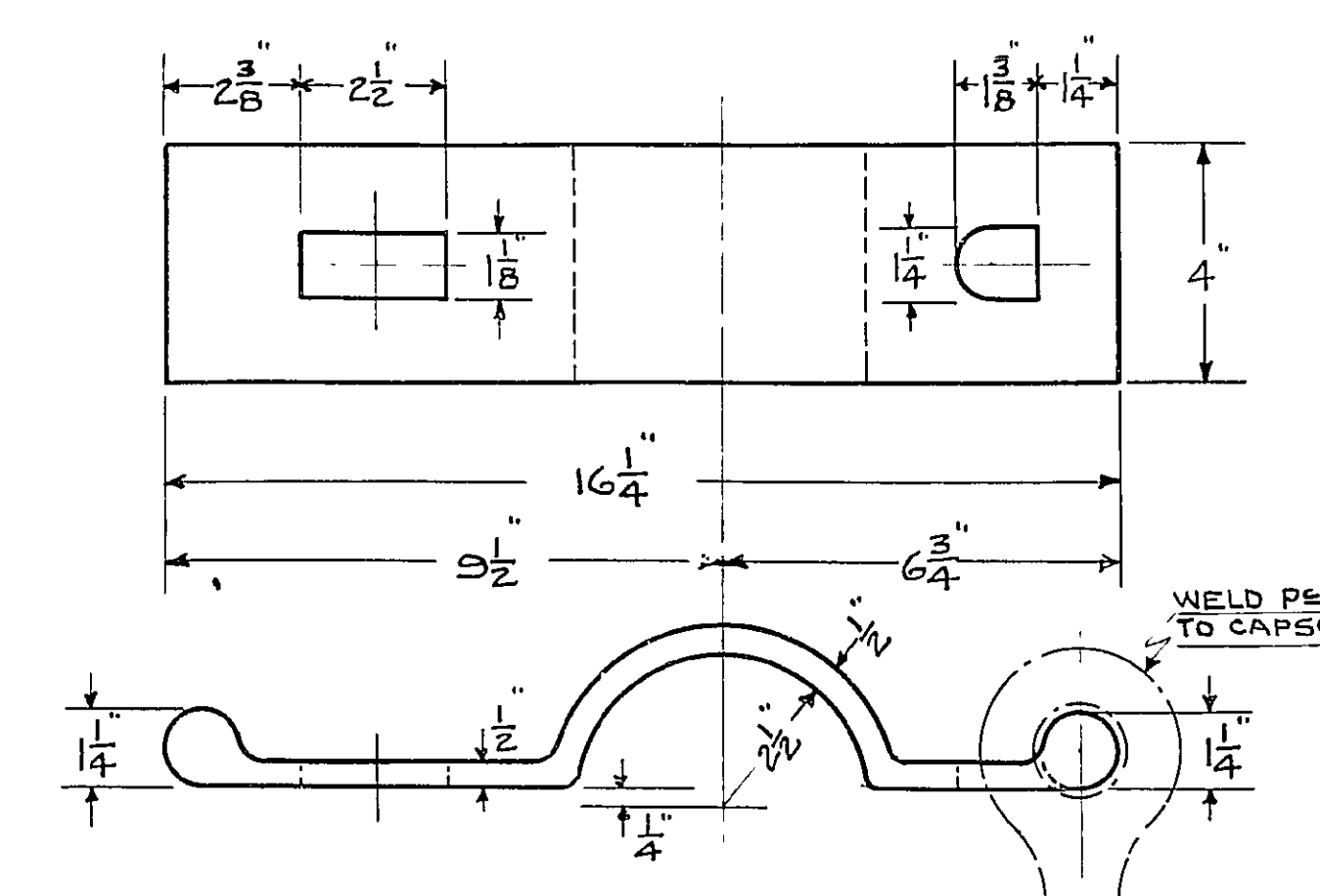


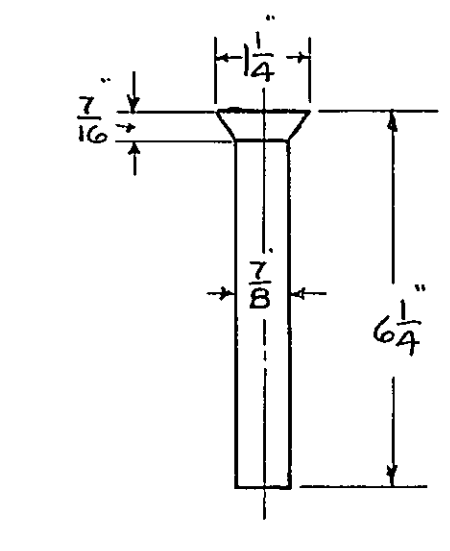
FIGHTING BOLT PAD ON CARRIAGE  
SCALE 3" = 1 FT.

