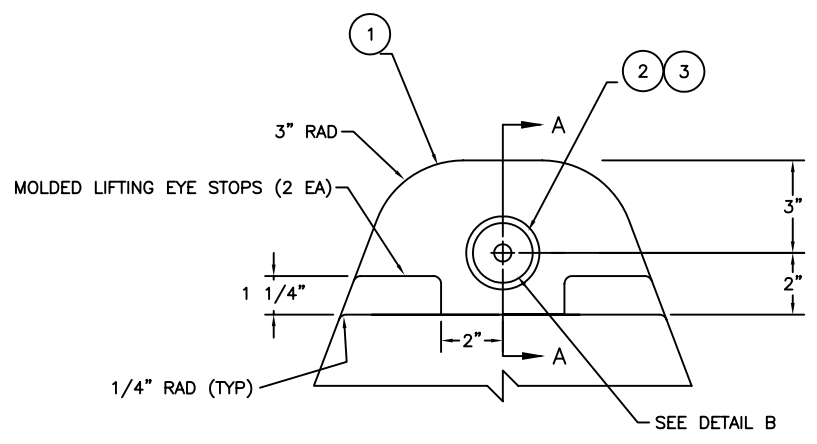
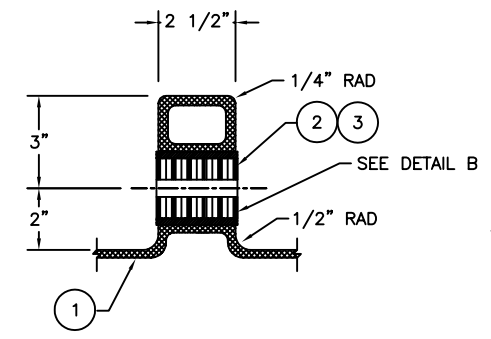


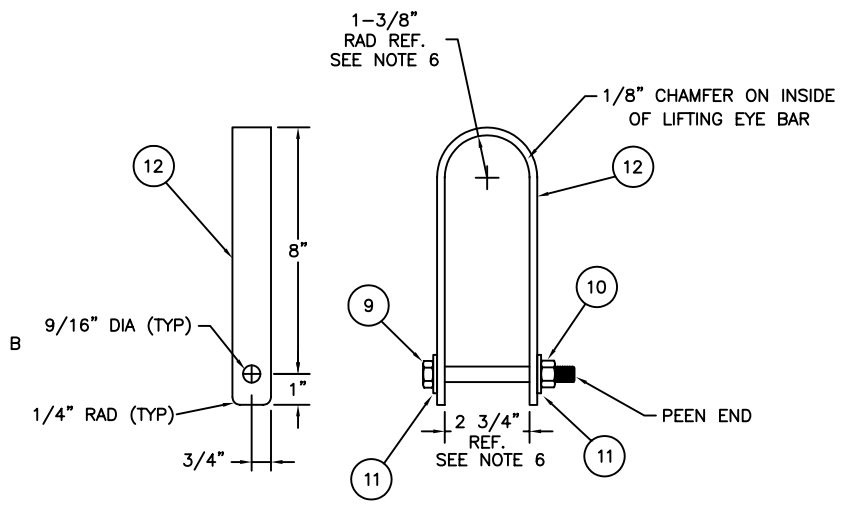
FRONT VIEW
SCALE: 2"=1'-0"



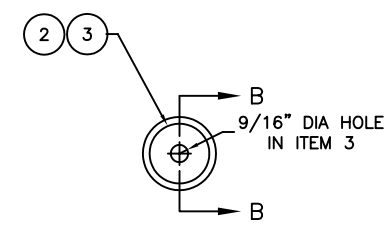
DETAIL A
SCALE: 4"=1'-0"



