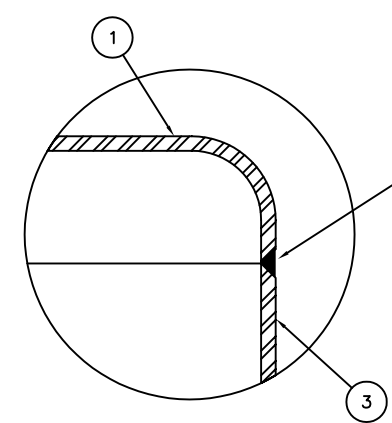
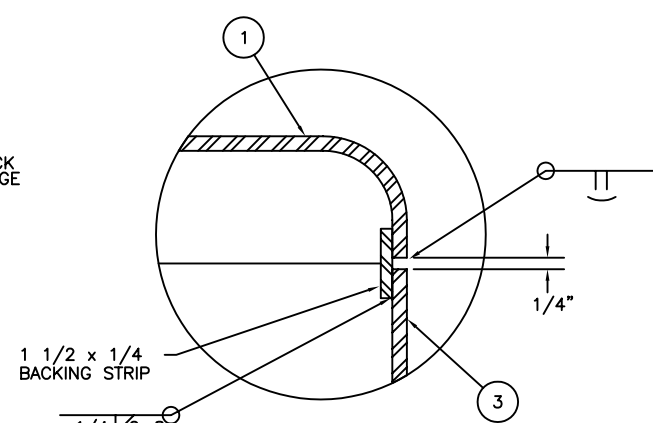


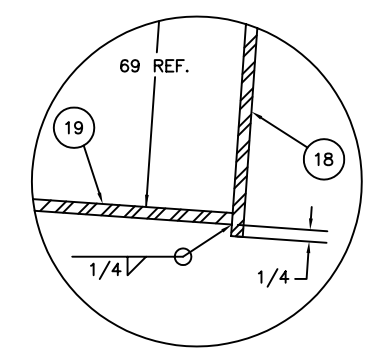
8x21 LR BUOY ASSEMBLY
SCALE: 1"=1'-0"



