

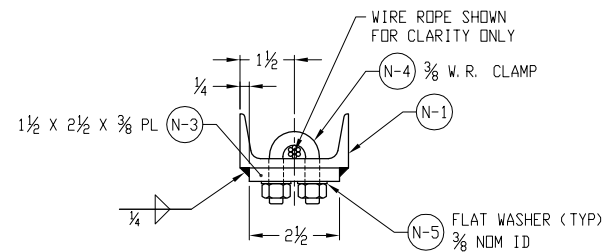
LIST OF ASSEMBLIES												LIST OF MATERIAL (QUANTITY FOR ONE COFFERDAM)										REVISIONS			
ST-08	ST-07	ST-06	ST-05	ST-04	ST-03	ST-02	ST-01	ITEM NO.	QTY	DESCRIPTION	LAST TOTAL NO. USED	MATL SPEC	MATL ROD	NSN OR MFGR PART NO.	SCE	APL NO.	UNIT WT	REMARKS	REV	ZONE	DESCRIPTION	BY	DATE	APPROVED	
1	2	2	2	2	2	2	2	N-1		CHANNEL, 3 X 1-1/2 X 1.78#		ASTM-B221	AL-5086	979540-00-542-2736	IAF		1.78	TEMPER H-111							
2	2	2	2	2	2	2	2	N-2		PLATE, 4 X 3 X 2.78#		ASTM-B221	AL-5086	979540-00-542-2764	IAF		2.78	TEMPER H-111							
2	2	2	2	2	2	2	2	N-3		PLATE, 3/8 THK		ASTM-B209	AL-5086	929535-01-012-3426	IAF		5.18	TEMPER H-116							
-	2	2	2	2	2	2	2	N-4		CLAMP WIRE ROPE, FDR 3/8 W.R.				924030-00-243-4439	IAF										
-	4	4	4	4	4	4	4	N-5		WASHER, FLAT, 3/8 NDM ID		FF-W-92	CRES	925310-00-773-7618	IAF			MS15795-814							
-	4	4	4	4	4	4	4	N-6		BOLT, 5/8-11 UNC-2A X 1-1/2 LG		FF-S-85	CRES	925305-00-721-5322	IAF			MS35307-462							
-	8	8	8	8	8	8	8	N-7		WASHER, FLAT, 5/8 NDM I.D.		FF-W-92	CRES	925310-00-614-3505	IAF			MS15795-600							
-	4	4	4	4	4	4	4	N-8		NUT, 5/8-11 UNC-3B		NASM-25027	CRES	915310-00-406-7240	IAF			MS17830-10C							
1	1	1	1	1	1	1	1	N-9		PAINT, BAR-RUST BR235 (BUFF)		MIL-P-23236B	PAINT	908010-01-359-5541	IAF										
1	1	1	1	1	1	1	1	N-10		PAINT, BAR-RUST BR235 (WHITE)		MIL-P-23236B	PAINT	908010-AU-101-23AA	IAF										

