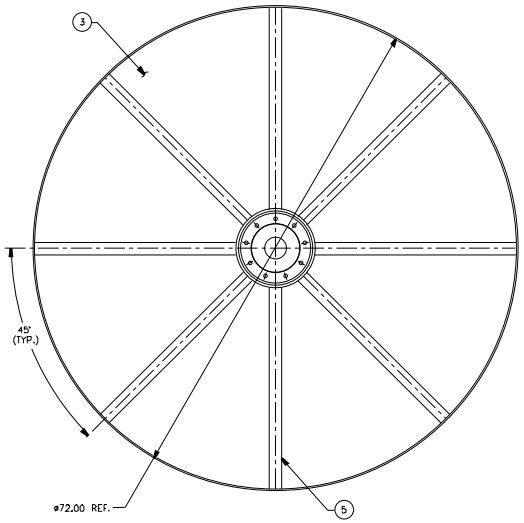
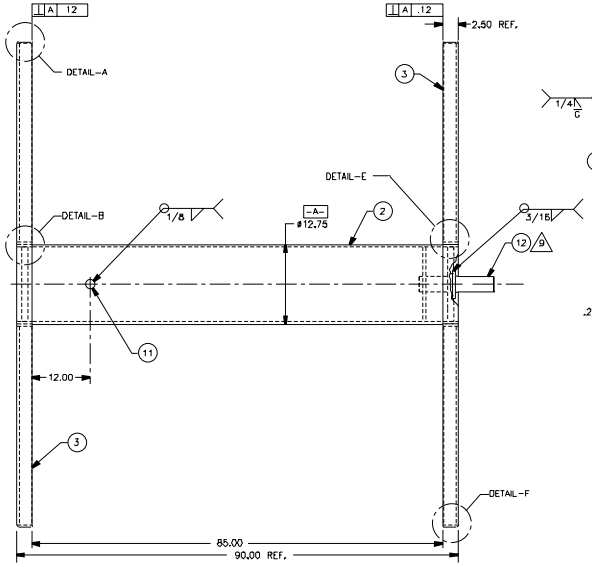
NOTES.

1. INTERPRET DRAWING PER MIL-STD-100E.
2. UNLESS OTHERWISE SPECIFIED.
   A. BREAK ALL SHARP EDGES: .005-.015R.
   B. GRIND ALL FLAME OR SAW CUT EDGES SMOOTH.
   C. MACHINE SURFACE FINISH 125 √
3. MATERIALS: ALL MATERIALS SHALL BE OF NEW MANUFACTURE. PIPE SHALL BE 12.00 NOM., STD. WT., SEAMLESS PER MIL-P-25995. MILL TEST CERTIFICATES REQUIRED FOR ALL MATERIALS INCLUDING WELDING FILLER METAL.
4. (C) REMOVE ALL CHIPS BEFORE INSTALLING INSERTS. INSTALL .75-1.50 PITCH BELOW SURFACE. BREAK OFF TANGS
5. WELDING: INERT GAS SHIELDED TUNGSTEN ARC PROCESS IN ACCORDANCE WITH MIL-W-22248A, CLASS 3, USING ER4043 FILLER METAL PER MIL-E-16053, TYPE 4043. SUBSEQUENT HEAT TREATMENT REQUIREMENTS NOT APPLICABLE.
6. CLEAN AND DEGREASE. MASK BOLTING SURFACES AND FINISH PER THE PROVISIONS OF OSI-SPEC-1000A. DO NOT PAINT INSIDE SURFACES OF FLANGES OR DRUM.
7. MAY BE HALVED
8. INERT GAS METAL ARC WELDING MAY BE USED IN LIEU OF TUNGSTEN ARC PROCESS BY PRIOR WRITTEN PERMISSION ONLY FROM DESIGN ACTIVITY.
9. PROTECT SHAFT SURFACES FROM WELDING SPLATTER DURING FABRICATION AND ASSEMBLY PROCESSES
10. FINISH SPEC. NOT APPLICABLE FOR CONTRACT DTCG23-92-C-EC1069
11. ADD FLANGE PLATE ON STUB SHAFT END ONLY.