DETAIL A
SCALE: HALF

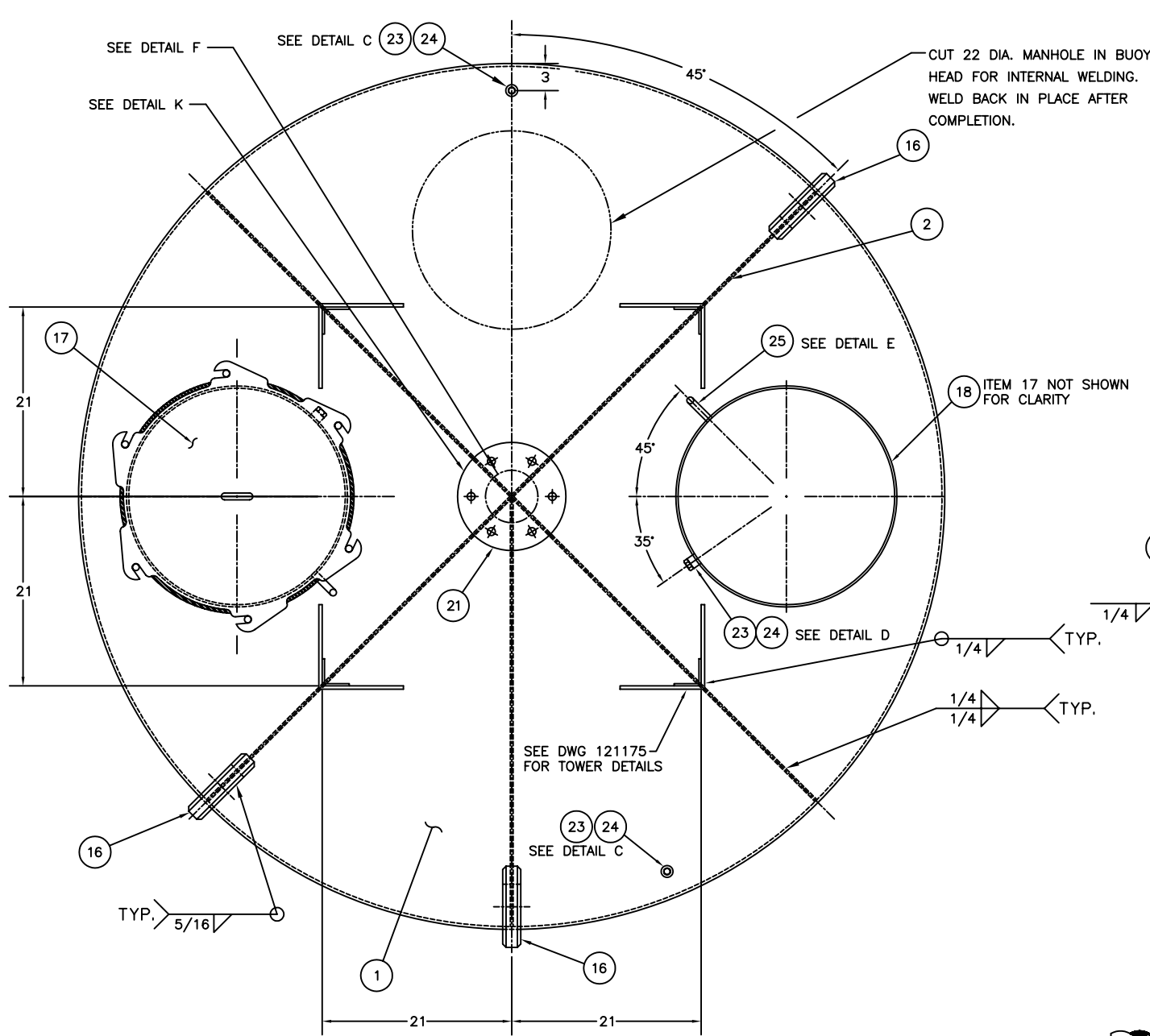


DETAIL A
SCALE: HALF
OPTIONAL

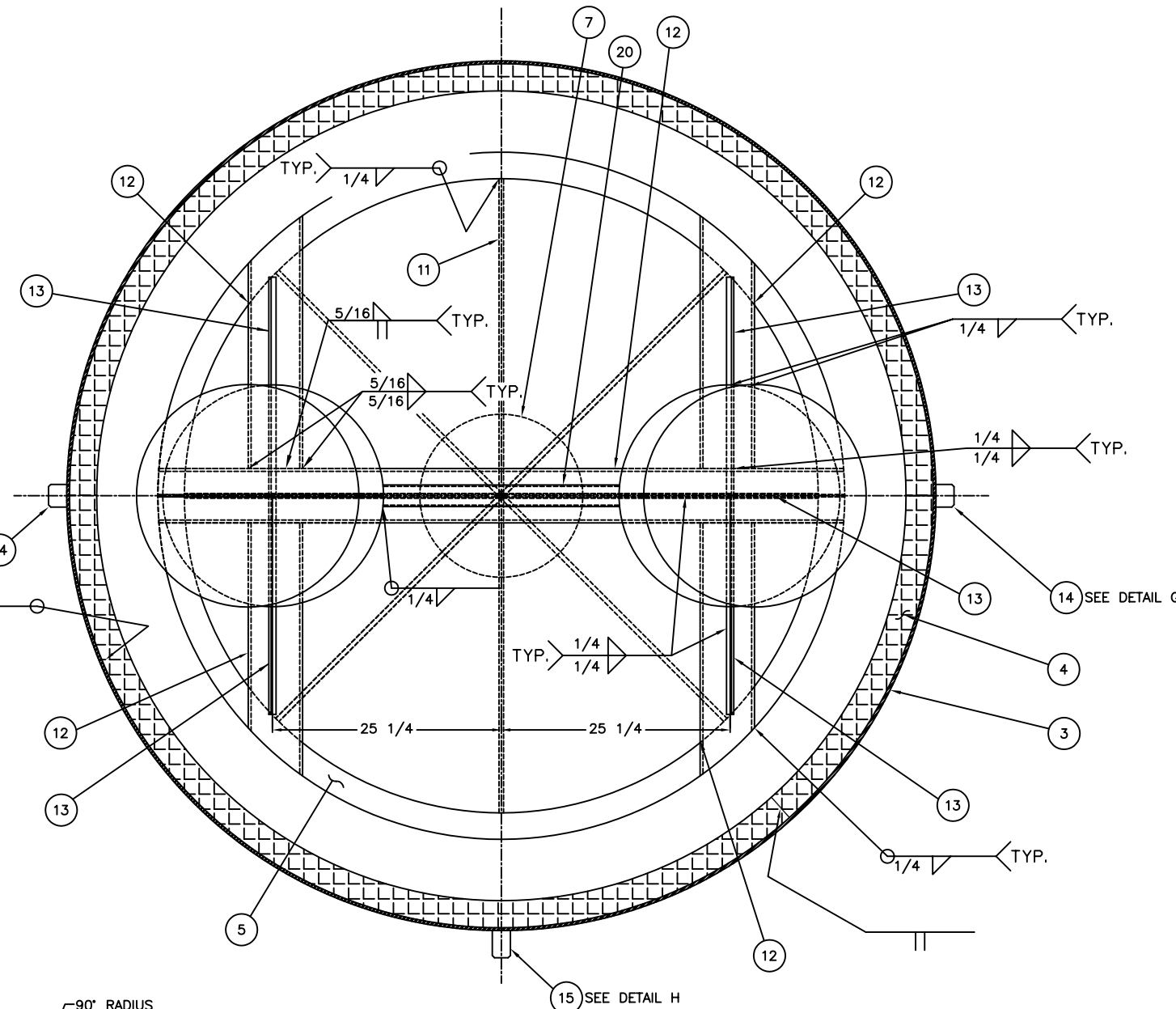


DETAIL B
SCALE: HALF

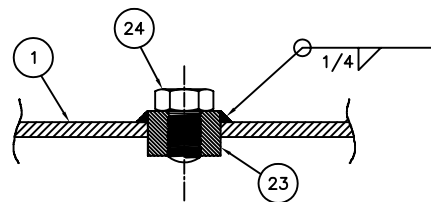
REV.	DATE	APPR.	DESCRIPTION	BY
E	6-4-99	S.W.	ADDED ADDITIONAL AIR TEST FITTING (ITEMS 23 & 24).	S.M.
D	10-1-97	S.W.	REORG DWG. DEL TOWER DETAILS. REF DRAWING 121175 FOR TWR. DEL 2 EA ITEMS 26, 27, & 28. SHORTEN ITEM 25.	S.M.
C	6-22-95	S.W.	CORRECTED BUOY DIAMETER DIMENSION ON ASSEMBLY VIEW. MOD NOTE 2. CLARIFIED WELD SYMBOLS IN DETAIL G	S.M.
B	10-26-94	S.W.	DEL ITEM 26. MOD. SECTION F-F AND QTY FOR ITEM 24.	S.M.
A	2-17-93	CAK	REORGANIZED DRAWING. MODIFIED NOTES AND NO. REQ. FOR ITEMS 6, 22, 23, 27, & 40. DELETED ITEMS 7, 21, & 41.	S.M.
DESIGNED: RT/SM			U.S. COAST GUARD HEADQUARTERS	
DRAWN: SM			CIVIL ENGINEERING	
TRACED:			1991 TYPE	
CHECKED: SM			8x21 LR BUOY	
REVIEWED BY:			R. J. Wells	
REVIEWED BY:			6/4/91	
REVIEWED BY:			APPROVED: R. J. Wells	
REVIEWED BY:			DATE: 6/4/91	
REVIEWED BY:			CHIEF, OCEAN ENGINEERING BRANCH	
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±1°			DRAWING NUMBER 121145	
SCALE: AS NOTED			REV. E	
SHEET 1 OF 4				



