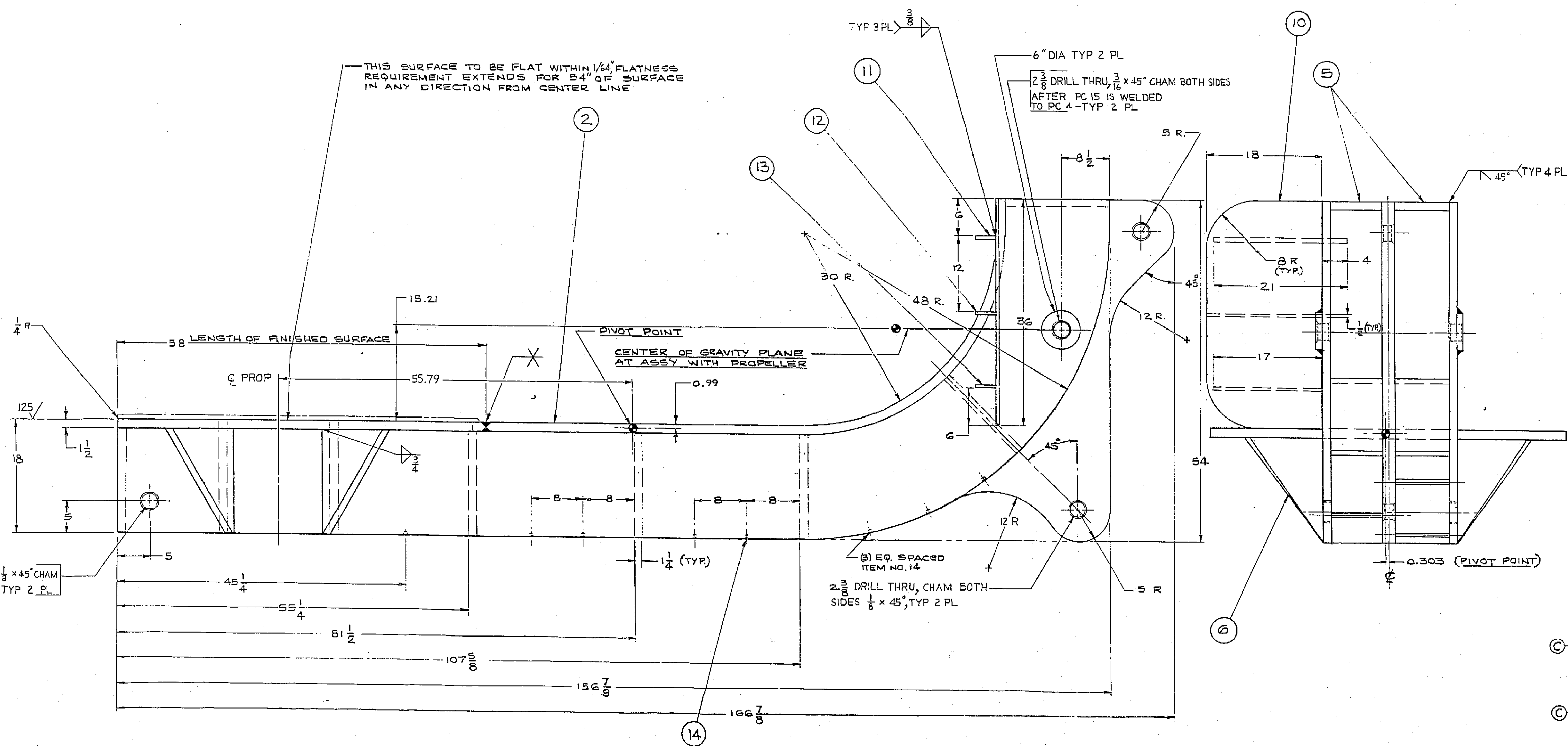


B TURNING BRACKET ASSEMBLY - PC NO. 1
SCALE: 1 INCH = 0 FT-8 INCHES

| REVISIONS | | | DATE | APPROVED |
|-----------|--|--|---------|----------|
| A | ADDED NOTE 10, ADDED PC.16. CHANGED DIM. OF PC.2 | | 5/24/85 | |
| B | DELETED PC 8 AND STORAGE HOLES FOR PC 8. INCREASED SIZE OF EYEBOLTS FROM 3 1/2 TO 4" AND SIZE OF EYEBOLT HOLES TO 4 1/8". ADDED AND MODIFIED WELDING SYMBOLS. DELETED ALL EXST GENL NOTES ON SHT 1 AND ADDED ALL NEW GENL NOTES ON SHT 2. REPLACED EXST SHT 2 WITH NEW, DELETED DETAIL VIEW OF PC 15 AND PC 8. ADDED REF LIST ON SHT 1. BY: DON HENRIKSEN 8-14-86 CODE 266 | | 8/14/86 | |
| C | REVISED "STENCIL DATA", GENL NOTE 14, SHT 2. PARTS LIST: CHANGED GRADE & CLASS OF MILSPEC FROM GR EH-345 TO GR D, CL P, FOR ITEM NO. 5, 2 THRU 7, 10 THRU 13 & 16. CHANGED MILSPEC OF ITEM NO. 9 FROM MIL-S-890 CL 8 TO MIL-S-22698B. CHANGED MILSPEC OF ITEM NO. 15 FROM ASTM A501-74 TO MIL-S-22698B. BY: D. HENRIKSEN C/266 3-11-87 | | 3/11/87 | |
| D | IN ACCORDANCE W/ NAVSEA LTR SER 56X7222 OF 14SEP 1988, THE THD LG OF PC 9 WAS REDUCED BY 1/4 INCH. BY: Michael K. Koelzer 9-21-88 | | 9/21/88 | |

| ITEM NO. | QTY | CODE IDENT. | PART NO. | DESCRIPTION | MATERIAL | SIZE | REMARKS |
|----------|-----|-------------|----------|-------------------|--------------|-----------------------|------------------------------|
| 16 | 1 | | | PLATE | STEEL | 2" x 56 x 58 | MIL-S-22698B - GRADE D, CL P |
| 15 | 2 | | | STRESS PLATE | STEEL | 2" DIA. x 1" | MIL-S-22698B - GRADE D, CL P |
| 14 | 8 | | | STRUCTURAL TUBING | STEEL | 7/16 x 8 1/2 | ASTM A501-74 |
| 13 | 1 | | | SUPPORT | STEEL | 17 x 3 x 1/2 | MIL-S-22698B - GRADE D, CL P |
| 12 | 1 | | | SUPPORT | STEEL | 18 x 3 x 1/2 | MIL-S-22698B - GRADE D, CL P |
| 11 | 1 | | | SUPPORT | STEEL | 21 x 3 x 1/2 | MIL-S-22698B - GRADE D, CL P |
