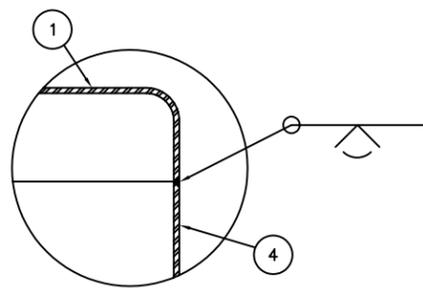
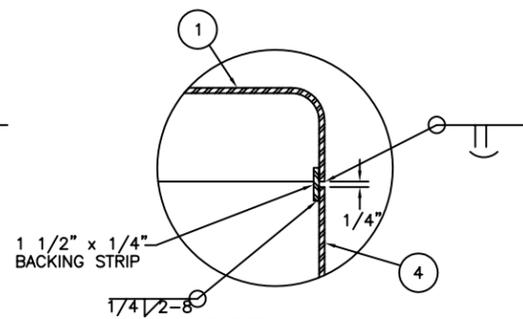


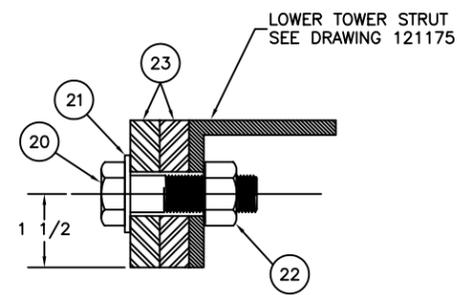
9x20 R BUOY  
SCALE: 1"=1'-0"



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

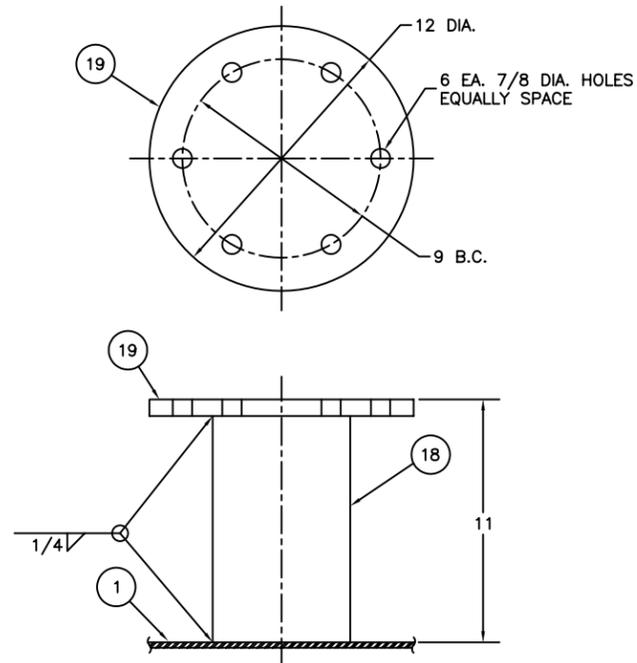


DETAIL A  
OPTIONAL  
SCALE: 3"=1'-0"

