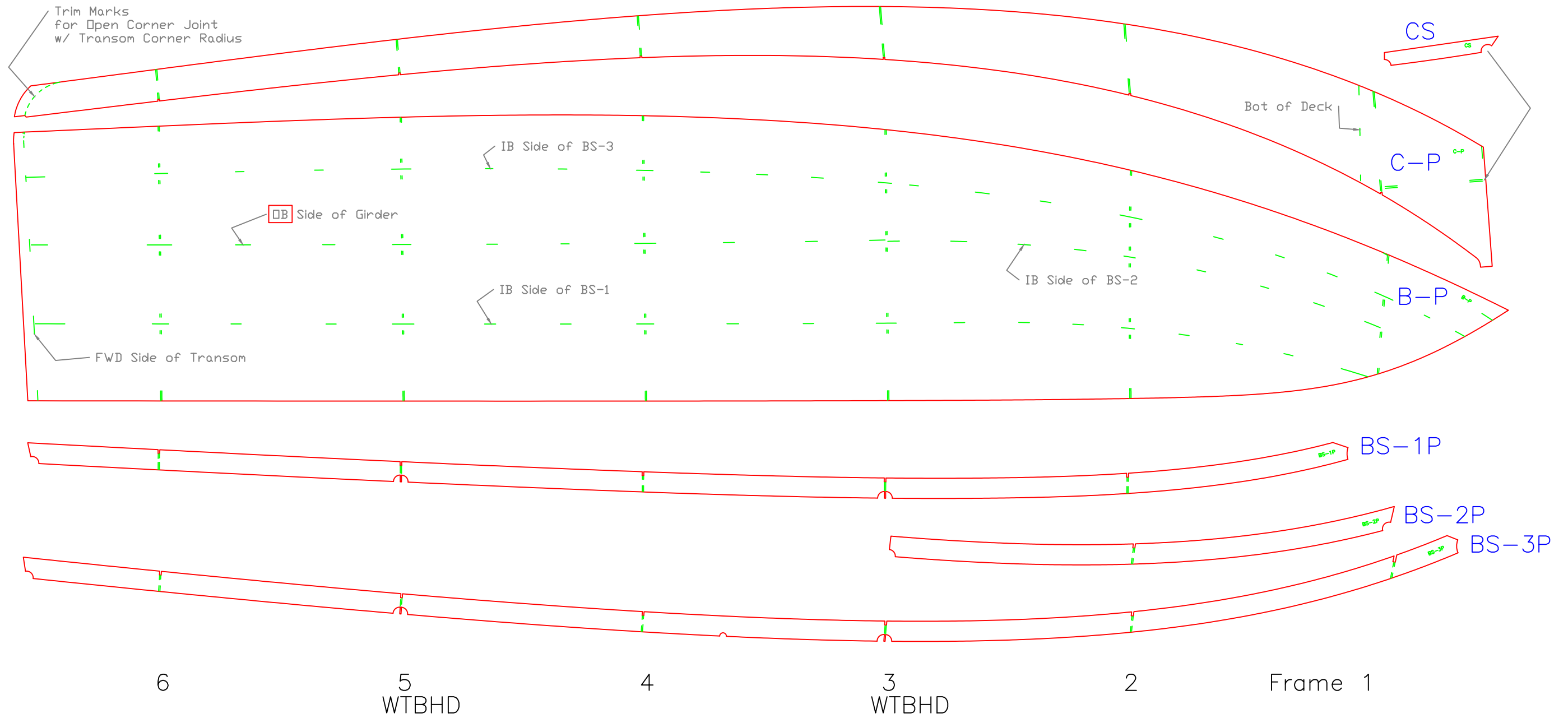
ALIGNED (INCHES)

	A	B	C	D	E	F
A to						
B to						
C to						
D to						
E to						
F to						

KEEL LAYOUT		
20' x 8'3" VBB		
SCALE 3/4" = 1'	DES/DWN WAL	DATE 9/8/19
Response Marine, Inc. Newburyport, MA, www.responsemarine.com		DWG. NO. 592-2-1