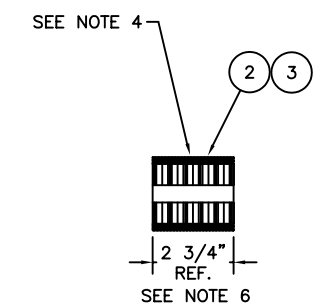
SECTION A-A
SCALE: 4"=1'-0"



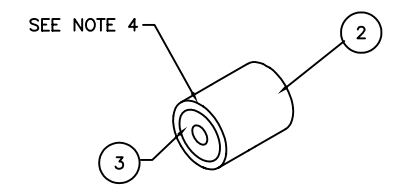
DETAIL C
SCALE: 4"=1'-0"



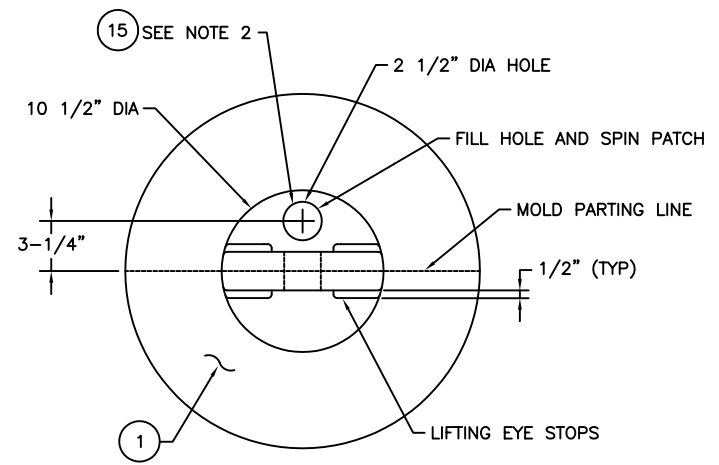
DETAIL B
SCALE: 4"=1'-0"



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



EYE SLEEVE AND BEARING INSERT
(ISOMETRIC VIEW)
SCALE: NONE

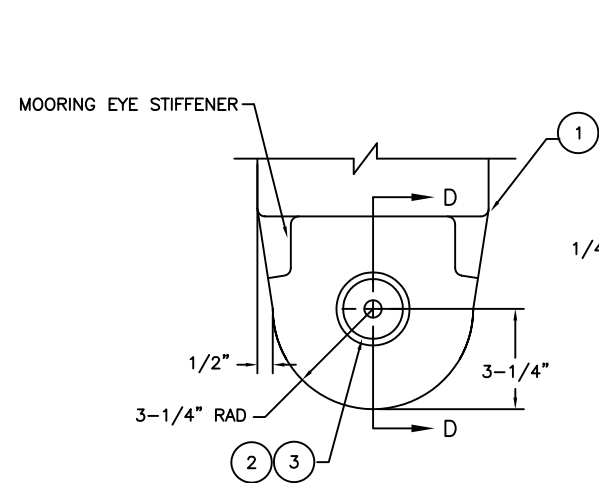


TOP VIEW
SCALE: 2"=1'-0"

