

BulletProof



The logo for BulletProof Mini Jet features the brand name in a bold, black, sans-serif font. The 'i' in 'BulletProof' is stylized with a bullet shape. Below the main text, there is a graphic of a jet's hull and a stylized wave. The words 'Mini Jet' are written in a smaller, bold, black font below the graphic.

Congratulations on your purchase of your all new DIY BulletProof Mini Jet hull kit. Everything required to complete a hull is included in this kit. If you require any extras such as swim deck, railings, engine cover, etc. please contact us via email at charles@bulletproofwelding.ca or by phone at 780-786-2345. If you happen to damage a piece and require another we can cut each individual piece out as required just contact us with the part and orientation (left or right) and we would be happy to assist.

Please note that some trimming and tweaking of bends may be required depending on how your kit goes together and the tools at your disposal.

Tools required:

- Rubber mallet or dead blow
- 1-2 ratchet straps
- Aluminum welder(Spool gun, pulsed mig or Tig)
- Sharpie
- Tape measure
- A friend or two
- 2' square
- bar clamp or bessey clamp(Not necessary but helps)
- Porta-power(Not necessary but helps)
- Adjustable square
- Grinder with cutting and ALU grinding disk
- Level

To begin start by welding the nose pieces onto the hull bottom on either side(10' is a single piece so this step is not required). Be sure to Vee out the joint a little to ensure good penetration as you will be grinding the bottom side flush during the finishing process. Next tack weld the tips onto the side pieces while the hull cools from welding. Again be sure to Vee out your joint slightly as you will also be grinding the outside flush in the end.

Place the hull bottom on a flat surface such as the pallet it was shipped on or the shop floor. Measure and mark a line 3/8" from the rear of the hull bottom. This is where the transom will sit. Place the

transom on the line *NOTE: SOME GRINDING OF THE TRANSMOM BOTTOM MAY BE REQUIRED FOR PROPER FIT DON'T WORRY ABOUT A SMALL AMOUNT OF GAP IF THERE IS ANY*

Square the transom from the rear of hull and check to make sure it is square with tips as well. Use your 2' square to ensure it is sitting straight up and down off the hull bottom. Use a level to ensure the transom top is sitting level forward to back. Tack the transom in place and run a reinforcement horizontally from the top of the transom to the center of the hull. Once square tack/stitch weld the transom in place. You may use more material to keep the transom square if you'd like.

Using a combination of ratchet straps and bar clamps pull the hull tips together. It is helpful to belly wrap the hull with the ratchet straps and work from back to front of the bow stitch welding as you go. You may need to tack pieces of scrap or flatbar onto the hull side to prevent the straps from sliding. Once this is done you may cut off the tabs on the nose following the natural curve of the bow.

Now attach the chines to the hull bottom. Start at the back and work forward. They will require a bit of force from a friend to bend them into position along the curve of the bow as you go stitch weld as before.

Next attach the sides, again start from the back and work forward this time though work side to side as well keeping both sides the same. The transom reinforcement may need to be moved at this point to ensure the transom matches up with the sides. Ensure you re attach it if you do remove it for this purpose.

Now attach the combings using the same method as the sides, back to front and side to side as you go. Ensure you place good stitch welds on everything as there is significant force on the hull at this point you don't want a tack to break and then require you to go back and re do things. *NOTE: THE SIDE TIPS MAY REQUIRE TRIMMING AT THIS POINT FOR YOUR NOSE TO FIT UP PROPERLY*

You may now attach the deck piece. Start at the front for this working back. We find it is easier to attach the tip of the deck and do one side before the other. Any angle in the deck will be adjusted when you install the dash piece and windscreen.

Fill in the gaps from the deck to sides with the gunnels. You may trim the gunnels to fit flush or have them sit on top of the sides.

Install the dash piece working from the center out side to side.

NOTE: INSTALLING THE WINDSHIELD ONCE ALL HULL WELDING AND CLEANUP IS COMPLETE IS MUCH EASIER. YOU MAY EVEN CHOOSE TO INSTALL WINDSHIELD ONCE MOTOR IS IN AND UHMW INSTALLED IF YOU USE UHMW.

Tack the windscreen sides onto the windscreen on a flat surface. Place the windscreen assembly on the deck a few inches back from the dash. Once satisfied with windscreen placement ensuring it is square to the boat tack it down and fit the visor piece into the top of the windscreen. (no visor with sport windscreen) You may be required to cut a few tacks to get this part right and squared up. Ensure there is no bowing in the windscreen sides as this will complicate your lexan/glass installation down the road. Once happy with the windscreen placement install the nose cone in front center of windscreen(no lexan or nose cone with sport windshield).*NOTE:MAY REQUIRE SOME TWEAKING OF ANGLES TO FIT NOSE CONE DEPENDING ON HOW AND WHERE YOU PLACED THE WINDSCREEN*

At this point you may install your stringers . We recommend not doing this until you have a motor as the stringers make great mounting spots for your motor mounts as well as you need to know motor size before placing your engine bay support to ensure sufficient room for all components in the engine bay. You may require a bottle jack or portapower to push stringers down into place once you install them.

NOTE: BEFORE WELDING HULL YOU MUST TACK AN ENGINE BAY SUPPORT INTO PLACE TO AVOID THE HULL PULLING INWARDS. DO NOT REMOVE ANY REINFORCEMENTS UNTIL WELDED HULL HAS COOLED FROM WELDING.

If you have any questions during your build don't hesitate to call us or email. Thank you for your business and enjoy your new BulletProof Mini Jet!