1



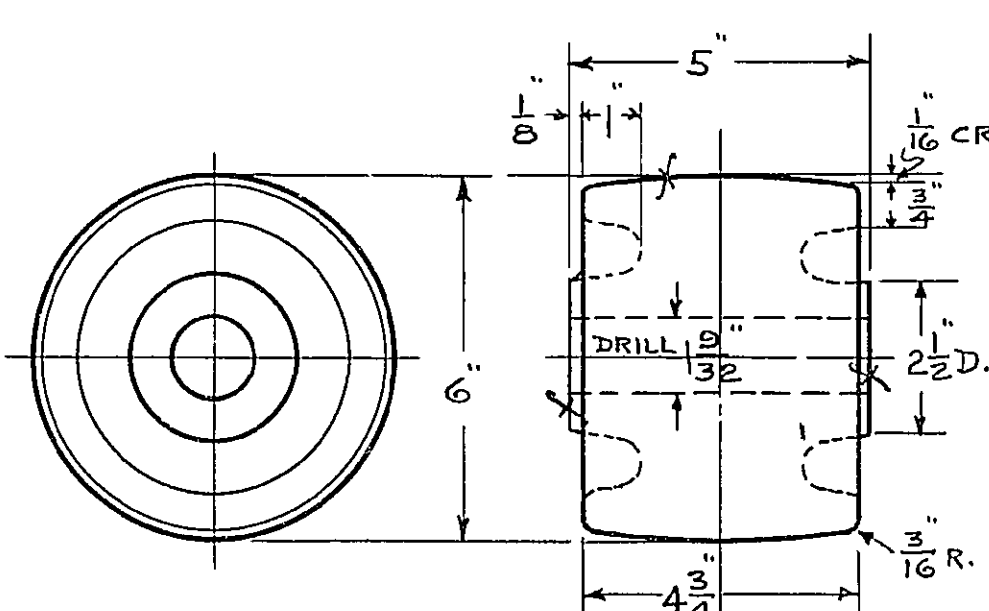
CAPSQUARE  
SCALE 3" = 1 FT.