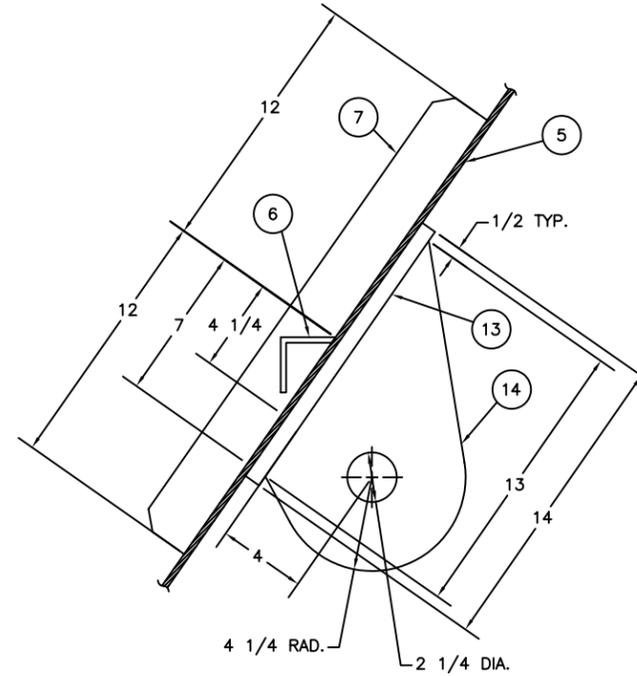


DETAIL B  
SCALE: NONE

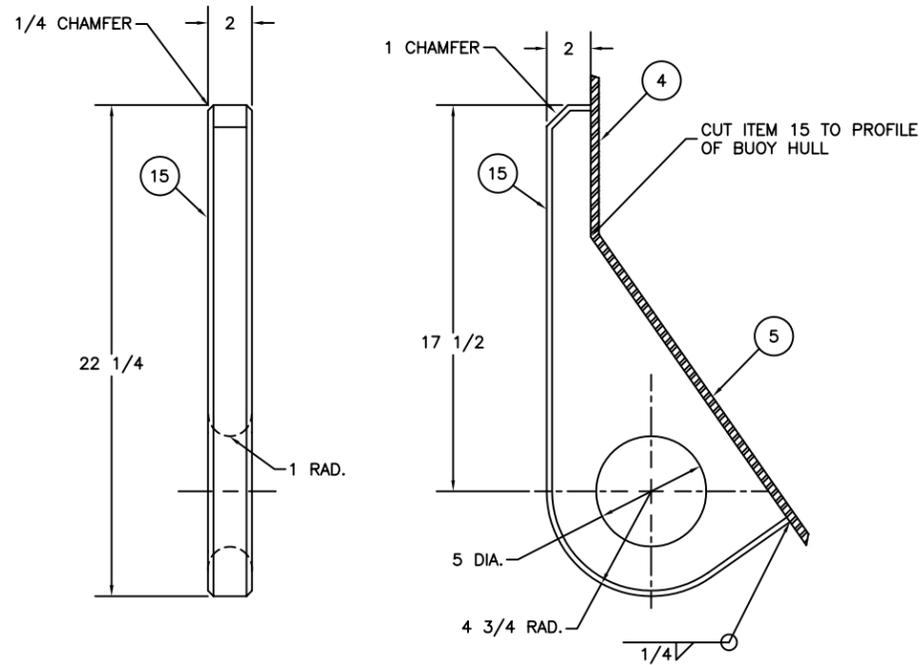
REV.	DATE	APPR.	DESCRIPTION	BY
F	6-4-99	S.W.	ADDED ADDITIONAL AIR TEST FITTING (ITEMS 24 & 25).	S.M.
E	10-1-97	S.W.	REORG DWG. DEL TOWER DETAILS. REF DRAWING 121175 FOR TOWER.	S.M.
D	10-13-94	SW	MODIFIED ITEMS 33, 38, & SECTION F-F. ADDED DETAIL P.	S.M.
C	2-23-93	CAK	REORGANIZED DRAWING. ROTATED ITEM 20. MODIFIED THICKNESS OF ITEMS 41 & 42. ADDED ADDITIONAL PAGE.	S.M.
B	11-10-92	CAK	DELETED ITEM 12, SECTION D-D, AND PAGES 4-8. MODIFIED ITEMS 11 & 20, SECTION C-C, AND BILL OF MATERIALS.	S.M.
A	8-28-92	CAK	MODIFIED BUOY TOWER & REORGANIZED DRAWING.	S.M.
DESIGNED: CAK U.S. COAST GUARD HEADQUARTERS				
DRAWN: RVF/WEK CIVIL ENGINEERING				
TRACED: S.M.				
CHECKED: S.M.				
REVIEWED BY:				
R. M. Trainor PROJECT ENGINEER				
REVIEWED BY:				
S. D. Walker G-ECV-3B				
REVIEWED BY:				
APPROVED: R. J. Wells				DATE: 10/10/90
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. 1°				
DRAWING NUMBER: 121137			REV. F	
SCALE: AS NOTED			SHEET 1 OF 4	



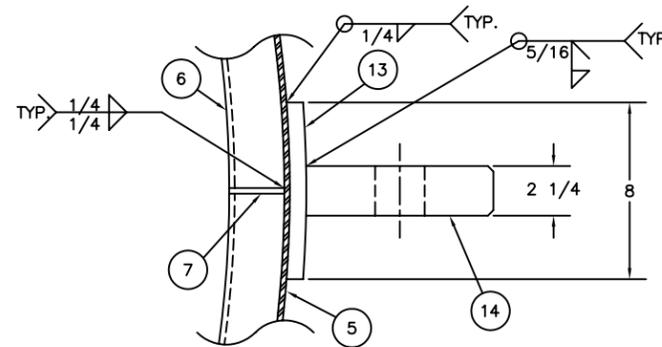
**DETAIL E**  
SCALE: 3"=1'-0"



