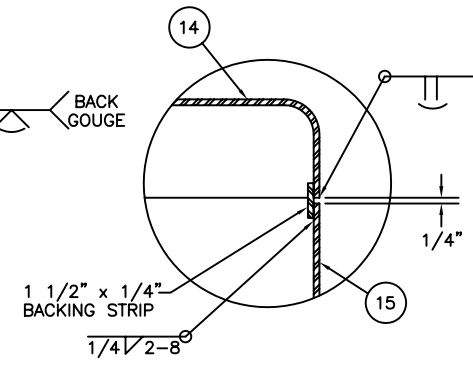
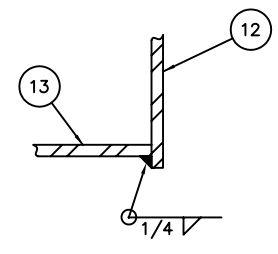


DETAIL A  
SCALE: NONE



DETAIL A  
SCALE: NONE  
OPTIONAL



DETAIL B  
SCALE: NONE

BILL OF MATERIALS

ITEM NO.	NO. REQ.	DESCRIPTION	MATL.	REMARKS
1	1	RADAR REFLECTOR	ALUM.	SEE NOTE 3
2				
3				
4				
5	1	RADAR REFLECTOR SUPPORT PL.	STAIN. STEEL	11-1/4 DIA. x 3/8 THK.
6	1	RADAR REF. SUPPORT STAND	STEEL	6 IPS PIPE SCH. 40
7	1	BATTERY POCKET COVER	STEEL	SEE DRAWING 121143
8				
9				
10				
11				
12	1	BATTERY POCKET WRAPPER	STEEL	1/4 THK.
13	1	BATTERY POCKET BOTTOM	STEEL	1/4 THK.
14	1	BUOY TOP HEAD	STEEL	3/16 THK.
15	1	BUOY BODY WRAPPER	STEEL	3/16 THK.
16	1	BUOY BOTTOM HEAD	STEEL	1/4 THK.
17	1	CTWT. TUBE (WELD. PIPE)	STEEL	30 DIA. SCH. 20 PIPE
18	1	COUNTERWEIGHT	STEEL	35 DIA. x 1-3/4 THK. SEE NOTE 2
19				
20	4	LIFTING EYE	STEEL	SEE DRAWING 121140
21	2	CHAFING STRIP	STEEL	3 X 1/4 THK.
22	2	MOORING ARM	STEEL	2-1/4 THK.
23	2	MOORING ARM PIN	STEEL	2 DIA. x 4 1/4 LG.
24	2	MOORING ARM RETAINER	STEEL	5 O.D. x 2 1/16 I.D. x 3/4 THK.

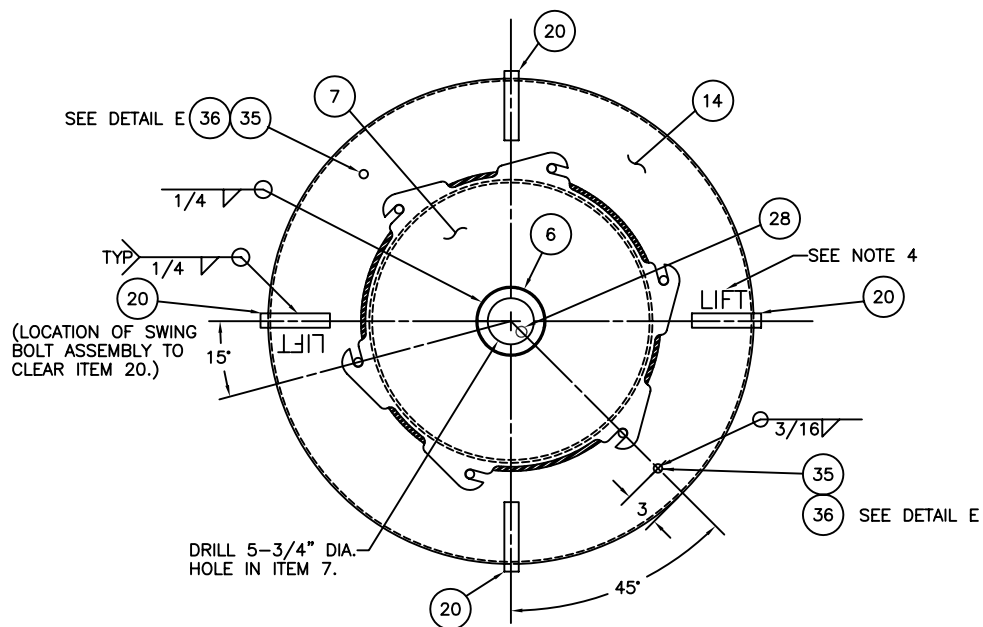
NOTES:

