

FOUR77 / COAST

LAST LIGHT

ST2130 prototype build sheet

40 mm integrated-bracelet case
Sea-Gull ST2130 automatic
28,800 vph / no-date display
Sapphire crystal / 10 bar case rating

CASE

40 × 44.5 × 11.5 mm

DIAL

31 mm wave / custom no-date

MOVEMENT

ST2130 / H3 / 4 Hz

STATUS

Prototype / fit-check required



COMPLETED WATCH RENDER

Final Coast / Last Light configuration

Bill of materials

Watch, presentation box and finishing materials

ITEM	SPECIFICATION / SELECTION	SOURCE	EST.	CONTROL NOTE
01 Case assembly	Tandorio PRX-style, 40 mm, polished bezel, solid back; ETA 2824 / PT5000 option.	Tandorio [1]	\$66.84	Integrated bracelet included; confirm holder, clamps, stem and gaskets.
02 Dial	31 mm white wave dial, Color I no-date, ETA 2824 / PT5000 feet; refinish as custom dial.	Tandorio [2]	\$21.95	Order I no date / ETA option; verify 31.0 mm fit.
03 Movement	Genuine Sea-Gull ST2130 / TY2130, 28,800 vph; calendar hidden by no-date dial.	Sea-Gull [3]	\$85.00	25.6 mm casing diameter; approx. 4.8 mm high; first detent remains unused.
04 Hand set	Silver lumed baton hour + syringe minute; blue lumed lollipop seconds with orange tip.	Candidate [4]	\$10-30	Holes 1.50 / 0.90 / 0.25 mm; target lengths 8-9 / 12-13 / 12-14 mm.
05 Stem + retention	ST2130 stem; case-specific movement ring, clamps and screws.	Movement / case kit	verify	Do not assume NH stems or spacers interchange.
06 Watch consumables	Gasket grease, Rodico, blower, finger cots and optional low-strength thread retainer.	Watchmaker supply	\$15-30	Keep grease off dial, hands, crystal interior and stem threads.
07 Presentation box	Shoreline-standard FoldaBox A5 shallow natural linen; mechanical front tab; no magnets or ribbon.	FoldaBox SAM056060	\$18-35	Same exterior box across products; smallest measured interior governs insert.
08 Insert + retention	10 mm dark navy high-density EVA / XLPE over 2 mm navy EVA backer; optional navy flocking.	Packaging / craft supply	\$4-7	Re-cut Coast pocket for integrated bracelet; add lift tab and isolate metal.
09 Box customization	Ivory 80-100 lb lid card, Coast bookplate, landscape thank-you card and care card; transfer adhesive and 3/8 in navy grosgrain.	Print / craft supply	\$2-5	Use Shoreline dielines; change product typography only. Card and tool cutouts share the same apparent width.
10 Collateral + pack-out	Protective film, concealed 1 g silica, kraft cushioning and 10 x 8 x 3 in corrugated mailer.	Packaging / shipping supply	Thank-you card/tool bays must not migrate into the watch pocket.	

INDICATIVE TOTAL: \$210.79-\$258.79 Watch \$183.79-\$203.79 + packaging \$27-\$55; custom dial/caseback labor excluded. Fit gate: 31.0 mm dial vs 31.5-31.8 mm case.