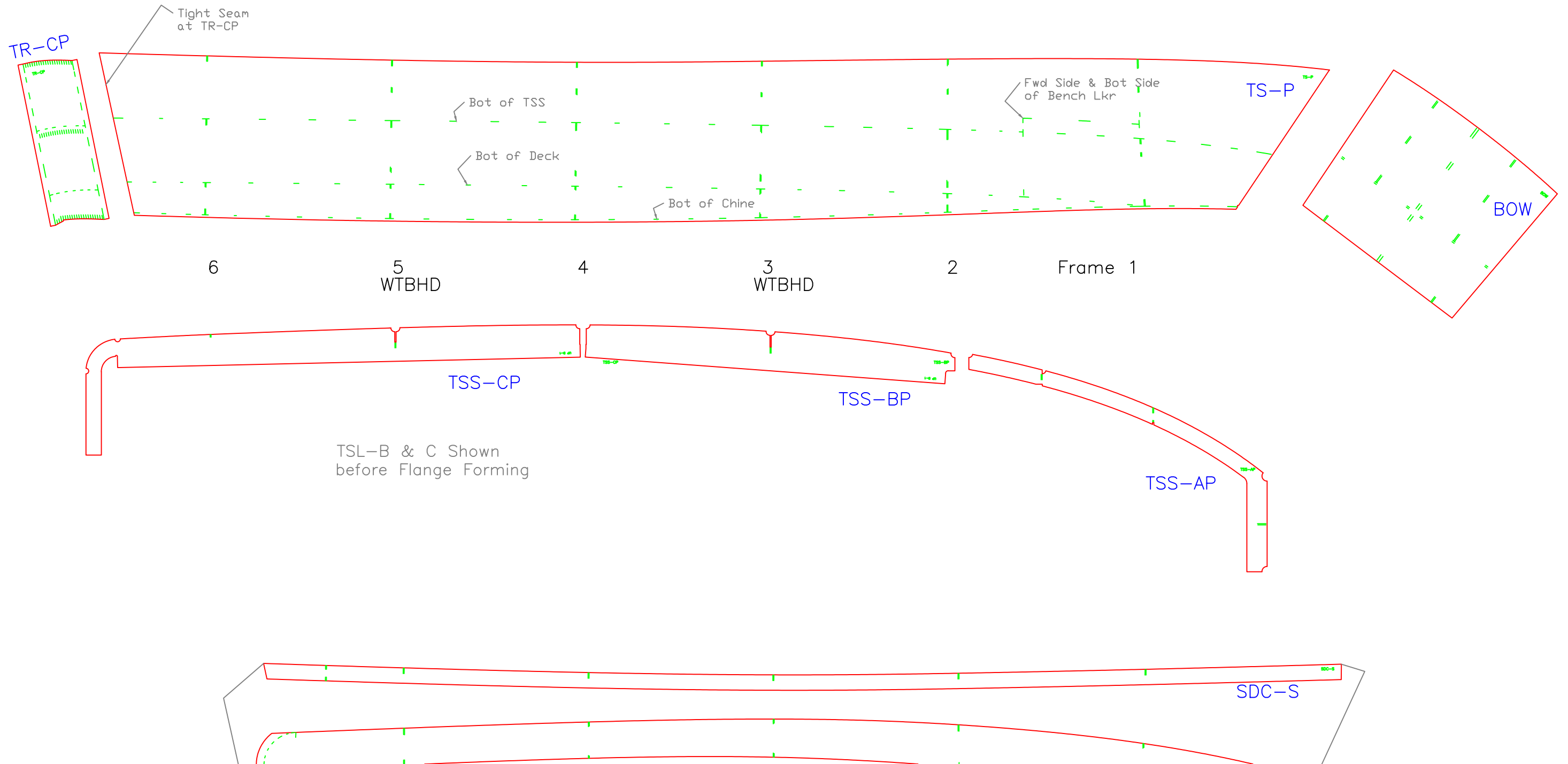


GIRDER LAYOUT		
20' x 8'3" VBB		
SCALE 1" = 1'	DES/DWN WAL	DATE 9/8/19
Response Marine, Inc. Newburyport, MA, www.responsemarine.com		DWG. NO. 592-2-2

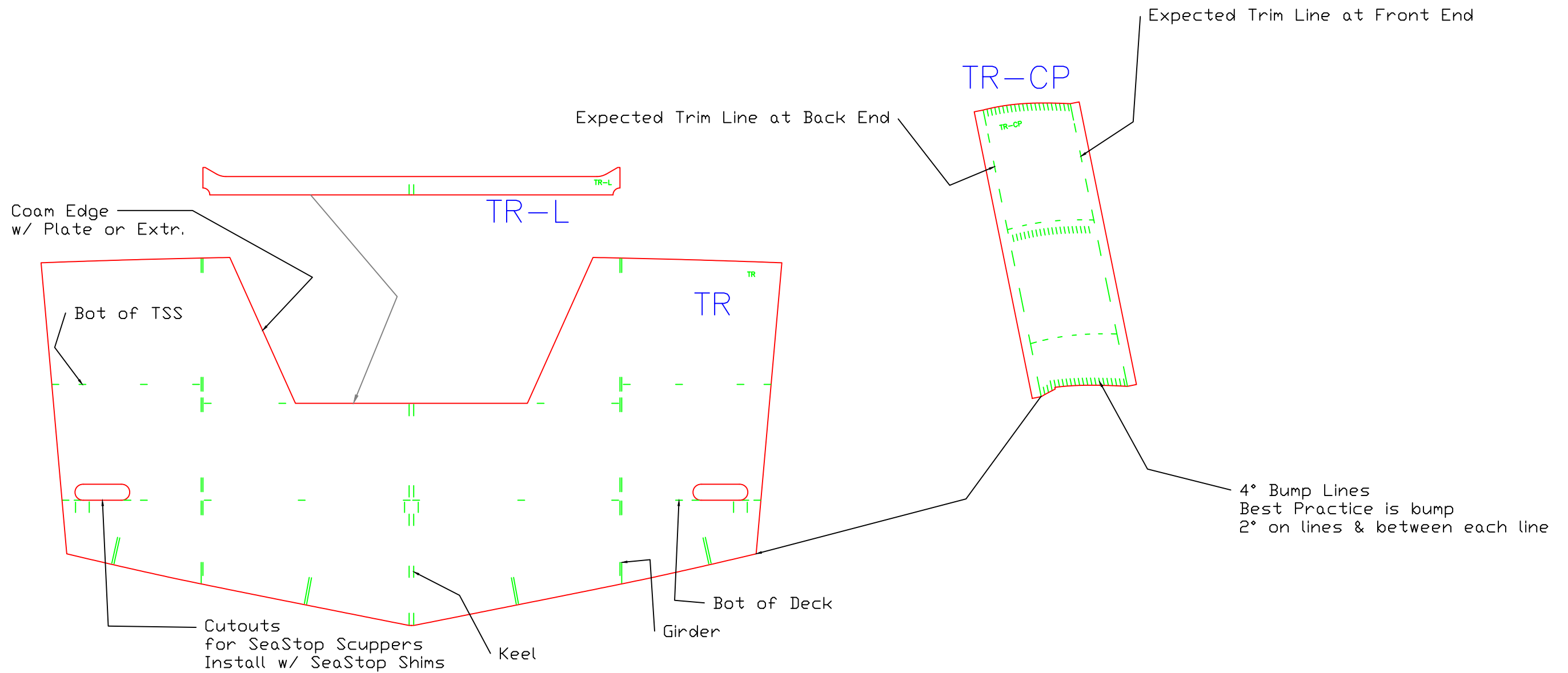


BOTTOM LAYOUT		
20' x 8'3" VBB		
SCALE 3/4" = 1'	DES/DWN WAL	DATE 9/8/19
<b>Response Marine, Inc.</b> Newburyport, MA, <a href="http://www.responsemarine.com">www.responsemarine.com</a>		SHEET DWG. NO. 592-2-3