- SEE LATEST REVISION OF U.S.C.G. CIVIL ENGINEERING SPECIFICATION No. 464 FOR FABRICATION REQUIREMENTS.
- ITEM 18 SHALL WEIGH 477 LBS. (+5% OR -1%).
- FOR GREEN CAN (LCR) BUOYS, FABRICATE RADAR REFLECTOR AS SHOWN IN DRAWING 121024. FOR RED NUN (LNR) BUOYS, FABRICATE RADAR REFLECTORS AS SHOWN IN DRAWING 120316.
- WELD THE WORD "LIFT" NEXT TO THE LIFTING EYES (ITEM 20) DIRECTLY ABOVE THE MOORING ARMS. THE WELD BEAD CHARACTERS SHALL BE A MINIMUM OF 1-1/2" IN HEIGHT.

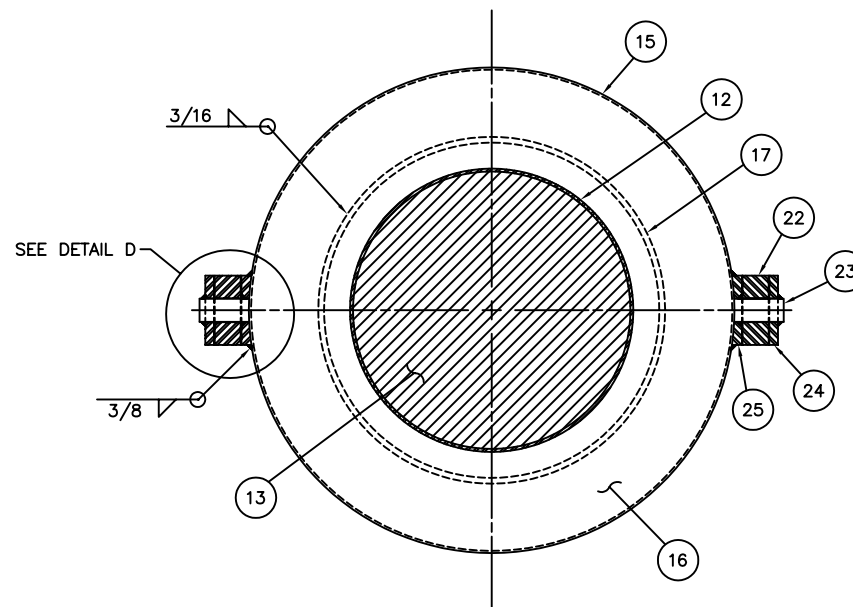
BILL OF MATERIALS

ITEM NO.	NO. REQ.	DESCRIPTION	MATL.	REMARKS
25	2	MOORING ARM DOUBLER PLATE	STEEL	6 O.D. x 2 1/16 I.D. x 5/8 THK.
26	2	VENT PIPE	STAIN. STEEL	3/4 IPS, SCH. 40
27	1	NIPPLE	STAIN. STEEL	3/4 SCH 40 x 8 LG.
28	1	NIPPLE	STAIN. STEEL	3/4 SCH 40 x 15 LG.
29	2	UNION	STAIN. STEEL	3/4 IPS, STD. WT.
30	1	ELBOW, 90°	STEEL	3/4 IPS STD. WT.
31	1	HOSE CLAMP	STAIN. STEEL	
32	1	NIPPLE	STEEL	3/4 SCH 40 x 7 1/2 LG.
33	1	VENT HOSE	NYLON	1 I.D.
34	1	RUBBER GROMMET	RUBBER	FOR 1 DIA. HOLE
35	3	HALF COUPLING	STAIN. STEEL	3/4 I.P.S.
36	2	PIPE PLUG	STAIN. STEEL	3/4 I.P.S.
37	1	STUFFING TUBE, STRAIGHT	NYLON	3/4 NPT, STD. WT.
38	4	BOLT, HEX HD.	STAIN. STEEL	3/4-10 UNC x 2 LG
39	4	NUT, HEX. HD. ELASTIC STOP	STAIN. STEEL	3/4-10 UNC
40	4	WASHERS	ALUM.	1/8 x 1 3/4 O.D. .812 I.D.
41				
42				