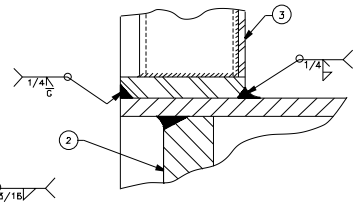
PARTS LIST

QTY REQD	CAGE CODE	SYM	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION	ZONE	ITEM NO.
			-1	REEL ASSY.			1
1			-2	CORE ASSY.			2
1			-3	FLANGE ASSY.			3
3			-4	FLANGE PL...12 NOM.THK.ø77 1/2" 6061-T6511	QQ-A-250/11		4
16			-5	RIB,ALUM. SQ.STRL.TBG.2"x2"x1/8" x 32"L. 6061-T6511	QQ-A-200/8		5
1			-6	CORE, ø12" STD. WT. SMLS. PIPE 6061-T6511	MIL-P-25995		6
2			-7	STIFFENER FB .375 NOM THK. x 2 1/2" 6061-T6511	QQ-A-200/8		7
2			-8	RIM, FB .25 NOM. THK. x 2 1/2" 6061-T6511	QQ-A-200/8		8
2			-9	DISC. PL. 1" NOM. THK. ø12" 6061-T651	QQ-A-250/11		9
9			-10	INSERT, HLCL., HELICOIL 1191-9CN-DB44	MS124701		10
1			-11	BUTTON,RND.BAR STK.ø1.50 NOM. x 1.50 L. 6061-T6	QQ-A-200/8		11
1			172314-1	STUB SHAFT			12

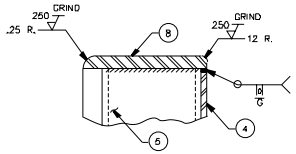




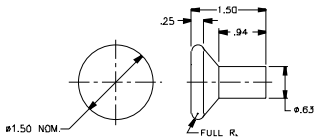
② REEL ASSY.



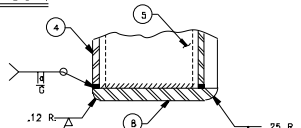
DETAIL-B
SCALE FULL



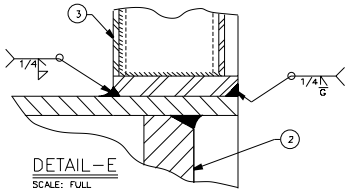
DETAIL-A
SCALE: FULL



⑪ BUTTON
SCALE: FULL



DETAIL-F
SCALE. FULL



DETAIL-E
SCALE: FULL

REV	DATE	APPR.	DESCRIPTION	BY
0	5/98	RD	ADDED DETAIL "E" AND "F"	DMB

CONTRACT NUMBER DTCG23-92-C-E-C1069

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES.
TOLERANCES FRACTIONS ±1/32 DECIMALS ±.01 ±.006 ANGLES ±1°

DICHROMA, INCORPORATED
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(703) 921-1440

CONSULTANTS

U. S. COAST GUARD
CIVIL ENGINEERING
WASHINGTON, DC

USCG. COMDT G-SEC-2
2100 2ND STREET SW
WASHINGTON, DC 20593-0001

MARK	DATE	DESCRIPTION
01	06/01/01	LV

A/E PROJECT NO: 236
CAD FILE NAME: 21725FSR0301001
DESIGNED BY: RMS
DRAWN BY: JGD
EDITED BY
CHECKED BY: RMS

SCALE: 1-1/2" = 1" PLOT SCALE:

SHEET TITLE
G-SEC-2C
WASHINGTON DC

FAST SWEEP REEL ASSY.

REVIEWED BY | REVIEWED BY | REVIEWED BY:
PROJECT ENG. | BRANCH CHIEF | G-SEC-2
CHIEF, CIVIL ENG | DATE

PROJECT NUMBER 98- | DRAWING NUMBER 1725FSR0301
DISCIPLINE/SHF NO | SHEET 1 OF 2