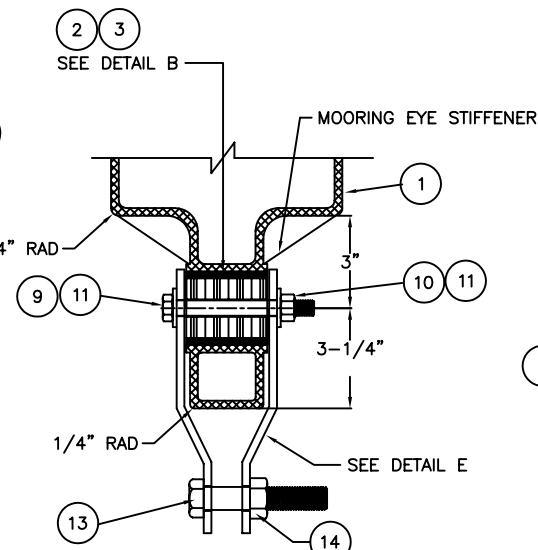
REV.	DATE	APPR.	DESCRIPTION	BY
G	4-30-03	W.D.	MODIFIED NOTE 4.	K.W.
F	2-26-03	W.D.	MODIFIED ITEM 18.	K.W.
E	9-17-01	W.D.	MODIFIED ITEMS 13 & 14.	K.W.
D	2-15-00	W.D.	MODIFIED ITEMS 13 & 14.	K.W.
C	2-23-99	S.W.	MOD ITEMS 7, 8, AND NOTES 4 & 6. ADDED NEW ITEMS 13 & 14.	D.W.
B	4-9-98	S.D.	ADDED ITEMS 15, 16, 17, 18, 19, AND NOTE 8.	S.M.
A	1-7-97	S.W.	MODIFIED MOORING EYE STIFFENER AND ITEMS 2, 5, AND 6. CHANGED NOTES 3, 4, 6, AND 7. DELETED ITEM 8.	C.B.

DESIGNED: C.B.	U.S. COAST GUARD	HEADQUARTERS
DRAWN: C.B.	CIVIL ENGINEERING	
TRACED: S.M.	5NPR	
CHECKED: S.M.	UNLIGHTED	
REVIEWED BY:	PLASTIC BUOY	
Corey Bonheim PROJECT ENGINEER	APPROVED: J. A. Rauch	DATE: 03/06/96
S. D. Walker G-SEC-2B	CHIEF, OFFICE OF CIVIL ENGINEERING	
L. E. Jaeger G-SEC-2		

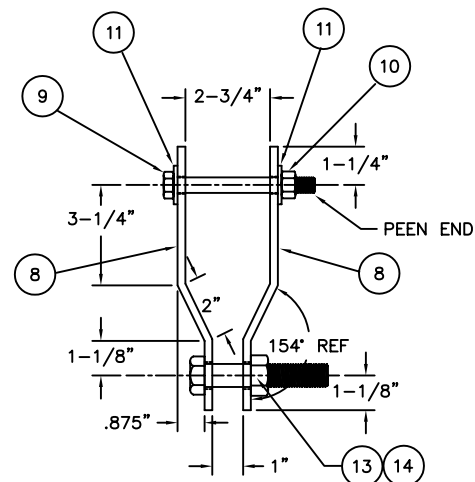
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. MOLD ±1/8; METAL ±1/16 ANG. ±1" (SEE NOTE 5)	DRAWING NUMBER 121173	REV. G
SCALE: AS NOTED	SHEET 1 OF 2	



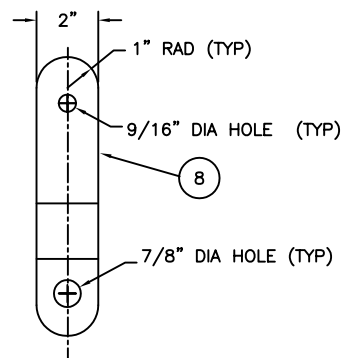
DETAIL D
SCALE: 4"=1'-0"



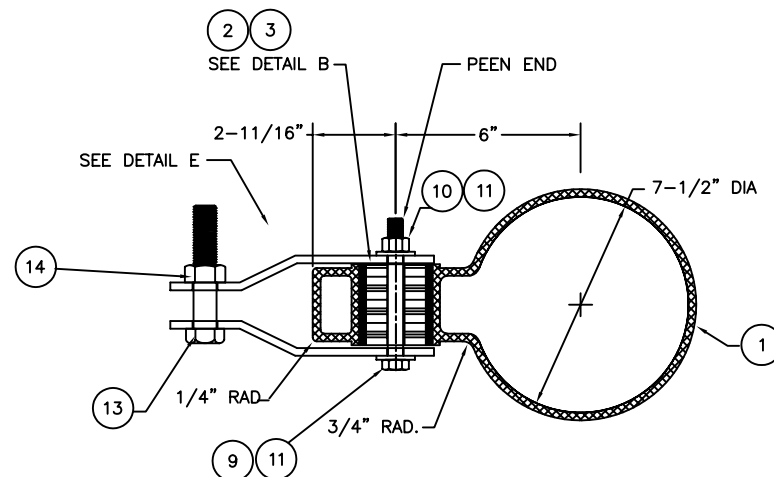
SECTION D-D
SCALE: 4"=1'-0"



