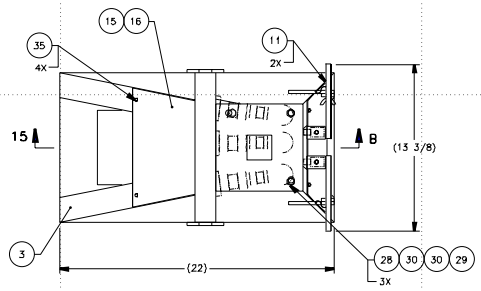
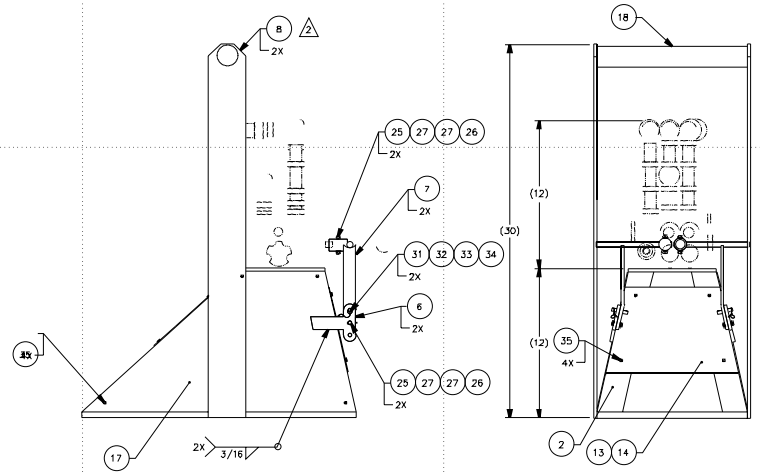
NOTES:

1. WELD IN ACCORDANCE WITH AWS D1.2
2. LOCATE AND WELD (FN 8) AFTER PUMP HAS BEEN ATTACHED TO BASE. (FN 10).
3. LOCATE AND RIVET ALL PLATE (FN 13, 15, 17) IN APPROXIMATED AREAS.
4. MATCH DRILL (FN 6) WITH VALVE AND HANDLE (FN 11) IN NEUTRAL POSITION.
5. 7/16 TEXT HEIGHT FOR THE DECAL TITLE AND 1/4 HEIGHT FOR THE REMAINING TEXT.
6. LOCATE AND CUT (FN 17) AFTER SAFE GUARD LOCK HAS BEEN WELDED TO SHORT LEGS. (FN 2 & 4).





-1 VOPS CONTROL VALVE STAND ASSEMBLY

PARTS LIST					
FIND NO.	QTY REQD	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL OR NOTE
1		53711	-1	VOPS CONTROL VALVE STAND ASSEMBLY	
2	1	53711	-2	RIGHT SHORT LEG	
3	1	53711	-3	RIGHT LONG LEG	
4	1	53711	-4	LEFT SHORT LEG	
5	1	53711	-5	LEFT LONG LEG	
6	2	53711	-6	SAFE GUARD LOCK	
7	2	53711	-7	SAFE GUARD	
8	2	53711	-8	HANDLE STRAPS	
9	1	53711	-9	TOP BASE	
10	1	53711	-10	BOTTOM BASE	
11	2	53711	-11	VALVE HANDLE	
12	1	53711	-12	VALVE HANDLE CONNECTOR	
13	1	53711	-13	CONTROL VALVE PLATE	
14	1	53711	-14	CONTROL VALVE DECAL	
15	1	53711	-15	IDENTIFICATION VALVE PLATE	
16	1	53711	-16	IDENTIFICATION VALVE DECAL	
17	2	53711	-17	SIDE PLATE	
18			COMMERCIAL	PIPE, 1-1/4 SCH 40 X 8 LONG	6061
19			COMMERCIAL	ANGLE, 2 X 2 X 1/4	6061-T6
20			COMMERCIAL	PLATE, 1/2	6061-T6
21			COMMERCIAL	PLATE, 1/4	6061-T6
22			COMMERCIAL	PLATE, 1/16	6061-T6
23			COMMERCIAL	BAR, ROUND, ø1/2	6061-T6
24			COMMERCIAL	TUBING, OD ø1 X 1/8 WALL THICKNESS	6061-T6
25	4		COMMERCIAL	BOLTS, 1/4-20 UNC X 1 LONG	SST
26	4		COMMERCIAL	NUT, WINGS, 1/4-20 UNC	SST
27	8		COMMERCIAL	WASHER, LOCK, 1/4	SST
28	3		COMMERCIAL	BOLTS, 7/16-14 UNC X 1 LONG	SST
29	3		COMMERCIAL	NUT, WINGS, 7/16-14 UNC	SST
30	6		COMMERCIAL	WASHER, LOCK, 7/16	SST
31	2		COMMERCIAL	PIN, COTTER, 1/4 X 3/4 LONG	SST
32	2		COMMERCIAL	SLEEVE, COMPRESSION, ø 1/16	SST
33			COMMERCIAL	CABLE, AIRCRAFT ø 1/16, TYPE 302	SST
34	2		COMMERCIAL	SCREW TEK 6-32 UNC X 1/4 LONG	SST
35	16		COMMERCIAL	RIVET, 3/16 X 1/2 LONG	SST
36	1		COMMERCIAL	SHEET, LASER, SILVER MYLAR PERMANENT ADHESIVE	

UNLESS OTHERWISE SPECIFIED:
ALL DIMENSIONS ARE IN INCHES.
TOLERANCES: DIM. 1/32
ANG. 1°

GPC - A JOINT VENTURE
WILLIAMSBURG, VA
757-887-7402

CONSULTANTS

DEPARTMENT OF THE NAVY
NAVAL SEA SYSTEMS COMMAND
WASHINGTON, D.C. 20362

SITE LOCATION:
WAREHOUSE # 12
CHEATHAM ANNEX
WILLIAMSBURG, VA.
23185

NAVSEA DWG NO:
7022760

U. S. COAST GUARD
OCEAN ENGINEERING DIV.
WASHINGTON, DC

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

ISSUE

MARK	DATE	DESCRIPTION

REFER TO NAVSEA DWG FOR REVISIONS

A/E PROJECT NO: N00024-96-D-4107
CAD FILE NAME: Z177013D01.DWG
DESIGNED BY: C. MOFFATT 1/28/00
DRAWN BY: R. NAZARETH 1/28/00
EDITED BY:
CHECKED BY: C. MOFFATT 1/28/00

SCALE: PLOT SCALE: 1=1

SHEET TITLE

VISCOUS OIL PUMPING SYSTEM
G-SEC-2C
WASHINGTON DC
CONTROL VALVE STAND

ASSEMBLY

REVIEWED BY: PCN	REVIEWED BY: BS	REVIEWED BY: RNL
PROJECT ENG.	BRANCH CHIEF	G-SEC-2

W.P. LAYNE, CAPT, USCG — CHIEF, CIVIL ENG
03/15/01 — DATE

PROJECT NUMBER: 177013
DRAWING NUMBER
DISCIPLINE/SHT NO: Z17713D01
SHEET 1 OF 3