GENERAL NOTES

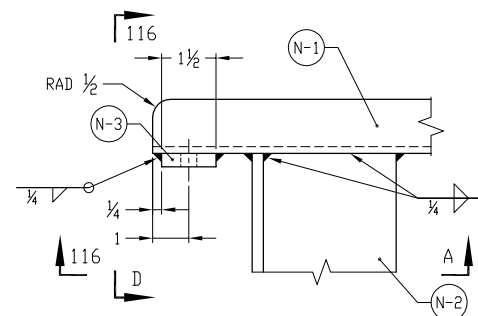
- 1.0 ALL FABRICATION, WELDING AND INSPECTION SHALL BE IN ACCORDANCE WITH MIL-STD 1689 (SH). TOLERANCES SHALL BE AS SPECIFIED IN THE DIMENSIONAL TOLERANCE BLOCK ON SHEET 1 OF THIS DRAWING.
- 1.1 ALL WELDS SHALL BE VISUALLY INSPECTED IN ACCORDANCE WITH MIL-STD-1689 (SH).
- 2.0 STANDOFFS SHALL BE BLASTED TO NEAR WHITE METAL (SSPC-SP10) AND PAINTED AS FOLLOWS
- 2.1 APPLY (1) COAT OF BAR-RUST 235 (BUFF) 4-6 MILS DFT
- 2.2 APPLY (2) COATS OF BAR-RUST 235 (WHITE) 4-6 MILS DFT/ COAT
- 3.0 GRIND A 1/8" RADIUS ON ALL EDGES OF THE STANDOFF TO PREVENT HOSE SHEAR.
- 4.0 THE CALCULATED AIR WEIGHT FOR THE STANDOFFS SHOWN IN TABLE 120-A ARE APPROXIMATE. THE ACTUAL WEIGHT OF EACH STANDOFF SHALL BE DETERMINED AFTER FABRICATION AND SHALL BE STAMPED ON THE STANDOFF LEGS.
- 5.0 STANDOFFS ARE DESIGNED FOR A MAXIMUM DEPTH OF 40'-0".
- 6.0 UPON COMPLETION OF STANDOFF AND AFTER DELIVERY, DIVERS SHALL INSTALL A LABEL PLATE TO IDENTIFY THE STANDOFF WITH THE FOLLOWING INFORMATION:
NAVSEA DRAWING NUMBER 53711-805-7370421
DATE MANUFACTURED
STANDOFF MODEL NUMBER

TEST NOTES

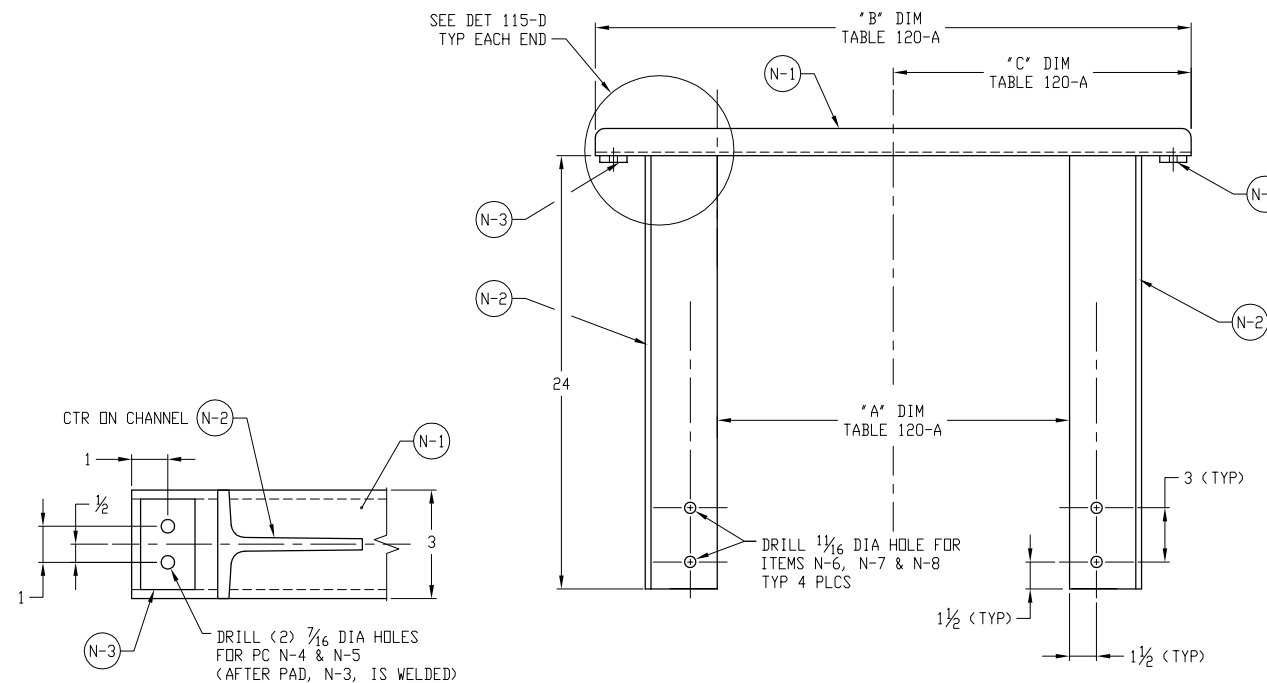
- T-1 NO NONDESTRUCTIVE TESTING OF STRUCTURE OR WELDS IS REQUIRED BY THIS DRAWING.



