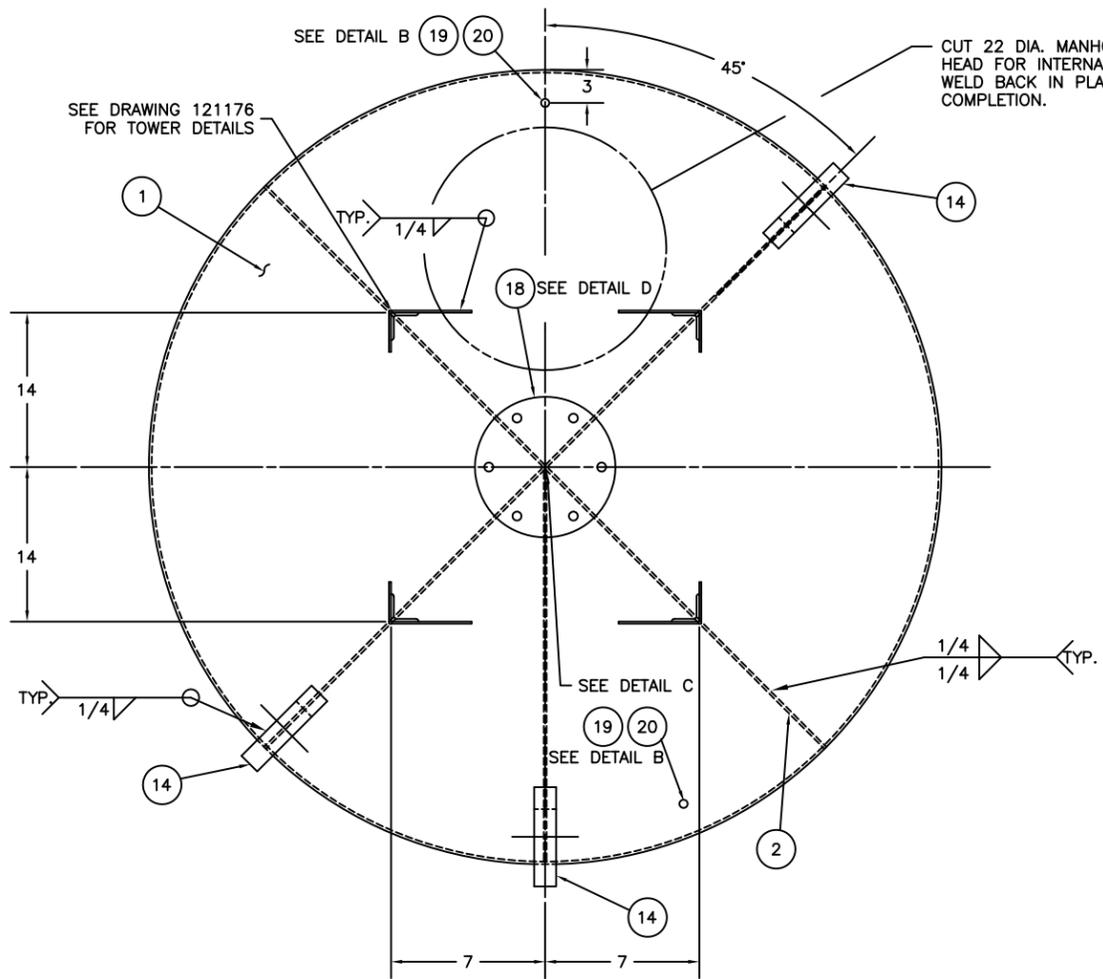


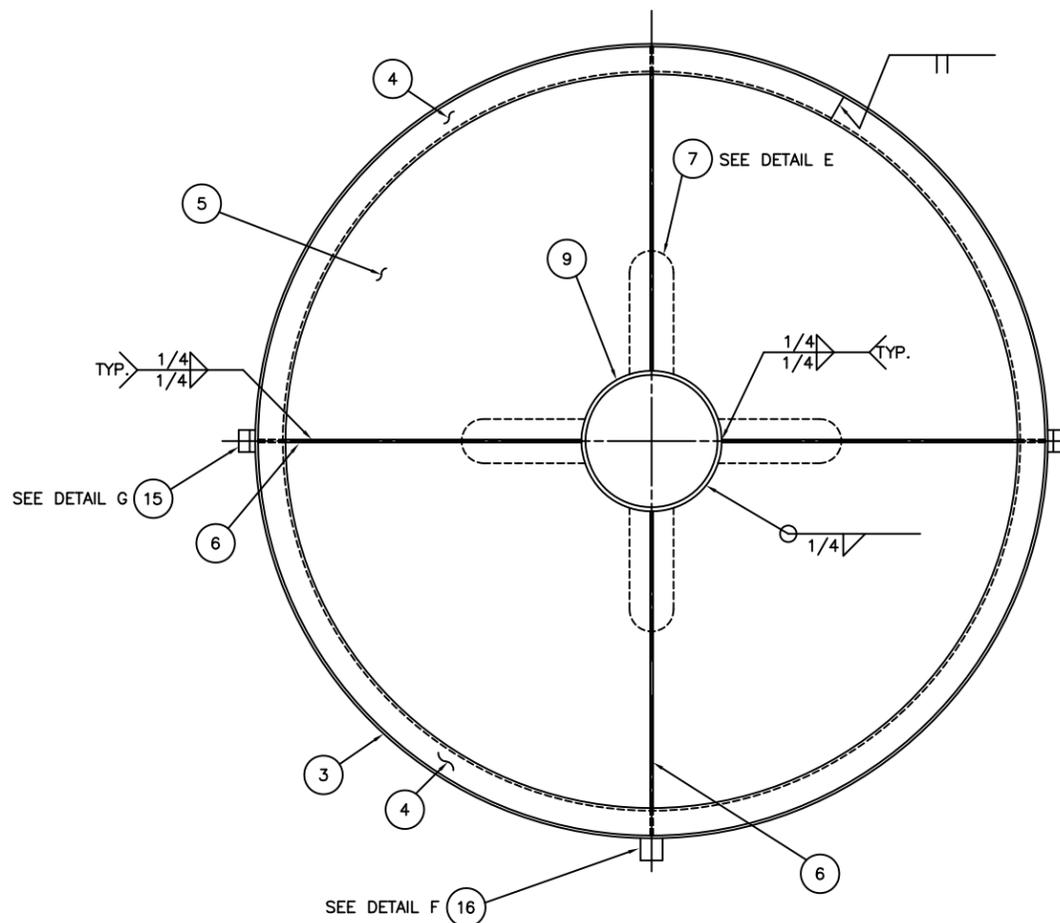
6x20LR BUOY ASSEMBLY

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

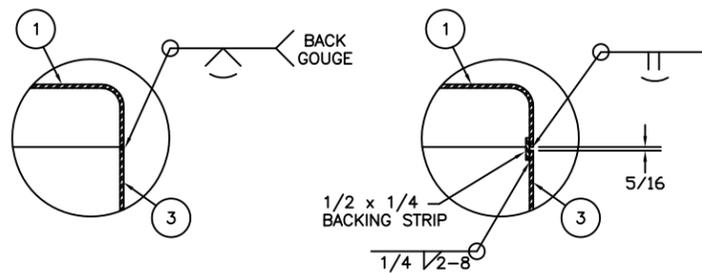
REV.	DATE	APPR.	DESCRIPTION	BY
DESIGNED:			U.S. COAST GUARD	HEADQUARTERS
DRAWN:	S.M.		CIVIL ENGINEERING	
TRACED:			2010 TYPE	
CHECKED:	S.M.		6x20LR BUOY	
REVIEWED BY:				
Sean McEvoy				
PROJECT ENGINEER				
REVIEWED BY:				
Wayne Danzik				
CG-432B				
REVIEWED BY:				
Stan Walker			Stan Walker /for	03/11/10
CG-432			CHIEF, CG-43	
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±1°			DRAWING NUMBER	REV.
			121192	
SCALE: AS NOTED			SHEET 1	OF 4



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

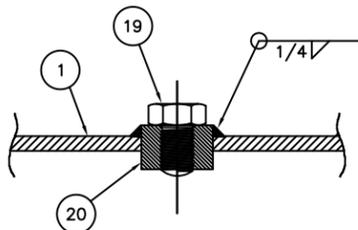


SECTION B-B
SCALE: 1-1/2"=1'-0"