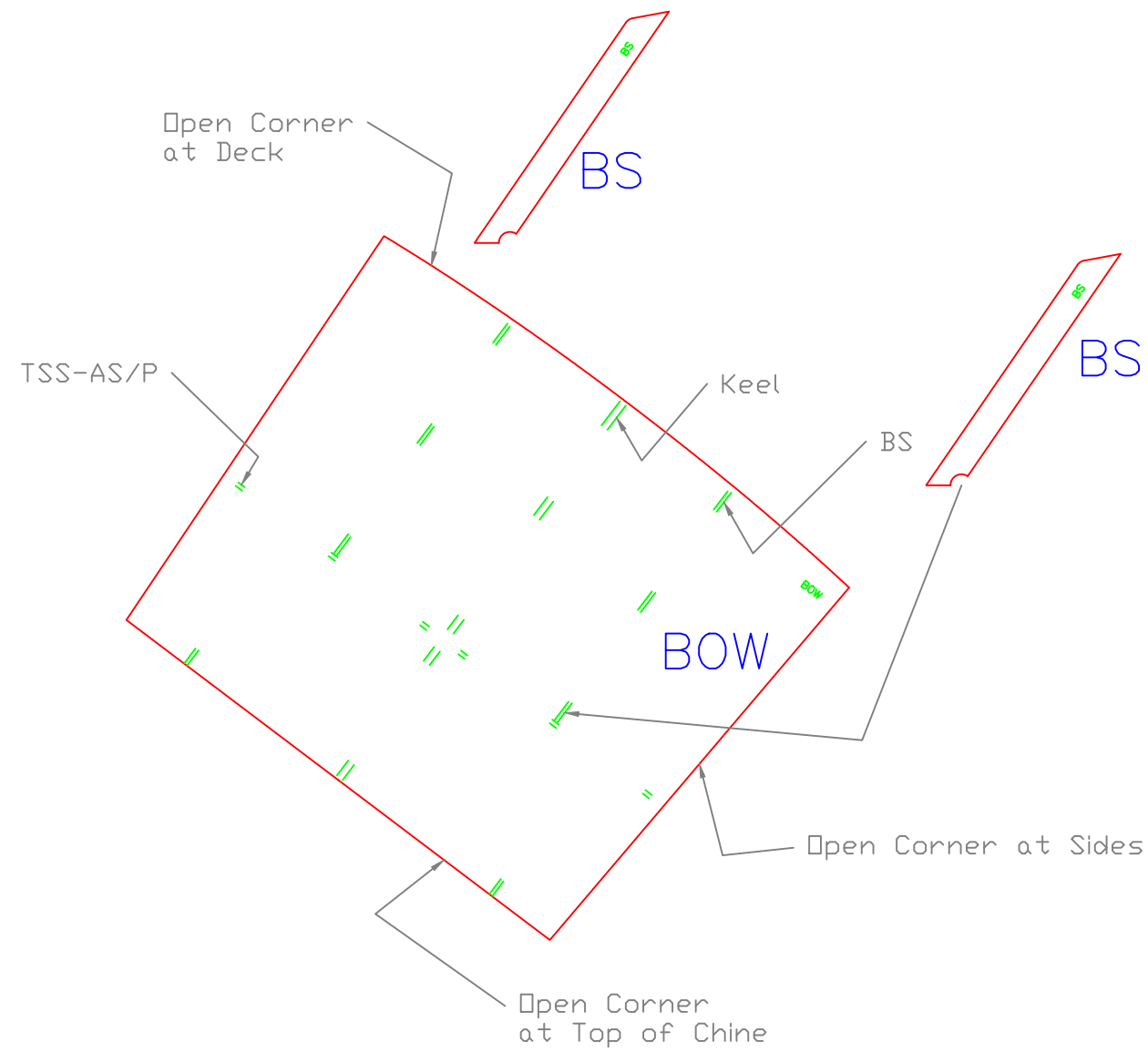


TOPSIDES LAYOUT		
20' x 8'3" VBB		
SCALE NONE	DES/DWN WAL	DATE 9/8/19
<b>Response Marine, Inc.</b>		SHEET
Newburyport, MA, <a href="http://www.responsemarine.com">www.responsemarine.com</a>		DWG. NO. 592-2-4



Note: Transom Lip Height is  
for 25" shaft, mounted in second bolt hole  
(i.e.  $\frac{3}{4}$ " above lip)

TRANSOM		
20' x 8'3" VBB		
SCALE 1"=1'	DES/DWN WAL	DATE 9/8/19
Response Marine, Inc.		SHEET
Newburyport, MA, www.responsemarine.com		DWG. NO. 592-2-5



BOW		
20' x 8'3" VBB		
SCALE 1"=1'	DES/DWN WAL	DATE 9/8/19
<b>Response Marine, Inc.</b>		SHEET
Newburyport, MA, <a href="http://www.responsemarine.com">www.responsemarine.com</a>		DWG. NO. 592-2-6

Deck Parts Viewed From Below

Margin Stringer  
 $1\frac{1}{2}'' \times \frac{3}{16}''$  Sq Tube  
 F3 to Transom

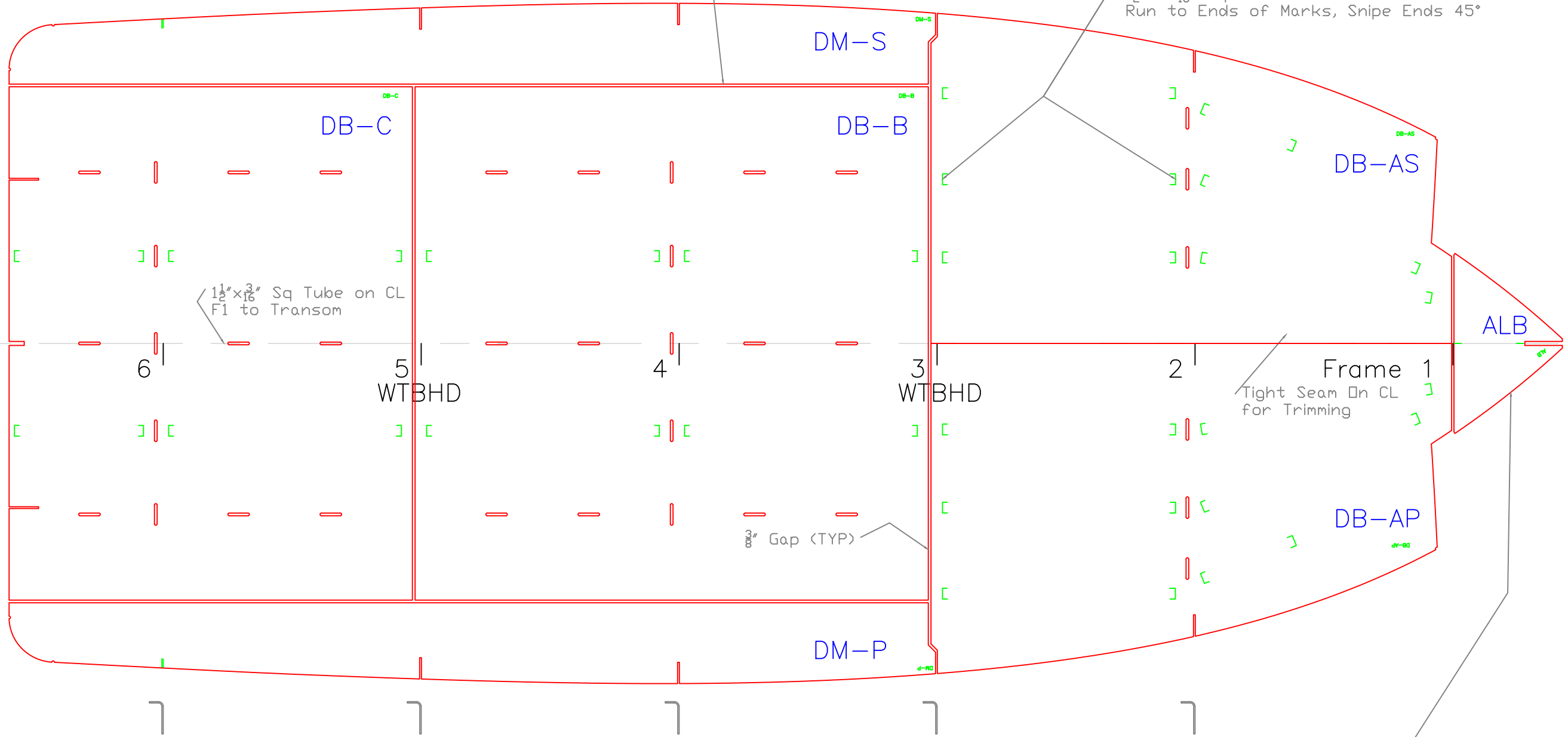
Intercostal Deck Stiffeners (TYP)  
 $1\frac{1}{2}'' \times \frac{3}{16}''$  Sq. Tube  
 Run to Ends of Marks, Snipe Ends 45°