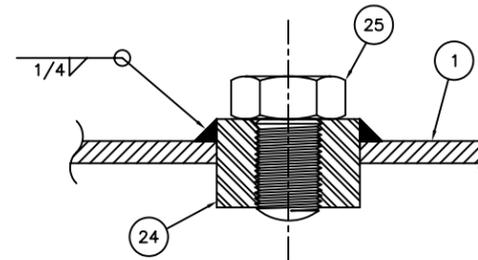
**DETAIL G**  
SCALE: 3"=1'-0"



**DETAIL F**  
SCALE: 3"=1'-0"

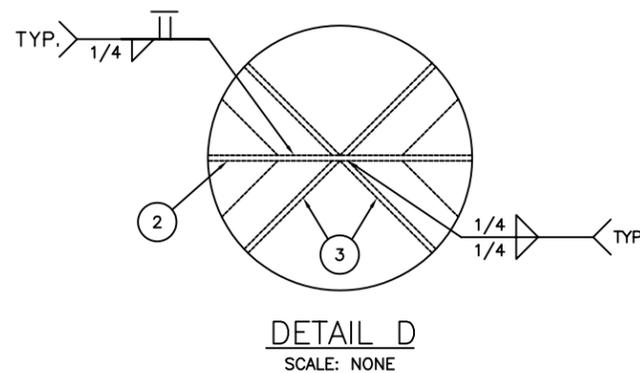
