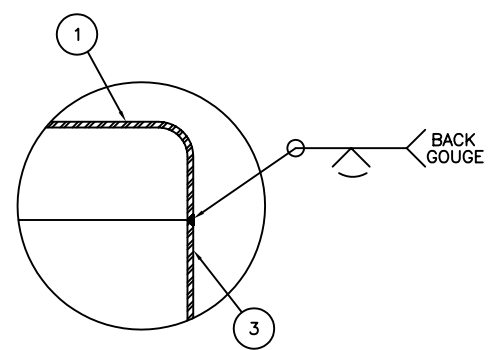


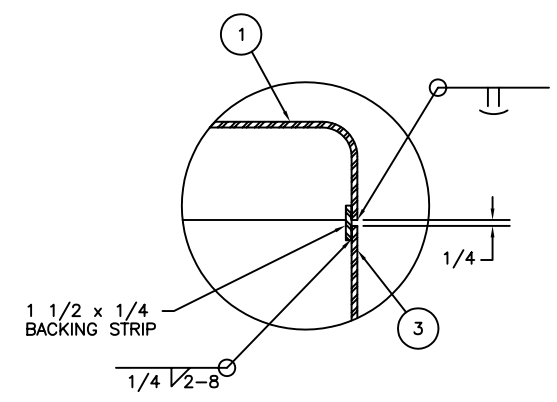
6x20 LR BUOY ASSEMBLY

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



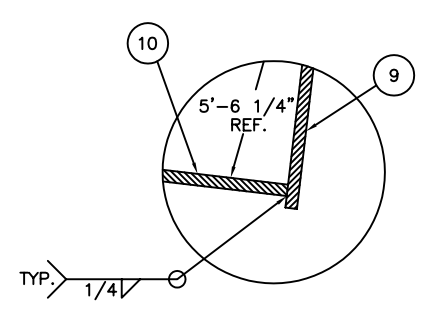
DETAIL A

SCALE: NONE



DETAIL A

SCALE: NONE
OPTIONAL



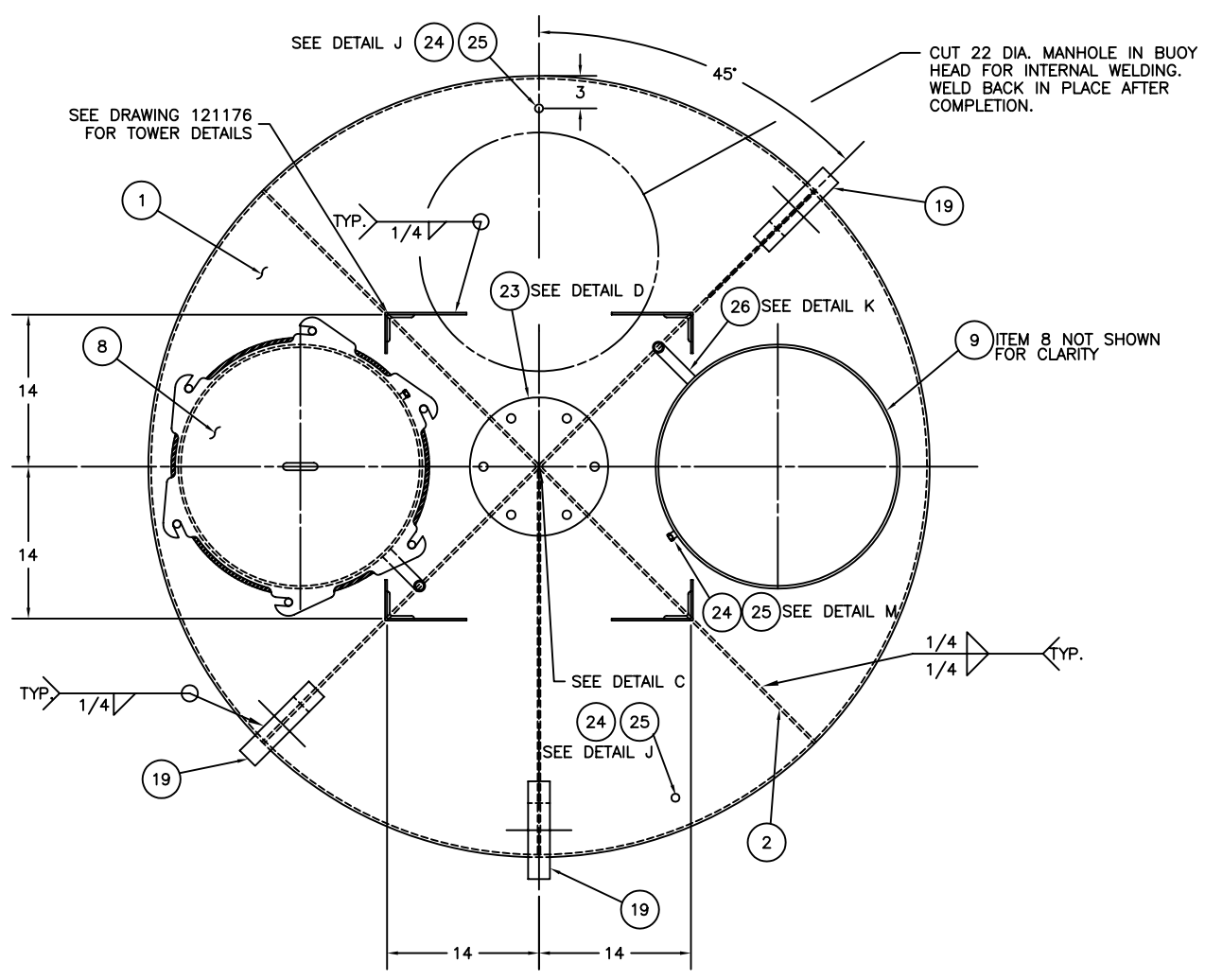
DETAIL B

SCALE: NONE

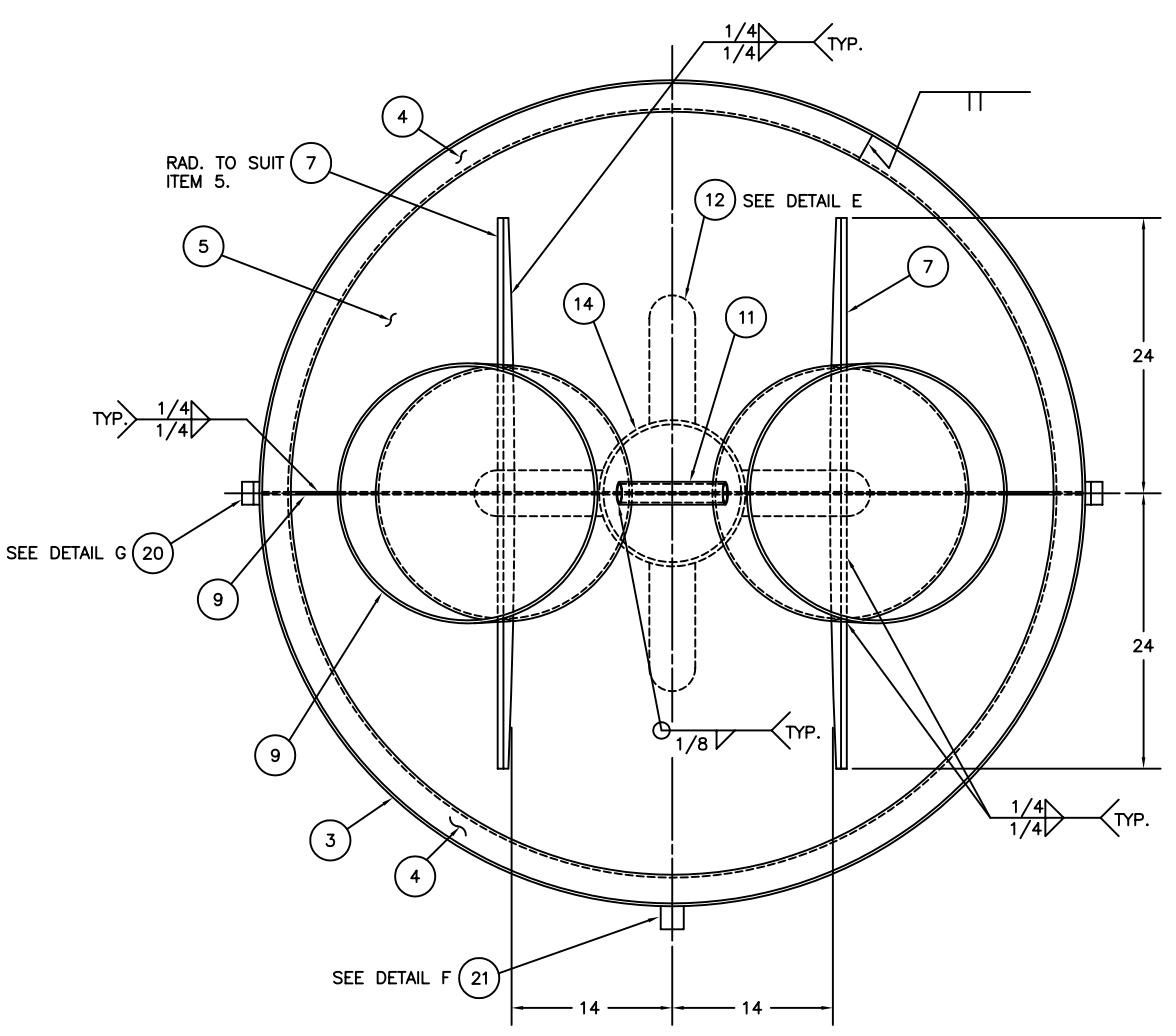
| REV. | DATE | APPR. | DESCRIPTION | BY |
|------|----------|-------|--|------|
| F | 6-4-99 | S.W. | ADDED ADDITIONAL AIR TEST FITTING (ITEMS 24 & 25). | S.M. |
| E | 5-12-99 | S.W. | MODIFIED DIMENSION IN DETAIL D. | S.M. |