6



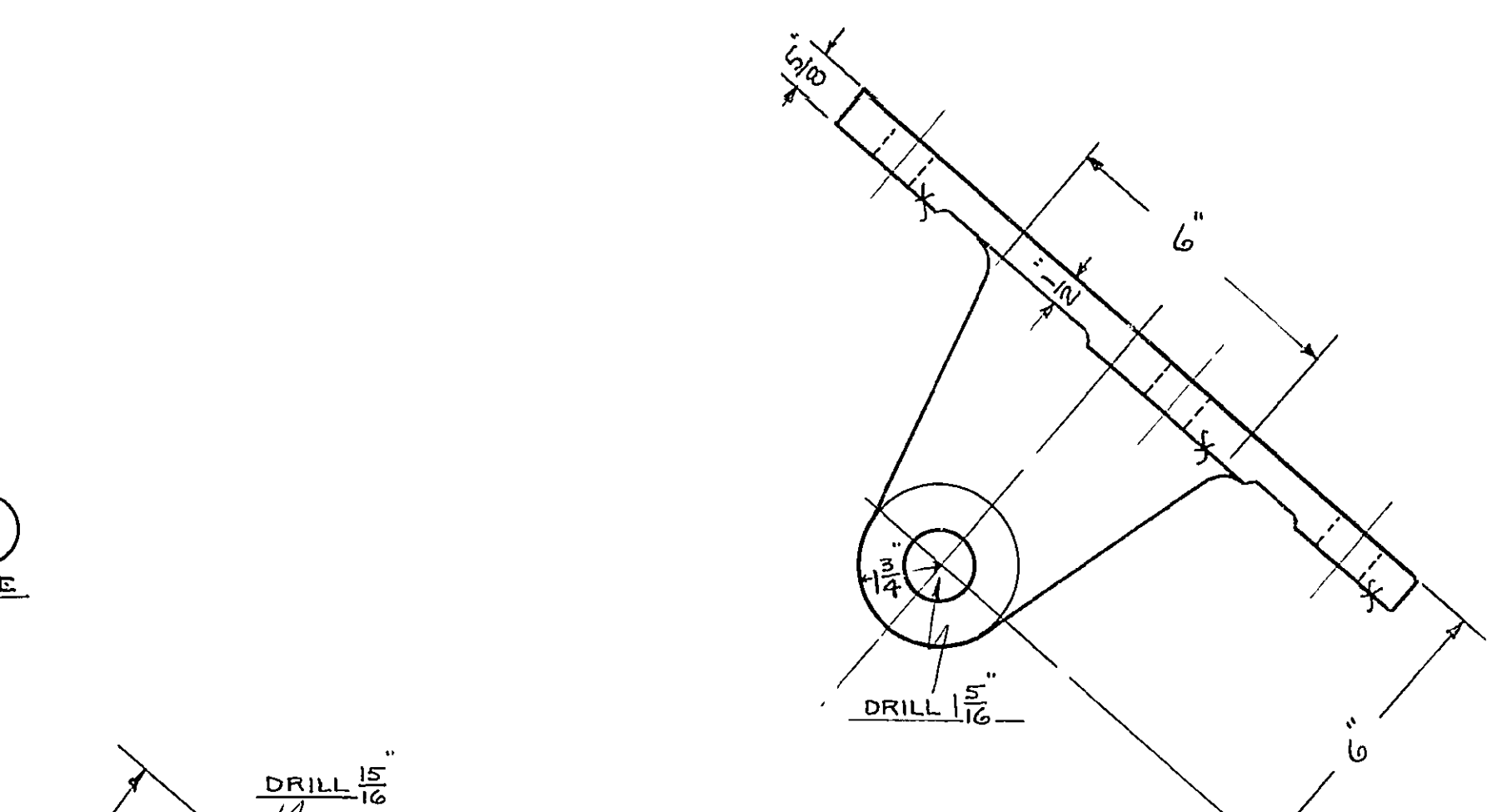
RIVETS

25



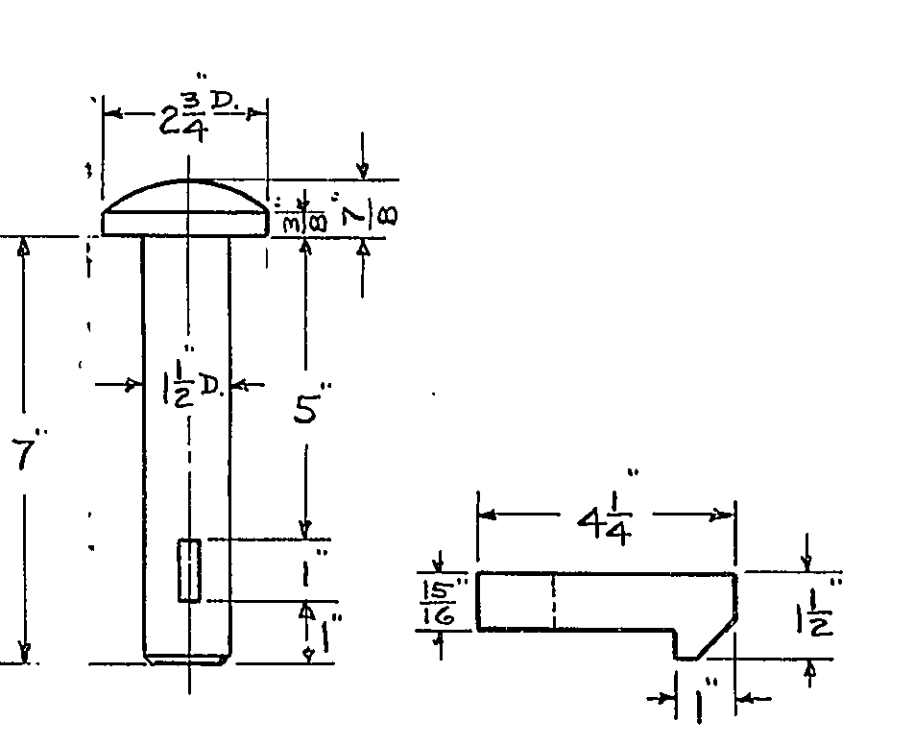
FORE TRUCKS  
SCALE 3" = 1 FT.

102



FORE TRUCK BEARING AND BOLTS  
SCALE 3" = 1 FT.

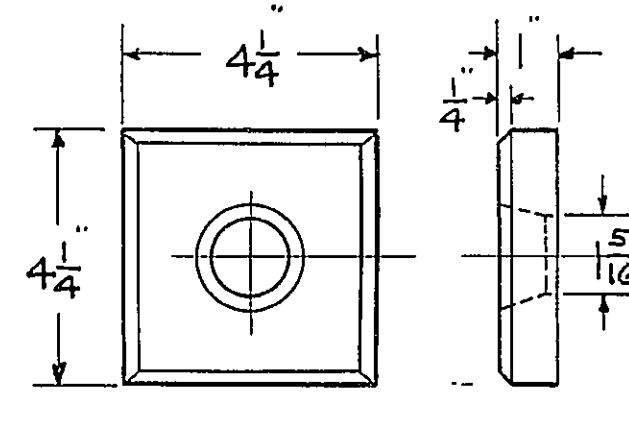
100 101



FIGHTING BOLT AND KEY  
SCALE 3" = 1 FT.