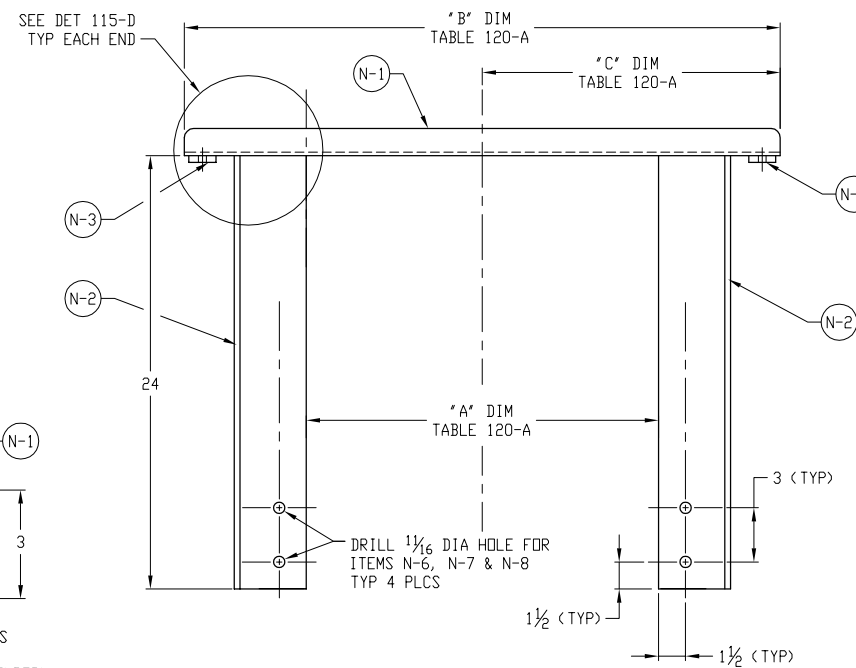
SECTION 116-D
SCALE: 6=1'-0
(115-D)



DETAIL 115-D
SCALE: 6=1'-0
(115-A)



SECTION 116-A
SCALE: 6=1'-0
(115-D)



DETAIL 115-A
BELLY BAND STANDOFF
SCALE: 3=1'-0

MODEL NUMBER	COFFERDAM MODEL(S)	CALC. WEIGHT	*A* DIMENSION	*B* DIMENSION	*C* DIMENSION
ST-08	36	14.60	49-1/2	63	31-1/2
ST-07	06	12.74	41-1/2	55	27-1/2
ST-06	05, 35	11.35	35-1/2	49	24-1/2
ST-05	04, 34	9.96	29-1/2	43	21-1/2
ST-04	03	8.57	23-1/2	37	18-1/2
ST-03	33, 41	7.65	19-1/2	33	16-1/2
ST-02	02	7.18	17-1/2	31	15-1/2
ST-01	01, 31	5.79	11-1/2	25	12-1/2

NO.	HULL	TITLE	IDENT
2	STD	ENGINEERING CALCULATIONS	53711-803-7370422
1	STD	UNDERWATER SHIP HUSBANDRY	S0600-A0PRO-160/CH-16

ITEM	SIZE	FSCM NO.	WT GRP	NAVSEA DRAWING NO.	REV
N	F	53711	805	7370421	G

TITLE
TYPICAL, BELLY BAND STANDOFF