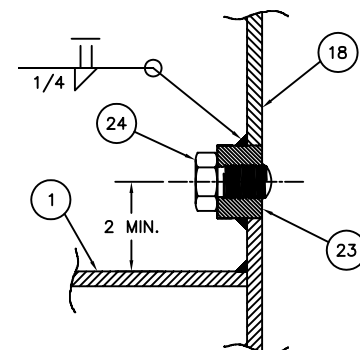
SECTION A-A
SCALE: 1 1/2"=1'-0"



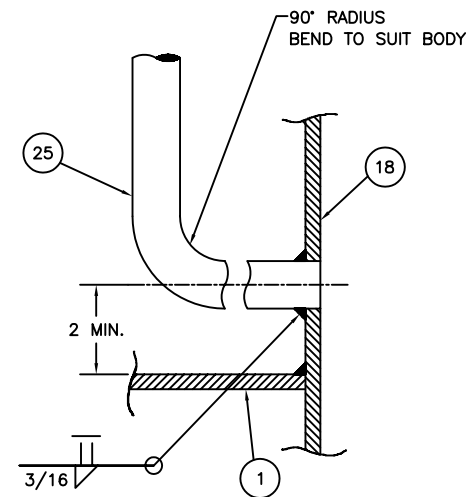
SECTION B-B
SCALE: 1 1/2"=1'-0"