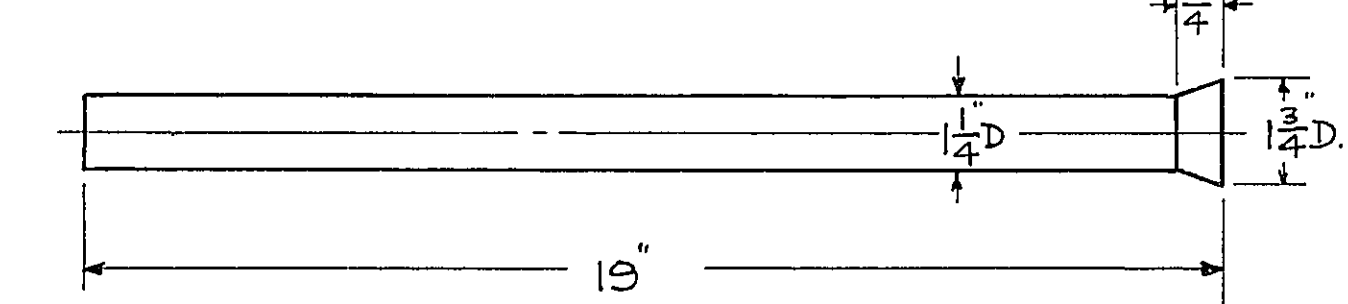
3

4



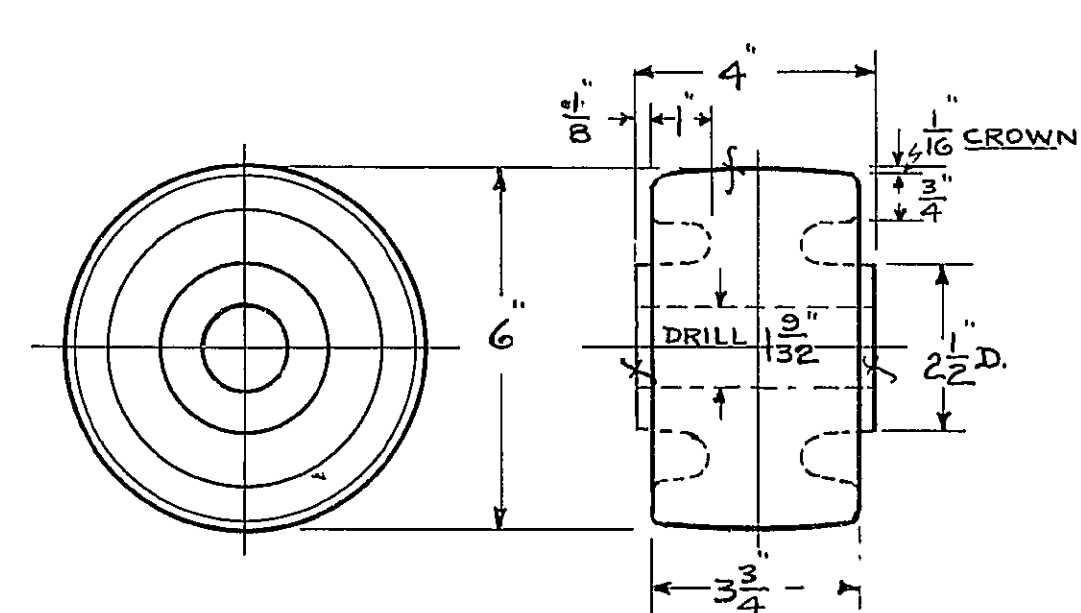
WASHER

5



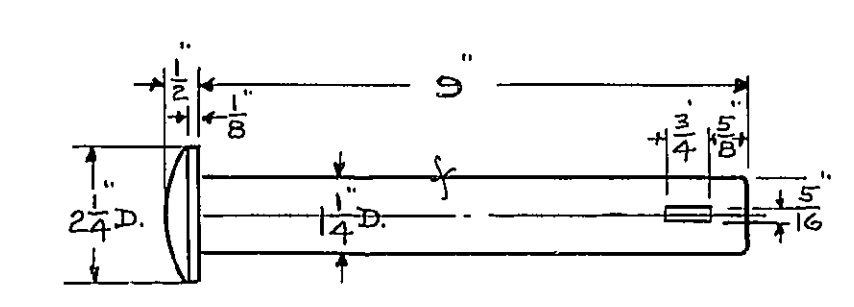
RIVET THRU SIDE OF SHIP

26



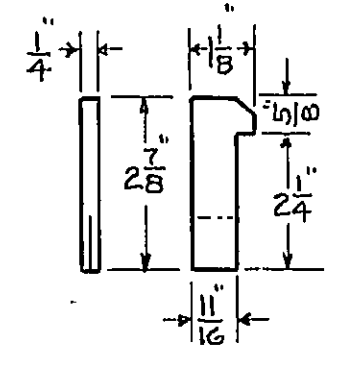
HIND TRUCKS  
SCALE 3" = 1 FT.

103



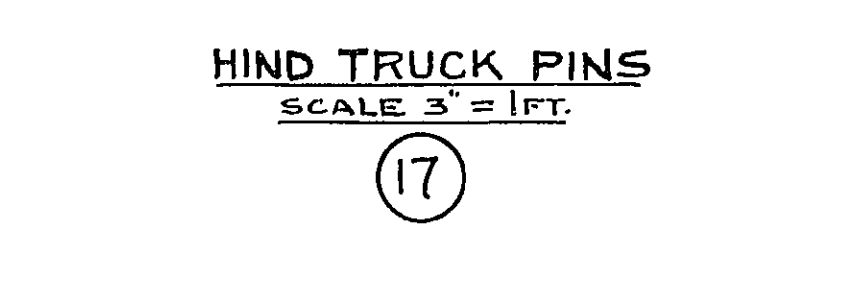
FORE TRUCK PINS  
SCALE 3" = 1 FT.