43				
44				
45				
46				
47				
48	2	CLIP, VENT PIPE	STAIN. STEEL	1/16 x 5/8 STRIP
49	2	CAP SCREW, HEX HD.	STAIN. STEEL	1/4-20 UNC x 1-3/4 LG.
50	2	NUT, HEX HD.	STAIN. STEEL	1/4-20 UNC
51				
52				
53				
54	1	GASKET	RUBBER	11-1/4 DIA. x 1/16 THK.
55	2	VENT LINE SUPPORT	ALUM.	2 x 1 x 1/8 C
56	1	STREET ELBOW	STEEL	3/4 IPS, STD. WT.

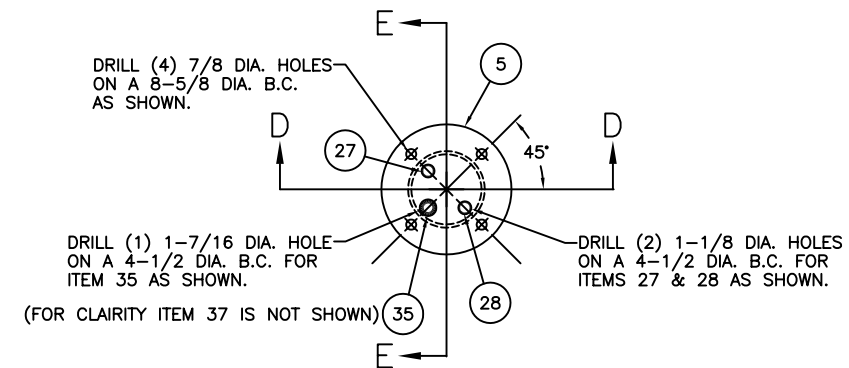
REV.	DATE	APPR.	DESCRIPTION	BY
D	6-4-99	S.W.	ADDED ADDITIONAL AIR TEST FITTING (ITEMS 35 & 36).	S.M.
C	6-6-95	SW	DEL 1" AIR HOLES IN ITEM 17. ADDED ADDITIONAL LIFT EYE (ITEM 20) AND NOTE 4.	S.M.
B	10-31-94	SW	MODIFIED ITEMS 35 & 36. ADDED 1" AIR HOLES IN ITEM 17. ADDED DETAIL E	S.M.
A	3-30-93	CAK	REORGANIZED DRAWING. DELETED ITEMS 2, 3, 8, 9, 11, & 19. MOD. ITEMS 13, 27, 28, & NOTES. ADDED ITEMS 55 & 56.	S.M.
DESIGNED:			U.S. COAST GUARD HEADQUARTERS	
DRAWN:			CIVIL ENGINEERING	
TRACED:			1992 TYPE	
CHECKED:			3-1/2x8 LR BUOY	
REVIEWED BY:				
R. M. Trainer PROJECT ENGINEER				
REVIEWED BY:				
S. D. Walker C-ECV-3B				
REVIEWED BY:				
APPROVED:			DATE	
S. E. Trenchard			5/20/92	
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ± 1/8 ANG. ± 30'			DRAWING NUMBER	
			121157	
			REV. D	
			SCALE: AS NOTED SHEET 1 OF 2	



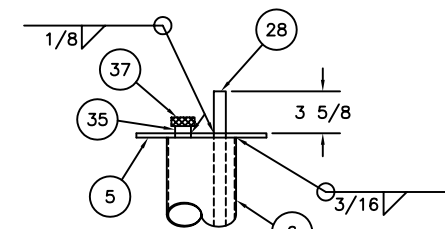
SECTION B-B  
 SCALE: 1-1/2"=1'-0"