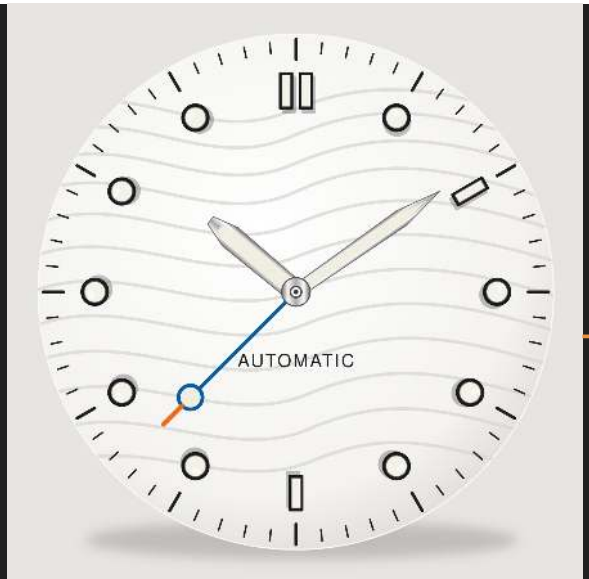
Exploded assembly view

Not to scale - order follows casing sequence



01 / CASE ASSEMBLY

Actual Tandorio case + bracelet [1]



02 / DIAL LAYOUT

Geometry-controlled no-date donor layout [2]



03 / ST2130

Official Sea-Gull movement photo [3]

FRONT-TO-BACK CASING STACK



Supplier photos are used for purchasable visible components. Gaskets, holder, clamps and caseback stack remain diagrammatic because the listings do not isolate them.

Fit gate: obtain written confirmation that the advertised 31.0 mm dial is retained by the case specified for 31.5-31.8 mm dials.

Dimensioned reference views

Actual supplier photos with published dimensions

FRONT ELEVATION



Actual supplier photograph [1]

SIDE PROFILE



Actual supplier photograph [1]

Case diameter	40.0 mm
Top to bottom	44.5 mm
Thickness	11.5 mm
Dial listing	31.0 mm
Case dial range	31.5-31.8 mm

THREE-QUARTER VIEW



Actual supplier photograph [1]

MEASUREMENT STATUS

Published supplier dimensions; photos are form references and are not pixel-scaled drawings.

Assembly sequence

Clean bench / magnification recommended

01 Incoming inspection

Check crystal, bezel, bracelet, crown tube, caseback threads, gaskets and dial finish. Measure the dial before committing.

02 Bench-test movement

Wind 5-10 crown turns; verify start-up, hacking and hand-setting. Record rate, amplitude and beat error. The calendar display will not be used.

03 Customize the dial

Refinish the factory no-date wave dial, align the applied markers, apply four77 / COAST branding and install the custom wave index at 6. Follow the page 07 workflow.

04 Install dial

Secure using the movement's dial-foot screws. Do not overtighten. Protect the dial face throughout the remaining work.

05 Set hand reference

Set the motion works to 12:00 and align the hour hand exactly at 12. No calendar-change indexing is required for this no-date build.

06 Fit hands

Press hour, minute, then seconds hands using correct flat dies. Hands must be parallel and fully seated without touching.

07 Function test

Rotate through at least 24 hours. Confirm 12:00 alignment, hand-to-hand clearance, dial clearance and an uninterrupted no-date dial surface.

08 Case the movement

Clean the crystal interior, place movement/dial into the case, orient crown axis, and install the specified ring/clamps.

09 Cut and fit stem

Measure twice; shorten incrementally. Deburr and test winding, hacking, time setting and screw-down engagement before final retention.

10 Seal and commission

Lightly grease gaskets, close caseback to supplier method, clean exterior, time-test, then pressure-test before water use.

ETA-FAMILY KEYLESS WORKS

Use minimal pressure on the stem-release detent; excess force can dislodge the setting lever and require dial-side repair.

Water resistance is a tested result, not a parts-list claim. Do not expose the finished watch to water before pressure testing.

Stock parts to final finish

Supplier parts / prepared donor at left; custom targets at right

CASE / NO CHANGE



OFF THE SHELF

Keep factory brushing, polished bezel, crown, crystal and bracelet untouched.