16



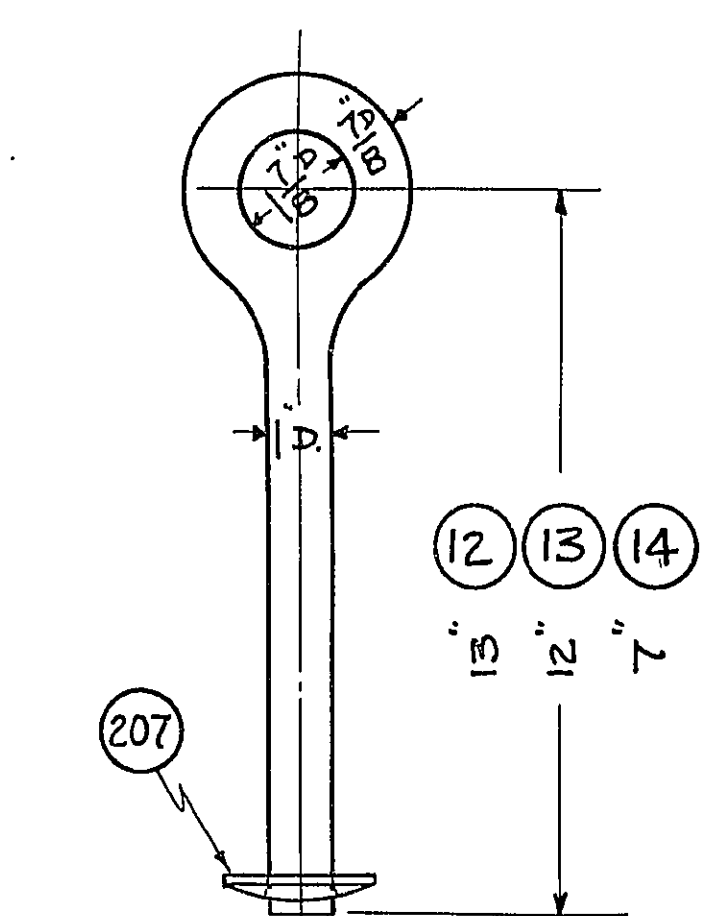
KEY

18



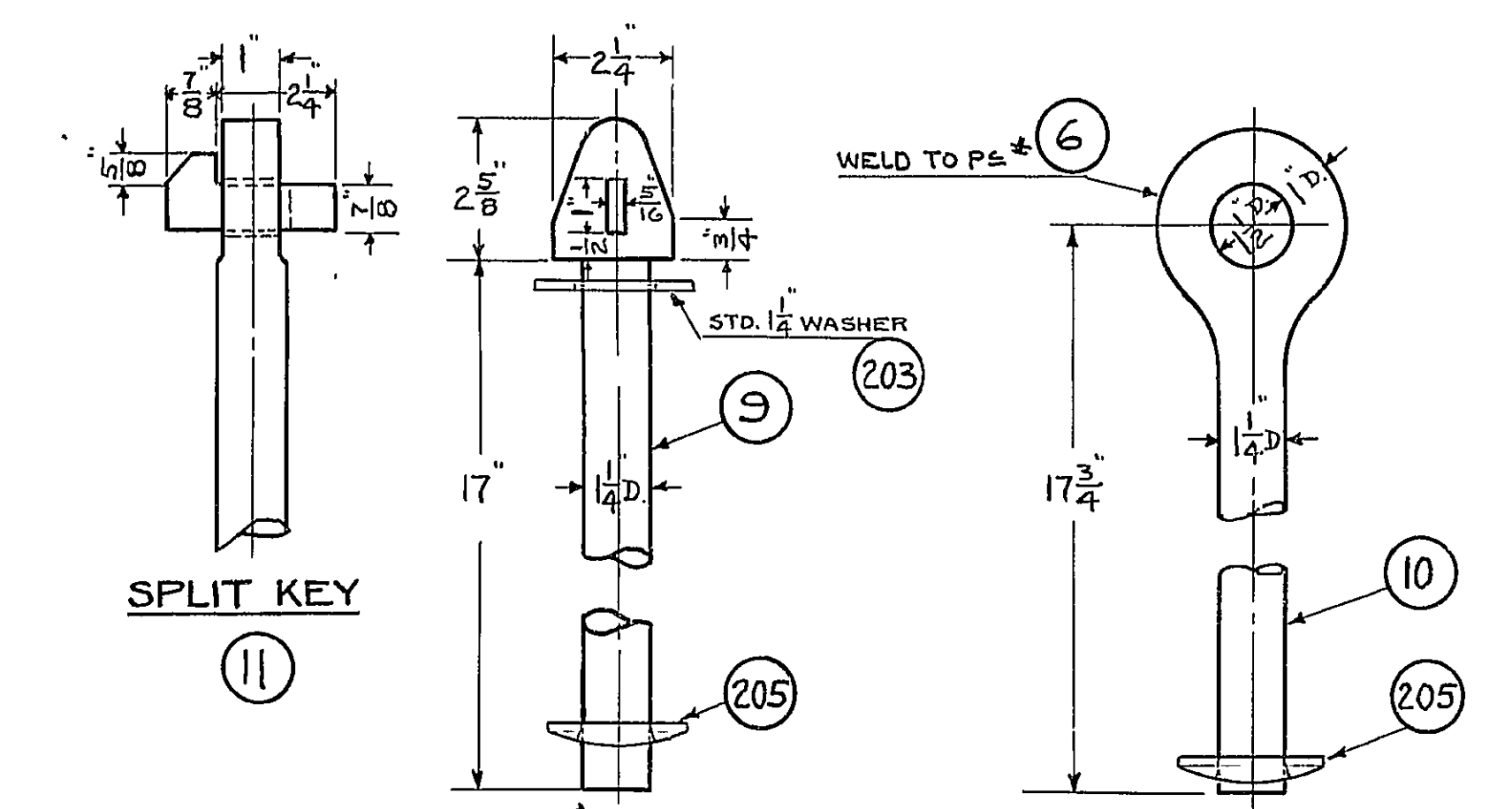
HIND TRUCK PINS  
SCALE 3" = 1 FT.