$1\frac{1}{2}'' \times \frac{3}{16}''$  Sq Tube on CL  
 F1 to Transom

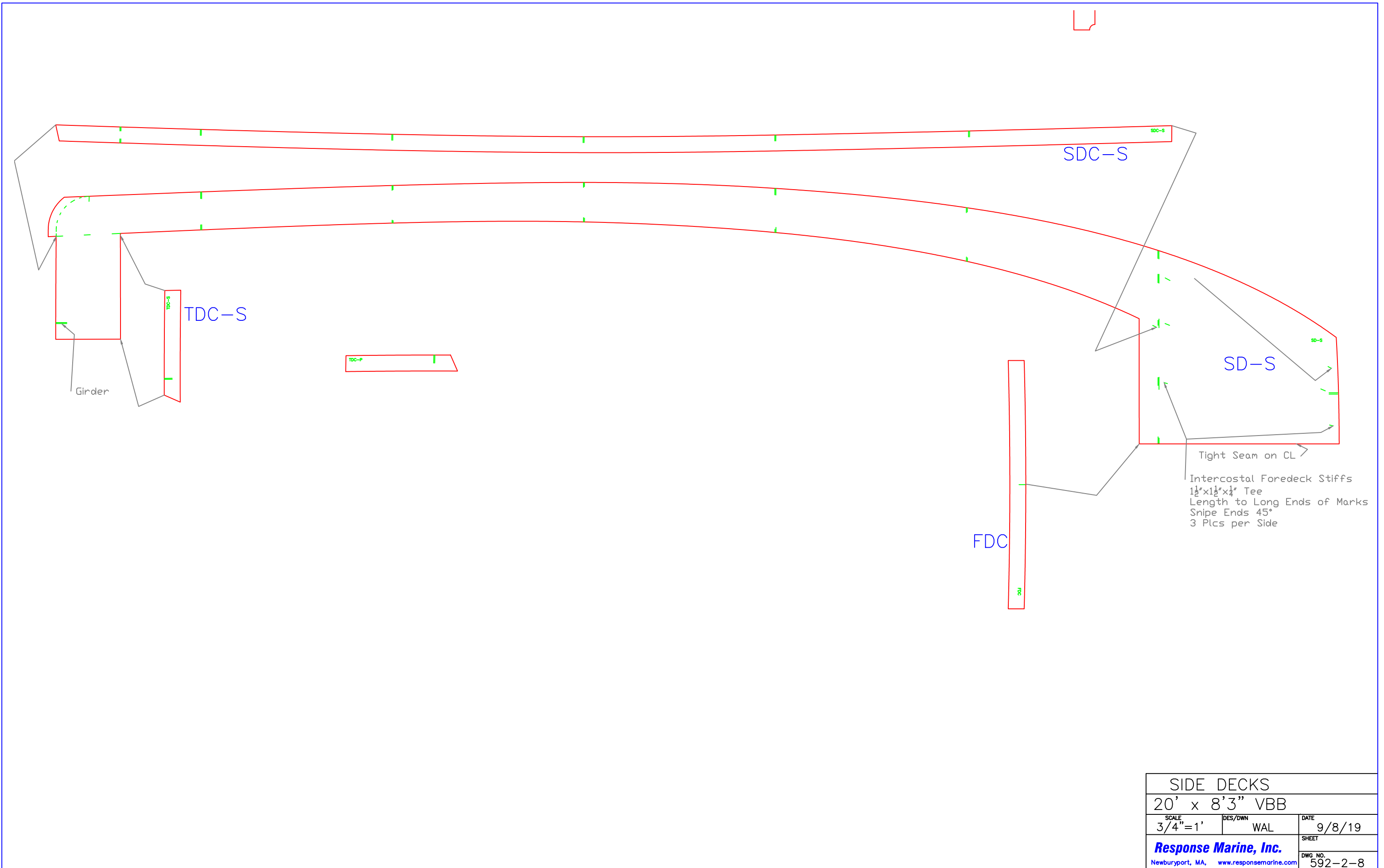
Frame 1  
 Tight Seam On CL  
 for Trimming

$\frac{3}{8}''$  Gap (TYP)

