



BILL OF MATERIALS				
ITEM NO.	NO. REQ.	DESCRIPTION	MATL.	REMARKS
1	AR	COMMON LINK	STEEL	
2	4	END LINK	STEEL	

NOTES

- SEE OCEAN ENGINEERING SPECIFICATION No. 377.
- WELD OVERAGE SHALL NOT BE INCLUDED IN THE MEASUREMENT OF DIMENSIONS "C" AND "F" (OVERALL WIDTH).
- OVERALL LENGTH OF 1/2" (12mm) DIAMETER WILL BE EITHER 90' (27.4 METERS) OR 45' (13.7 METERS).
- END LINKS ARE REQUIRED ON 1/2" AND 3/4" CHAIN ONLY.

U.S. CUSTOMARY
(INCHES)

①				②				APPROX. WEIGHT PER SHOT (LBS.)
A	B	C	TOLERANCE (B & C)	D	E	F	TOLERANCE (E & F)	
1/2	3	1-7/8	±1/32	3/4	4-1/2	2-11/16	±1/16	210
3/4	4-1/2	2-11/16	±1/16	7/8	5-1/4	3-1/8	±1/16	440
1	6	3-9/16	±3/32					750
1-1/8	6-3/4	4	±3/32					950
1-1/4	7-1/2	4-7/16	±1/8					1200
1-1/2	9	5-5/16	±5/32					1740
1-3/4	10-1/2	6-1/4	±3/16					2350
1-7/8	11-1/4	6-11/16	±3/16					2700
2	12	7-1/8	±1/4					3090
2-1/8	12-3/4	7-9/16	±1/4					3480
2-1/4	13-1/2	8-1/16	±1/4					3910

METRIC
(MILLIMETERS)

①				②				APPROX. WEIGHT PER SHOT (KGS.)
A	B	C	TOLERANCE (B & C)	D	E	F	TOLERANCE (E & F)	
12.7	76.2	48	±1	19	114	68.5	±1.5	95
19	114	68.5	±1.5	22	132	79.5	±1.5	200
25	150	87.5	±2.5					340
28	168	100.5	±2.5					431
32	192	114	±3.5					544
38	228	134.5	±4.0					789
44	264	158	±5.0					1066
48	288	171	±5.0					1225
51	305	181	±6.3					1402
54	324	192	±6.3					1580
57	343	205	±6.3					1775

DIA. TOLERANCE					
U.S. CUSTOMARY (INCHES)			METRIC (mm)		
(A & D)	PLUS	MINUS	(A & D)	PLUS	MINUS
1/2-1 1/2	1/32	1/64	12.7-38	1	.5
1-3/4-2-1/4	1/16	1/64	44-57	1.5	.5

REV.	DATE	APPR.	DESCRIPTION	BY
G	10-19-00	WD	ADDED 2", 2-1/2" & 1-1/4" CHAIN SIZES.	J.J.
F	2-5-98	SW	DEL. 7/8 AND 1-5/8 CHAIN. DEL END LINKS ON ALL CHAIN EXCEPT FOR 1/2 AND 3/4 CHAIN.	W.D.
E	3-08-96	SW	ADDED NOTE 3.	C.B.
D	3-13-91	SW	REDRAWN USING AUTOCAD	DAG
C	8-1-86	SW	ADDED NOTES 2. DELETED REFERENCES TO OCEAN ENGINEERING DIVISION.	W.D.
B	3-3-86	SW	CHANGED DIMS "C" AND "F" FOR ALL ITEMS ON BOTH TABLES	W.D.
A	9-18-84	SW	CHANGED "C" DIM. ON ITEM 1 IN EACH TABLE FOR 1/2 & 12.7 DIA'S.	GWB

DESIGNED: SDR
 DRAWN: GWB
 TRACED: DAG
 CHECKED: SDR
 REVIEWED BY:

S. D. Walker
 PROJECT ENGINEER

P. J. Glabe
 G-ECV-3B
 REVIEWED BY:

U.S. COAST GUARD HEADQUARTERS
 CIVIL ENGINEERING

BUOY CHAIN

APPROVED: **K. D. Urfer** DATE: 2-16-83
 CHIEF, OCEAN ENGINEERING BRANCH

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. ±1°	DRAWING NUMBER 121032	REV. G
SCALE: NONE	SHEET 1 OF 1	