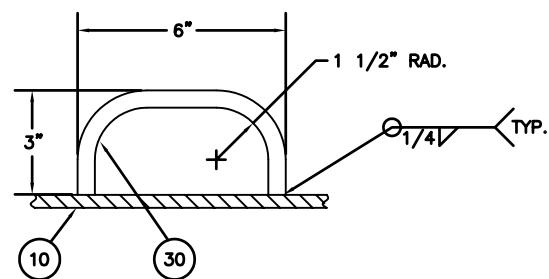
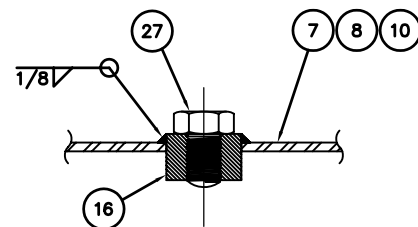


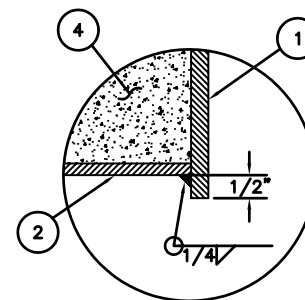
7x20 LI BUOY
SCALE: 1 1/2"=1'-0"



DETAIL A
SCALE: HALF

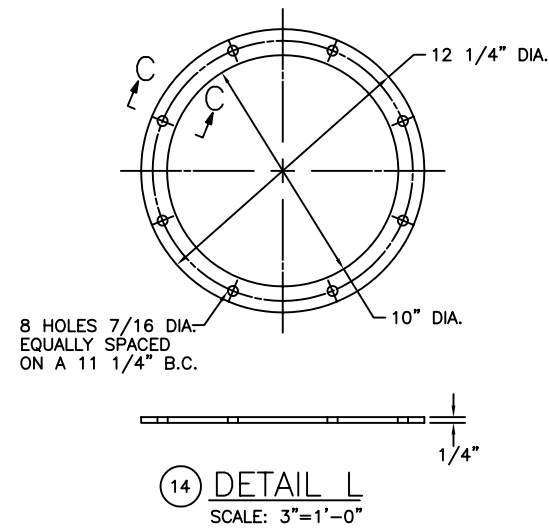
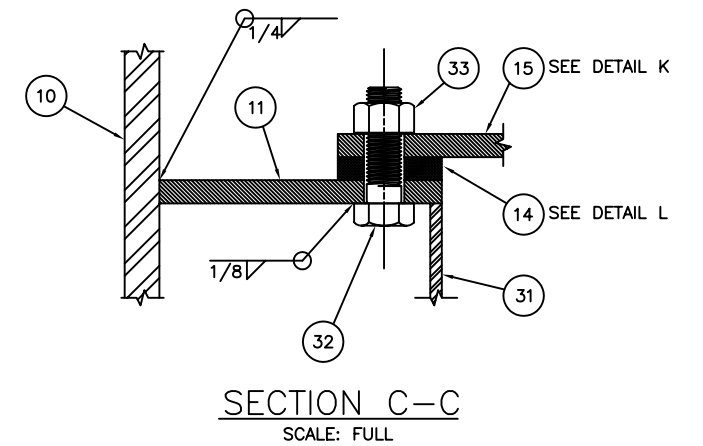
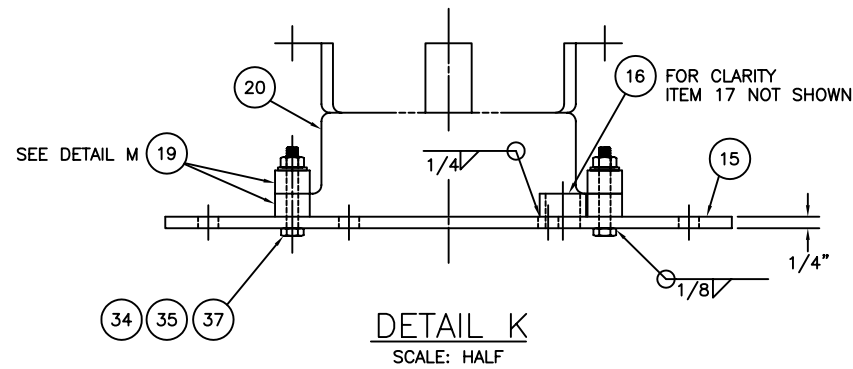