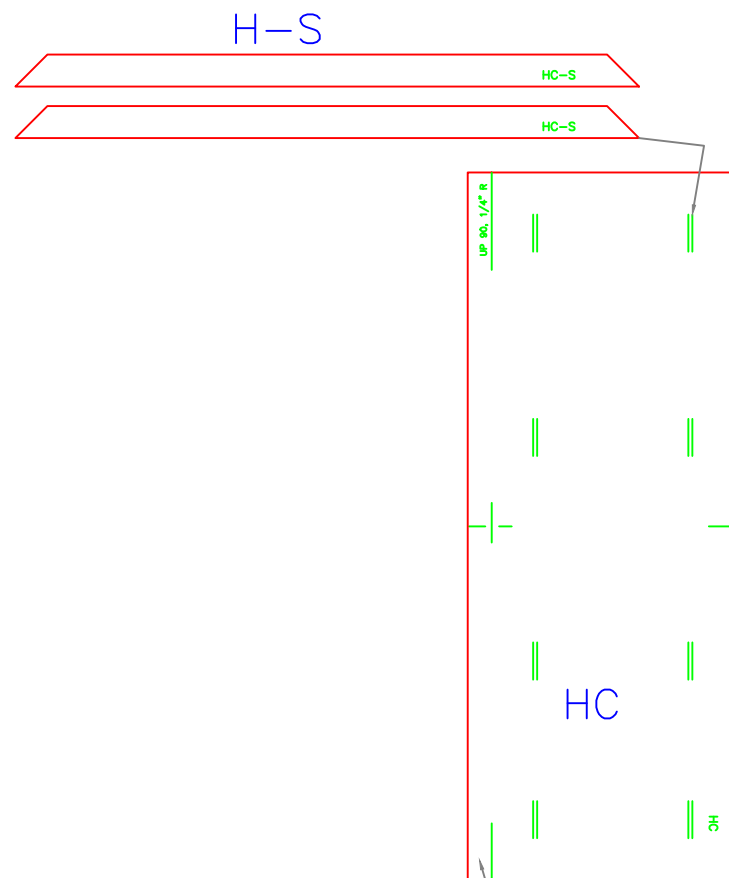
ALB  
 Fits Fwd of F1, DN TOP of chine



COCKPIT DECK		
20' x 8'3" VBB		
SCALE 3/4"=1'	DES/DWN WAL	DATE 9/8/19
Response Marine, Inc. Newburyport, MA, www.responsemarine.com		DWG. NO. 592-2-7

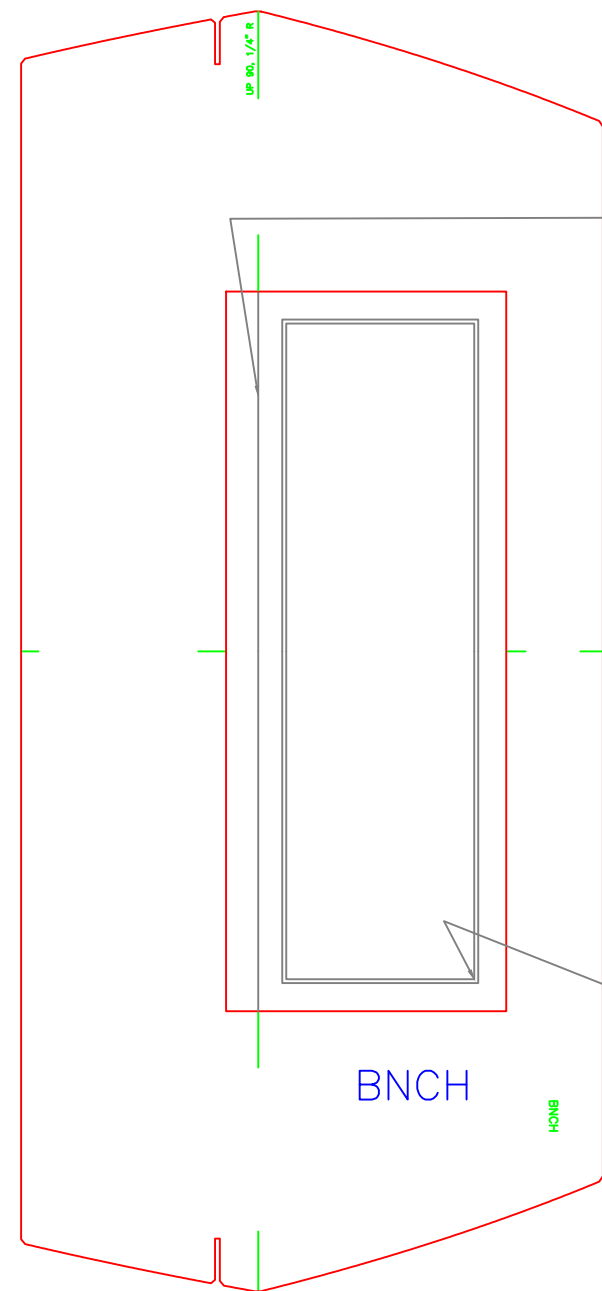


SIDE DECKS		
20' x 8'3" VBB		
SCALE 3/4"=1'	DES/DWN WAL	DATE 9/8/19
<b>Response Marine, Inc.</b>		SHEET
Newburyport, MA, <a href="http://www.responsemarine.com">www.responsemarine.com</a>		DWG. NO. 592-2-8



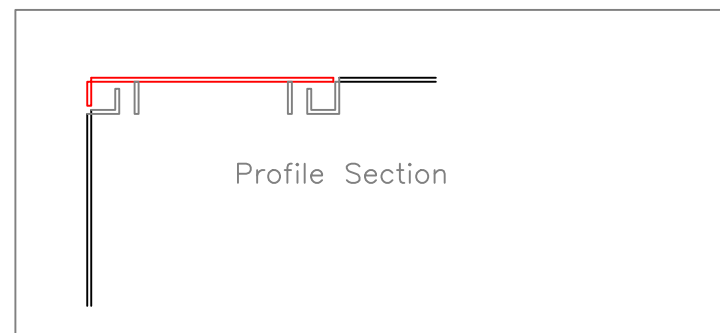
Lip on Hatch Cover  
Bend Down 90°  
1/4" ISR