17



TRAINING-OUTHAUL AND INHAUL BOLTS  
SCALE 3" = 1 FT.

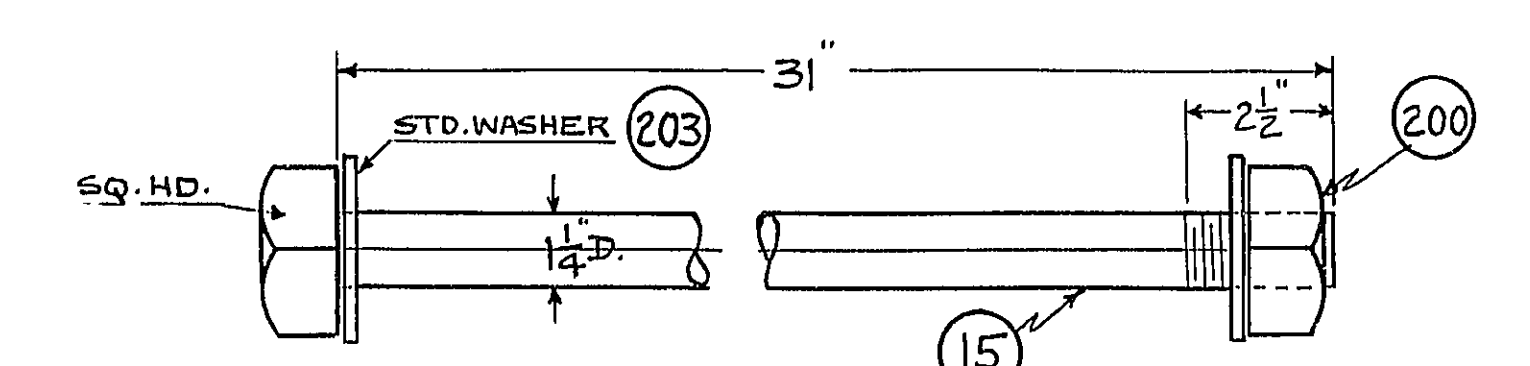
12 13 14



CAPSQUARE BOLTS  
SCALE 3" = 1 FT.

