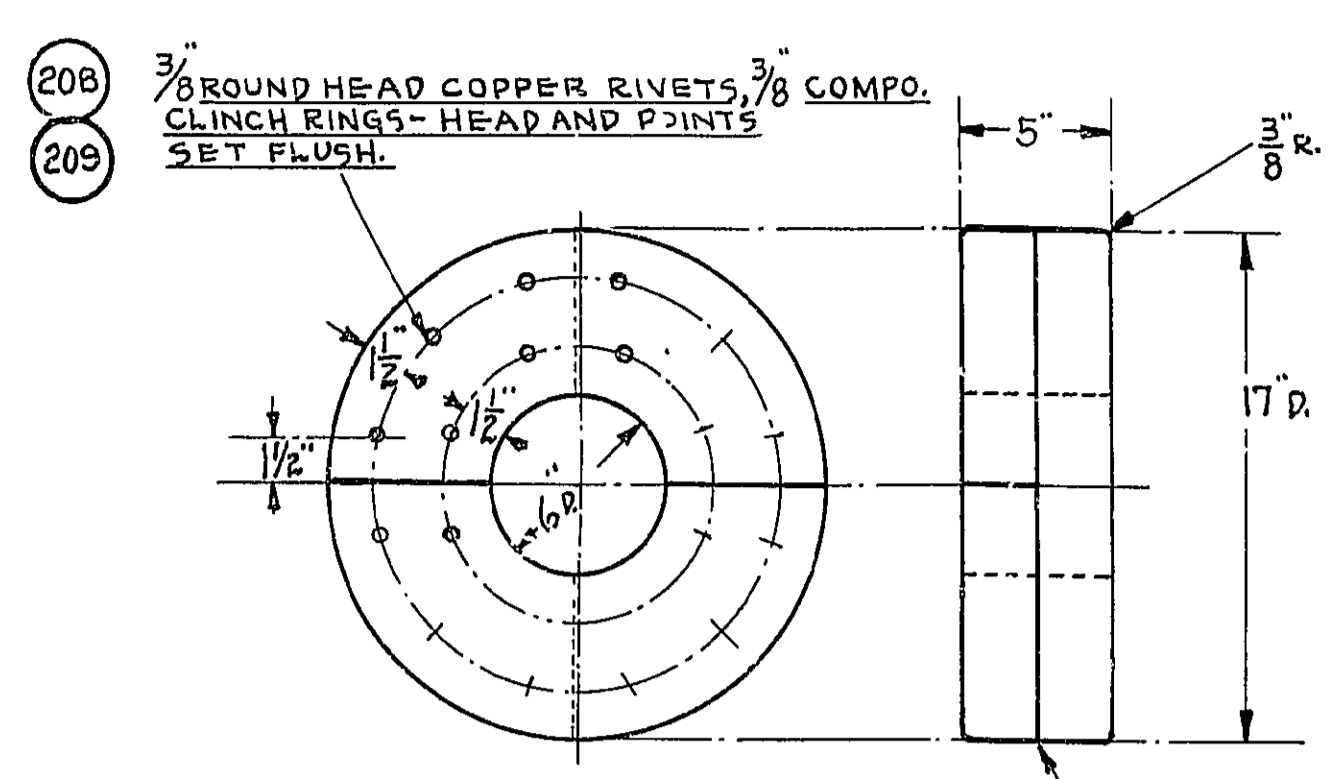
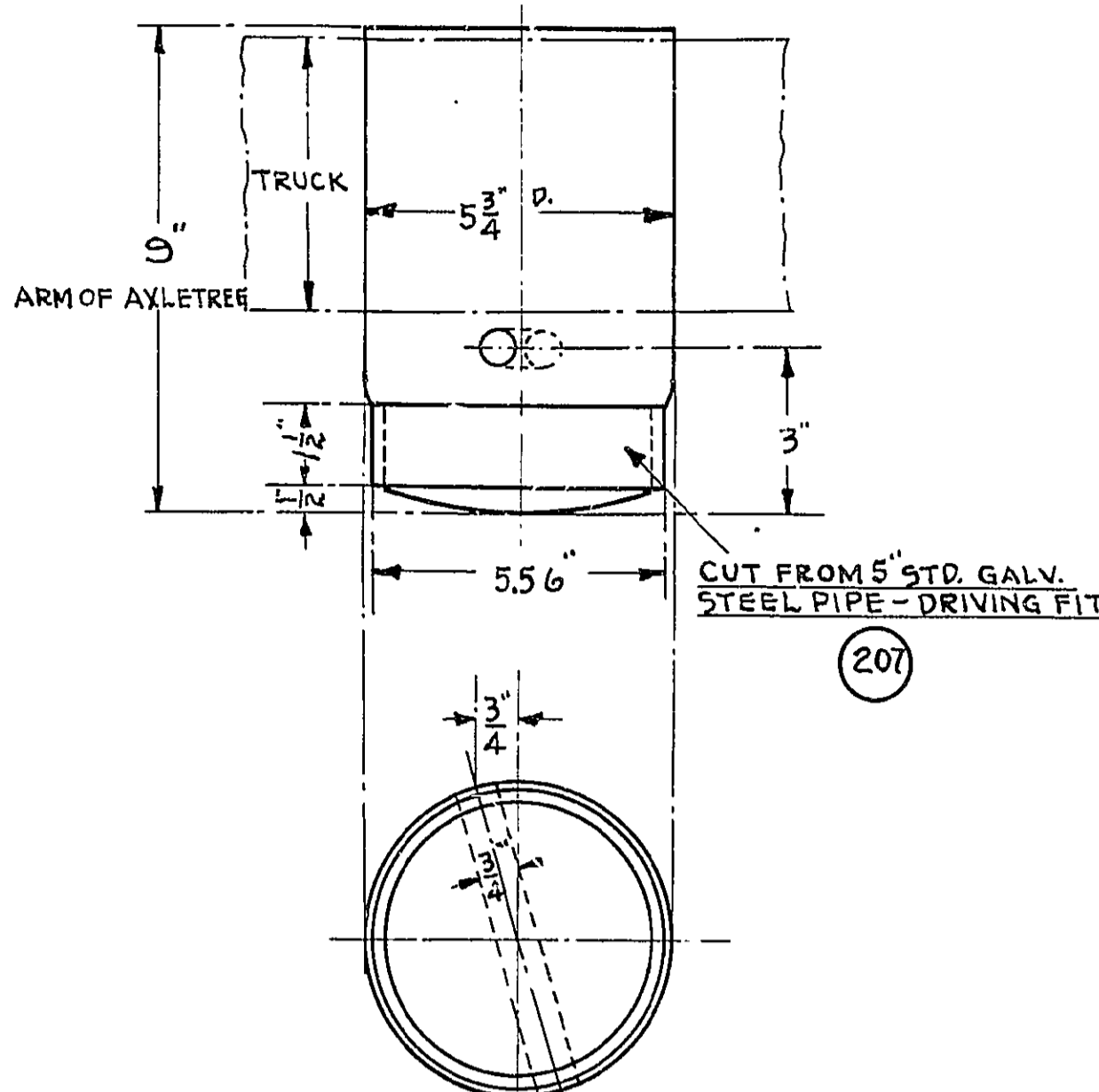