Form Parts BNCH & HC (5052 H32)  
as Marked 1/4" IS Radius,



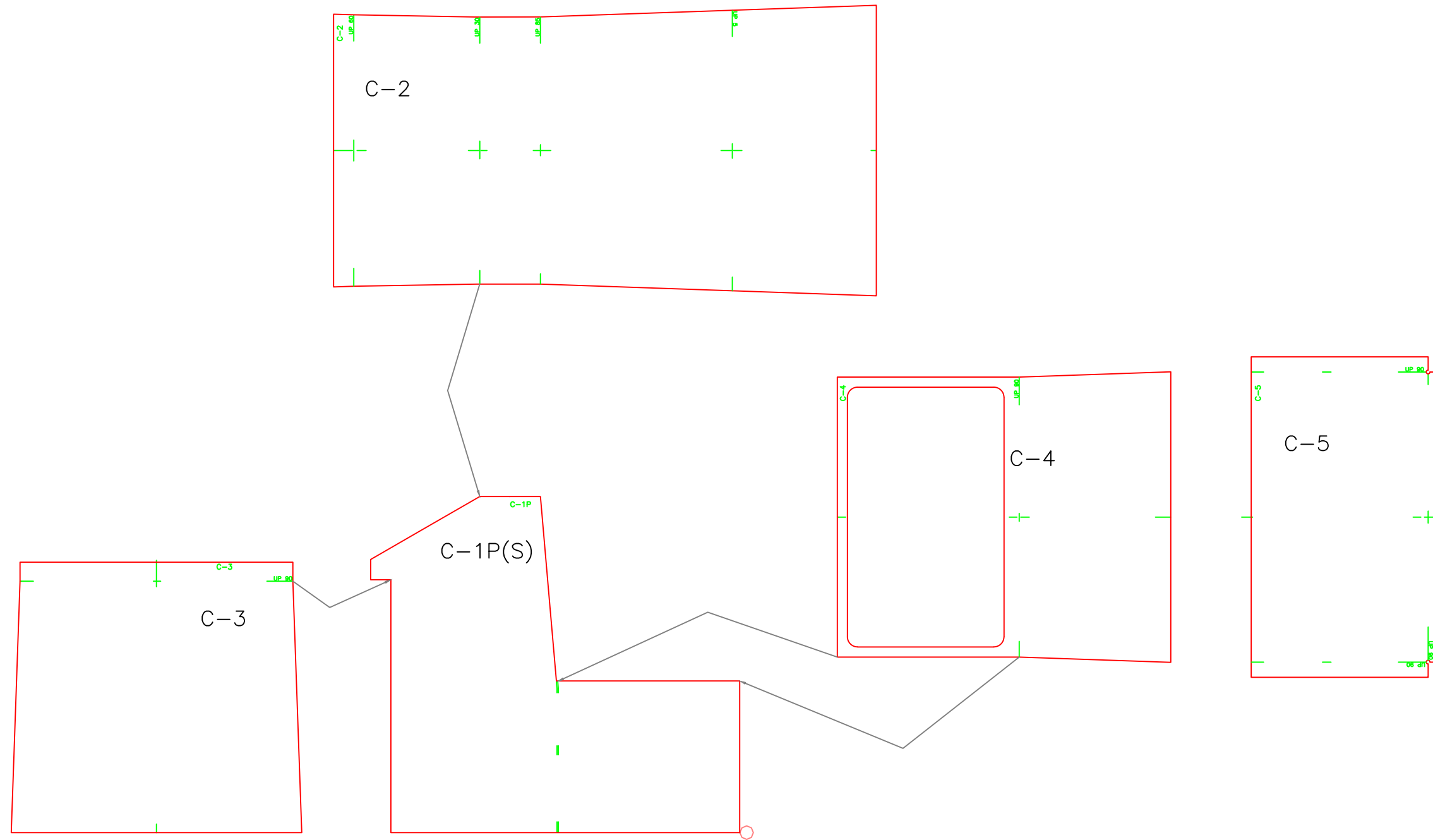
Rip Fwd Leg off this Aft Channel  
(see Profile)

Hatch Gutter  
Rip Inboard Leg down  
3/16" for Gasket



Profile Section

FWD BENCH		
20' x 8'3" VBB		
SCALE 1"=1'	DES/DWN WAL	DATE 9/8/19
Response Marine, Inc.		SHEET
Newburyport, MA, www.responsemarine.com		DWG. NO. 592-2-9



Notes:

Console is  $\frac{1}{8}$ " 5052. Form w/ tight ( $\sim\frac{1}{4}$ " ) inside radius.  
 Suggest (2) Vertical Stiffeners on Aft Face & Fwd/Upper Face  
 Helm Panel will need Stiffening near helm and controls.

CONSOLE (from #502A)		
20' x 8'3" VBB		
SCALE 1"=1'	DES/DWN WAL	DATE 9/8/19
<b>Response Marine, Inc.</b>		SHEET
Newburyport, MA, <a href="http://www.responsemarine.com">www.responsemarine.com</a>		DWG. NO. 592-4-1

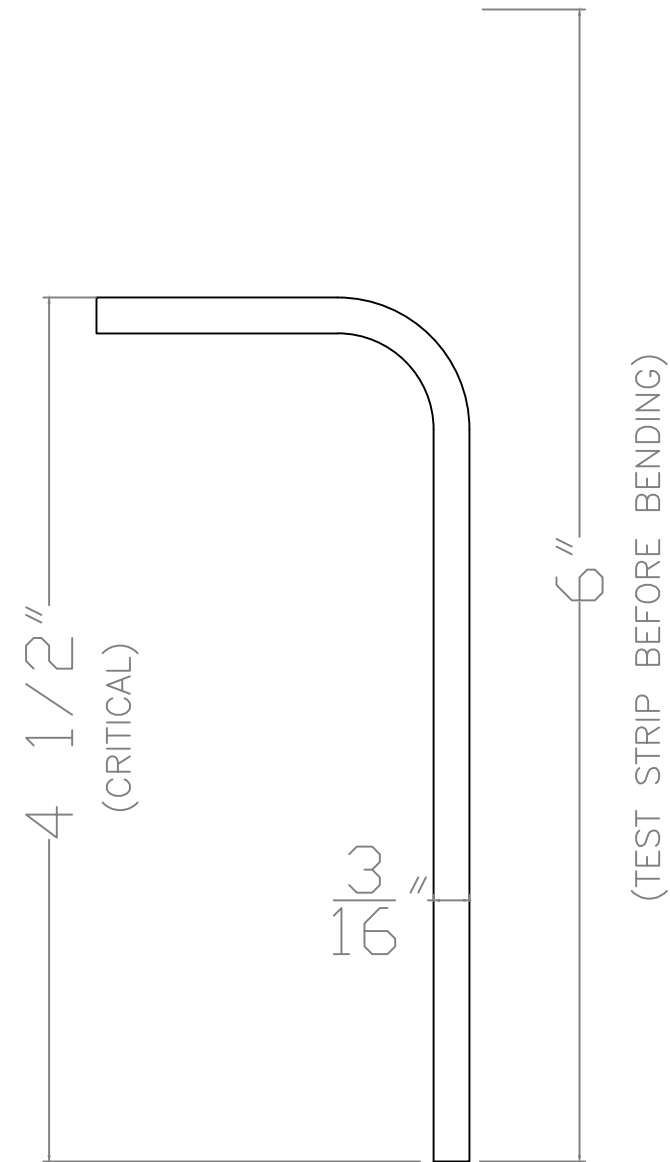
- BG-P Bottom Girder, Port
- BG-S Bottom Girder, Stbd
- F2 Frame 2
- F2P Frame 2, port
- F2S Frame 2, stbd
- F3 Frame 3
- F3-P Frame 3, port
- F3-S Frame 3, stbd
- F4 Frame 4
- F4-P Frame 4, port
- F4-S Frame 4, stbd
- F5 Frame 5
- F5-P Frame 5, port
- F5-S Frame 5, stbd
- F6 Frame 6
- TSS-BP Topsides Stringer Shelf, F2-F4, Port
- TSS-BS Topsides Stringer Shelf, F2-F4, Stbd
- TSS-CP Topsides Stringer Shelf, F4-Tran, Port
- TSS-CS Topsides Stringer Shelf, F4-Tran, Stbd