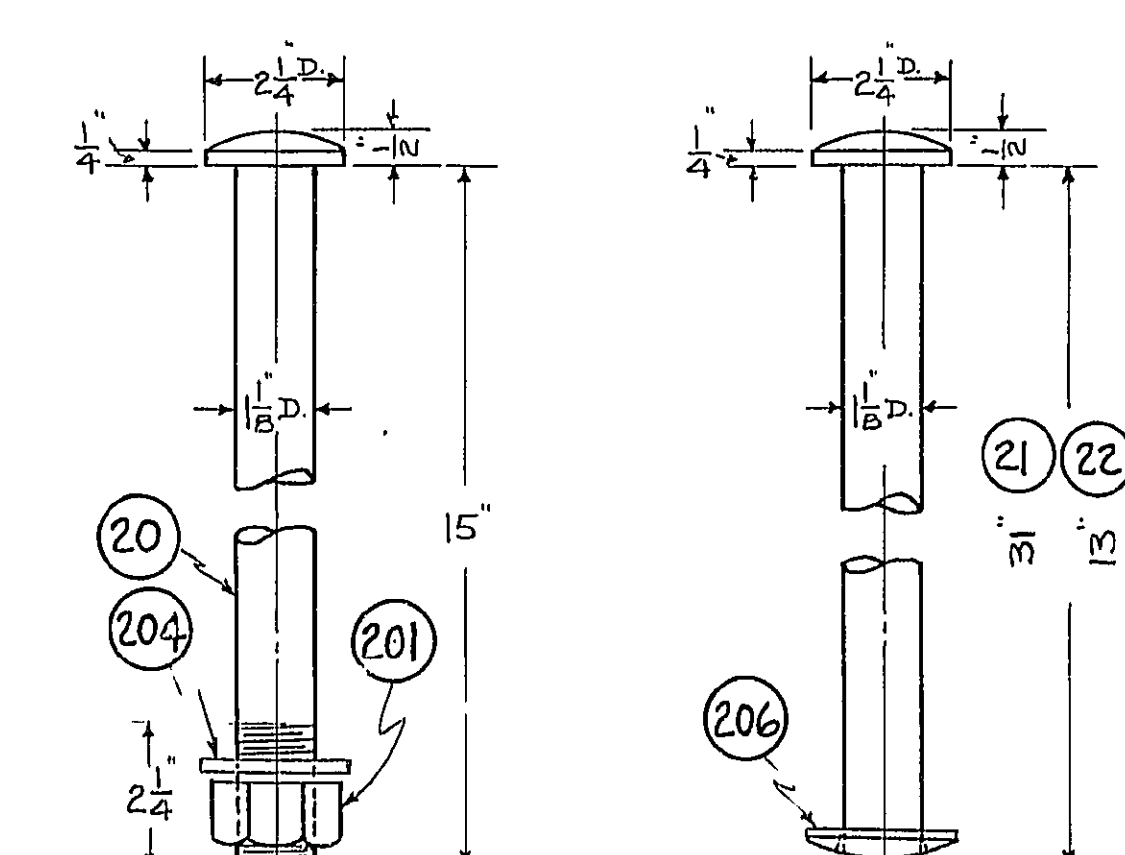
SPLIT KEY

11



TIE BOLT  
SCALE 3" = 1 FT.

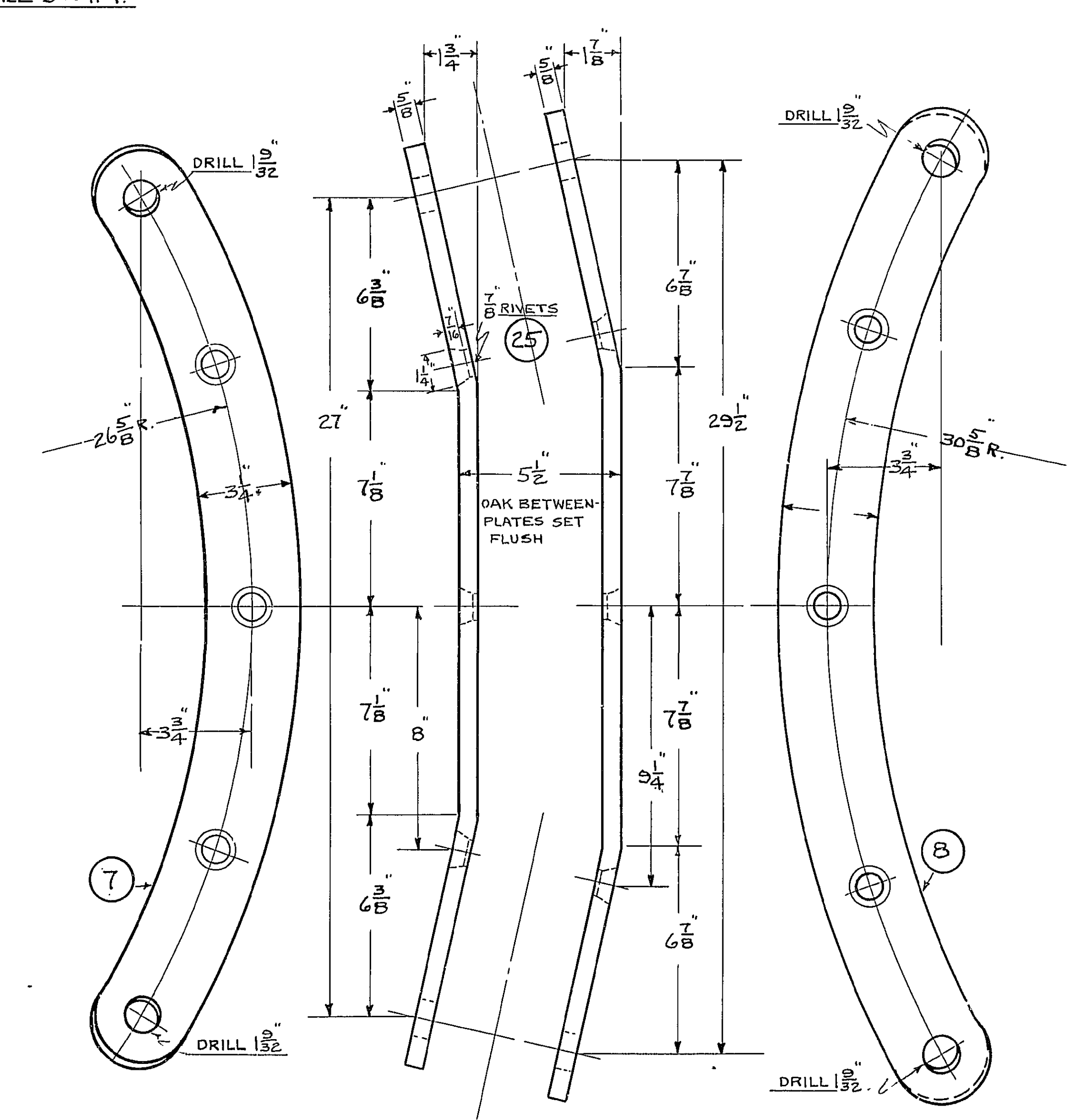
15



CARRIAGE AND SLIDE BOLTS  
SCALE 3" = 1 FT.

20 204

21 22 23 24



HIND TRUCK BEARINGS  
SCALE 3" = 1 FT.