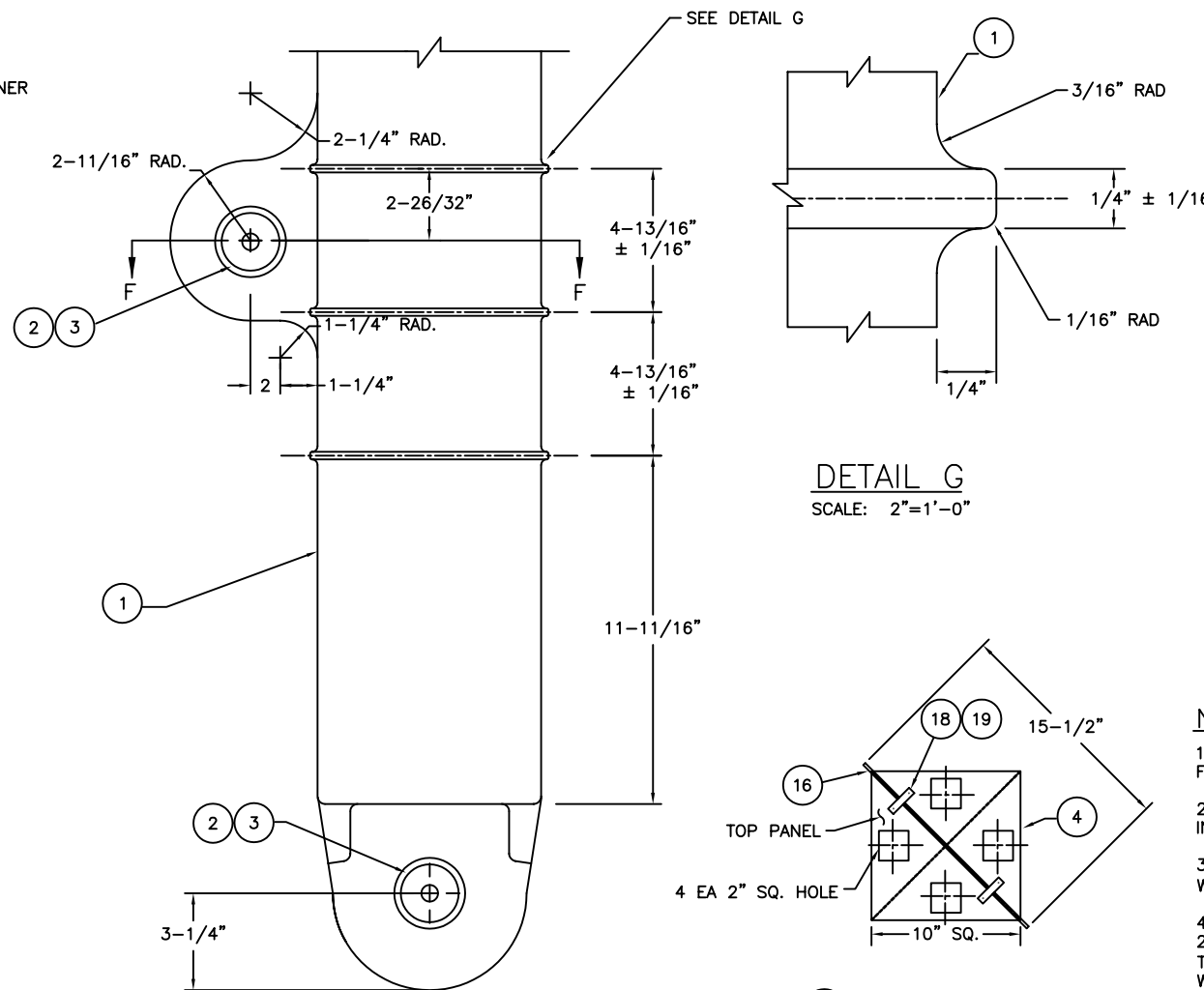
DETAIL E
SCALE: 4"=1'-0"