19 Parts

STANDARD FLANGE "B-1" BENDING:  $\frac{3}{16}$ " 5086/83 H116 Stock

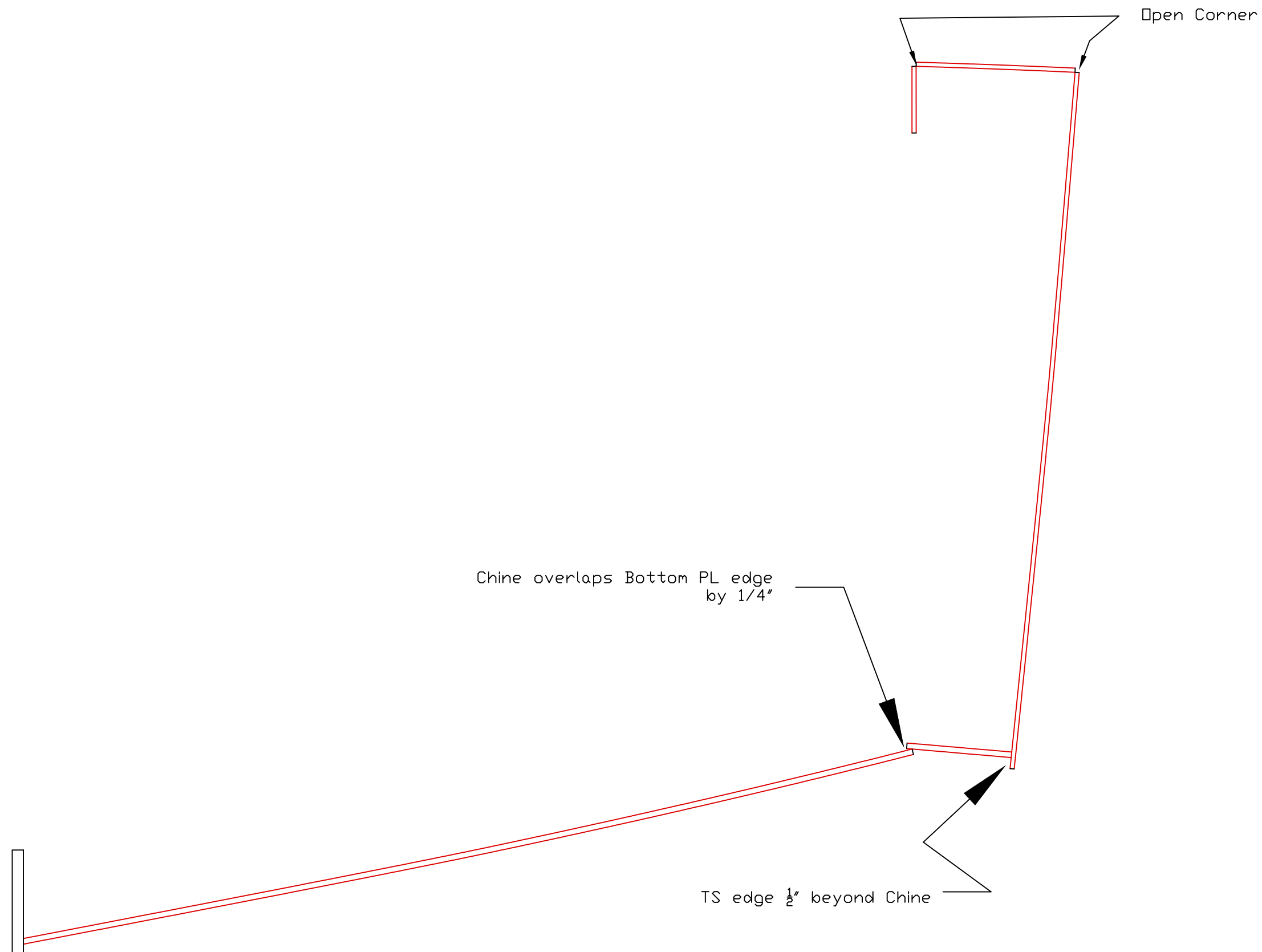
- 1) Confirm results for dimensions and cracking with test strips before bending frames.
- 2) Expected Die Radius is  $\frac{1}{2}$ "
- 3) Flanges are designed for outside major flange length of  $1\frac{1}{2}$ " less than flat stock length as shown.
- 4) Expected Back Gauge setting is 1.72", but confirm and adjust, based on test strip.

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



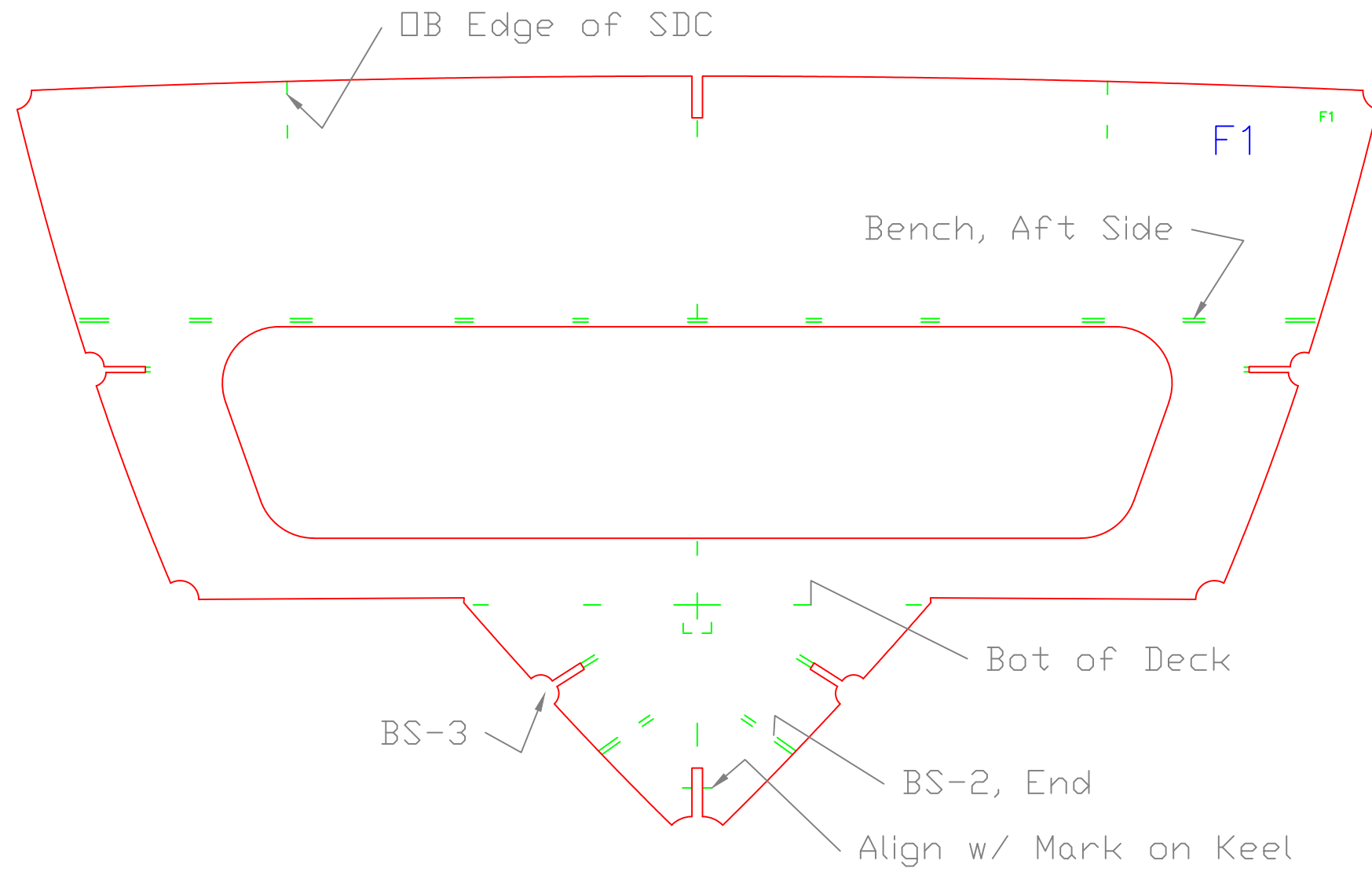
FLANGE "B-1" Forming		
20' x 8'3" VBB		
SCALE 1"=1'	DES/DWN WAL	DATE 9/8/19
<b>Response Marine, Inc.</b>		SHEET
Newburyport, MA, <a href="http://www.responsemarine.com">www.responsemarine.com</a>		DWG. NO. 592-B-1





