



transom frame with three #12 x 2 1/2-in. fh screws. Fit angle blocks between motor board and transom (Fig. 5), and secure to transom with two 5/16 x 5 1/2-in. carriage bolts.

Rip saw four 9 ft. lengths of 3/4 x 3/4-in. spruce stock for carlins and deck stringers. Measure and notch the carlins into the transom, #1 and 2 frames and bevel the forward end to fit against the clamp as in Fig. 5. Fasten with one #8 x 1 1/2 in. fh screw to each joint. Cut two uprights (Fig. 5) for the previously cut #3 frame cockpit beams and assemble to #3 frame with 10-32 x 2-in. rh machine screws. Notch the beam for the carlin and fasten carlin with one #8 x 1 1/2 fh screw. Measure and notch the transom, #1, 2 and 3 frames for the 3/4 x 3/4-in. deck stringers so that the stringers will be midway between clamps and

**MATERIALS LIST—SPITFIRE**

No.	Description	Use
<b>PLYWOOD (EXTERIOR GRADE AA)</b>		
1	1/4" x 4' x 5' fir	aft bottom planking
1	1/4" x 4' x 6' fir	fore bottom planking
1	1/4" x 4' x 8' fir	side planking—floor
1	3/8" x 12" x 8' fir	coamings—motor board
1	3/8" x 10" x 4' fir	transom
2	1/8" x 24" x 5' mahogany or birch	side decks
1	3/4" x 8" x 30' fir	steering wheel brackets
(3/4" spruce lumber may be substituted for 3/4" plywood)		
<b>LUMBER (SPRUCE EXCEPT WHERE SPECIFIED)</b>		
2	3/4" x 3" x 12'	frames
1	3/4" x 5 1/2" x 6'	#1 frame bottom
1	3/4" x 2 1/4" x 36"	aft keel tie bar
1	3/4" x 12" x 12'	deck beams, steering brackets, etc.
1	3/4" x 2 3/8" x 10'	makes 2 chines
1	3/4" x 1 7/8" x 10' 4"	makes 2 clamps
2	3/4" x 1 1/2" x 7'	bilge battens
1	1/2" x 1 1/2" x 6'	deck batten
2	5/8" x 3/4" x 6'	deck stringers
4	3/4" x 3/4" x 10'	carlins, deck stringers
2	3/4" x 2 1/4" x 7'	floor member, aft keel
1	3/4" x 2" x 6'	fore keel
2	1/2" x 3/4" x 10' 4"	sheer molding
1	2" x 4" (1 5/8" x 3 5/8") x 16" fir	motor board angle blocks
1	2" x 10" (1 5/8" x 9 1/2") x 12" fir	stem
1	2" x 6" (1 5/8" x 5 5/8") x 10' fir	building form
1	2" x 4" (1 5/8" x 3 5/8") x 10' fir	keel fillers—step piece angle blocks
<b>FASTENINGS</b>		
4 gross	#6 x 1" fh screws	
1 gross	#8 x 1 1/2" fh screws	
1 gross	#6 x 3/4" fh screws	
2	#7 x 2" fh screws	
3	#7 x 3" fh screws	
3	#12 x 2 1/2" fh screws	
12	#3 x 5/8" fh screws	
6	10-32 x 2" rh machine screws	
2	5/16" x 5 1/2" carriage bolts	
1 box	5/16" copper tacks	
<b>PAINT</b>		
1 qt.	Kuhl's Brushlast	
1 pt.	Condon's Boatlife (white)	
1 pt.	Condon's Boatlife (red or green)	
1 pt.	Condon's Boatlife (clear)	
1 qt.	Firzite (white)	
2 qts.	airplane wing dope	
2 lbs.	waterproof glue	
<b>MISCELLANEOUS</b>		
1	15 in. dia. dash-mounting, racer steering wheel	
1	Keller or Finson racing throttle	
1	aluminum racing fin	
1	0 to 50 MPH water speedometer	
2	sponge-rubber knee pads for cockpit floor	
1	life preserver (bright orange color)	
4	steering rope pulleys (2 with eye snaps, 2 with flange eyes)	
2	rope tighteners	
5 ft.	Bowden wire and casing (for throttle control)	
2	rope clamps	
24 ft.	3/16" nylon covered steel tiller cable	
3	aluminum lifting handles	