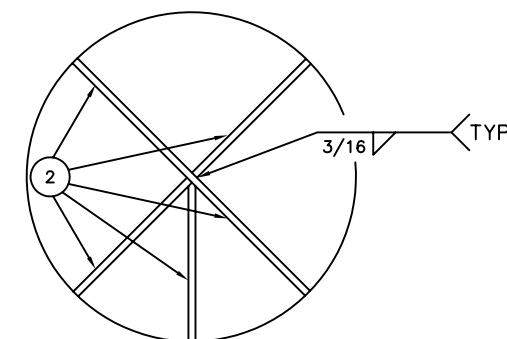
DETAIL C
SCALE: HALF



DETAIL D
SCALE: HALF

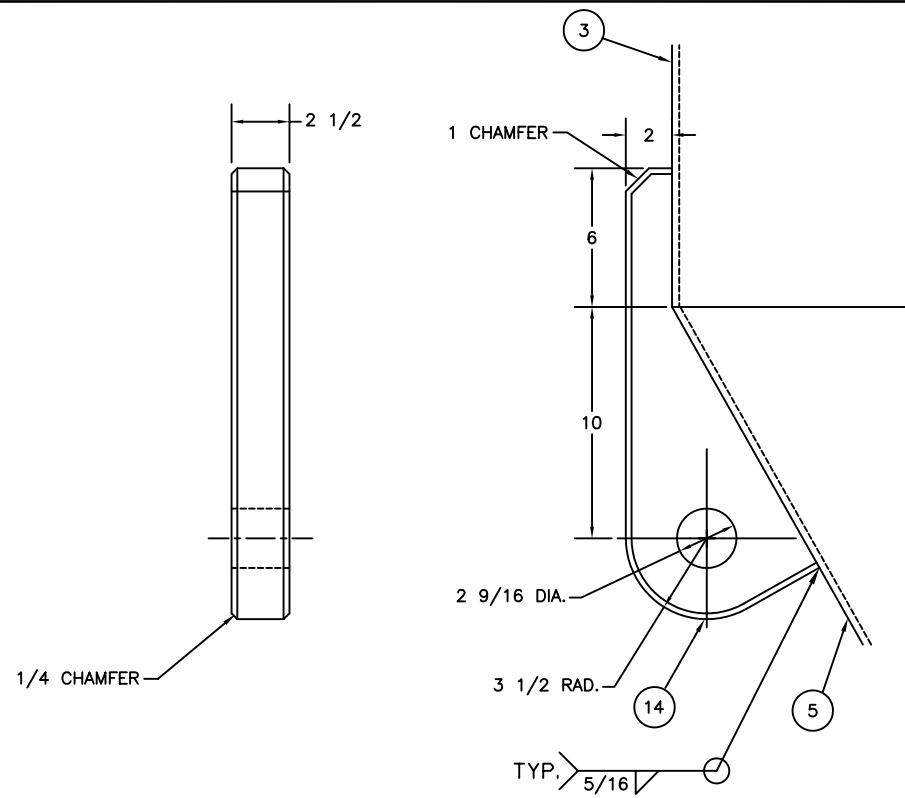


DETAIL E
SCALE: HALF

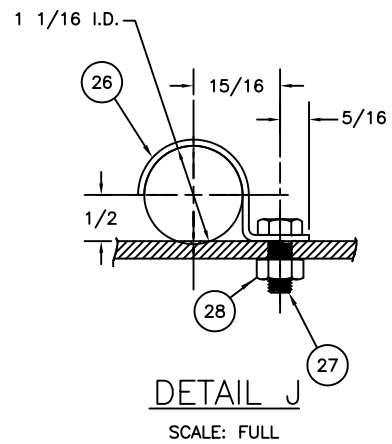


DETAIL F
SCALE: NONE

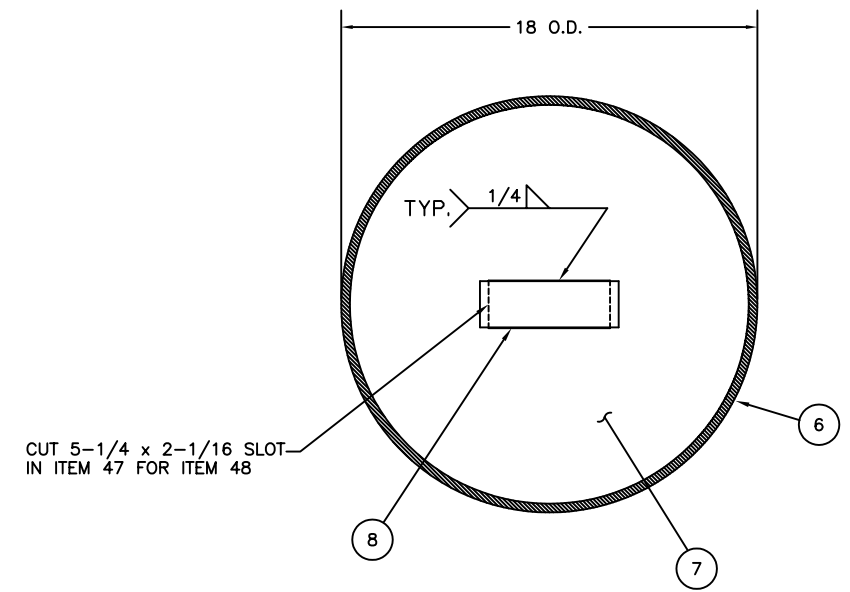
E	6-4-99	S.W.	ADDED ADDITIONAL AIR TEST FITTING (ITEMS 23 & 24).	S.M.
D	10-1-97	S.W.	REORG DWG. DEL TOWER DETAILS. REF DRAWING 121175 FOR TWR. DEL 2 EA ITEMS 26, 27, & 28. SHORTEN ITEM 25.	S.M.
C	6-22-95	S.W.	CORRECTED BUOY DIAMETER DIMENSION ON ASSEMBLY VIEW. MOD NOTE 2. CLARIFIED WELD SYMBOLS IN DETAIL G	S.M.
B	10-26-94	S.W.	DEL ITEM 26. MOD. SECTION F-F AND QTY FOR ITEM 24.	S.M.
A	2-17-93	CAK	REORGANIZED DRAWING. MODIFIED NOTES AND NO. REQ. FOR ITEMS 6, 22, 23, 27, & 40. DELETED ITEMS 7, 21, & 41.	S.M.
REV.	DATE	APPR.	DESCRIPTION	BY
DESIGNED:	RT/SM	U.S. COAST GUARD HEADQUARTERS		
DRAWN:	SM	CIVIL ENGINEERING		
TRACED:		1991 TYPE		
CHECKED:	SM	8x21 LR BUOY		
REVIEWED BY:	R. M. Trainer PROJECT ENGINEER			
REVIEWED BY:	S. D. Walker G-ECV-3B			
REVIEWED BY:		APPROVED:	R. J. Wells CHIEF, OCEAN ENGINEERING BRANCH	DATE 6/4/91
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±1°			DRAWING NUMBER 121145	REV. E
PLOTING SCALE: 1-1/2"=1'-0"			SCALE: AS NOTED	SHEET 2 OF 4