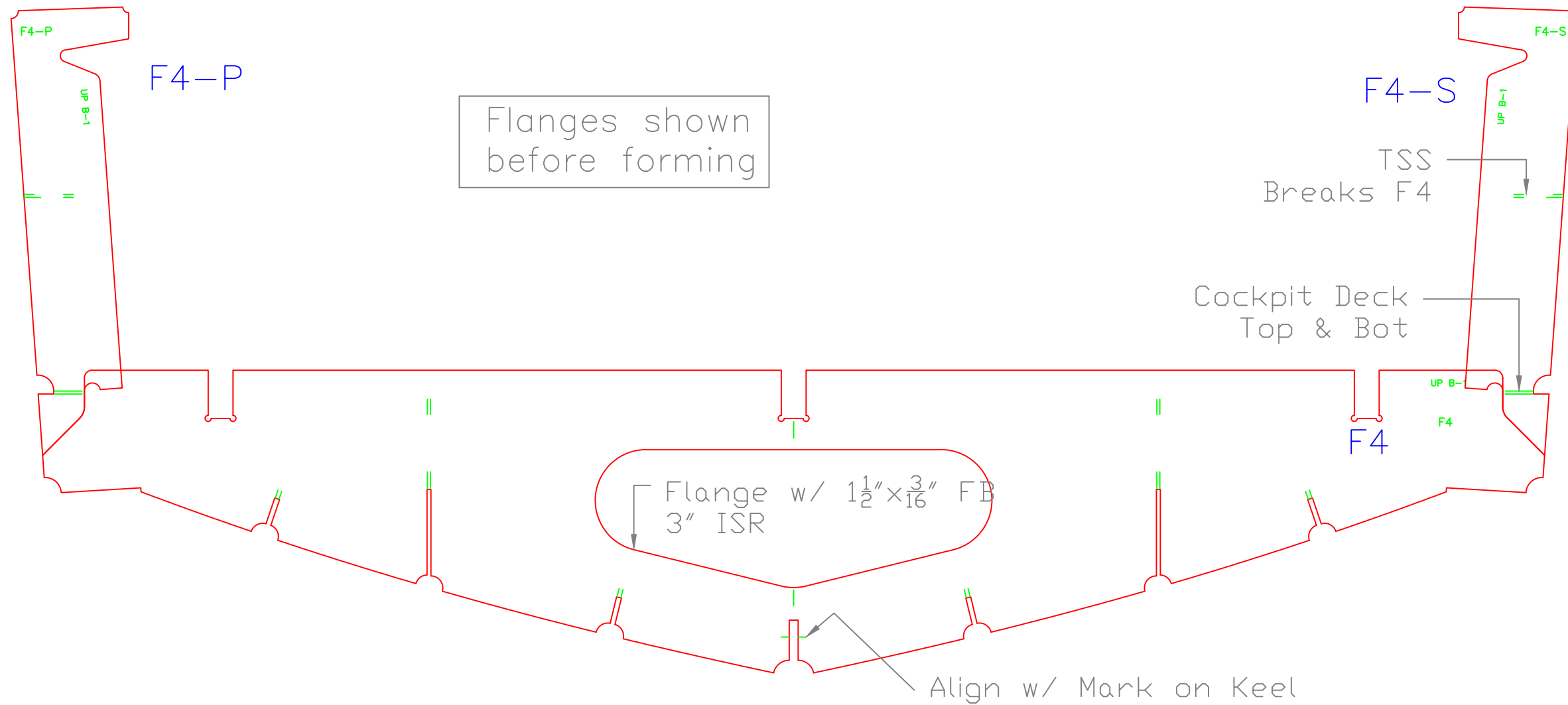
TYPICAL SKIN JOINTS		
20' x 8'3" VBB		
SCALE NONE	DES/DWN WAL	DATE 9/8/19
<b>Response Marine, Inc.</b>		DWG. NO. 592-C-1
Newburyport, MA, <a href="http://www.responsemarine.com">www.responsemarine.com</a>		

L'kg Fwd  
Install with Marks Aft



FRAME 1		
20' x 8'3" VBB		
SCALE 1 1/2"=1'	DES/DWN WAL	DATE 9/8/19
<b>Response Marine, Inc.</b> Newburyport, MA, <a href="http://www.responsemarine.com">www.responsemarine.com</a>		DWG. NO. 592-F1

L'kg Fwd  
 Install with Marks & Flanges Aft



FRAME 4		
20' x 8'3" VBB		
SCALE 1 1/2"=1'	DES/DWN WAL	DATE 9/8/19
<b>Response Marine, Inc.</b>		SHEET
Newburyport, MA, www.responsemarine.com		DWG. NO. 592-F4