SCHEDULE OF MATERIAL FOR 2 GUN CARRIAGES

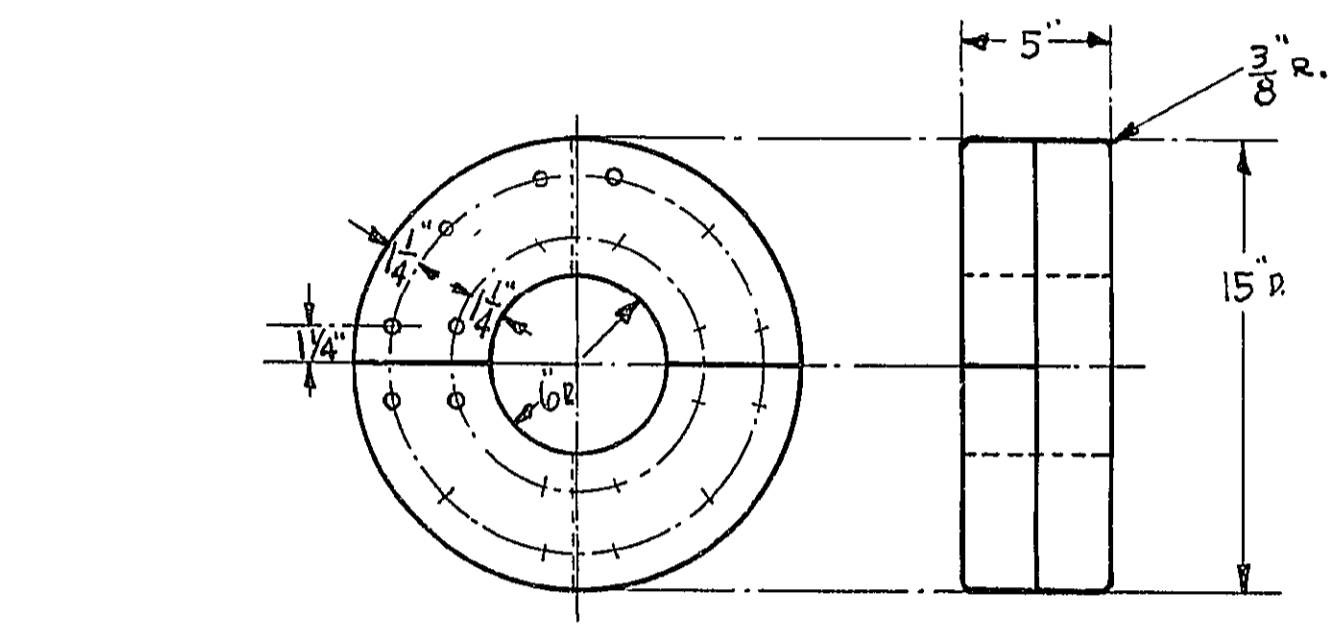
NO.	AMT.	DESCRIPTION	MATERIAL	REMARKS
1	4	JOINT BOLT - 1 1/8 D. x 14 1/2 L.	MED. STL.	THREAD 2 1/4"
2	4	" " 1 1/8 D. x 16 1/2 L.	" "	" "
3	4	" " 1 1/8 D. x 17 L.	" "	" "
4	2	TIE BOLT 1 1/4 D. x 29 1/2 L.	" "	2 1/2 - SQ. HD.
5	2	" " 1 1/4 D. x 31 L.	" "	2 1/2 - SQ. HD.
6	4	CAPSQUARE EYEBOLT 1 1/4 D. x 22 1/2 L.	" "	2 1/4"
7	4	CAPSQUARE KEYBOLT 1 1/4 D. x 28 1/2 L.	" "	2 1/4"
8	4	CAPSQUARE KEY	" "	" "
9	8	TRAINING EYEBOLT	" "	DIE # 1140
10	2	AXLE TREE EYEBOLT - 8 1/2 L.	" "	" "
11	2	" " 14 3/4 L.	" "	" "
12	4	BREECHING EYEBOLT	" "	" 1142
13	4	BREECHING RING	" "	" "
14	4	BUMPER BOLTS 1 D. x 14 L.	" "	BUTTON HEAD
15	4	BED BLOCK BOLTS 3/4 D. x 10 L.	" "	SQ. HD. AND NUT
16	4	STAYS	" "	" "
17	8	LINCHPINS	" "	" "
18	4	CAPSQUARES	" "	" "
200	12	HEX NUTS - 1/8"	MED. STL.	" "
201	12	WASHERS - FOR 1 1/8 D. BOLTS	" "	STANDARD
202	8	HEX NUTS - 1/4"	" "	" "
203	8	WASHERS - FOR 1/4 D. BOLTS	" "	STANDARD
204	4	SQUARE NUTS - 1/4"	" "	" "
205	12	1" CLINCH RINGS	IRON	GALV.
206	4	1/8" " "	" "	" "
207	8	FERRULES - AXLE TREE	STEEL	CUT FROM 5" STD. GALV. PIPE
208	175	3/8 D. ROUND HEAD RIVETS - 5 1/2 LONG	COPPER	" "
209	175	3/8 CLINCH RINGS	COMPO.	" "
210	4	FORE TRUCKS - 17 DIA.	W. OAK	" "
211	4	HIND TRUCKS - 15 DIA.	" "	" "
212	2	FORE AXLE TREES	" "	" "
213	2	HIND AXLE TREES	" "	" "
214	4	SIDES	" "	5-8 1/2 x 19 x 5"
215	2	TRANSOM	" "	20 x 11 x 5 1/2"
216	2	BED BLOCK	" "	20 x 5 3/4 x 3"
217	2	BED	" "	2-8 1/4 x 11 x 3 1/4"
218	2	BUMPER	" "	28 x 9 x 3 1/4"
219	2	COIN	" "	" "
220	2	COIN BATTEN	" "	" "
221	2	COIN HANDLE	" "	" "