| D | 10-1-97 | S.W. | REORG DWG. DEL TOWER DETAILS. REF DWG 121176 FOR TWR. DEL 2 EA ITES 27, 28, & 29. SHORTEN ITEM 26. | S.M. |
| C | 10-26-94 | S.W. | DEL ITEM 49. MOD ITEM 18 & 36. ADDED QTY FOR ITEM 59. | S.M. |
| B | 2-26-93 | CAK | REORGANIZED DWG. DELETED FROM BILL OF MATERIALS ITEMS 29-31, 55, & 61-71. MODIFIED ITEMS 3, 4, 12, 39, 48, 49, & 50. SPECIFIED NUMBER REQUIRED FOR ITEMS 43, 53, 56, & 57. ADDED NOTES | S.M. |
| B | 2-26-93 | CAK | & 50. SPECIFIED NUMBER REQUIRED FOR ITEMS 43, 53, 56, & 57. ADDED NOTES | S.M. |
| A | 9-15-92 | WD | MODIFIED BUOY TOWER AND DELETED ITEMS 52 & 58. | S.M. |

DESIGNED: U.S. COAST GUARD HEADQUARTERS
 DRAWN: S.M.
 TRACED:
 CHECKED: S.M.
 REVIEWED BY:
R. M. Trainer
 PROJECT ENGINEER
 REVIEWED BY:
S. D. Walker
 G-ECV-3B
 APPROVED: **R. J. Wells** DATE: 6/4/91
 CHIEF, OCEAN ENGINEERING BRANCH

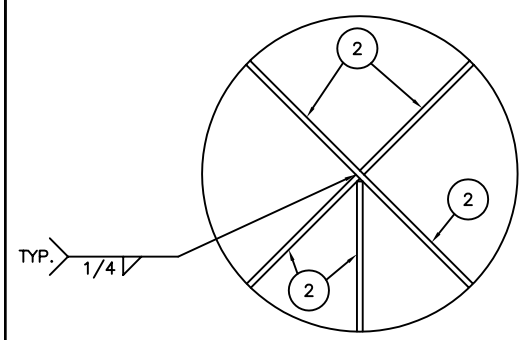
| | | | |
|--|--|---------------------------------|------------------|
| UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±30° | | DRAWING NUMBER 121152 | REV. F |
| SCALE: AS NOTED | | SHEET 1 | OF 4 |