| 10 | 1 | | | PLATFORM | STEEL | 36 x 18 x 1/2 | MIL-S-22698B - GRADE D, CL P |
| 9 | 2 | | | EYEBOLT | FORGED STEEL | 4" 8UNC-A | MIL-S-22698B - CL H, TYP |
| 8 | 2 | | | LOCATING PIN | SS-13-18 | 3/16 x 1/2 x 1/2 | 40-28-35 |
| 7 | 1 | | | NEST | STEEL | 18 x 10 x 1/8 | MIL-S-22698B - GRADE D, CL P |
| 6 | 4 | | | SUPPORT PLATE | STEEL | 16 1/2 x 15 1/2 x 1/4 | MIL-S-22698B - GRADE D, CL P |
| 5 | 12 | | | SPACER | STEEL | 16 1/2 x 8 1/2 x 1/4 | MIL-S-22698B - GRADE D, CL P |
| 4 | 2 | | | SIDE PLATE | STEEL | 15 1/2 x 34 x 1/4 | MIL-S-22698B - GRADE D, CL P |
| 3 | 1 | | | CENTER PLATE | STEEL | 16 1/2 x 54 x 2 | MIL-S-22698B - GRADE D, CL P |
| 2 | 1 | | | PLATE | STEEL | 11 7/8 x 21 1/2 | MIL-S-22698B - GRADE D, CL P |
| 1 | | | | ASSEMBLY | | | |

| | |
|--|--|
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS: 1/16, 1/8, 1/4, 3/8, 1/2, 5/8, 3/4, 7/8, 1, 1 1/4, 1 1/2, 1 3/4, 2, 2 1/4, 2 1/2, 2 3/4, 3, 3 1/4, 3 1/2, 3 3/4, 4, 4 1/4, 4 1/2, 4 3/4, 5, 5 1/4, 5 1/2, 5 3/4, 6, 6 1/4, 6 1/2, 6 3/4, 7, 7 1/4, 7 1/2, 7 3/4, 8, 8 1/4, 8 1/2, 8 3/4, 9, 9 1/4, 9 1/2, 9 3/4, 10, 10 1/4, 10 1/2, 10 3/4, 11, 11 1/4, 11 1/2, 11 3/4, 12, 12 1/4, 12 1/2, 12 3/4, 13, 13 1/4, 13 1/2, 13 3/4, 14, 14 1/4, 14 1/2, 14 3/4, 15, 15 1/4, 15 1/2, 15 3/4, 16, 16 1/4, 16 1/2, 16 3/4, 17, 17 1/4, 17 1/2, 17 3/4, 18, 18 1/4, 18 1/2, 18 3/4, 19, 19 1/4, 19 1/2, 19 3/4, 20, 20 1/4, 20 1/2, 20 3/4, 21, 21 1/4, 21 1/2, 21 3/4, 22, 22 1/4, 22 1/2, 22 3/4, 23, 23 1/4, 23 1/2, 23 3/4, 24, 24 1/4, 24 1/2, 24 3/4, 25, 25 1/4, 25 1/2, 25 3/4, 26, 26 1/4, 26 1/2, 26 3/4, 27, 27 1/4, 27 1/2, 27 3/4, 28, 28 1/4, 28 1/2, 28 3/4, 29, 29 1/4, 29 1/2, 29 3/4, 30, 30 1/4, 30 1/2, 30 3/4, 31, 31 1/4, 31 1/2, 31 3/4, 32, 32 1/4, 32 1/2, 32 3/4, 33, 33 1/4, 33 1/2, 33 3/4, 34, 34 1/4, 34 1/2, 34 3/4, 35, 35 1/4, 35 1/2, 35 3/4, 36, 36 1/4, 36 1/2, 36 3/4, 37, 37 1/4, 37 1/2, 37 3/4, 38, 38 1/4, 38 