

Reassembly of spliced Conventional mast

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General

This instruction describes how to reassembly a mast section which is delivered in two parts. This instruction applies to mast section C156 – C304.

Section	C156	C175	C193	C211	C227	C245	C264	C285	C304
Part No.	507-448-01	507-446-01	507-444-01	507-409-01	507-410-01	507-419-01	507-421-01	507-423-01	507-425-01

Tools

Pop rivet gun, drill, 6,5 mm drill bit, half round file, hammer, 2,5 mm mandrel, sail makers needle. Screwdriver with torx bit for M6.

Mast section reassembly

1. Put the mast parts with fronts facing upwards.
2. Tie the halyard messenger lines together, checking carefully that the lines are correctly connected and not twisted.
3. Feed fitted cables through the lower mast part.
4. Clean the surface of the joint.
5. Loosen the temporary join screws in the joint sleeve.
6. Keep messenger lines and cables tight to prevent them from damaged when the mast parts are pushed together, while feeding cable conduit into their proper positions.
7. Keep the mast straight at the joint by supporting both mast parts rigidly. Keep the two halves tighter by tensioning the halyards.
8. Align mast parts carefully so the predrilled holes in mast section front and joint sleeve match perfectly.
9. Press mast half, joint sleeve together along the A-line using the screws in row 1 and row 2 on both sides, see join drawing (table above). Threaded hole in the joint sleeve decide the position.
10. Fasten the adjoining rivets in row 1 and row 2 on both sides. see mast join drawing for the size of rivets.
11. Remove the screw on the A-line, drill 6,5 mm and rivet.
12. Turn the mast with one side upwards. Recheck mast straightness at the joint.
13. Press the joint tight using screws in the remaining threaded holes in the joint sleeve.
14. Rivet the adjoining rivets holes, remove the screws, drill and complete riveting in the joint sleeve.
15. Turn the mast and repeat this operation on the other side.
16. Punch out all mandrel heads. Remaining mandrel heads may create corrosion or damage sail.



Conventional mast C156

The C156 Mast has some extra screws in the join. Put Loctite 639 on the thread and fasten the screws. (MFT 6x10. See PS drawing for more info.

Check point

- Check the sail groove. Some grinding may be necessary to make them smooth at the joint.

Spinnaker pole track

- Fit spinnaker pole track if any.
- Fit all the rivets into their holes provisionally before they are permanently riveted. (the track might have been put up side down). Punch out the mandrel heads.

Halyard

1. Fit the halyard one by one. Do not untie more than one messenger line at a time, as they easily get tangled.
2. Using a sail makers needle, feed the top end of the messenger line through the lower end of the appropriate halyard and knot.
3. Carefully pull the halyards down inside the mast.