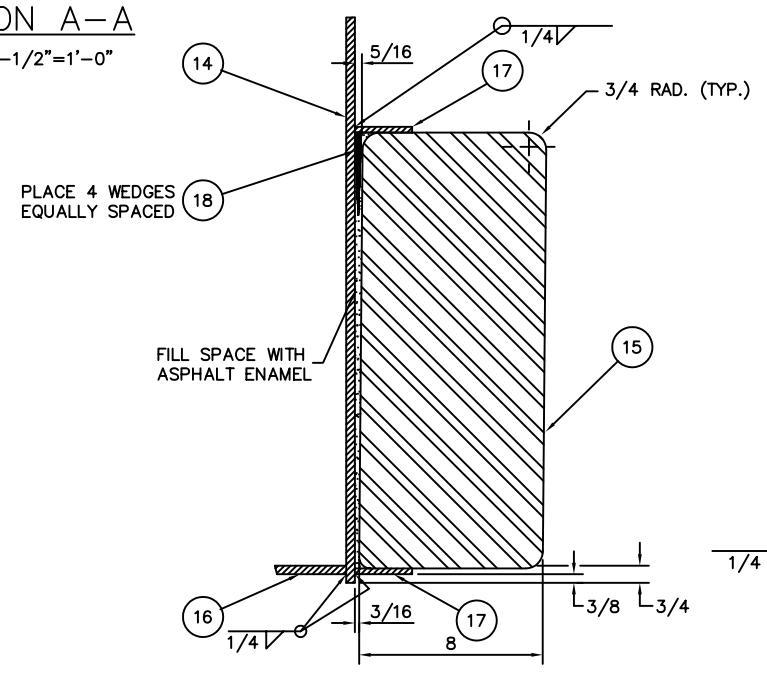
SECTION A-A
SCALE: 1-1/2"=1'-0"



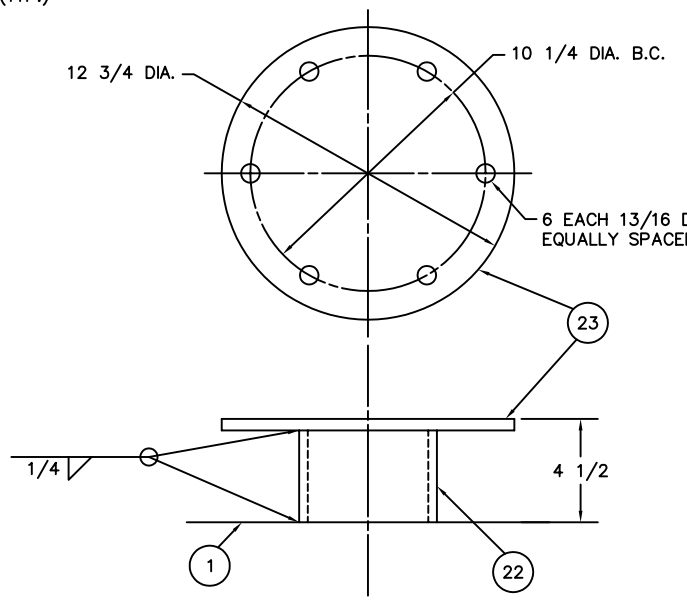
SECTION B-B
SCALE: 1-1/2"=1'-0"



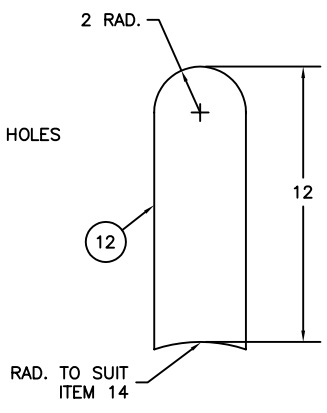
DETAIL C
SCALE: 3"=1'-0"



SECTION C-C
SCALE: 3"=1'-0"