1/2, 38 3/4, 39, 39 1/4, 39 1/2, 39 3/4, 40, 40 1/4, 40 1/2, 40 3/4, 41, 41 1/4, 41 1/2, 41 3/4, 42, 42 1/4, 42 1/2, 42 3/4, 43, 43 1/4, 43 1/2, 43 3/4, 44, 44 1/4, 44 1/2, 44 3/4, 45, 45 1/4, 45 1/2, 45 3/4, 46, 46 1/4, 46 1/2, 46 3/4, 47, 47 1/4, 47 1/2, 47 3/4, 48, 48 1/4, 48 1/2, 48 3/4, 49, 49 1/4, 49 1/2, 49 3/4, 50, 50 1/4, 50 1/2, 50 3/4, 51, 51 1/4, 51 1/2, 51 3/4, 52, 52 1/4, 52 1/2, 52 3/4, 53, 53 1/4, 53 1/2, 53 3/4, 54, 54 1/4, 54 1/2, 54 3/4, 55, 55 1/4, 55 1/2, 55 3/4, 56, 56 1/4, 56 1/2, 56 3/4, 57, 57 1/4, 57 1/2, 57 3/4, 58, 58 1/4, 58 1/2, 58 3/4, 59, 59 1/4, 59 1/2, 59 3/4, 60, 60 1/4, 60 1/2, 60 3/4, 61, 61 1/4, 61 1/2, 61 3/4, 62, 62 1/4, 62 1/2, 62 3/4, 63, 63 1/4, 63 1/2, 63 3/4, 64, 64 1/4, 64 1/2, 64 3/4, 65, 65 1/4, 65 1/2, 65 3/4, 66, 66 1/4, 66 1/2, 66 3/4, 67, 67 1/4, 67 1/2, 67 3/4, 68, 68 1/4, 68 1/2, 68 3/4, 69, 69 1/4, 69 1/2, 69 3/4, 70, 70 1/4, 70 1/2, 70 3/4, 71, 71 1/4, 71 1/2, 71 3/4, 72, 72 1/4, 72 1/2, 72 3/4, 73, 73 1/4, 73 1/2, 73 3/4, 74, 74 1/4, 74 1/2, 74 3/4, 75, 75 1/4, 75 1/2, 75 3/4, 76, 76 1/4, 76 1/2, 76 3/4, 77, 77 1/4, 77 1/2, 77 3/4, 78, 78 1/4, 78 1/2, 78 3/4, 79, 79 1/4, 79 1/2, 79 3/4, 80, 80 1/4, 80 1/2, 80 3/4, 81, 81 1/4, 81 1/2, 81 3/4, 82, 82 1/4, 82 1/2, 82 3/4, 83, 83 1/4, 83 1/2, 83 3/4, 84, 84 1/4, 84 1/2, 84 3/4, 85, 85 1/4, 85 1/2, 85 3/4, 86, 86 1/4, 86 1/2, 86 3/4, 87, 87 1/4, 87 1/2, 87 3/4, 88, 88 1/4, 88 1/2, 88 3/4, 89, 89 1/4, 89 1/2, 89 3/4, 90, 90 1/4, 90 1/2, 90 3/4, 91, 91 1/4, 91 1/2, 91 3/4, 92, 92 1/4, 92 1/2, 92 3/4, 93, 93 1/4, 93 1/2, 93 3/4, 94, 94 1/4, 94 1/2, 94 3/4, 95, 95 1/4, 95 1/2, 95 3/4, 96, 96 1/4, 96 1/2, 96 3/4, 97, 97 1/4, 97 1/2, 97 3/4, 98, 98 1/4, 98 1/2, 98 3/4, 99, 99 1/4, 99 1/2, 99 3/4, 100, 100 1/4, 100 1/2, 100 3/4, 101, 101 1/4, 101 1/2, 101 3/4, 102, 102 1/4, 102 1/2, 102 3/4, 103, 103 1/4, 103 1/2, 103 3/4, 104, 104 1/4, 