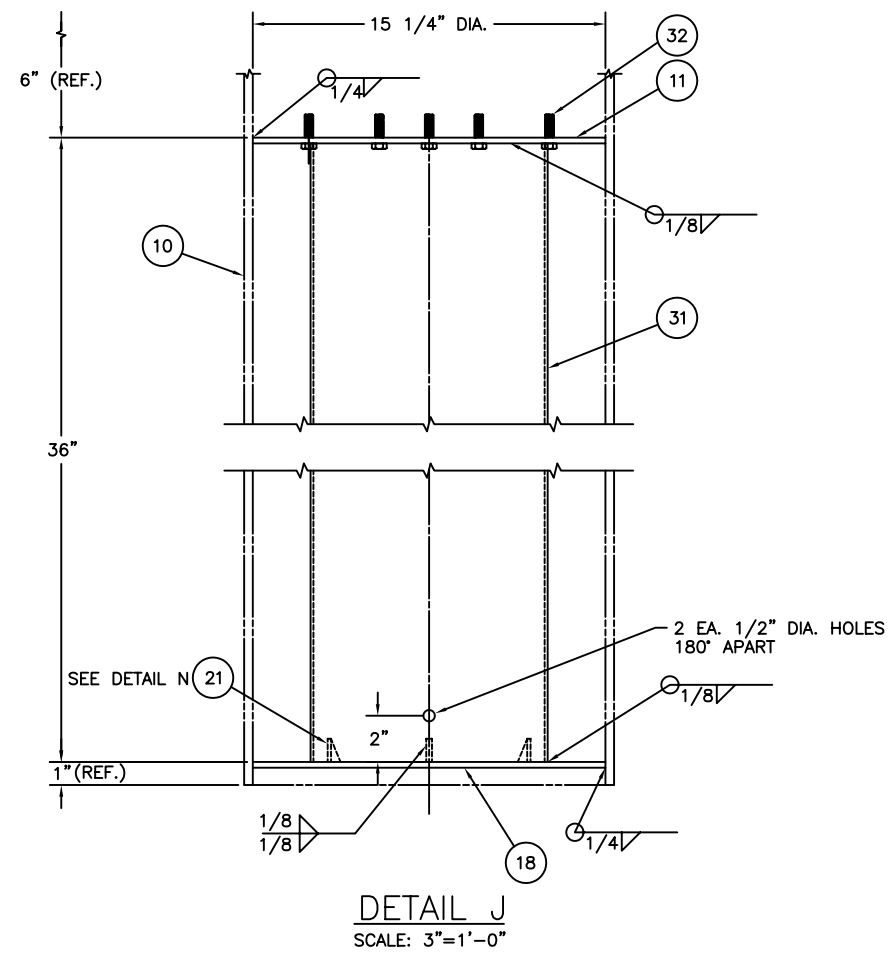
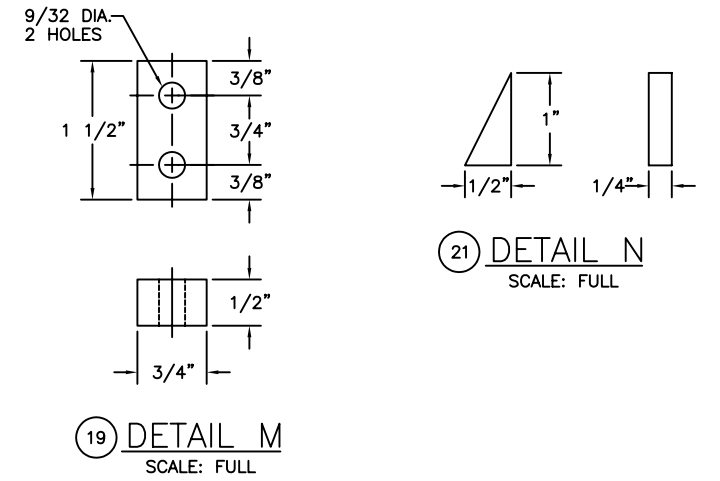
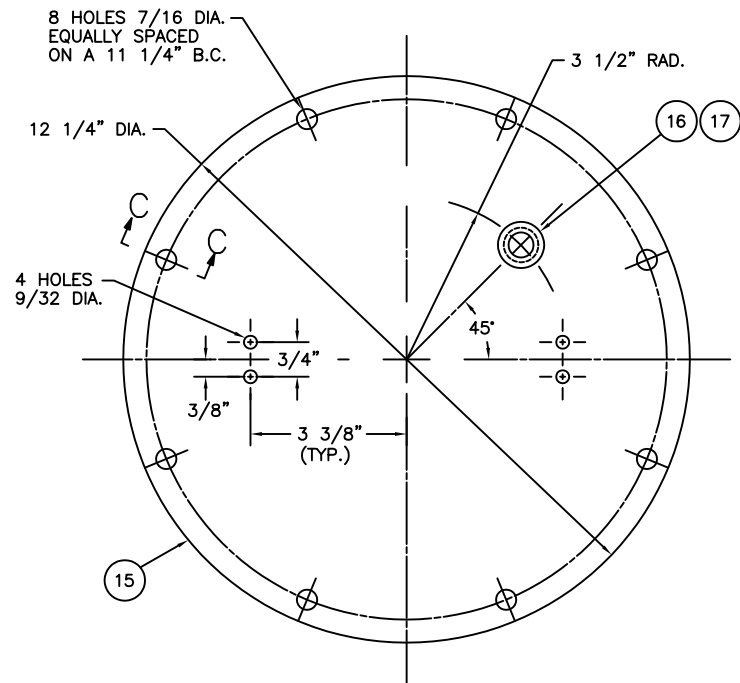
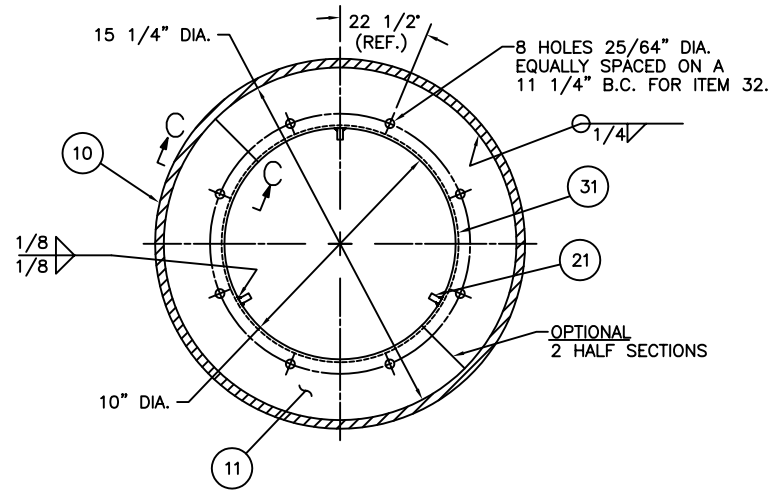