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

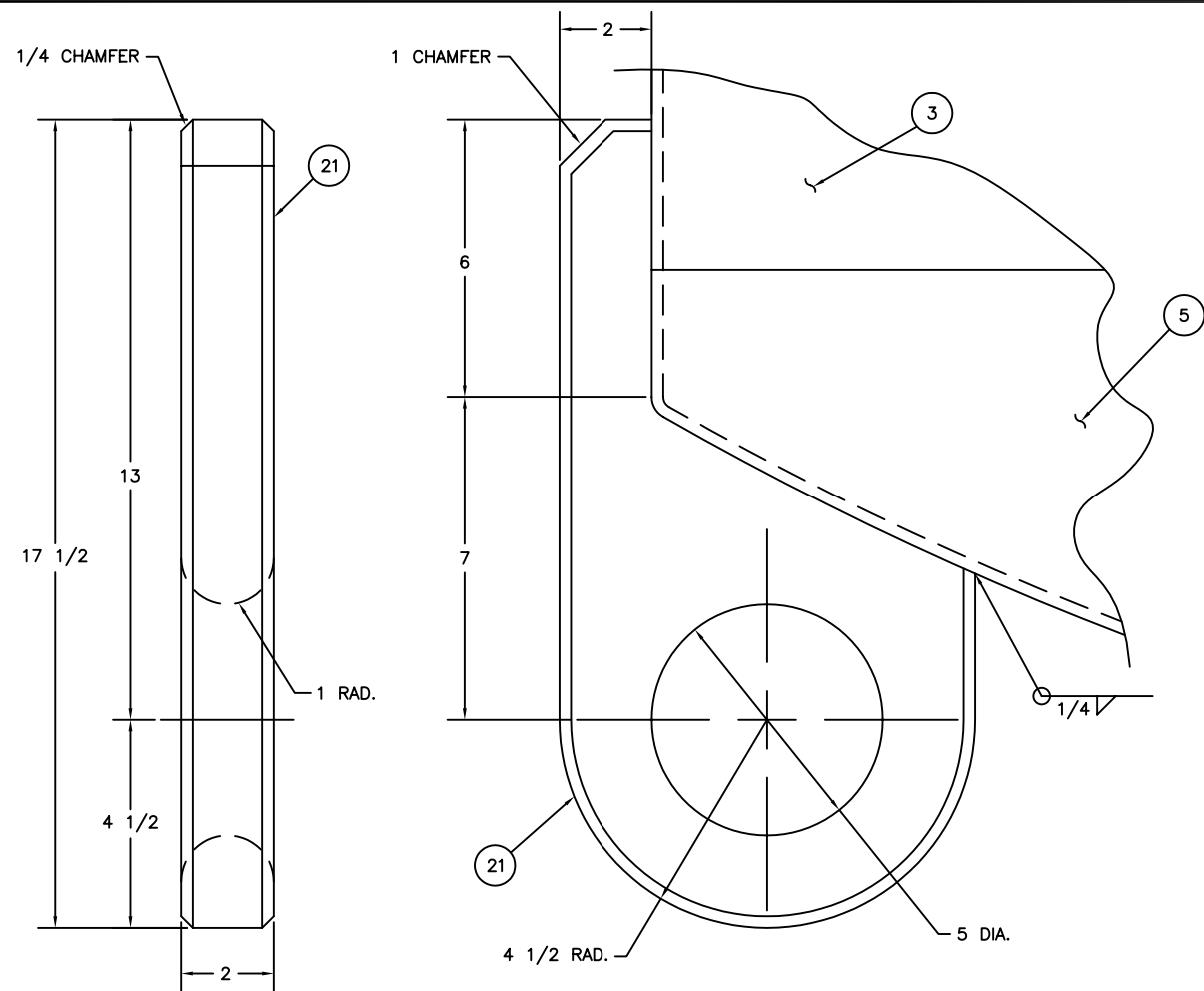


DETAIL E
SCALE: 3"=1'-0"