104 1/2, 104 3/4, 105, 105 1/4, 105 1/2, 105 3/4, 106, 106 1/4, 106 1/2, 106 3/4, 107, 107 1/4, 107 1/2, 107 3/4, 108, 108 1/4, 108 1/2, 108 3/4, 109, 109 1/4, 109 1/2, 109 3/4, 110, 110 1/4, 110 1/2, 110 3/4, 111, 111 1/4, 111 1/2, 111 3/4, 112, 112 1/4, 112 1/2, 112 3/4, 113, 113 1/4, 113 1/2, 113 3/4, 114, 114 1/4, 114 1/2, 114 3/4, 115, 115 1/4, 115 1/2, 115 3/4, 116, 116 1/4, 116 1/2, 116 3/4, 117, 117 1/4, 117 1/2, 117 3/4, 118, 118 1/4, 118 1/2, 118 3/4, 119, 119 1/4, 119 1/2, 119 3/4, 120, 120 1/4, 120 1/2, 120 3/4, 121, 121 1/4, 121 1/2, 121 3/4, 122, 122 1/4, 122 1/2, 122 3/4, 123, 123 1/4, 123 1/2, 123 3/4, 124, 124 1/4, 124 1/2, 124 3/4, 125, 125 1/4, 125 1/2, 125 3/4, 126, 126 1/4, 126 1/2, 126 3/4, 127, 127 1/4, 127 1/2, 127 3/4, 128, 128 1/4, 128 1/2, 128 3/4, 129, 129 1/4, 129 1/2, 129 3/4, 130, 130 1/4, 130 1/2, 130 3/4, 131, 131 1/4, 131 1/2, 131 3/4, 132, 132 1/4, 132 1/2, 132 3/4, 133, 133 1/4, 133 1/2, 133 3/4, 134, 134 1/4, 134 1/2, 134 3/4, 135, 135 1/4, 135 1/2, 135 3/4, 136, 136 1/4, 136 1/2, 136 3/4, 137, 137 1/4, 137 1/2, 137 3/4, 138, 138 1/4, 138 1/2, 138 3/4, 139, 139 1/4, 139 1/2, 139 3/4, 140, 140 1/4, 140 1/2, 140 3/4, 141, 141 1/4, 141 1/2, 141 3/4, 142, 142 1/4, 142 1/2, 142 3/4, 143, 143 1/4, 143 1/2, 143 3/4, 144, 144 1/4, 144 1/2, 144 3/4, 145, 145 1/4, 145 1/2, 145 3/4, 146, 146 1/4, 146 1/2, 146 3/4, 147, 147 1/4, 147 1/2, 147 3/4, 148, 148 1/4, 148 1/2, 148 3/4, 149, 149 1/4, 149 1/2, 149 3/4, 150, 150 1/4, 150 1/2, 150 3/4, 151, 151 1/4, 151 1/2, 151 3/4, 152, 152 1/4, 152 1/2, 152 3/4, 153, 153 1/4, 153 1/2, 153 3/4, 154, 154 1/4, 154 1/2, 154 3/4, 155, 155 1/4, 155 1/2, 155 3/4, 156, 156 1/4, 156 1/2, 156 3/4, 157, 157 1/4, 157 1/2, 157 3/4, 158, 158 1/4, 158 1/2, 158 3/4, 159, 159 1/4, 159 1/2, 159 3/4, 160, 160 1/4, 160 1/2, 160 3/4, 161, 161 1/4, 161 1/2, 161 3/4, 162, 162 1/4, 162 1/2, 