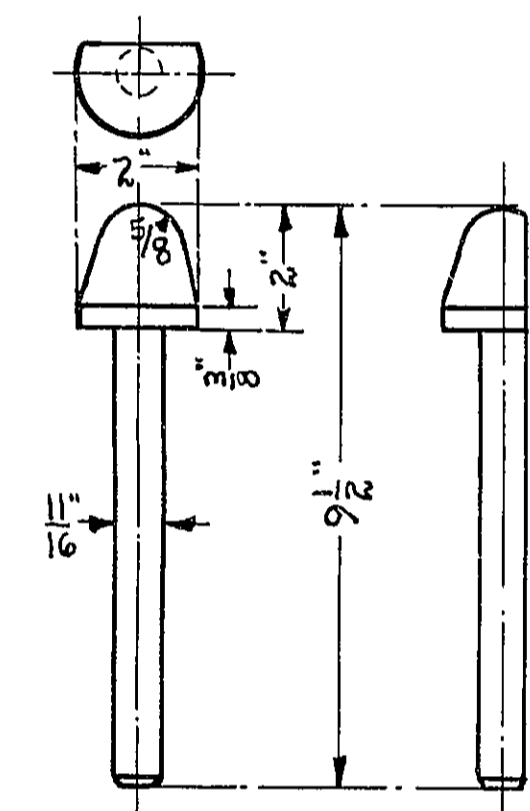
FORE TRUCKS  
SCALE 1/2" = 1 FT. (210)



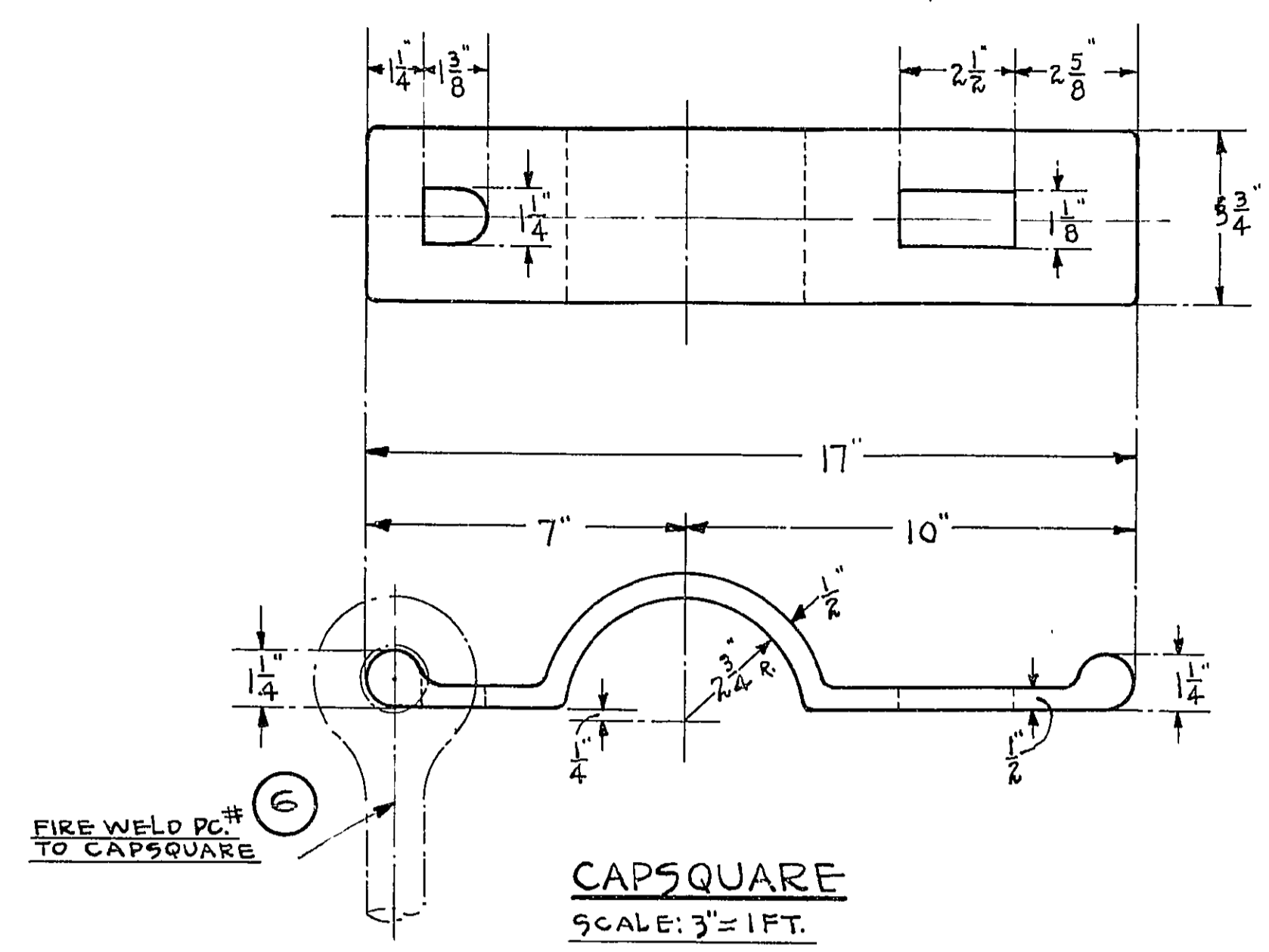
DETAIL OF FORE AND HIND AXLE TREE ARMS  
SCALE: 3" = 1 FT.