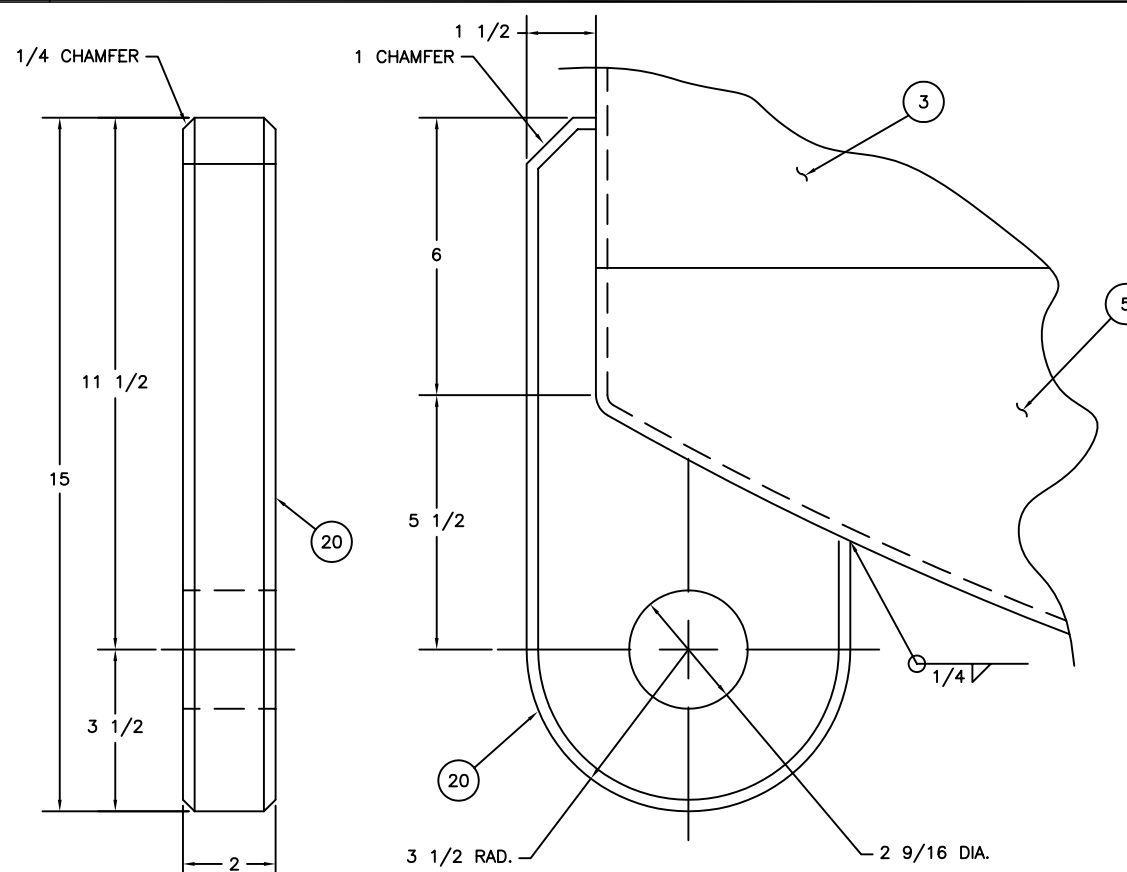
| REV. | DATE | APPR. | DESCRIPTION | BY |
|------|---------|-------|--|------|
| F | 6-4-99 | S.W. | ADDED ADDITIONAL AIR TEST FITTING (ITEMS 24 & 25). | S.M. |
| E | 5-11-99 | S.W. | MODIFIED DIMENSION IN DETAIL D. | S.M. |
| D | 10-1-97 | S.W. | REORG DWG. DEL TOWER DETAILS. REF DWG 121176 FOR TWR. DEL 2 EA ITES 27, 28, & 29. SHORTEN ITEM 26. | S.M. |
| C | 0-26-94 | S.W. | DEL ITEM 49. MOD ITEM 18 & 36. ADDED QTY FOR ITEM 59. | S.M. |
| B | 2-26-93 | CAK | REORGANIZED DWG. DELETED FROM BILL OF MATERIALS ITEMS 29-31, 55, & 61-71. MODIFIED ITEMS 3, 4, 12, 39, 48, 49, & 50. SPECIFIED NUMBER REQUIRED FOR ITEMS 43, 53, 56, & 57. ADDED NOTES | S.M. |
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| A | 9-15-92 | WD | MODIFIED BUOY TOWER AND DELETED ITEMS 52 & 58. | S.M. |

| | | |
|--------------|--|----------------|
| DESIGNED: | U.S. COAST GUARD HEADQUARTERS | |
| DRAWN: | S.M. | |
| TRACED: | S.M. | |
| CHECKED: | S.M. | |
| REVIEWED BY: | R. M. Trainer PROJECT ENGINEER | |
| REVIEWED BY: | S. D. Walker G-ECV-3B | |
| APPROVED: | R. J. Wells CHIEF, OCEAN ENGINEERING BRANCH | DATE 6/4/91 |