162 3/4, 163, 163 1/4, 163 1/2, 163 3/4, 164, 164 1/4, 164 1/2, 164 3/4, 165, 165 1/4, 165 1/2, 165 3/4, 166, 166 1/4, 166 1/2, 166 3/4, 167, 167 1/4, 167 1/2, 167 3/4, 168, 168 1/4, 168 1/2, 168 3/4, 169, 169 1/4, 169 1/2, 169 3/4, 170, 170 1/4, 170 1/2, 170 3/4, 171, 171 1/4, 171 1/2, 171 3/4, 172, 172 1/4, 172 1/2, 172 3/4, 173, 173 1/4, 173 1/2, 173 3/4, 174, 174 1/4, 174 1/2, 174 3/4, 175, 175 1/4, 175 1/2, 175 3/4, 176, 176 1/4, 176 1/2, 176 3/4, 177, 177 1/4, 177 1/2, 177 3/4, 178, 178 1/4, 178 1/2, 178 3/4, 179, 179 1/4, 179 1/2, 179 3/4, 180, 180 1/4, 180 1/2, 180 3/4, 181, 181 1/4, 181 1/2, 181 3/4, 182, 182 1/4, 182 1/2, 182 3/4, 183, 183 1/4, 183 1/2, 183 3/4, 184, 184 1/4, 184 1/2, 184 3/4, 185, 185 1/4, 185 1/2, 185 3/4, 186, 186 1/4, 186 1/2, 186 3/4, 187, 187 1/4, 187 1/2, 187 3/4, 188, 188 1/4, 188 1/2, 188 3/4, 189, 189 1/4, 189 1/2, 189 3/4, 190, 190 1/4, 190 1/2, 190 3/4, 191, 191 1/4, 191 1/2, 191 3/4, 192, 192 1/4, 192 1/2, 192 3/4, 193, 193 1/4, 193 1/2, 193 3/4, 194, 194 1/4, 194 1/2, 194 3/4, 195, 195 1/4, 195 1/2, 195 3/4, 196, 196 1/4, 196 1/2, 196 3/4, 197, 197 1/4, 197 1/2, 197 3/4, 198, 198 1/4, 198 1/2, 198 3/4, 199, 199 1/4, 199 1/2, 199 3/4, 200, 200 1/4, 200 1/2, 200 3/4, 201, 201 1/4, 201 1/2, 201 3/4, 202, 202 1/4, 202 1/2, 202 3/4, 203, 203 1/4, 203 1/2, 203 3/4, 204, 204 1/4, 204 1/2, 204 3/4, 205, 205 1/4, 205 1/2, 205 3/4, 206, 206 1/4, 206 1/2, 206 3/4, 207, 207 1/4, 207 1/2, 207 3/4, 208, 208 1/4, 208 1/2, 208 3/4, 209, 209 1/4, 209 1/2, 209 3/4, 210, 210 1/4, 210 1/2, 210 3/4, 211, 211 1/4, 211 1/2, 211 3/4, 212, 212 1/4, 212 1/2, 212 3/4, 213, 213 1/4, 213 1/2, 213 3/4, 214, 214 1/4, 214 1/2, 214 3/4, 215, 215 1/4, 215 1/2, 215 3/4, 216, 216 1/4, 216 1/2, 216 3/4, 217, 217 1/4, 217 1/2, 217 3/4, 218, 218 1/4, 218 1/2, 218 3/4, 219, 219 1/4, 219 1/2, 219 3/4, 220, 220 1/4, 220 1/2, 220 