UNCHANGED



FINAL

SOLID CASEBACK / EXTERIOR WRIST-FACING EMOSS

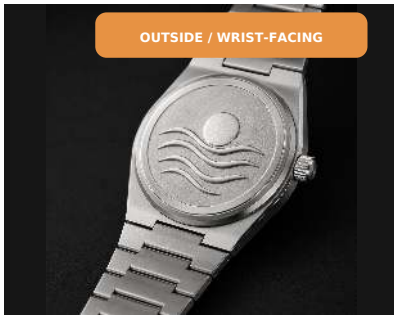


OFF THE SHELF

Raised relief projects outward from the installed wrist-facing back plate.



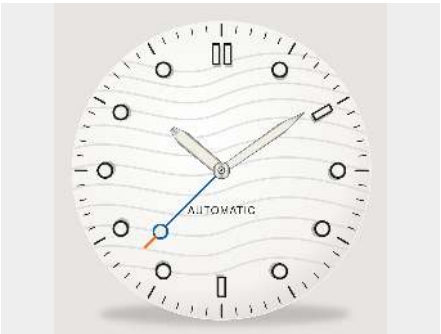
OUTSIDE / WRIST-FACING



FINAL RENDERING

Keep the gasket land and threads untouched.

DIAL + HANDS / EXACT 30° INDICES + 60-MARK CHAPTER RING



PRE-CUSTOMIZATION LAYOUT [2]

NO-DATE



FINAL PRECISION RENDER

CUSTOMIZATION SCHEDULE

CASE	No intervention; protect factory finish.
CASEBACK	Emboss the outside wrist-facing rear face only; keep gasket land and threads untouched.
HANDS	Polished silver lumed baton hour + syringe minute; blue lumed lollipop seconds, orange tip.
DIAL	Factory no-date donor; blue-to-orange paint; apply four77 / COAST.
INDICES	Raised applied gold markers; exact radial alignment; Shoreline/Breakwater crest at 6.

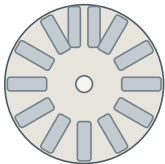
CUSTOM WORK + TOOLING NOT INCLUDED IN BOM TOTAL

Dial painting workflow

Three-stage color build / keep every coat thin / cure fully between systems

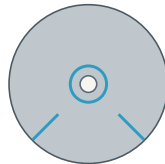
01 Document + strip

Photograph the donor and record every index center. Remove hands and dial. Lift applied markers and the 6 o'clock wave only if they can be removed without bending.



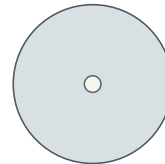
02 Mask critical areas

Mask the center hole, dial feet, underside, marker holes and outer seating edge. Mount by the protected feet or a disposable edge holder.



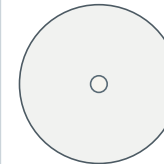
03 Clean + key

Test cleaner on scrap first. Degrease without soaking, lightly key the face with 1000-1500 grit, then remove every particle with clean air and a lint-free wipe.



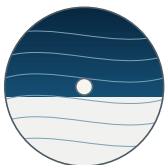
04 Prime lightly

Use a primer/sealer compatible with the full paint system. Apply 1-2 mist coats only; preserve the wave relief and keep all openings clear. Cure to the maker's TDS.



05 Apply deep navy

Mist deep navy from 12 toward the center, leaving the lower half in primer. Build opacity with several translucent passes; keep the spray perpendicular to preserve the wave relief.



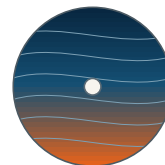
06 Add Coast blue

Feather Coast blue through the upper-middle and center, blending it into the navy. Stop around a blue-gray midpoint and keep the lower quarter clean for orange.



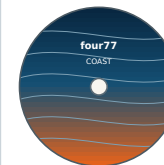
07 Add sunset orange

Build Last Light orange upward from 6, meeting the blue-gray transition with transparent passes. Compare the blend to the target under neutral light before curing.



08 Brand + clear

Apply four77 / COAST by pad print, dry transfer or a white-ink waterslide. Lock the completed three-color gradient with the thinnest compatible clear system, then allow a full cure.