DETAIL B
SCALE: HALF

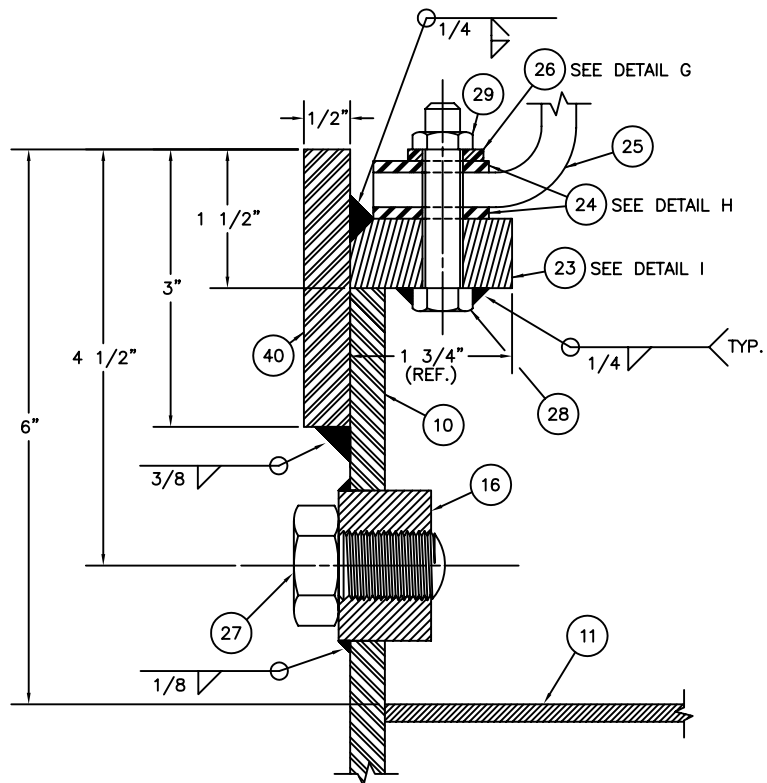


DETAIL C
SCALE: HALF

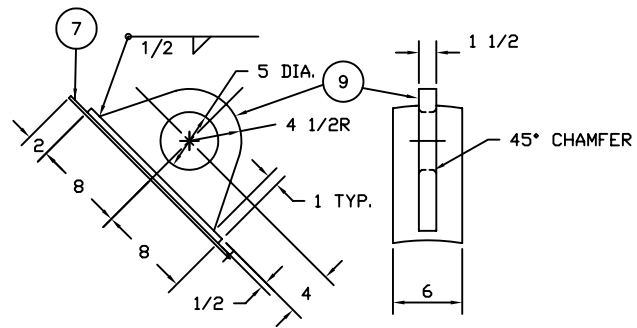
REV.	DATE	APPR.	DESCRIPTION	BY
K	6-4-99	SW	ADDED ADDITIONAL AIR TEST FITTINGS (ITEMS 16 AND 27).	S.M.
J	12-14-94	SW	MODIFIED ITEM 10 & DETAIL D.	S.M.
I	11-9-94	SW	THIS REVISION INCORPORATES ALL PREVIOUS REVISIONS. REORG. DWG & BILL OF MATERIALS. MODIFIED ITEMS 31 & 40.	S.M.
DESIGNED: P.J.G. DRAWN: S.M. TRACED: CHECKED: REVIEWED BY: Paul J. Glahe Ch. B & S Sec. REVIEWED BY: R. Bates Ch. SIG BRANCH				
APPROVED:			D. A. Naus	DATE
			CHIEF OF DIVISION	7-8-81
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ± 1/8 ANG. ± 1°				DRAWING NUMBER 120976 REV. K
SCALE: NONE				SHEET 1 OF 4



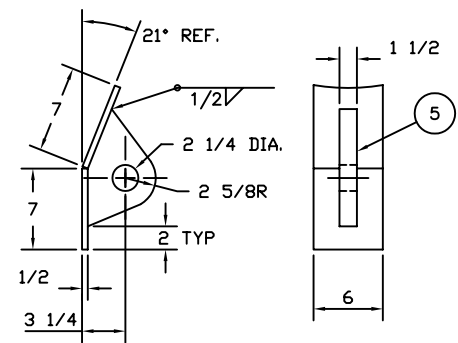
REV.	DATE	APPR.	DESCRIPTION	BY
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J	12-14-94	SW	MODIFIED ITEM 10 & DETAIL D.	S.M.
I	11-9-94	SW	THIS REVISION INCORPORATES ALL PREVIOUS REVISIONS. REORG. DWG & BILL OF MATERIALS. MODIFIED ITEMS 31 & 40.	S.M.
DESIGNED: P.J.G.			U.S. COAST GUARD HEADQUARTERS	
DRAWN: S.M.			CIVIL ENGINEERING	
TRACED:			7x20 LI ICE BUOY	
CHECKED:				
REVIEWED BY: Paul J. Glahe Ch. B & S Sec.				
REVIEWED BY: R. Bates Ch. SIG BRANCH				
APPROVED: D. A. Naus CHIEF OF DIVISION			DATE: 7-8-81	
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±1°			DRAWING NUMBER: 120976 REV. K	
SCALE: NONE			SHEET 3 OF 4	