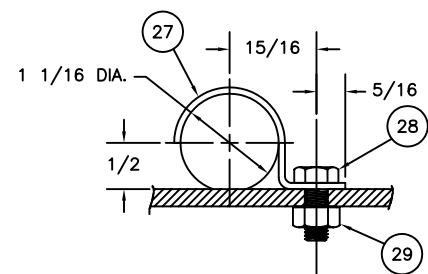
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|--|--|--------------------------|-----------|
| UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±30' | | DRAWING NUMBER 121152 | REV. F |
| SCALE: AS NOTED | | SHEET 2 OF 4 | |



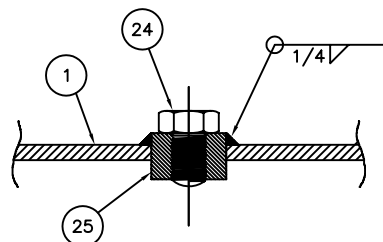
DETAIL F
SCALE: HALF



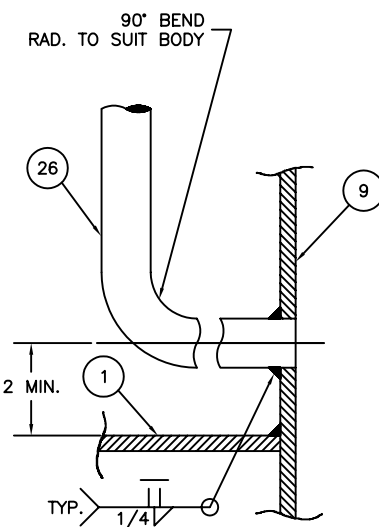
DETAIL G
SCALE: HALF



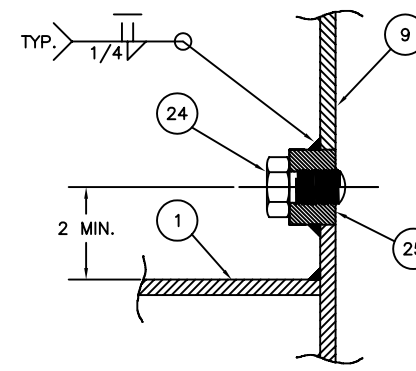
DETAIL H
SCALE: FULL



DETAIL J
SCALE: FULL



DETAIL K
SCALE: FULL



DETAIL M
SCALE: FULL

| REV. | DATE | APPR. | DESCRIPTION | BY |
|------|----------|-------|--|------|
| F | 6-4-99 | S.W. | ADDED ADDITIONAL AIR TEST FITTING (ITEMS 24 & 25). | S.M. |
| E | 5-11-99 | S.W. | MODIFIED DIMENSION IN DETAIL D. | S.M. |
| D | 10-1-97 | S.W. | REORG DWG. DEL TOWER DETAILS. REF DWG 121176 FOR TWR. DEL 2 EA ITES 27, 28, & 29. SHORTEN ITEM 26. | S.M. |
| C | 10-26-94 | S.W. | DEL ITEM 49. MOD ITEM 18 & 36. ADDED QTY FOR ITEM 59. | S.M. |
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| B | 2-26-93 | CAK | | S.M. |
| A | 9-15-92 | WD | MODIFIED BUOY TOWER AND DELETED ITEMS 52 & 58. | S.M. |

DESIGNED: U.S. COAST GUARD HEADQUARTERS
 DRAWN: S.M.
 TRACED:
 CHECKED: S.M.
 REVIEWED BY:
 R. M. Trainer
 PROJECT ENGINEER
 REVIEWED BY:
 S. D. Walker
 G-ECV-3B
 APPROVED: R. J. Wells
 CHIEF, OCEAN ENGINEERING BRANCH
 DATE: 6/4/91

| | | |
|---|--------------------------|-----------|
| UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. $\pm 1/8$ ANG. $\pm 30^\circ$ | DRAWING NUMBER 121152 | REV. F |
| SCALE: AS NOTED | SHEET 3 OF 4 | |