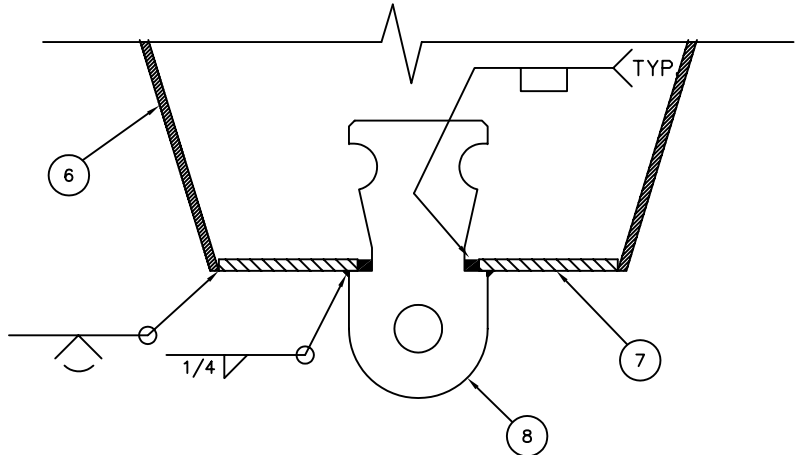
DETAIL G
SCALE: 3"=1'-0"



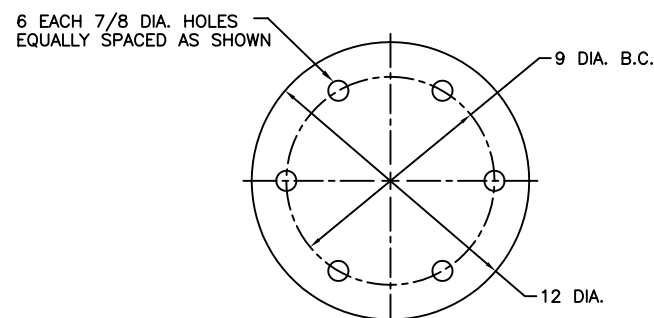
DETAIL J
SCALE: FULL



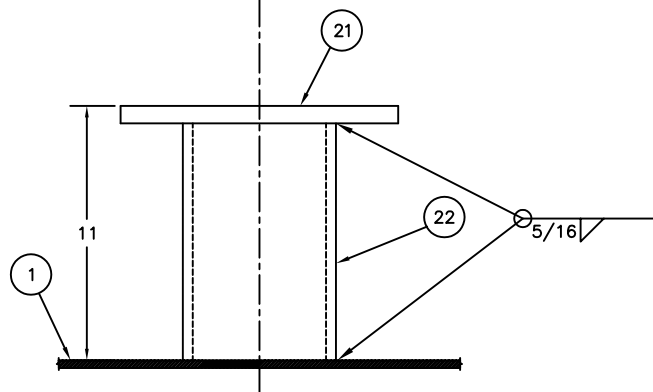
CUT 5-1/4 x 2-1/16 SLOT
IN ITEM 47 FOR ITEM 48