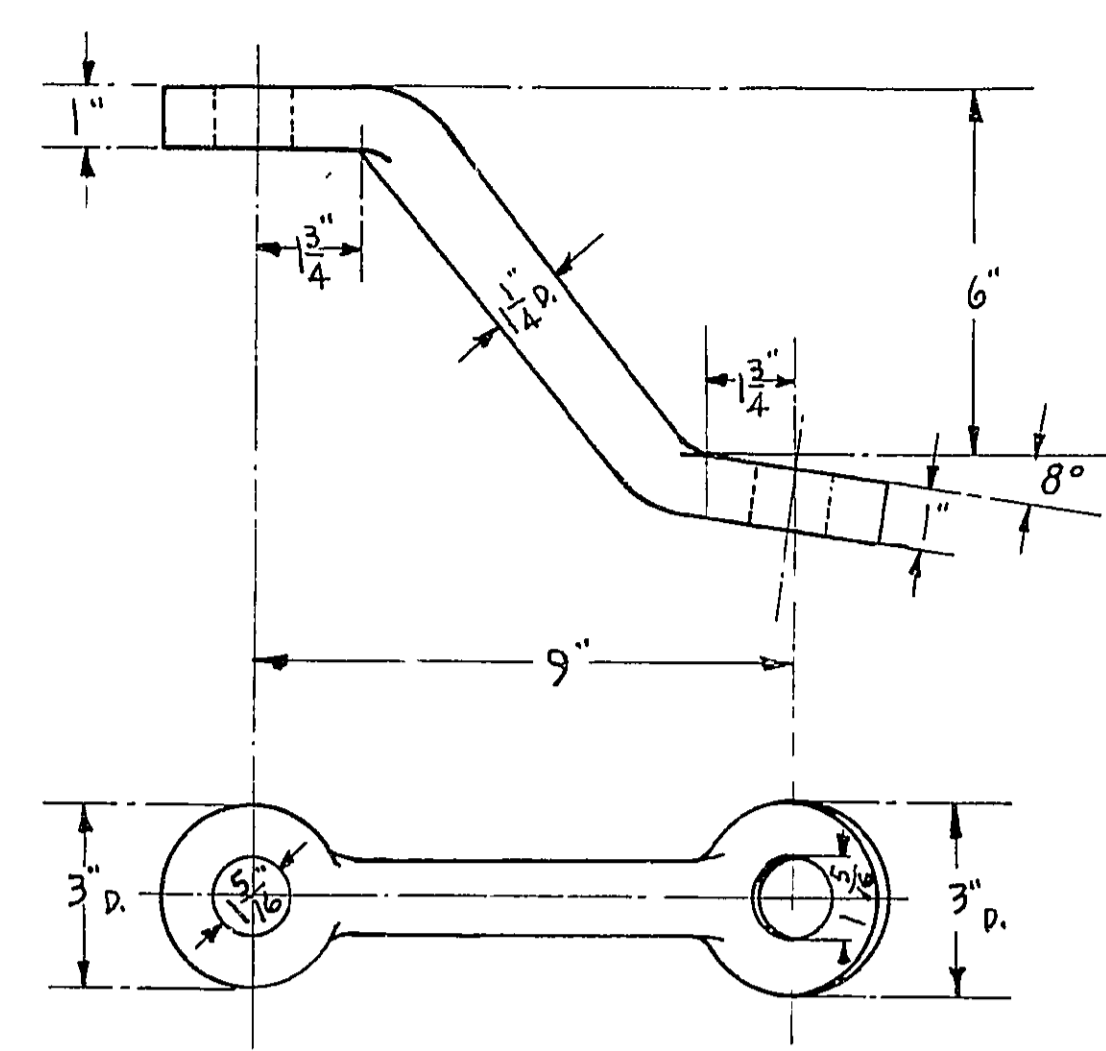
HIND TRUCKS (211)  
SCALE 1/2" = 1 FT.  
CONSTRUCTION SIMILAR TO FORE TRUCKS



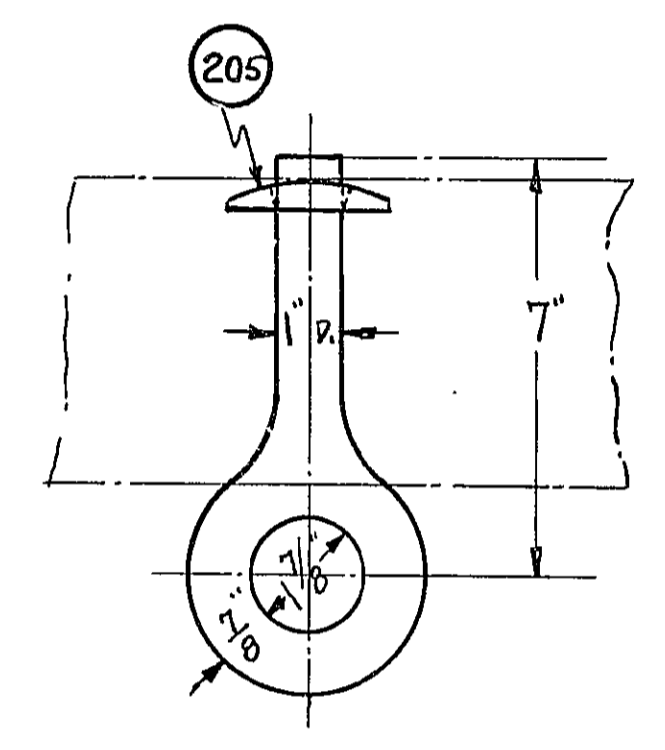
LINCHPIN  
SCALE: 3" = 1 FT. (17)