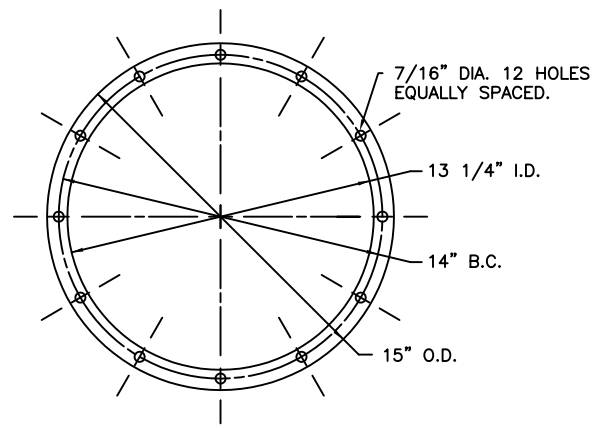
DETAIL D
SCALE: FULL



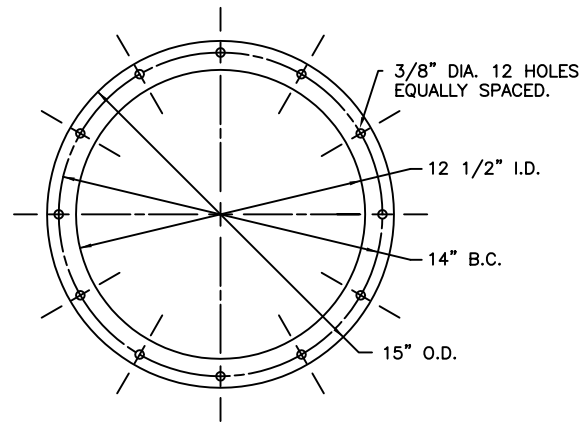
DETAIL E
SCALE: 1 1/2"=1'-0"



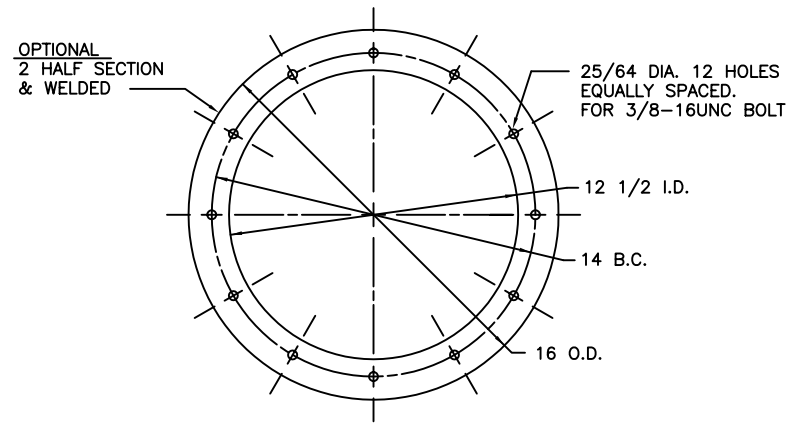
DETAIL F
SCALE: 1 1/2"=1'-0"



