



BILL OF MATERIALS				
ITEM NO.	NO. REQ.	DESCRIPTION	MATL.	REMARKS
1	AR	COMMON LINK	STEEL	
2	4	END LINK	STEEL	
3	1	CENTER RING	STEEL	

NOTES

- SEE LATEST REVISION OF U.S.C.G CIVIL ENGINEERING SPECIFICATION No. 377 FOR FABRICATION REQUIREMENTS.
- WELD OVERAGE SHALL NOT BE INCLUDED IN THE MEASUREMENT OF DIMENSIONS 'C' AND 'F' (OVERALL WIDTH) OR DIMENSION 'H' (INSIDE DIAMETER OF CENTER RING).

PROOF AND BREAKING LOADS					
BRIDLE LINK DIAMETER		PROOF LOAD		BREAKING LOAD	
IN	MM	LB	KG	LB	KG
7/8	22	22,000	9,979	44,000	19,958
1	25	29,000	13,154	58,000	26,308
1-1/4	32	45,500	20,638	91,000	41,277
1-1/2	38	65,500	29,710	131,000	59,421

U.S. CUSTOMARY (INCHES)

TYPE (INCHESxFEET)	1				2				3			LENGTH IN FEET		APPROX. WEIGHT IN (LBS.)
	A	B	C	TOLERANCE (B & C)	D	E	F	TOLERANCE (E & F)	G	H	TOLERANCE (H)	MINIMUM	MAXIMUM	
7/8x10	7/8	5 1/4	3 1/8	±1/16	1 1/8	6 3/4	4	±3/32	1 1/4	6	±1/8	10'-0"	10'-7"	80
1x12	1	6	3 9/16	±3/32	1 1/4	7 1/2	4 7/16	±1/8	1 1/2	6	±5/32	11'-3"	12'-3"	120
1 1/4x15	1 1/4	7 1/2	4 7/16	±1/8	1 1/2	9	5 5/16	±5/32	1 3/4	6	±3/16	14'-0"	15'-3"	215
1 1/2x18	1 1/2	9	5 5/16	±5/32	1 7/8	11 1/4	6 11/16	±3/16	2 1/4	8	±1/4	17'-0"	18'-3"	400
1 1/2x20	1 1/2	9	5 5/16	±5/32	1 7/8	11 1/4	6 11/16	±3/16	2 1/4	8	±1/4	19'-0"	20'-3"	430
1 1/2x26	1 1/2	9	5 5/16	±5/32	1 7/8	11 1/4	6 11/16	±3/16	2 1/4	8	±1/4	25'-0"	26'-3"	555

DIA. TOLERANCE U.S. CUSTOMARY (INCHES)		
DIA. A D & G	PLUS	MINUS
1/2-1 1/2	1/32	1/64
1 5/8-2 1/4	1/16	1/64
METRIC (mm)		
DIA. A D & G	PLUS	MINUS
12.7-38	1	.5
42-56	1.5	.5

METRIC (MILLIMETERS)

TYPE (MMxM)	1				2				3			LENGTH IN METERS		APPROX. WEIGHT IN (KGS.)
	A	B	C	TOLERANCE (B & C)	D	E	F	TOLERANCE (E & F)	G	H	TOLERANCE (H)	MINIMUM	MAXIMUM	
22x3.1	22	132	79.5	±1.5	28	168	100.5	±2.5	32	150	±3.5	3.00	3.20	36.3
25x3.6	25	150	87.5	±2.5	32	192	114	±3.5	38	150	±4.0	3.38	3.65	54.5
32x4.5	32	192	114	±3.5	38	228	134.5	±4.0	44	150	±5.0	4.24	4.57	97.5
38x5.5	38	228	134.5	±4.0	48	288	171	±5.0	56	203	±6.5	5.12	5.50	181.5
38x6.1	38	228	134.5	±4.0	48	288	171	±5.0	56	203	±6.5	5.70	6.12	195
38x7.9	38	228	134.5	±4.0	48	288	171	±5.0	56	203	±6.5	7.46	8.00	252.0

F	11-7-05	WD	ADDED PROOF AND BREAKING LOAD CHART. ADDED MIN AND MAX DIMENSIONS FOR OVERALL LENGTH	S.M.
E	2-5-98	S.W.	CORRECTED THE LENGTH DIM FOR THE 38x6.1 BRIDLE	S.M.
D	12-5-93	WD	ADDED 1 1/2x20 (38x6.1) BRIDLE. MODIFIED NOTE 1.	S.M.
C	3-13-91	SW	REDRAWN USING AUTOCAD	DAG
B	8-1-86	SW	ADDED NOTES 2. DELETED REFERENCES TO OCEAN ENGINEERING DIVISION.	W.D.
A	3-3-86	SW	CHANGED DIMS "C" AND "F" FOR ALL ITEMS ON BOTH TABLES	W.D.
REV.	DATE	APPR.	DESCRIPTION	BY
DESIGNED:	SDR	U.S. COAST GUARD HEADQUARTERS		
DRAWN:	GWB	CIVIL ENGINEERING		
TRACED:	DAG	BUOY BRIDLES		
CHECKED:	SDR	S. D. Walker		
REVIEWED BY:	G-ECV-3B	P. J. Glahe		
REVIEWED BY:	G-ECV-3	APPROVED: L. R. Lomer		DATE: 2-16-83
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ANG.			DRAWING NUMBER: 121031	REV. F
SCALE: NONE			SHEET 1 OF 1	