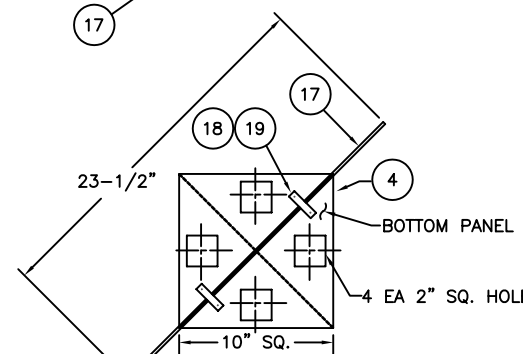
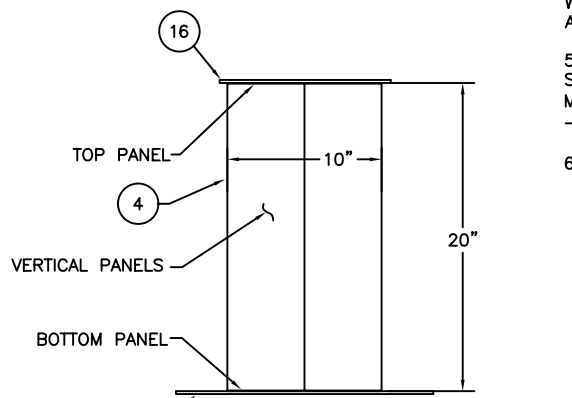
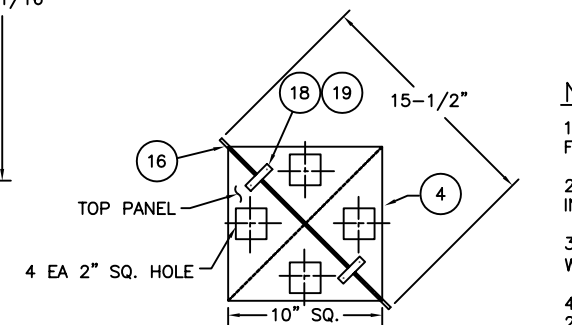
DETAIL F
SCALE: 4"=1'-0"



SECTION F-F
SCALE: 4"=1'-0"



DETAIL G
SCALE: 2"=1'-0"



DETAIL J
SCALE: 2"=1'-0"