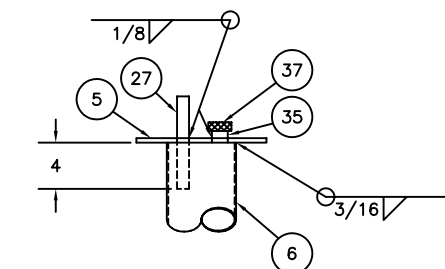
SECTION C-C  
 SCALE: 1-1/2"=1'-0"



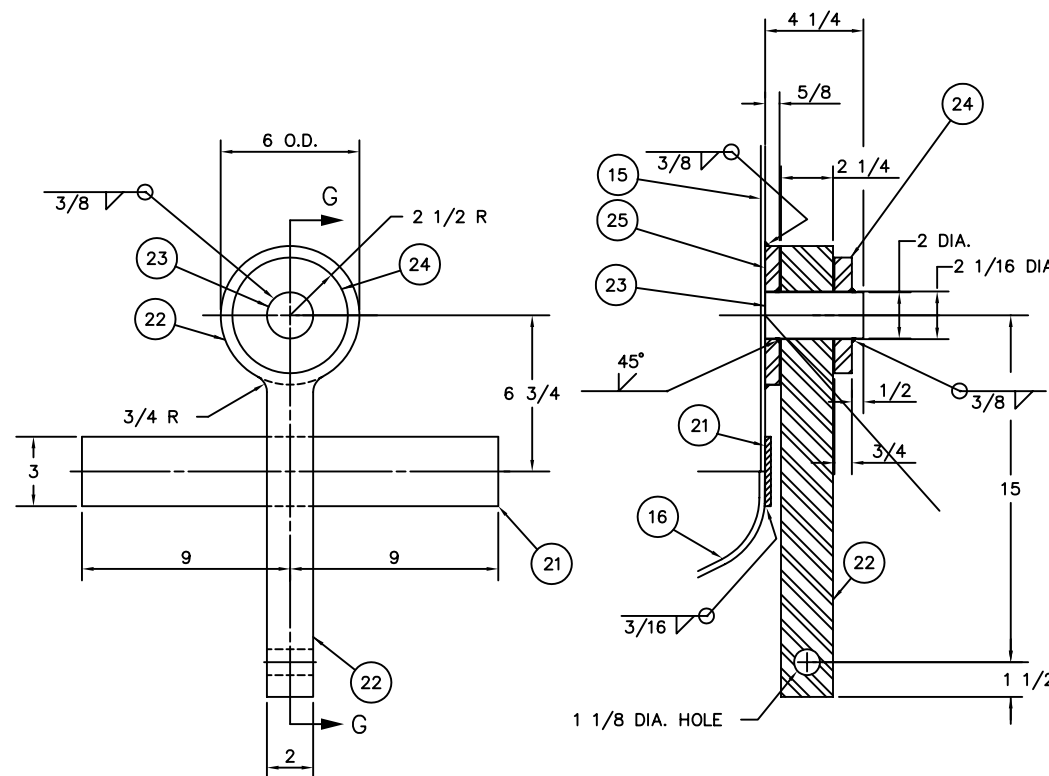
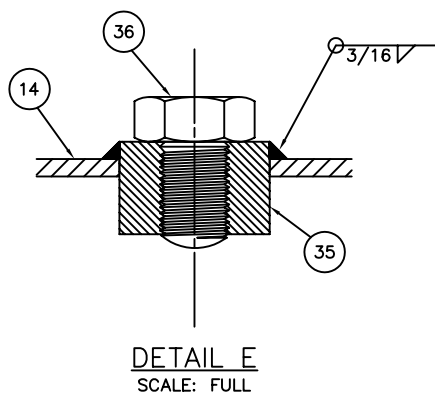
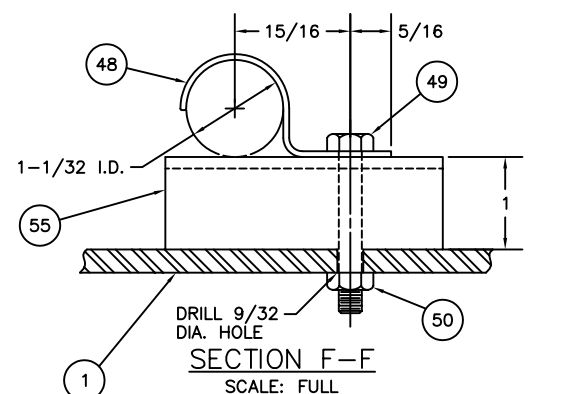
SECTION A-A  
 SCALE: 1-1/2"=1'-0"