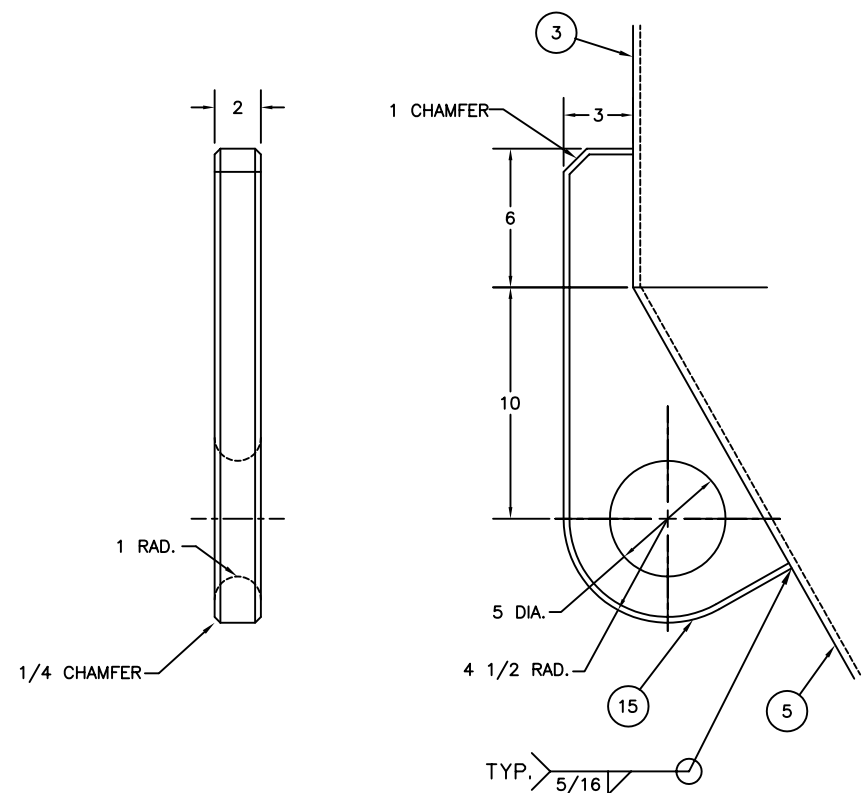
DETAIL L
SCALE: 3"=1'-0"



6 EACH 7/8 DIA. HOLES
EQUALLY SPACED AS SHOWN



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



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

REV.	DATE	APPR.	DESCRIPTION	BY
E	6-4-99	S.W.	ADDED ADDITIONAL AIR TEST FITTING (ITEMS 23 & 24).	S.M.
D	10-1-97	S.W.	REORG DWG. DEL TOWER DETAILS. REF DRAWING 121175 FOR TWR. DEL 2 EA ITEMS 26, 27, & 28. SHORTEN ITEM 25.	S.M.
C	6-22-95	S.W.	CORRECTED BUOY DIAMETER DIMENSION ON ASSEMBLY VIEW. MOD NOTE 2. CLARIFIED WELD SYMBOLS IN DETAIL G	S.M.
B	10-26-94	S.W.	DEL ITEM 26. MOD. SECTION F-F AND QTY FOR ITEM 24.	S.M.
A	2-17-93	CAK	REORGANIZED DRAWING. MODIFIED NOTES AND NO. REQ. FOR ITEMS 6, 22, 23, 27, & 40. DELETED ITEMS 7, 21, & 41.	S.M.
DESIGNED: RT/SM		U.S. COAST GUARD HEADQUARTERS		
DRAWN: SM		CIVIL ENGINEERING		
TRACED:		1991 TYPE		
CHECKED: SM		8x21 LR BUOY		
REVIEWED BY:		R. M. Trainer PROJECT ENGINEER		
REVIEWED BY:		S. D. Walker G-ECV-3B		
REVIEWED BY:		APPROVED:	R. J. Wells CHIEF, OCEAN ENGINEERING BRANCH	DATE 6/4/91
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±1°		DRAWING NUMBER 121145		
		SCALE: AS NOTED SHEET 3 OF 4		