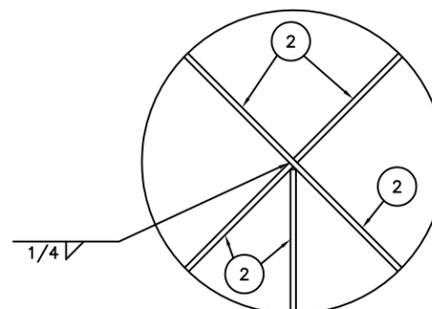


DETAIL A
SCALE: NONE

DETAIL A
SCALE: NONE
OPTIONAL

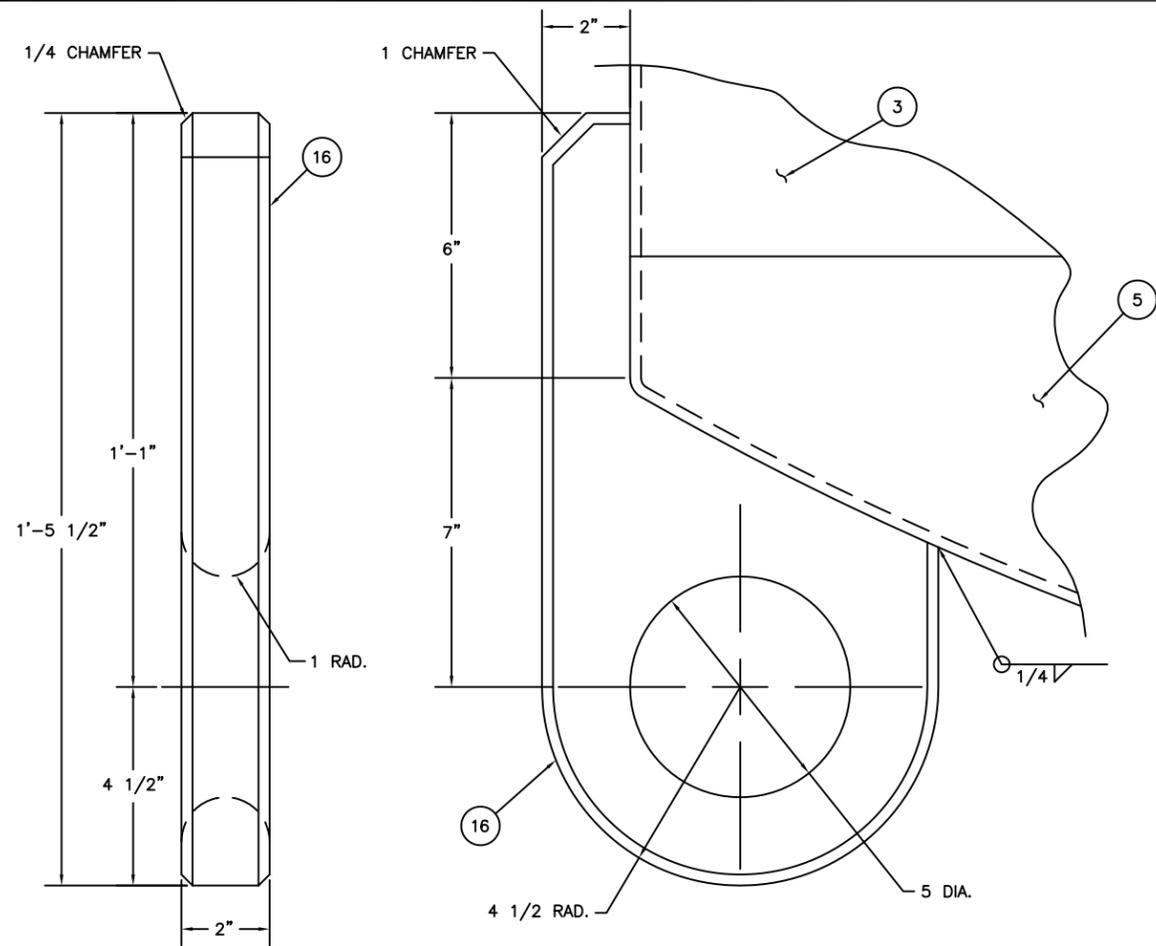


DETAIL B
SCALE NONE

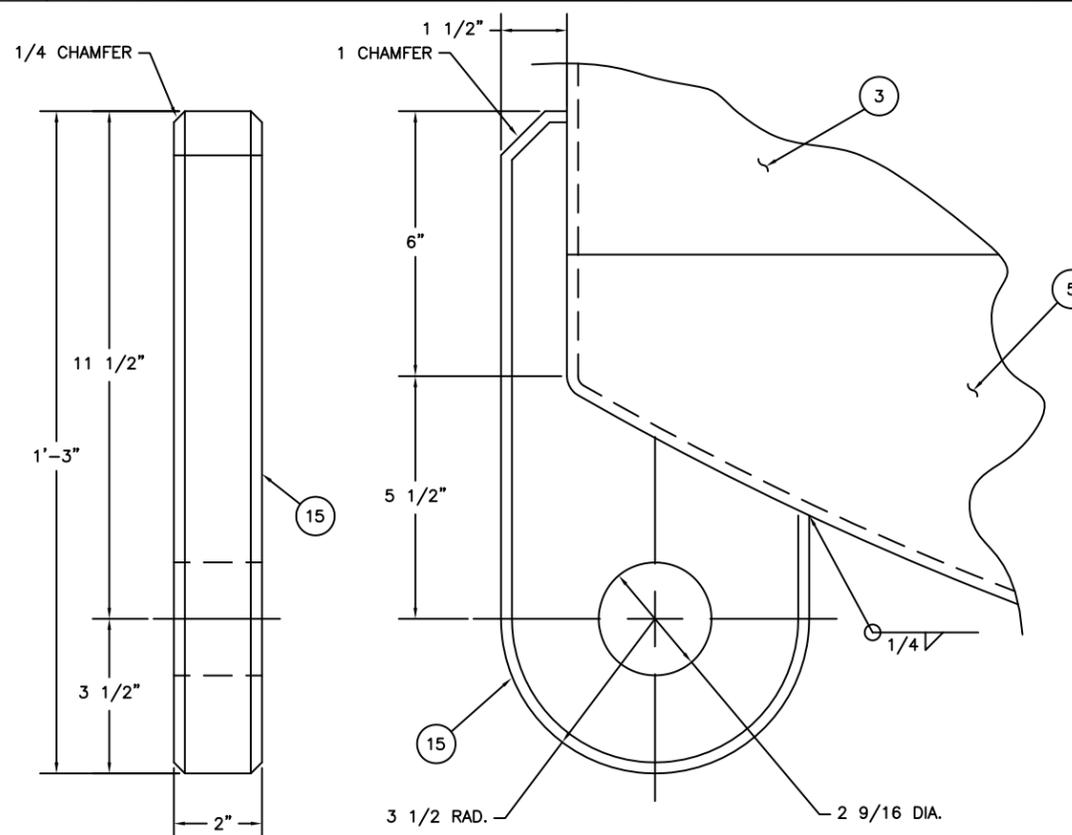


DETAIL C
SCALE: NONE

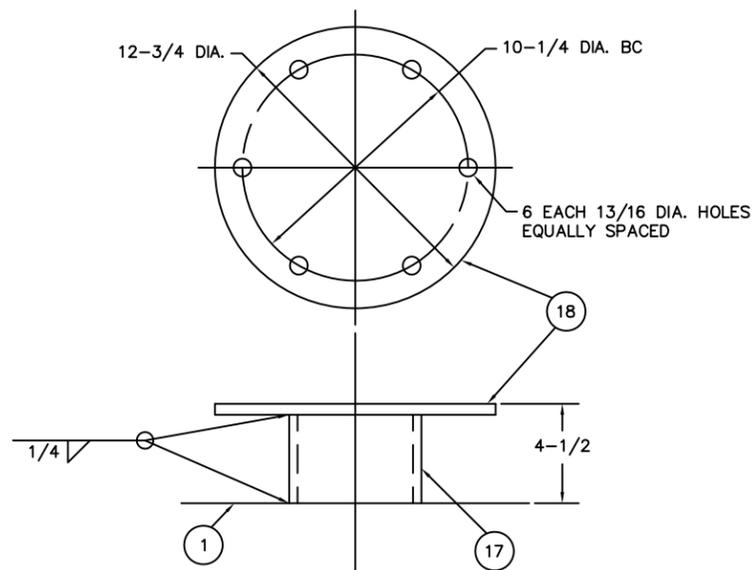
REV.	DATE	APPR.	DESCRIPTION	BY
DESIGNED:			U.S. COAST GUARD	HEADQUARTERS
DRAWN:	S.M.		CIVIL ENGINEERING	
TRACED:			2010 TYPE	
CHECKED:	S.M.		6x20LR BUOY	
REVIEWED BY:				
Sean McEvoy				
PROJECT ENGINEER				
REVIEWED BY:				
Wayne Danzik				
CG-432B				
REVIEWED BY:				
Stan Walker			Stan Walker /for	DATE 03/11/10
CG-432			CHIEF, CG-43	
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±1°			DRAWING NUMBER	REV.
			121192	
SCALE: AS NOTED			SHEET 2	OF 4