3/4, 221, 221 1/4, 221 1/2, 221 3/4, 222, 222 1/4, 222 1/2, 222 3/4, 223, 223 1/4, 223 1/2, 223 3/4, 224, 224 1/4, 224 1/2, 224 3/4, 225, 225 1/4, 225 1/2, 225 3/4, 226, 226 1/4, 226 1/2, 226 3/4, 227, 227 1/4, 227 1/2, 227 3/4, 228, 228 1/4, 228 1/2, 228 3/4, 229, 229 1/4, 229 1/2, 229 3/4, 230, 230 1/4, 230 1/2, 230 3/4, 231, 231 1/4, 231 1/2, 231 3/4, 232, 232 1/4, 232 1/2, 232 3/4, 233, 233 1/4, 233 1/2, 233 3/4, 234, 234 1/4, 234 1/2, 234 3/4, 235, 235 1/4, 235 1/2, 235 3/4, 236, 236 1/4, 236 1/2, 236 3/4, 237, 237 1/4, 237 1/2, 237 3/4, 238, 238 1/4, 238 1/2, 238 3/4, 239, 239 1/4, 239 1/2, 239 3/4, 240, 240 1/4, 240 1/2, 240 3/4, 241, 241 1/4, 241 1/2, 241 3/4, 242, 242 1/4, 242 1/2, 242 3/4, 243, 243 1/4, 243 1/2, 243 3/4, 244, 244 1/4, 244 1/2, 244 3/4, 245, 245 1/4, 245 1/2, 245 3/4, 246, 246 1/4, 246 1/2, 246 3/4, 247, 247 1/4, 247 1/2, 247 3/4, 248, 248 1/4, 248 1/2, 248 3/4, 249, 249 1/4, 249 1/2, 249 3/4, 250, 250 1/4, 250 1/2, 250 3/4, 251, 251 1/4, 251 1/2, 251 3/4, 252, 252 1/4, 252 1/2, 252 3/4, 253, 253 1/4, 253 1/2, 253 3/4, 254, 254 1/4, 254 1/2, 254 3/4, 255, 255 1/4, 255 1/2, 255 3/4, 256, 256 1/4, 256 1/2, 256 3/4, 257, 257 1/4, 257 1/2, 257 3/4, 258, 258 1/4, 258 1/2, 258 3/4, 259, 259 1/4, 259 1/2, 259 3/4, 260, 260 1/4, 260 1/2, 260 3/4, 261, 261 1/4, 261 1/2, 261 3/4, 262, 262 1/4, 262 1/2, 262 3/4, 263, 263 1/4, 263 1/2, 263 3/4, 264, 264 1/4, 264 1/2, 264 3/4, 265, 265 1/4, 265 1/2, 265 3/4, 266, 266 1/4, 266 1/2, 266 3/4, 267, 267 1/4, 267 1/2, 267 3/4, 268, 268 1/4, 268 1/2, 268 3/4, 269, 269 1/4, 269 1/2, 269 3/4, 270, 270 1/4, 270 1/2, 270 3/4, 271, 271 1/4, 271 1/2, 271 3/4, 272, 272 1/4, 272 1/2, 272 3/4, 273, 273 1/4, 273 1/2, 273 3/4, 274, 274 1/4, 274 1/2, 274 3/4, 275, 275 1/4, 275 1/2, 275 3/4, 276, 276 1/4, 276 1/2, 276 3/4, 277, 277 1/4, 277 1/2, 277 3/4, 278, 278 1/4, 278 1/2, 278 3/4, 279, 