

# Gypsy Bill of Materials

The following list of materials is intended to be a general guide only. Before ordering any materials, the text and plans should be checked for possible options. All lumber listed as 1" stock is to be standard "lumberyard four-quarter" material which when finished may vary to somewhat less or slightly more than 3/4" in thickness. All widths are NET and all lengths allow for cutting to fit. Grouping lumber and purchasing random-random material to resaw to the required size will result in considerable savings. All lumber used should be first grade free from shakes and knots. Although spruce (Sitka variety) and mahogany (dark red Philippine type) are called out in the listing, lumber typical to the locale and of similar types and weights may be substituted. All plywood (PW) is to be marine (MAR) or exterior (EXT) grade. The marine-type is preferable as the inner cores are solid and thus the panel has more structural integrity. Douglas-fir (DF) is satisfactory with the quality of the exposed faces of the veneer being designated by the letters "A" or "B". The "AA" grade panels are always preferable, however, "AB" grade is acceptable. All plywood should be a minimum of three plies. All fastenings should be bronze or hot dipped galvanized ferrous metal. Brass fastenings are not advised nor are the electroplated screws commonly sold in hardware stores. All screws are to be of the flat head type intended for wood. All nails are of the ring-type nail common to boat construction. Unless otherwise specified, all wood-to-wood joints are to be glued with a waterproof or highly water resistant glue such as plastic resin, resorcinol, epoxy, or other equivalent type used per the manufacturer's instructions regarding temperature, clamping requirements, curing time, and mixing method.

CHECK ALL SIZES TO THE WORK PRIOR TO CUTTING. Abbreviations used are: Mahog = mahogany; SP=Sitka spruce; DF = Douglas-fir; PW=plywood; Ext=exterior; MAR=marine.

ITEM	MATERIAL	NO. PCS.	SIZE
<b>LUMBER:</b>			
Frames	Mahog, Oak or SP	45 Random bd. ft.	1" material
Keel and bulwark uprights	DF	1	*2" x 4" x 20'
Chine logs	Mahog, Oak or SP	2	1-1/4" x 2-1/2" x 20'
Bottom battens	DF	2	1-1/4" x 3" x 16'
	DF	2	1-1/4" x 3" x 15'
	DF	2	1-1/4" x 3" x 12'

Lower sheer clamp	Mahog, Oak or SP	4	5/8" net x 1-1/4" x 15'
Upper sheer clamp	Mahog, Oak or SP	2	1-1/4" x 1-1/2" x 20'
Cockpit seat carling	DF	2	1-1/4" x 3" x 6'
Solid harpin	DF	8 Lineal ft.	1" x 6"
Bulwark cleat	DF	26 Lineal ft.	1" x 3"
Cabin clamp	DF	2	1" x 3" x 13'
Cockpit sole beam	DF	1	1-1/4" x 3" x 6'
Cabin sole strongback	DF	1	1" x 2" x 10'
Side cap rails	Mahog Mahog	2 2	1-1/2" net x 4" x 3' 1-1/2" net x 6" x 5'
Forward cap rail	Mahog	8 Lineal ft.	1-1/2" net x 8"
Cabin side-lower piece	Mahog	2	1" x 8" x 13'
Cabin side-upper piece	Mahog	2	1" x 6" x 13'
Cabin side-uprights	Mahog	2	1" x 6" x 12'
Cabin side roof cleat	DF	2	1" x 1-1/2" x 13'
Cabin roof beams	DF	2	1-1/4" x 4" x 13'
Cabin room facing pieces	Mahog	2	1" x 7" x 8'
Bulkhead roof cleats	DF	2	1" x 2" x 8'
Rub rails	Mahog	76 Lineal ft.	1" x 1-1/2"
Skeg	Mahog, Oak or DF	1	1-1/4" x 3" x 10'
<b>PLYWOOD:</b>			
Transom, floor timbers	DF Ext AB	2	3/4" x 4' x 8'
Stem, breasthook	DF Ext AB	1	3/4" x 2' x 8'
Side planking & bulwark	DF Ext or MAR AA	4	3/8" x 4' x 10'***
Forward bulwark	DF Ext or MAR AA	1	3/8" x 2' x 8'
Bottom planking, harpin	DF Ext or MAR AA	2 2	3/8" x 4' x 8' 3/8" x 4' x 12'***
Cockpit seat top, cockpit sole	DF Ext AC	2	1/2" x 4' x 8'
Gussets	DF Ext AB	1	1/4" x 4' x 6'
Cabin sole	DF Ext AC	2	1/2" x 4' x 10'***
Cabin roof	DF Ext AB	3	3/8" x 4' x 8' or 1/2" x 4' x 8'
*Designates material that may be standard lumber yard material in both width and thickness.			
**4' x 8' sheets can be substituted for longer sheets in all cases. Adjust quantities accordingly.			

**FASTENINGS:**

**Screws:** Flathead wood type, bronze or hot dipped galvanized

- 3/4" #8 - 2 gross & 3 dozen
- 1" #8 - 7 gross & 3 dozen
- 1-1/2" #8 - 2 gross
- 2" #10 - 9 dozen
- 3" #14 - 18 only

**Nails:** Ring type boat nails, bronze, stainless steel or Monel

- 1" - 1 pound
- 1-1/4" - 1 pound

**Carriage Bolts:** Bronze or hot dipped galvanized complete with nuts and washers.

- Keel to Stem - 3/8" x 7" - 2 required
- Skeg to Keel - 1/4" x 6" - 9 required

**Glue:** Epoxy - 3 gallons