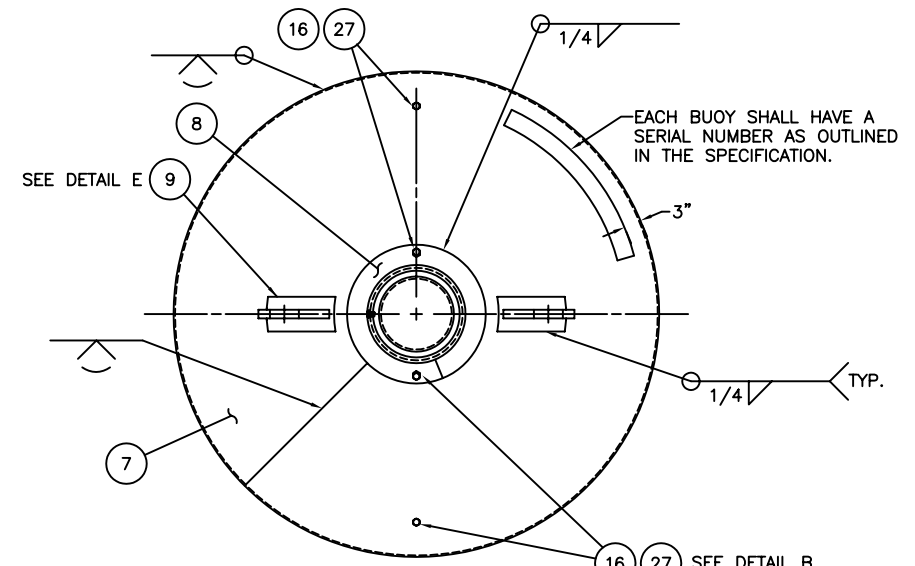
DETAIL G
SCALE: 3"=1'-0"



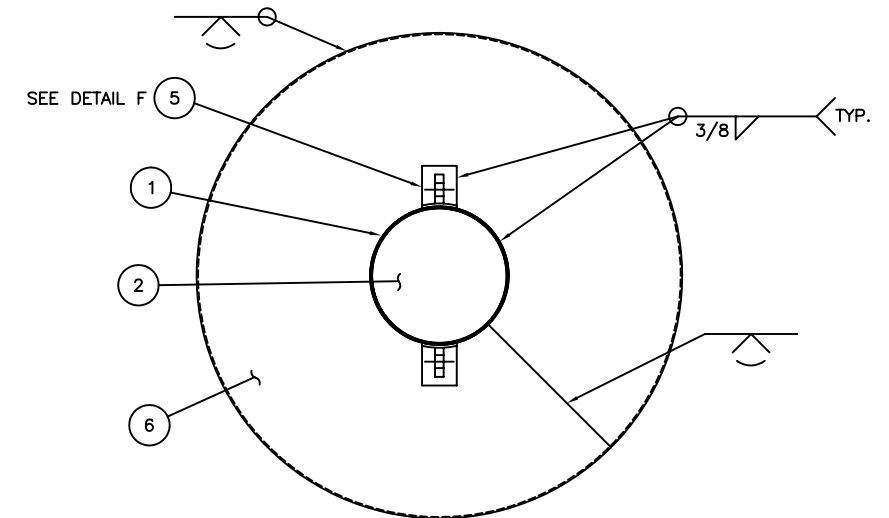
DETAIL H
SCALE: 3"=1'-0"



DETAIL I
SCALE: 3"=1'-0"



SECTION A-A
SCALE: 3/4"=1'-0"



SECTION B-B
SCALE: 3/4"=1'-0"

REV.	DATE	APPR.	DESCRIPTION	BY
K	6-4-99	SW	ADDED ADDITIONAL AIR TEST FITTINGS (ITEMS 16 & 27).	S.M.
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I	11-9-94	SW	THIS REVISION INCORPORATES ALL PREVIOUS REVISIONS. REORG. DWG & BILL OF MATERIALS. MODIFIED ITEMS 31 & 40.	S.M.
DESIGNED: P.J.G.			U.S. COAST GUARD HEADQUARTERS	
DRAWN: S.M.			CIVIL ENGINEERING	
TRACED:			7x20 LI ICE BUOY	
CHECKED:				
REVIEWED BY: Paul J. Glahe Ch. B & S Sec.				
REVIEWED BY: R. Bates Ch. SIG BRANCH				
APPROVED: D. A. Naus CHIEF OF DIVISION			DATE: 7-8-81	
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±1°			DRAWING NUMBER: 120976 REV. K	
SCALE: NONE			SHEET 2 OF 4	