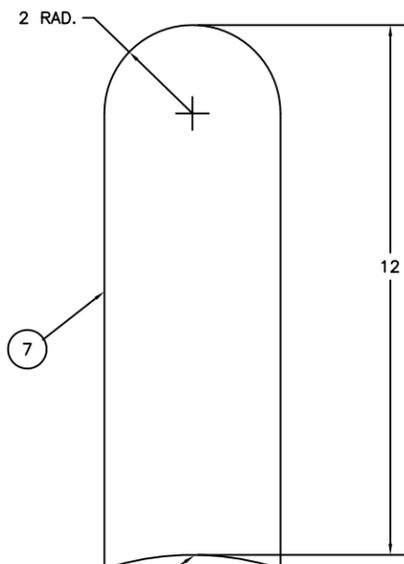
DETAIL F
SCALE: HALF



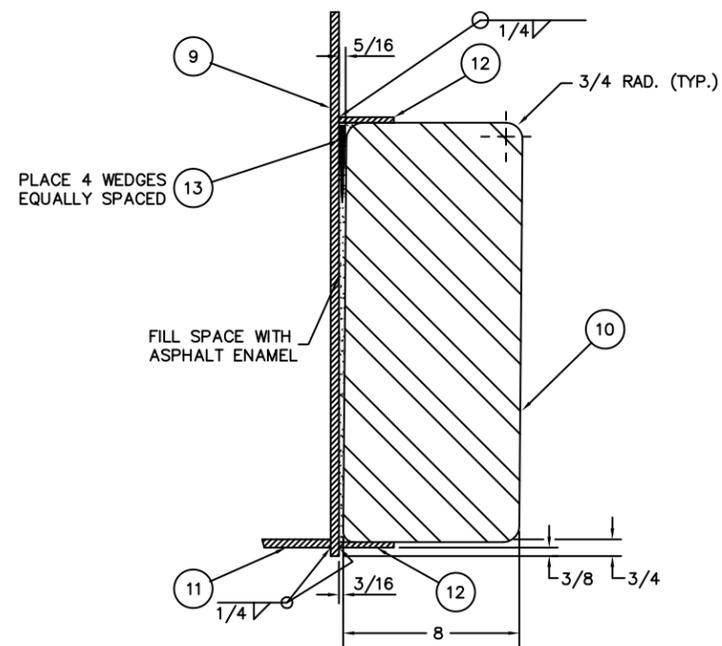
DETAIL G
SCALE: HALF



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



DETAIL E
SCALE: HALF



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

REV.	DATE	APPR.	DESCRIPTION	BY
DESIGNED:			U.S. COAST GUARD	HEADQUARTERS
DRAWN:	S.M.		CIVIL ENGINEERING	
TRACED:			2010 TYPE	
CHECKED:	S.M.		6x20LR BUOY	
REVIEWED BY:				
Sean McEvoy				
PROJECT ENGINEER				
REVIEWED BY:				
Wayne Danzik				
CG-432B				
REVIEWED BY:				
Stan Walker				
CG-432				
APPROVED:			Stan Walker /for	DATE 03/11/10
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±1°			DRAWING NUMBER 121192	REV.
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	2	BOTTOM HEAD STIFFENER	STEEL	10 x 1/4 THK.
7	4	DOUBLER PLATE	STEEL	4 x 1/4 THK. x 12 LG.
8	4	GUSSET	STEEL	9 x 9 x 1/4 THK.
9	1	COUNTERWEIGHT TUBE	STEEL	12 SCH. 40
10	1	COUNTERWEIGHT	CAST IRON	SEE NOTE 2
11	1	COUNTERWEIGHT BOTTOM PLATE	STEEL	1/2 THK.
12	2	COUNTERWEIGHT CLAMP RING	STEEL	12 3/4 ID x 17 3/4 OD x 1/4 THK
13	4	WEDGE	STEEL	1 WD. x 1/4 THK. x 2 1/2 LG.
14	3	TOP HEAD LIFT EYE	STEEL	SEE DRAWING 121140
15	2	MOORING EYE	STEEL	2 THK.
16	1	BOTTOM HEAD LIFT EYE	STEEL	2 THK.
17	1	BELL STAND	STEEL	6 SCH. 80
18	1	BELL STAND PLATE	STEEL	12-3/4 DIA. x 1/2
19	2	PIPE PLUG	STAIN. STEEL	3/4 NPT
20	2	HALF COUPLING	STAIN. STEEL	3/4 NPT

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%).

REV.	DATE	APPR.	DESCRIPTION	BY
DESIGNED:			U.S. COAST GUARD	HEADQUARTERS
DRAWN: S.M.			CIVIL ENGINEERING	
TRACED:			2010 TYPE	
CHECKED: S.M.			6x20LR BUOY	
REVIEWED BY:				
Sean McEvoy PROJECT ENGINEER				
Wayne Danzik CG-432B				
REVIEWED BY:		APPROVED:		DATE
Stan Walker CG-432		Stan Walker /for		03/11/10
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±1°			DRAWING NUMBER	REV.
			121192	
SCALE: AS NOTED			SHEET 4	OF 4