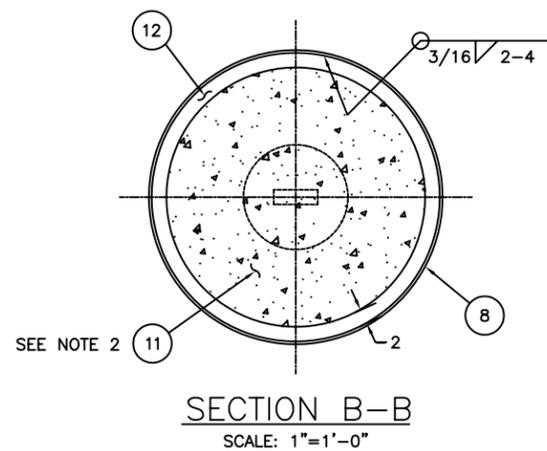
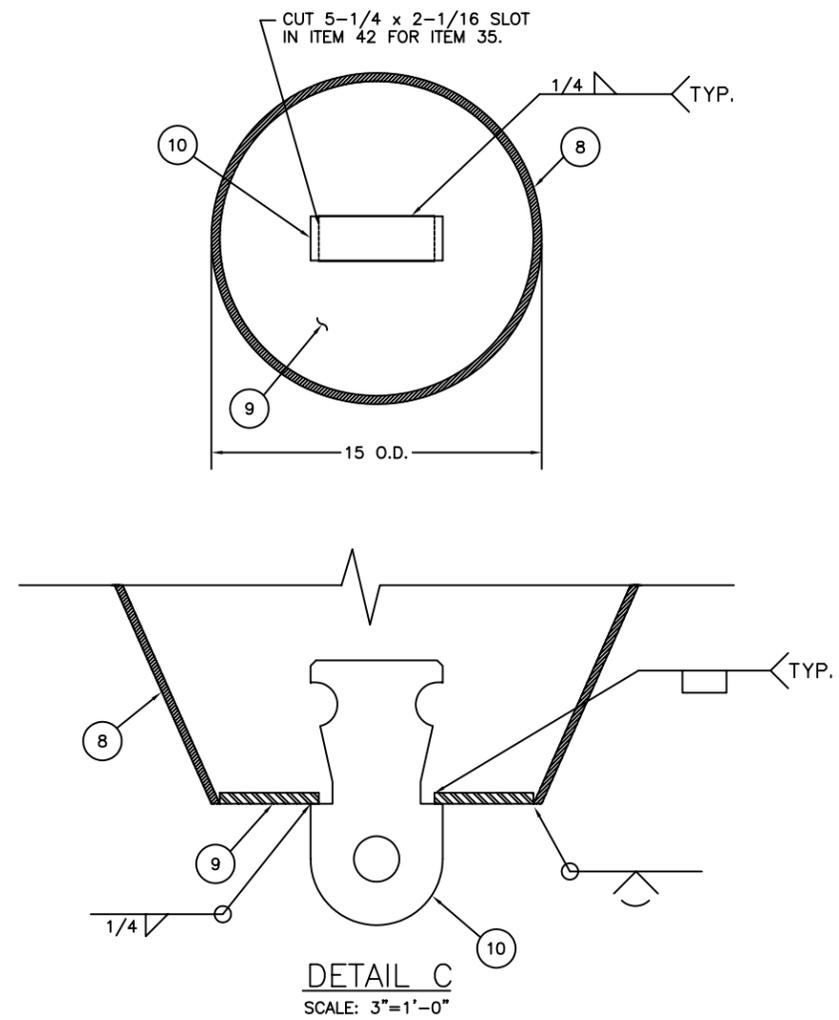
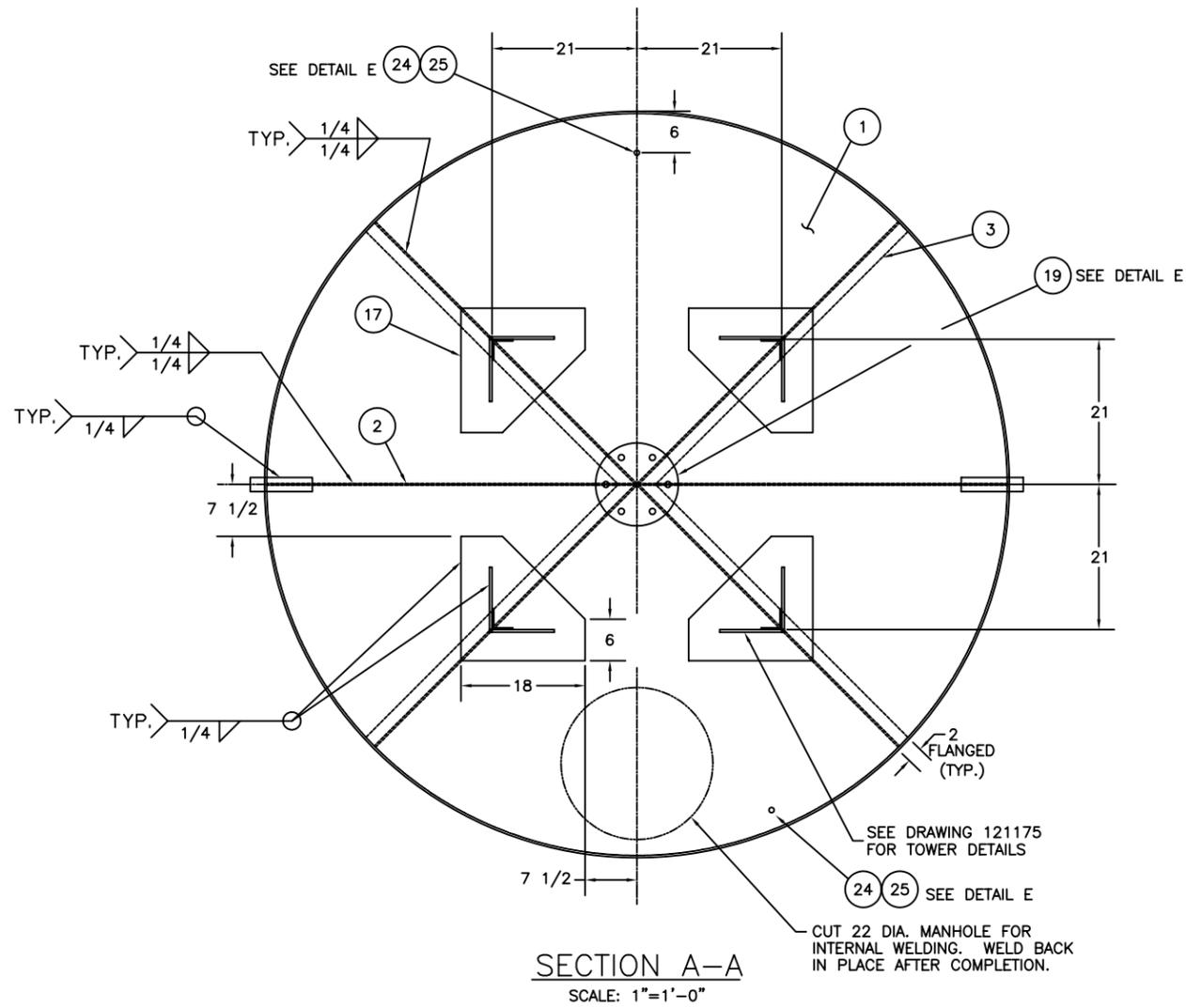