7

8

| SCHEDULE OF MATERIAL FOR 20 GUN CARRIAGES |      |  |              |                                  |
|---|------|--|--------------|----------------------------------|
| NO.                                       | AMT. | DESCRIPTION                              | MATERIAL     | REMARKS                          |
| 1   | 20   | FIGHTING BOLT PAD ON CARRIAGE            | STL. ALLOY B |                                  |
| 2   | 20   | " " " SHIP                               | "            |                                  |
| 3   | 20   | " " " PIN                                | "            |                                  |
| 4   | 20   | " " " KEY                                | "            |                                  |
| 5   | 40   | SQ. WASHER                               | "            |                                  |
| 6   | 40   | CAPSQUARE                                | "            |                                  |
| 7   | 20   | HIND TRUCK BEARING PLATE                 | "            |                                  |
| 8   | 20   | " " " "                                  | "            |                                  |
| 9   | 40   | CAPSQUARE BOLT - 1 1/2" D. x 17" LONG    | "            |                                  |
| 10  | 40   | " " " "                                  | "            |                                  |
| 11  | 40   | " " " KEY                                | "            |                                  |
| 12  | 20   | EYE BOLT - 1" D. x 15" LONG              | "            | DIE # 1140                       |
| 13  | 40   | " " " "                                  | "            |                                  |
| 14  | 40   | " " " "                                  | "            |                                  |
| 15  | 20   | TIE BOLT - 1 1/2" D. x 31" LONG          | "            | SQ. HEAD - THREADED              |
| 16  | 40   | FORE TRUCK PINS 1 1/2" D. x 5"           | "            |                                  |
| 17  | 40   | HIND " " " " 1 1/2" D. x 7 1/4"          | "            |                                  |
| 18  | 80   | TRUCK PIN KEYS                           | "            |                                  |
| 19  | 160  | FORE TRUCK BEARING BOLTS - 7/8" D.       | "            | THREADED                         |
| 20  | 160  | CARRIAGE AND SLIDE BOLTS 1 1/2" D.       | "            |                                  |
| 21  | 40   | " " " " 1 1/2" x 3 1/4" L.               | "            |                                  |
| 22  | 40   | " " " " 1 1/2" x 10" L.                  | "            |                                  |
| 23  | 40   | " " " " 1 1/2" x 10" L.                  | "            |                                  |
| 24  | 160  | " " " " 1 1/2" x 6 1/2" L.               | "            |                                  |
| 25  | 380  | RIVETS - CSK. HD. 5/8" D. x 6 1/4" LONG  | "            |                                  |
| 26  | 40   | " " " " 1 1/2" D. x 19"                  | "            |                                  |
| 100                                       | 20   | FORE TRUCK BEARING - RIGHT HAND          | CAST STL.    |                                  |
| 101                                       | 20   | " " " " LEFT                             | "            |                                  |
| 102                                       | 40   | FORE TRUCKS                              | COMPO X G    |                                  |
| 103                                       | 40   | HIND " " " "                             | "            |                                  |
| 200                                       | 20   | 1/4" SQ. NUTS                            | STEEL        |                                  |
| 201                                       | 160  | 1/8" HEX. "                              | "            |                                  |
| 202                                       | 160  | 7/8" " "                                 | "            |                                  |
| 203                                       | 80   | 1/4" STD. WASHER                         | "            |                                  |
| 204                                       | 160  | 1/8" " "                                 | "            |                                  |
| 205                                       | 80   | 1/4" CLINCH RINGS                        | "            | GA. 1                            |
| 206                                       | 280  | 1/8" " "                                 | "            |                                  |
| 207                                       | 100  | " " " "                                  | "            |                                  |
| 208                                       | 40   | CARRIAGE SIDES - 10 x 5 1/2 x 6-1"       | W. OAK       |                                  |
| 209                                       | 40   | " " " " INBD ENDS 10 x 5 1/2 x 3'0"      | "            | OUTBOARD END - 11 x 5 1/2 x 3'0" |
| 210                                       | 40   | SLIDE SIDES 12 1/4 x 5 x 3-4 3/4"        | "            |                                  |
| 211                                       | 60   | " " " " BED 10 x 5 1/2 x 3-4 3/4"        | "            |                                  |
| 212                                       | 40   | " " " " FILLING PIECES 10 x 5 1/2 x 1'0" | "            |                                  |
| 213                                       | 40   | " " " " CLAMPS 10 x 3 x 2'0"             | "            |                                  |
| 214                                       | 20   | HIND TRUCK BEARING 8 x 8 x 3'0"          | "            |                                  |
| 215                                       | 20   | " " " " COIN                             | "            |                                  |
| 216                                       | 20   | " " " " HANDLES                          | "            |                                  |
| 217                                       | 20   | " " " " GUIDE                            | "            |                                  |

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

REFERENCE PLANS  
 32 PDR CARRONADE GUN - BOSTON NO 21250

CORRECTED FOR FINISHED PLAN  
 RESTORATION 1927-1931  
**U.S. FRIGATE CONSTITUTION**  
**GUN CARRIAGES**  
 FOR 32 PDR CARRONADES - SPAR DECK  
 NAVY YARD BOSTON MARCH 12, 1931  
 SCALES INDICATED

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