BILL OF MATERIALS

ITEM NO.	NO. REQ.	DESCRIPTION	MATL.	REMARKS
1	1	BUOY SHELL	POLY-ETHYLENE	AS DESCRIBED IN THE SPECIFICATION
2	3	EYE SLEEVE	STAIN. STEEL	2 IN. SCHEDULE 80 PIPE, SEE NOTE 4
3	3	EYE BEARING INSERT	POLY-ETHYLENE	SEE NOTE 4
4	1	RADAR REFLECTOR	ALUM. SHEET	MIN. THICKNESS=.028 MAX. THICKNESS=.0625
5	1	FOAM	POLY-URETHANE	2.0 ± 0.5 PCF
6	1	COUNTERWEIGHT	STEEL SHOT	50 LBS
7	1	COUNTERWEIGHT ADHESIVE	POLY-URETHANE	TWO-COMPONENT CASTING RESIN
8	4	MOORING EYE BAR	STAIN. STEEL	8-3/4 LNG x 2 WIDE x 1/4 THK
9	3	HEX HEAD BOLT	STAIN. STEEL	1/2-13UNC 4-1/2 LONG
10	3	HEX NUT	STAIN. STEEL	1/2-13UNC NYLOC
11	6	WASHER	STAIN. STEEL	1/2 NOM.
12	1	LIFTING EYE BAR	STAIN. STEEL	1-1/2 WIDE x 1/4 THK.
13	2	HEX HEAD BOLT	STAIN. STEEL	3/4-10UNC 4 LONG
14	2	HEX NUT	STAIN. STEEL	3/4-10UNC NYLOC
15	1	SPIN PATCH	POLY-ETHYLENE	3-1/2 DIA.
16	1	TOP MOUNTING ROD	ALUM.	3/16 DIA. x 15-1/2 LONG
17	1	BOTTOM MOUNTING ROD	ALUM.	3/16 DIA. x 23-1/2 LONG
18	4	ATTACHMENT STRAPS	ALUM.	1/2 x 2 x 0.032 THK. (MIN.)
19	8	RIVETS	ALUM.	1/8 x 1/4
20	3	RETROREFLECTIVE MATERIAL	-	6 x 6 SEE NOTE 6

NOTES:

- SEE LATEST REVISION OF U.S.C.G. CIVIL ENGINEERING SPECIFICATION No. 491 FOR FABRICATION REQUIREMENTS.
- FILL HOLE SHALL BE SPIN PATCHED PER SPECIFICATION 491 AFTER INSERTION OF THE COUNTERWEIGHT, COUNTERWEIGHT ADHESIVE, AND FOAM.
- DIMENSIONS FOR ITEM 6 ARE FOR REFERENCE PURPOSES ONLY. THE TOTAL WEIGHT OF ITEM 6 SHALL BE 50 LBS (± 5%).
- THE OUTER DIAMETER OF ITEM 3 SHALL BE SIZED TO FIT SNUG WITHIN ITEM 2. THE LENGTH OF ITEMS 2 AND 3 SHALL BE ADJUSTED TO ENSURE THAT THEY ARE FLUSH OR NO GREATER THAN 1/8" LONGER ON EACH SIDE THAN THE WIDTH OF THE MOLDED PLASTIC EYE. THE BEND RADIUS OF ITEM 12 SHALL BE ADJUSTED TO FIT THE LENGTH OF ITEMS 2 AND 3 WHERE APPLICABLE.
- TOLERANCES SHOWN ARE FOR MOLD AND STEEL DIMENSIONS ONLY. SHRINKAGE OF THE MOLDED BUOY SHALL NOT BE GREATER THAN 3% OF ANY MOLD DIMENSION. THE THICKNESS OF THE PLASTIC SHALL BE 1/4" +1/4" OR -1/16".
- INSTALL ITEM 20 120' APART, 6" FROM THE TOP OF THE BUOY.

REV.	DATE	APPR.	DESCRIPTION	BY
G	4-30-03	W.D.	MODIFIED NOTE 4.	K.W.
F	2-26-03	W.D.	MODIFIED ITEM 18.	K.W.
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DESIGNED: C.B.	U.S. COAST GUARD	HEADQUARTERS
DRAWN: C.B.	CIVIL ENGINEERING	
TRACED: S.M.	5NPR	
CHECKED: S.M.	UNLIGHTED	
REVIEWED BY:	PLASTIC BUOY	
Corey Bonheim PROJECT ENGINEER		
REVIEWED BY:		
S. D. Walker G-SEC-2B	APPROVED:	DATE
REVIEWED BY:	L. E. Jaeger	03/06/96
	CHIEF, OFFICE OF CIVIL ENGINEERING	

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. MOLD ±1/8; METAL ±1/16 ANG. ±1' (SEE NOTE 5)	DRAWING NUMBER 121173	REV. G
SCALE: AS NOTED	SHEET 2 OF 2	