BILL OF MATERIALS

ITEM NO.	NO. REQ.	DESCRIPTION	MATL.	REMARKS
1	1	COUNTERWEIGHT PIPE	STEEL	24 O.D. 3/8 WALL
2	1	BOTTOM PLATE	STEEL	1/4 THK.
3	3	COUNTERWEIGHT BAR	STEEL	RE-BAR 1x23 LG.
4	1	COUNTERWEIGHT	CONCRETE	SEE NOTE 3
5	2	MOORING EYE	STEEL	SEE DETAIL F
6	1	BOTTOM CONIC SECTION	STEEL	3/8 THK.
7	1	MIDDLE CONIC SECTION	STEEL	1/4 THK.
8	1	TOP CONIC SECTION	STEEL	3/8 THK.
9	2	LIFTING EYE	STEEL	SEE DETAIL E
10	1	BATTERY POCKET PIPE	STEEL	16 O.D. 3/8 WALL
11	1	BATTERY POCKET FLANGE	STEEL	15 1/4 OD x 10 ID x 1/4 THK.
12	1	BATTERY CLAMP	STEEL	SEE DWG 120982
13	1	BATTERY PACK	STEEL	9 O.D.
14	1	BATTERY POCKET GASKET	RUBBER	SEE DETAIL L
15	1	BATTERY POCKET COVER	STEEL	SEE DETAIL K
16	6	HALF COUPLING	STAIN. STEEL	3/4 IPS
17	1	STUFFING TUBE	BRASS	3/4 IPS SEE NOTE 2
18	1	BATTERY POCKET BOTTOM	STEEL	15-1/4 OD x 1/4 THK
19	4	SHOCK PAD	RUBBER	SEE DETAIL M
20	1	BRACKET ASS'Y	STAIN. STEEL	SEE DWG 120999
21	3	BATTERY WEDGES	STEEL	1/4 THK
22				
23	1	SUPPORT RING	STEEL	SEE DETAIL I
24	2	DOME GASKET	RUBBER	SEE DETAIL H
25	1	DOME (LENS)	LEXAN	SEE DWG 120981
26	1	TOP SUPPORT RING	STAIN. STEEL	SEE DETAIL G
27	5	PIPE PLUG	STAIN. STEEL	3/4 IPS
28	12	HEX HD. BOLT	STAIN. STEEL	3/8-16x2 LG.
29	12	STOP NUT	STAIN. STEEL	3/8-16
30	1	GRAB BAR	STEEL	1/2 DIA. ROD
31	1	BATTERY POCKET WRAPPER	STEEL	10 ID x 36 LG x 1/8 THK.
32	8	HEX HEAD BOLT	STAIN. STEEL	3/8-16UNCx1-1/4 LG
33	8	STOP NUT	STAIN. STEEL	3/8-16UNC
34	4	HEX HEAD SCREW	STAIN. STEEL	1/4-20UNCx1-3/4 LG
35	4	STOP NUT	STAIN. STEEL	1/4-20UNC
36				
37	4	FLAT WASHER	STAIN. STEEL	1/4 STD
38	1	TOP STIFFENING RING	STEEL	3/8 THKx3 FLAT BAR
39	1	BOTTOM STIFFENING RING	STEEL	3/8 THKx3 FLAT BAR
40	1	TOP RING	STEEL	3 WIDE x 1/2 THK.

NOTES:

- SEE LATEST REVISION OF U.S.C.G CIVIL ENGINEERING SPECIFICATION No. 464 FOR FABRICATION REQUIREMENTS.
- NYLON STUFFING TUBE WHICH MEETS THE REQUIREMENTS OF MIL SPEC MIL-S-19622 MAY BE SUBSTITUTED FOR ITEM 17.
- THE TOTAL WEIGHT OF ITEMS 1, 2, 3, & 4 SHALL BE 3,055# (+5% OR -1%).

▷ FOR REFERENCE ONLY. INSTALLED BY GOVERNMENT AT DESTINATION.

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DESIGNED:	P.J.G	U.S. COAST GUARD HEADQUARTERS		
DRAWN:	S.M.	CIVIL ENGINEERING		
TRACED:		7x20 LI ICE BUOY		
CHECKED:				
REVIEWED BY:	Paul J. Glahe Ch. B & S Sec.			
REVIEWED BY:	R. Bates Ch. SIG BRANCH			
REVIEWED BY:	APPROVED:	D. A. Naus		DATE 7-8-81
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±1'			DRAWING NUMBER 120976	REV. K
SCALE: NONE			SHEET 4 OF 4	