BILL OF MATERIALS

ITEM NO.	NO. REQ.	DESCRIPTION	MATL.	REMARKS
1	1	BUOY TOP HEAD	STEEL	96 DIA. x 5/16 THK.
2	5	TOP HEAD STIFFNER	STEEL	12 x 5/16 THK.
3	1	BODY WRAPPER	STEEL	96 DIA. x 5/16 THK.
4	1	WRAPPER STIFFNER	STEEL	3 x 3 x 1/4 L
5	1	CONICAL BODY BAND (TOP)	STEEL	3/8 THK.
6	1	CONICAL BODY BAND (BOTTOM)	STEEL	3/8 THK.
7	1	BOTTOM PLATE	STEEL	17 1/4 DIA. x 1/2 THK.
8	1	BOTTOM MOORING EYE	STEEL	SEE DRAWING 121153
9	1	CAST IRON COUNTERWEIGHT	CAST IRON	2980 # SEE NOTE 2
10	1	CONCRETE COUNTERWEIGHT	CONCRETE	4050 # SEE NOTE 2
11	4	REBAR	STEEL	1/2 DIA. ASTM 706 GRADE 60
12	5	CHANNEL BRACING	STEEL	C 6 x 10.5
13	5	POCKET BRACE	STEEL	8 x 1/4 THK.
14	2	MOORING EYE	STEEL	2 1/2 THK. PLATE
15	1	BOTTOM HEAD LIFT EYE	STEEL	2 THK. PLATE
16	3	TOP HEAD LIFT EYE	STEEL	SEE DRAWING 121140
17	2	POCKET COVER ASSEMBLY	STEEL	SEE DRAWING 121143
18	2	POCKET WRAPPER	STEEL	24 I.D. x 1/4 THK.
19	2	POCKET BOTTOM PLATE	STEEL	24 DIA. x 1/4 THK.
20	1	POCKET VENT PIPE	GAL. STL.	2 SCH 40
21	1	BELL STAND PLATE	STEEL	12 DIA. x 3/4 THK.
22	1	BELL STAND	STEEL	6 SCH. 80 PIPE
23	4	HALF COUPLING	STAIN. STEEL	3/4 NPT
24	4	PIPE PLUG	STAIN. STEEL	3/4 NPT
25	2	VENT LINE	STAIN. STEEL	3/4 SCH 40
26	2	VENT PIPE CLIPS	STAIN. STEEL	5/8 x 1/16 THK.
27	2	HEX HEAD CAP SCREW	STAIN. STEEL	1/4-20UNC-5/8 LG.
28	2	HEX NUT	STAIN. STEEL	1/4-20UNC

NOTES:

- SEE LATEST REVISION OF U.S.C.G. CIVIL ENGINEERING SPECIFICATION No. 464 FOR FABRICATION REQUIREMENTS.
- DIMENSIONS FOR ITEMS 9 & 10 ARE FOR REFERENCE PURPOSES ONLY. THE TOATAL WEIGHT OF ITEMS 5 THRU 11 SHALL BE 8,545 LBS (+5% OR -1%).
- TYPE 304 STAINLESS STEEL MAY BE SUBSTITUTED FOR ITEM 20.
- ITEM 10 SHALL HAVE A 4" SLUMP WITH A SMOOTH SURFACE AND NO CAVITIES.

E	6-4-99	S.W.	ADDED ADDITIONAL AIR TEST FITTING (ITEMS 23 & 24).	S.M.
D	10-1-97	SW	REORG DWG. DEL TOWER DETAILS. REF DRAWING 121175 FOR TWR. DEL 2 EA ITEMS 26, 27, & 28. SHORTEN ITEM 25.	S.M.
C	6-22-95	SW	CORRECTED BUOY DIAMETER DIMENSION ON ASSEMBLY VIEW. MOD NOTE 2. CLARIFIED WELD SYMBOLS IN DETAIL G	S.M.
B	10-26-94	SW	DEL ITEM 26. MOD. SECTION F-F AND QTY FOR ITEM 24.	S.M.
A	2-17-93	CAK	REORGANIZED DRAWING. MODIFIED NOTES AND NO. REQ. FOR ITEMS 6, 22, 23, 27, & 40. DELETED ITEMS 7, 21, & 41.	S.M.
REV.	DATE	APPR.	DESCRIPTION	BY
DESIGNED:	RT/SM	U.S. COAST GUARD HEADQUARTERS		
DRAWN:	SM	CIVIL ENGINEERING		
TRACED:		1991 TYPE		
CHECKED:	SM	8x21 LR BUOY		
REVIEWED BY:				
REVIEWED BY:				
REVIEWED BY:				
REVIEWED BY:				
REVIEWED BY:		APPROVED:	R. J. Wells	DATE: 6/4/91
		CHIEF, OCEAN ENGINEERING BRANCH		
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±1°		DRAWING NUMBER 121145		REV. E
PLOTING SCALE: 12"=1'-0"		SCALE: AS NOTED		SHEET 4 OF 4