PROCESS CONTROLS

Ventilation + SDS PPE / one compatible coating family / multiple mist coats / full cure before decals, adhesive or movement assembly.

Timing varies by coating and shop conditions: follow the selected product TDS. Example reference [5]: Createx AutoBorne Sealer technical data.

Presentation concept

Shoreline system / natural linen / dark navy insert / ivory paper



COAST IN SHORELINE PACKAGING SYSTEM

Final Coast watch; thank-you card replaces spare strap

four77

COAST

LAST LIGHT

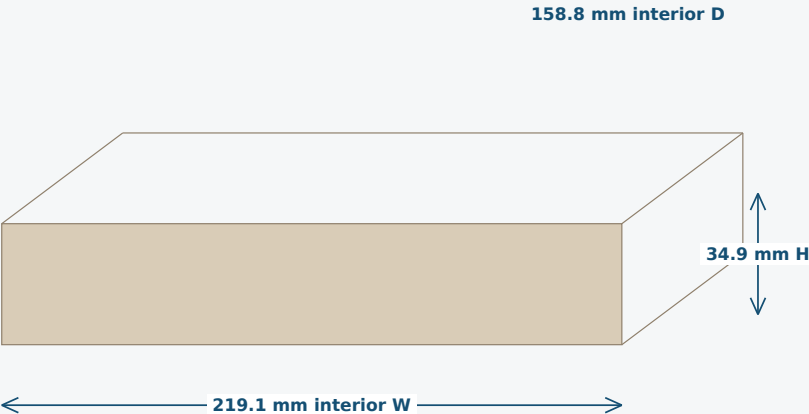
DESIGN INTENT

- Use the same shallow A5 natural-linen book box as Shoreline.
 - Mechanical front locking tab only; no magnets or hidden magnetic hardware.
 - Dark navy fitted insert is re-cut for the Coast integrated bracelet.
 - A landscape ivory thank-you card fills the upper-right bay; no alternate strap is packed.
- Concept rendering; final supplier samples govern color and texture.

Construction specification

Shoreline-standard box - measure delivered sample before cutting insert

A5 SHALLOW NATURAL-LINEN PRESENTATION BOX



Insert starts at 215.9 x 155.6 mm; trace the delivered box and Coast bracelet before final cutting.

COMPONENT	MATERIAL / FINISH	COLOR
Outer box	FoldaBox A5 shallow; mechanical front tab; no magnets or ribbon	Natural linen
Top insert	10 mm high-density EVA / XLPE; optional self-adhesive flocking	Dark navy
Backer	2 mm full-size EVA soft layer beneath all watch/accessory cutouts	Dark navy
Paper	80-100 lb lid card, bookplate, care card and landscape thank-you card	Ivory + navy
Type	four77 / COAST / LAST LIGHT; Shoreline dielines and placement	Navy ink

FINAL COMMISSIONING RECORD

FIT + COSMETIC

- ☐ Dial centered; no perimeter gap
- ☐ Factory no-date dial; no aperture
- ☐ All hour indices centered and radial
- ☐ Hands parallel and dust-free
- ☐ Bezel/crystal/caseback unmarked

FUNCTION

- ☐ Manual wind / automatic wind
- ☐ Hacking and time setting
- ☐ Unused calendar detent documented
- ☐ 24-hour hand-clearance cycle
- ☐ Crown threads engage smoothly

TEST

- ☐ Rate: ____ s/day
- ☐ Amplitude: ____°
- ☐ Beat error: ____ ms
- ☐ Power reserve: ____ h
- ☐ Pressure test: ____ bar / pass-fail

PACK-OUT

- ☐ Mechanical tab closes freely; no magnets
- ☐ Bracelet pocket and lift tab secure
- ☐ Thank-you card/tool bays isolated from watch
- ☐ Protective film removed at delivery

Supplier references [1]-[4] on the BOM are live hyperlinks. Prices checked 04 Sep 2026.