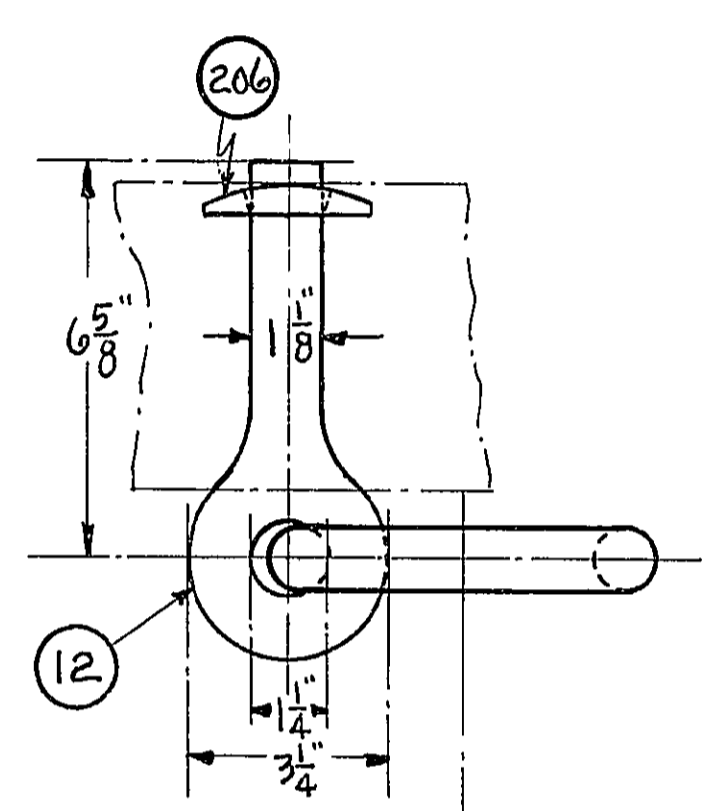
CAPSQUARE  
SCALE: 3" = 1 FT. (18)



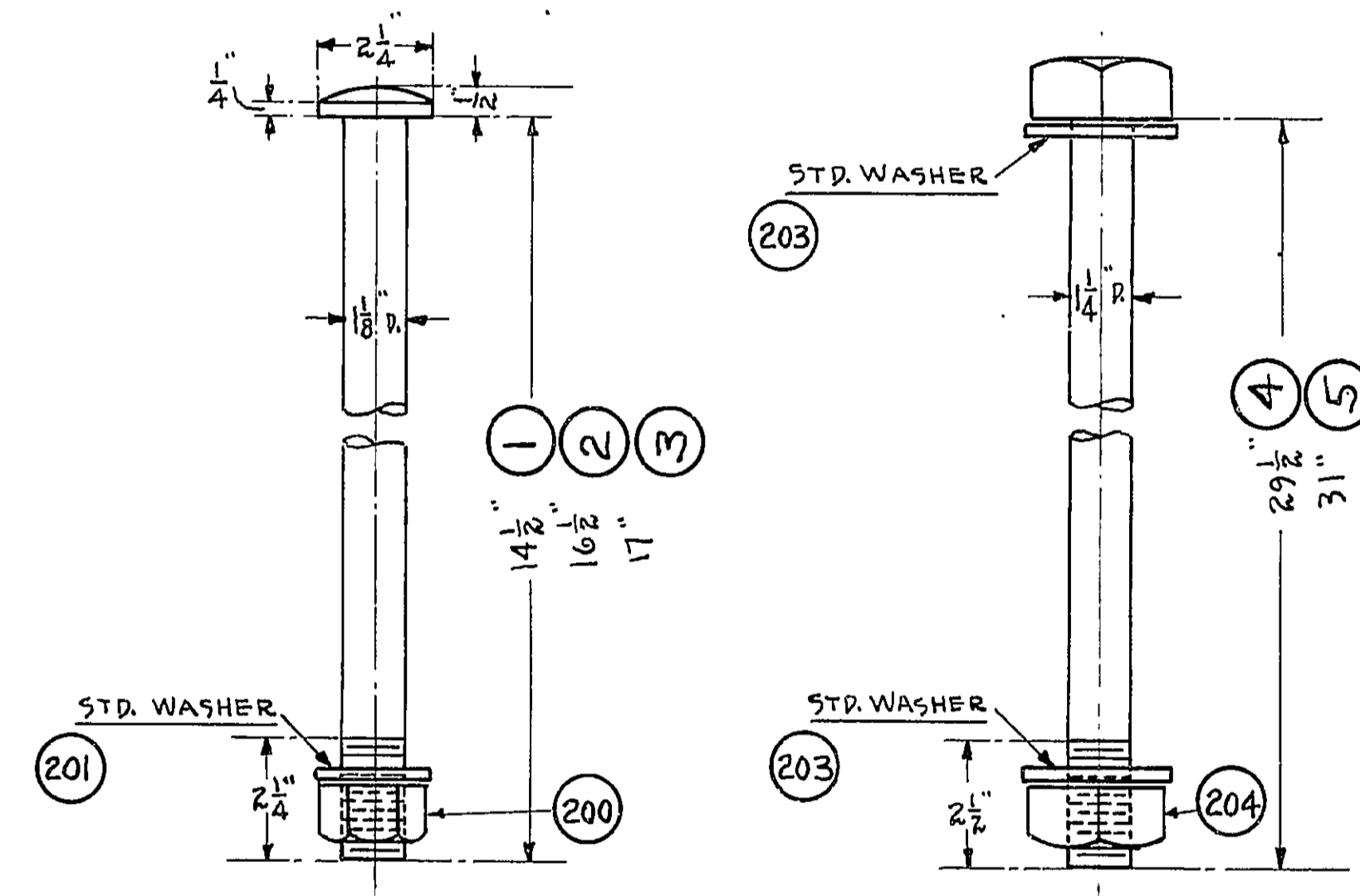
STAYS  
SCALE: 3" = 1 FT. (16)