BILL OF MATERIALS

| ITEM NO. | NO. REQ. | DESCRIPTION | MATL. | REMARKS |
|----------|----------|----------------------------|--------------|---------------------------------|
| 1 | 1 | TOP HEAD | STEEL | 72 DIA. x 1/4 THK. |
| 2 | 5 | TOP HEAD STIFFNER | STEEL | 3 x 1/4 THK. |
| 3 | 1 | WRAPPER | STEEL | 72 DIA. x 1/4 THK. |
| 4 | 1 | WRAPPER STIFFENER | STEEL | 2-1/2 x 2-1/2 x 1/4 |
| 5 | 1 | BOTTOM HEAD | STEEL | 72 DIA. x 1/4 THK. |
| 6 | 1 | BOTTOM HEAD STIFFENER | STEEL | 10 x 1/4 THK. |
| 7 | 4 | POCKET BRACE | STEEL | 8 x 1/4 THK. |
| 8 | 2 | POCKET COVER ASSEMBLY | STEEL | SEE DRAWING 121104 |
| 9 | 2 | POCKET WRAPPER | STEEL | 1/4 THK. |
| 10 | 2 | POCKET BOTTOM PLATE | STEEL | 22 I.D. x 1/4 THK. |
| 11 | 1 | POCKET VENT PIPE | GAL STEEL | 2 SCH. 40 |
| 12 | 4 | DOUBLER PLATE | STEEL | 4 x 1/4 THK. x 12 LG. |
| 13 | 4 | GUSSET | STEEL | 9 x 9 x 1/4 THK. |
| 14 | 1 | COUNTERWEIGHT TUBE | STEEL | 12 SCH. 40 |
| 15 | 1 | COUNTERWEIGHT | CAST IRON | SEE NOTE 2 |
| 16 | 1 | COUNTERWEIGHT BOTTOM PLATE | STEEL | 1/2 THK. |
| 17 | 2 | COUNTERWEIGHT CLAMP RING | STEEL | 12 3/4 ID x 17 3/4 OD x 1/4 THK |
| 18 | 4 | WEDGE | STEEL | 1 WD. x 1/4 THK. x 2 1/2 LG. |
| 19 | 3 | TOP HEAD LIFT EYE | STEEL | SEE DRAWING 121140 |
| 20 | 2 | MOORING EYE | STEEL | 2 THK. |
| 21 | 1 | BOTTOM HEAD LIFT EYE | STEEL | 2 THK. |
| 22 | 1 | BELL STAND | STEEL | 6 SCH. 80 |
| 23 | 1 | BELL STAND PLATE | STEEL | 12-3/4 DIA. x 1/2 |
| 24 | 4 | PIPE PLUG | STAIN. STEEL | 3/4 NPT |
| 25 | 4 | HALF COUPLING | STAIN. STEEL | 3/4 NPT |
| 26 | 2 | VENT PIPE | STAIN. STEEL | 3/4 SCH 40 |
| 27 | 4 | VENT PIPE CLIP | STAIN. STEEL | 5/8 x 1/16 THK. |
| 28 | 4 | HEX HEAD CAP SCREW | STAIN. STEEL | 1/4-20UNC-5/8 LG. |
| 29 | 4 | HEX NUT | STAIN. STEEL | 1/4-20UNC |

NOTES:

- SEE LATEST REVISION OF U.S.C.G. CIVIL ENGINEERING SPECIFICATION No. 464 FOR FABRICATION REQUIREMENTS.
- THE TOTAL WEIGHT OF ITEM 15 SHALL BE 2,600 LBS. (+5% OR -1%).
- TYPE 304 STAINLESS STEEL MAY BE SUBSTITUTED FOR ITEM 11.

| | | | | |
|--|-----------------------------------|--|--|----------------|
| F | 6-4-99 | S.W. | ADDED ADDITIONAL AIR TEST FITTING (ITEMS 24 & 25). | S.M. |
| E | 5-11-99 | S.W. | MODIFIED DIMENSIONS IN DETAIL D. | S.M. |
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| B | 2-26-93 | CAK | | S.M. |
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| REV. | DATE | APPR. | DESCRIPTION | BY |
| DESIGNED: | U.S. COAST GUARD HEADQUARTERS | | | |
| DRAWN: | S.M. | | | |
| TRACED: | | | | |
| CHECKED: | S.M. | | | |
| REVIEWED BY: | | | | |
| 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. ±30' | | | DRAWING NUMBER 121152 | REV. F |
| SCALE: AS NOTED | | | SHEET 4 | OF 4 |