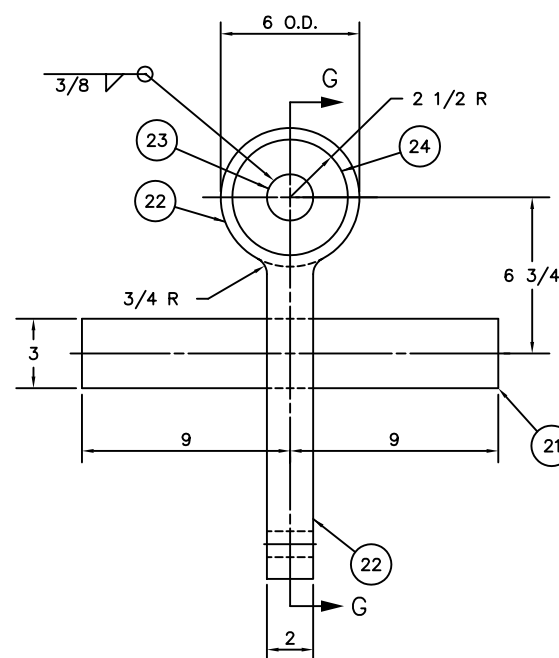
SECTION D-D  
 SCALE: 1-1/2"=1'-0"



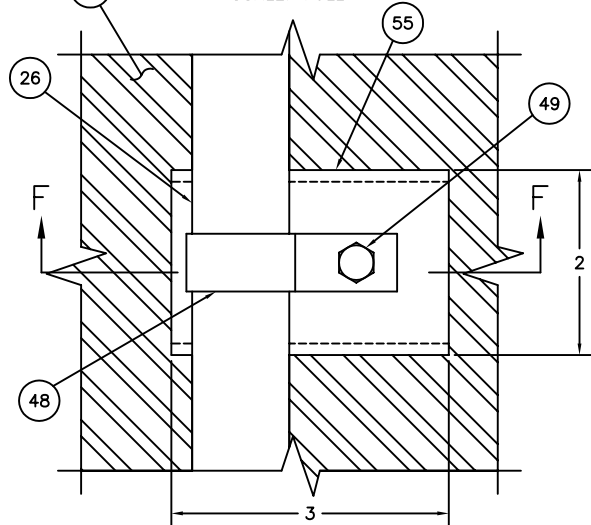
SECTION E-E  
 SCALE: 1-1/2"=1'-0"



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



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



DETAIL C  
 SCALE: FULL

REV.	DATE	APPR.	DESCRIPTION	BY
D	6-4-99	S.W.	ADDED ADDITIONAL AIR TEST FITTING (ITEMS 35 & 36).	S.M.
C	6-6-95	SW	DEL 1" AIR HOLES IN ITEM 17. ADDED ADDITIONAL LIFT EYE (ITEM 20) AND NOTE 4.	S.M.
B	10-31-94	SW	MODIFIED ITEMS 35 & 36. ADDED 1" AIR HOLES IN ITEM 17. ADDED DETAIL E.	S.M.
A	3-30-93	CAK	REORGANIZED DRAWING. DELETED ITEMS 2, 3, 8, 9, 11, & 19. MOD. ITEMS 13, 27, 28, & NOTES. ADDED ITEMS 55 & 56.	S.M.
DESIGNED:			U.S. COAST GUARD HEADQUARTERS	
DRAWN:			CIVIL ENGINEERING	
TRACED:			1992 TYPE	
CHECKED:			3-1/2x8 LR BUOY	
REVIEWED BY:				
R. M. Trainer PROJECT ENGINEER				
REVIEWED BY:				
S. D. Walker G-ECV-3B				
REVIEWED BY:				
APPROVED:			DATE	
S. E. Trenchard			5/20/92	
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ± 1/8 ANG. ± 30'			DRAWING NUMBER	
			121157	
			REV. D	
			SCALE: AS NOTED SHEET 2 OF 2	