TRAINING BOLT  
SCALE: 3" = 1 FT. (9)

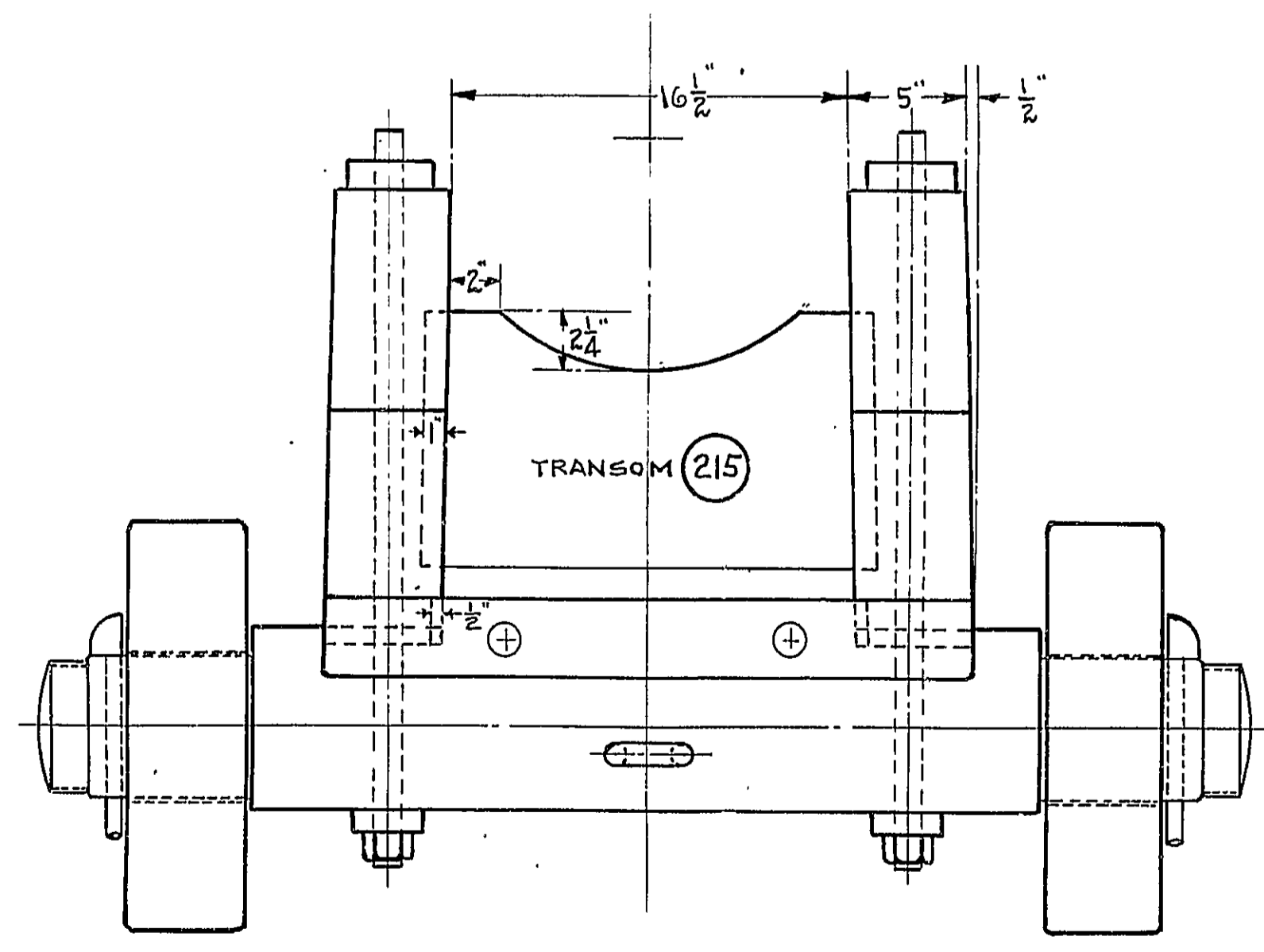
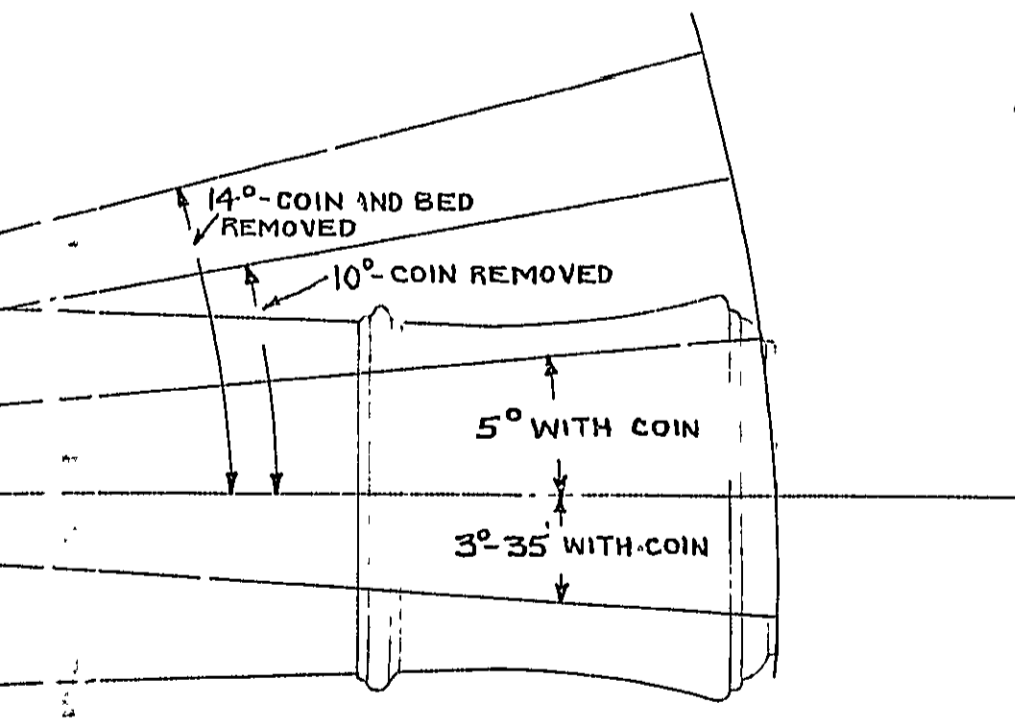