**DETAIL H**  
SCALE: FULL



**DETAIL I**  
SCALE: FULL

REV.	DATE	APPR.	DESCRIPTION	BY
F	6-4-99	S.W.	ADDED ADDITIONAL AIR TEST FITTING (ITEMS 24 & 25).	S.M.
E	10-1-97	S.W.	REORG DWG. DEL TOWER DETAILS. REF DRAWING 121175 FOR TOWER.	S.M.
D	10-13-94	SW	MODIFIED ITEMS 33, 38, & SECTION F-F. ADDED DETAIL P.	S.M.
C	2-23-93	CAK	REORGANIZED DRAWING. ROTATED ITEM 20. MODIFIED THICKNESS OF ITEMS 41 & 42. ADDED ADDITIONAL PAGE.	S.M.
B	11-10-92	CAK	DELETED ITEM 12, SECTION D-D, AND PAGES 4-8. MODIFIED ITEMS 11 & 20, SECTION C-C, AND BILL OF MATERIALS.	S.M.
A	8-28-92	CAK	MODIFIED BUOY TOWER & REORGANIZED DRAWING.	S.M.
DESIGNED: CAK			U.S. COAST GUARD HEADQUARTERS	
DRAWN: RVF/WEK			CIVIL ENGINEERING	
TRACED: S.M.			1990 TYPE 9x20 R BUOY	
CHECKED: S.M.				
REVIEWED BY:				
R. M. Trainor PROJECT ENGINEER				
S. D. Walker G-EGV-3B				
REVIEWED BY:			APPROVED:	DATE
			R. J. Wells	10/10/90
			CHIEF, OCEAN ENGINEERING BRANCH	
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. 1°			DRAWING NUMBER	REV.
			121137	F
			SCALE: AS NOTED	SHEET 3 OF 4



REV.	DATE	APPR.	DESCRIPTION	BY
F	6-4-99	S.W.	ADDED ADDITIONAL AIR TEST FITTING (ITEMS 24 & 25).	S.M.
E	10-1-97	S.W.	REORG DWG. DEL TOWER DETAILS. REF DRAWING 121175 FOR TOWER.	S.M.
D	10-13-94	SW	MODIFIED ITEMS 33, 38, & SECTION F-F. ADDED DETAIL P.	S.M.
C	2-23-93	CAK	REORGANIZED DRAWING. ROTATED ITEM 20. MODIFIED THICKNESS OF ITEMS 41 & 42. ADDED ADDITIONAL PAGE.	S.M.
B	11-10-92	CAK	DELETED ITEM 12, SECTION D-D, AND PAGES 4-8. MODIFIED ITEMS 11 & 20, SECTION C-C, AND BILL OF MATERIALS.	S.M.
A	8-28-92	CAK	MODIFIED BUOY TOWER & REORGANIZED DRAWING.	S.M.
DESIGNED: CAK U.S. COAST GUARD HEADQUARTERS				
DRAWN: RVF/WEK CIVIL ENGINEERING				
TRACED: S.M.				
CHECKED: S.M.				
REVIEWED BY:				
R. M. Trainor PROJECT ENGINEER				
REVIEWED BY:				
S. D. Walker G-ECV-3B				
REVIEWED BY:				
APPROVED: R. J. Wells				DATE: 10/10/90
CHIEF, OCEAN ENGINEERING BRANCH				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. 1°			DRAWING NUMBER 121137	REV. F
SCALE: AS NOTED			SHEET 2	OF 4