BREECHING RING BOLT  
SCALE: 3" = 1 FT. (13)

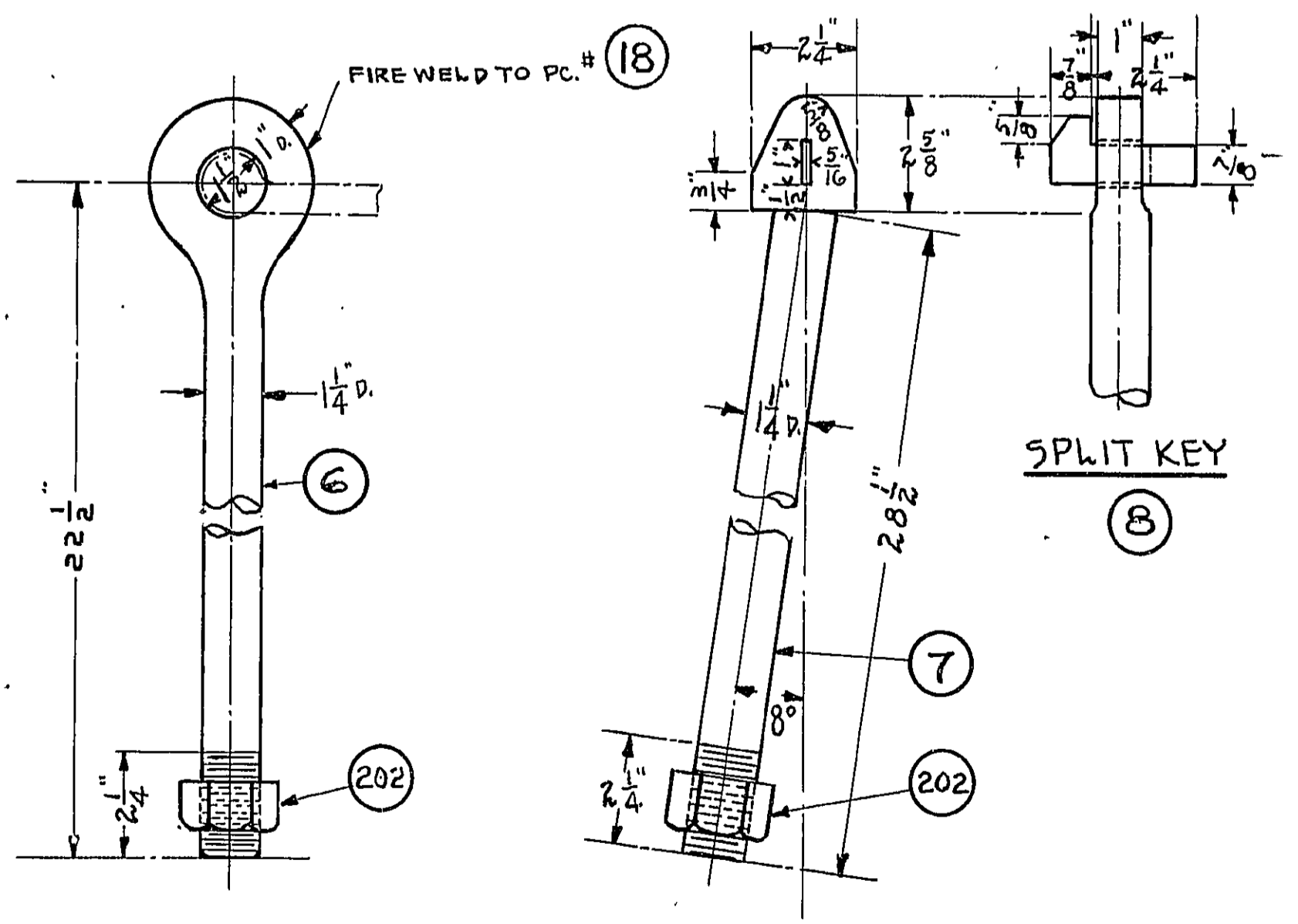


JOINT BOLTS  
SCALE: 1" = 1 FT.

TIE BOLTS  
SCALE: 3" = 1 FT.