**BILL OF MATERIALS**

ITEM NO.	NO. REQ.	DESCRIPTION	MATL.	REMARKS
1	1	BUOY TOP HEAD	STEEL	108 DIA. x 1/4 THK.
2	1	TOP HEAD BRACE	STEEL	12 x 3 x 1/4 THK.
3	4	FLANGED TOP HEAD BRACE	STEEL	12 x 3 x 1/4 THK.
4	1	BODY WRAPPER	STEEL	108 DIA. x 24 HIGH x 1/4 THK.
5	1	CONICAL BODY BAND (TOP)	STEEL	1/4 THK.
6	2	SIDE MOORING BRACE RING	STEEL	2-1/2 x 2-1/2 x 1/4 L
7	2	SIDE MOORING BRACE BAR	STEEL	2-1/2 x 1/4 THK.
8	1	CONICAL BODY BAND (BOTTOM)	STEEL	3/8 THK.
9	1	BOTTOM PLATE	STEEL	14-1/4 DIA. x 1/2 THK.
10	1	BOTTOM MOORING EYE	STEEL	SEE DRAWING 121153
11	1	COUNTERWEIGHT	CAST IRON	SEE NOTE 2
12	1	COUNTERWEIGHT CLAMP	STEEL	2 x 1/4 THK.
13	2	MOORING EYE DOUBLER PLATE	STEEL	8 x 14 x 3/4 THK.
14	2	MOORING EYE	STEEL	2-1/4 THK.
15	1	BOTTOM LIFT EYE	STEEL	2 THK.
16	2	TOP HEAD LIFT EYE	STEEL	SEE DRAWING 121140
17	4	DOUBLER PLATE	STEEL	1/4 THK.
18	1	BELL AND GONG SUPPORT PIPE	STEEL	6 SCH. 80 PIPE
19	1	BELL AND GONG SUPPORT PLATE	STEEL	12 DIA. x 3/4 THK.
20	8	HEX HEAD BOLT	STAIN. STEEL	5/8-11UNC x 2-1/4 LG.
21	8	FLAT WASHER	STAIN. STEEL	5/8 NOM.
22	8	ELASTIC STOP NUT	STAIN. STEEL	5/8-11UNC
23	8	TAPPER STOP	NEOPRENE	2-1/2 x 1/2 THK. x 8 LG.
24	2	HALF COUPLING	STAIN. STEEL	3/4 NPT
25	2	PIPE PLUG	STAIN. STEEL	3/4 NPT
26	1	BELL STAND ASSEMBLY	STEEL	SEE DRAWING 120998
27	1	GONG STAND ASSEMBLY	STEEL	SEE DRAWING 120998
28	1	225 LB. BELL	CAST COPPER	SEE DRAWING 120994
29	3	GONGS #1, #3, & #4	CAST COPPER	SEE DRAWING 120994
30	4	TAPPER ASSEMBLY	STEEL	SEE DRAWING 121159

**NOTES:**

- SEE LATEST REVISION OF U.S.C.G. CIVIL ENGINEERING SPECIFICATION No. 464 FOR FABRICATION REQUIREMENTS.
- DIMENSION FOR ITEM 11 IS FOR REFERENCE PURPOSES ONLY. THE TOTAL WEIGHT OF ITEMS 8 THRU 12 SHALL BE 3475 LBS. (+5% OR - 1%).
- THE TOP HEAD LIFT EYE DIRECTLY ABOVE THE BOTTOM LIFT EYE SHALL HAVE THE WORD "LIFT" WELDED ON IT.

F	6-4-99	S.W.	ADDED ADDITIONAL AIR TEST FITTING (ITEMS 24 & 25).	S.M.
E	10-1-97	S.W.	REORG DWG. DEL TOWER DETAILS. REF DRAWING 121175 FOR TOWER.	S.M.
D	10-13-94	SW	MODIFIED ITEMS 33, 38, & SECTION F-F. ADDED DETAIL P.	S.M.
C	2-23-93	CAK	REORGANIZED DRAWING. ROTATED ITEM 20. MODIFIED THICKNESS OF ITEMS 41 & 42. ADDED ADDITIONAL PAGE.	S.M.
B	11-10-92	CAK	DELETED ITEM 12, SECTION D-D, AND PAGES 4-8. MODIFIED ITEMS 11 & 20, SECTION C-C, AND BILL OF MATERIALS.	S.M.
A	8-28-92	CAK	MODIFIED BUOY TOWER & REORGANIZED DRAWING.	S.M.
REV.	DATE	APPR.	DESCRIPTION	BY
DESIGNED: CAK		U.S. COAST GUARD HEADQUARTERS		
DRAWN: RVF/WEK		CIVIL ENGINEERING		
TRACED: S.M.		1990 TYPE		
CHECKED: S.M.		9x20 R BUOY		
REVIEWED BY:				
R. M. Trainor PROJECT ENGINEER				
REVIEWED BY:				
S. D. Walker G-ECV-3B				
REVIEWED BY:	APPROVED:	R. J. Wells		DATE
		CHIEF, OCEAN ENGINEERING BRANCH		10/10/90
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES. TOLERANCES: DIM. ±1/8 ANG. 1°			DRAWING NUMBER	REV.
			121137	F
SCALE: AS NOTED			SHEET 4	OF 4