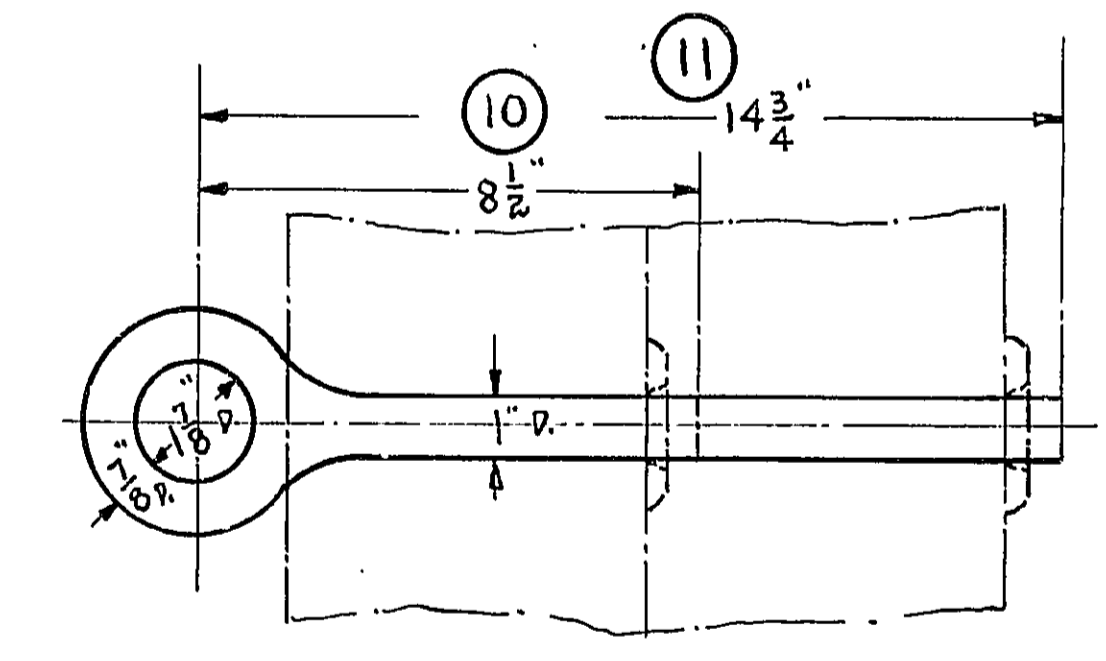


LOOKING AT FORE AXLE TREE

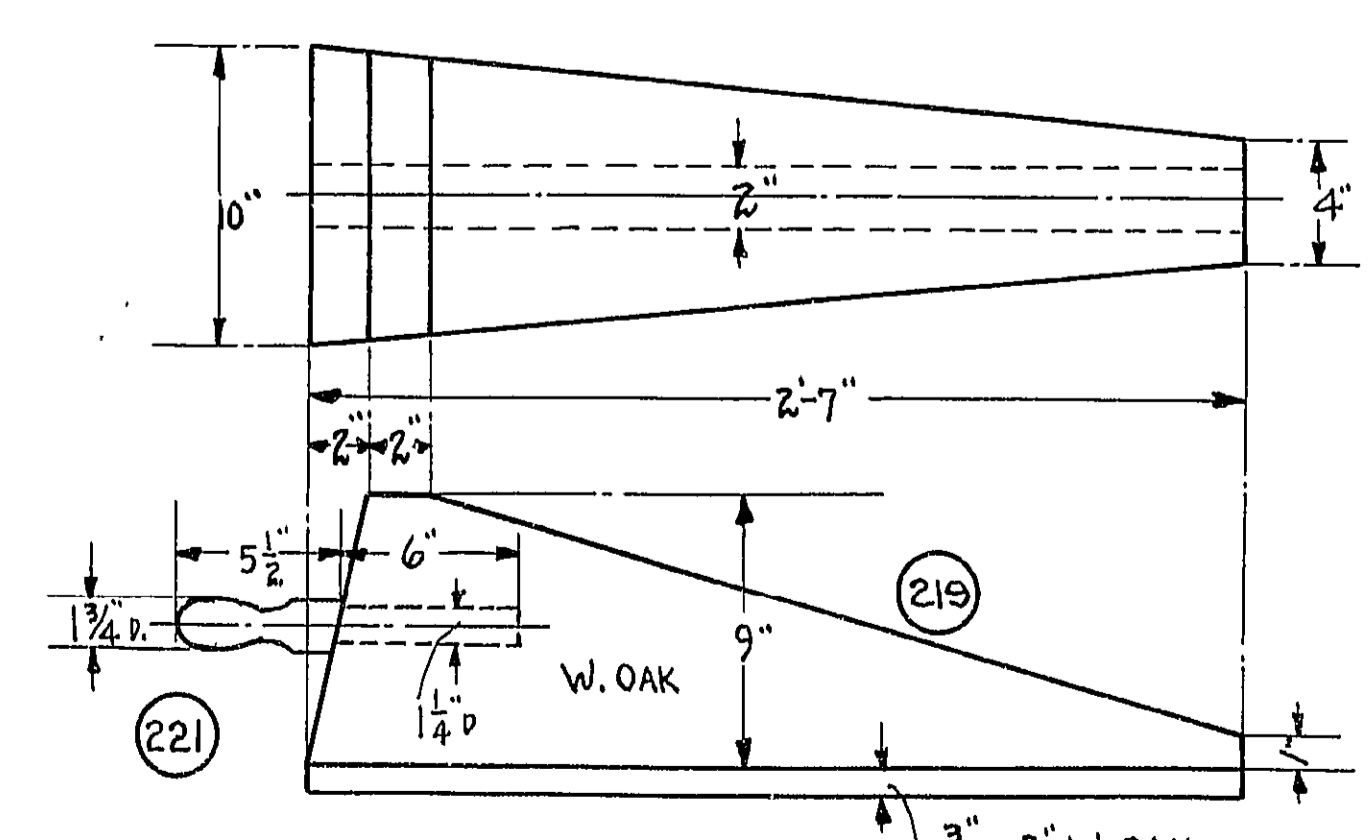


CAPSQUARE BOLTS  
SCALE: 3" = 1 FT.

SPLIT KEY (8)



FORE AND HIND AXLE TREE BOLTS  
SCALE: 3" = 1 FT.



COIN  
SCALE: 3" = 1 FT. (221)

- NOTES
- WOOD JOINTS TO BE MADE UP WITH WHITE LEAD.
  - IRON WORK TO BE GIVEN ONE COAT OF RED LEAD BEFORE INSTALLATION.
  - COMPLETED CARRIAGES TO BE GIVEN ONE COAT OF PRIMING AND TWO COATS OF BLACK.

REFERENCE PLANS  
24 FOR GUN - BOW CHASER (18 FOR BORED FOR 24 FOR) BOSTON NO 22361

CORRECTED FOR FINISHED PLAN  
RESTORATION 1927-1931  
U.S. FRIGATE CONSTITUTION  
GUN CARRIAGES  
FOR 24 FOR BOW CHASERS - SPAR DECK

NAVY YARD BOSTON JANUARY 5, 1931  
SCALES INDICATED

APPROVED FOR MANAGER  
*John A. Long*  
LIEUT. (C.C.) U. S. N.  
SUPT. OF RESTORATION