279 1/4, 279 1/2, 279 3/4, 280, 280 1/4, 280 1/2, 280 3/4, 281, 281 1/4, 281 1/2, 281 3/4, 282, 282 1/4, 282 1/2, 282 3/4, 283, 283 1/4, 283 1/2, 283 3/4, 284, 284 1/4, 284 1/2, 284 3/4, 285, 285 1/4, 285 1/2, 285 3/4, 286, 286 1/4, 286 1/2, 286 3/4, 287, 287 1/4, 287 1/2, 287 3/4, 288, 288 1/4, 288 1/2, 288 3/4, 289, 289 1/4, 289 1/2, 289 3/4, 290, 290 1/4, 290 1/2, 290 3/4, 291, 291 1/4, 291 1/2, 291 3/4, 292, 292 1/4, 292 1/2, 292 3/4, 293, 293 1/4, 293 1/2, 293 3/4, 294, 294 1/4, 294 1/2, 294 3/4, 295, 295 1/4, 295 1/2, 295 3/4, 296, 296 1/4, 296 1/2, 296 3/4, 297, 297 1/4, 297 1/2, 297 3/4, 298, 298 1/4, 298 1/2, 298 3/4, 299, 299 1/4, 299 1/2, 2 | |
|--|--|



| | | | | | | |
|---|----|----|-------------------|--------------|-------------------------|----------------------------------|
| A | 10 | 1 | PLATE | STEEL | 2" x 64" x 58 | MIL-S-32678-B GRADE D, C.I.P. |
| | 15 | 2 | STRESS PLATE | STEEL | 6" DIA. x 1" | MIL-S-32678-B GRADE D, C.I.P. |
| | 14 | 8 | STRUCTURAL TUBING | STEEL | 3/4" x 3" x 1/2" | ASTM A301-74 |
| | 13 | 1 | SUPPORT | STEEL | 17 x 3 x 1/2 | MIL-S-32678-B GRADE D, C.I.P. |
| C | 12 | 1 | SUPPORT | STEEL | 18 x 3 x 1/2 | MIL-S-32678-B GRADE D, C.I.P. |
| | 11 | 1 | SUPPORT | STEEL | 21 x 3 x 1/2 | MIL-S-32678-B GRADE D, C.I.P. |
| | 10 | 1 | PLATFORM | STEEL | 36 x 18 x 1/2 | MIL-S-32678-B GRADE D, C.I.P. |
| | 9 | 2 | EYEBOLT | FORGED STEEL | 4" BUNC-A | MIL-S-24093 GRADE B, C.I.P. |
| B | 8 | 2 | LOADING PIN | SAE 52100 | 3/4" x 1 1/2" x 3 1/2" | SAE J423-59 |
| | 7 | 1 | LEG | STEEL | 18 x 20.0 x 18 | MIL-S-32678-B GRADE D, C.I.P. |
| C | 6 | 4 | SUPPORT PLATE | STEEL | 16 1/2 x 15 1/2 x 1 1/2 | MIL-S-32678-B GRADE D, C.I.P. |
| | 5 | 12 | SPACER | STEEL | 16 1/2 x 9 1/2 x 1 1/2 | MIL-S-32678-B GRADE D, C.I.P. |
| | 4 | 2 | SIDE PLATE | STEEL | 36 1/2 x 34 1/4 | MIL-S-32678-B GRADE D, C.I.P. |
| | 3 | 1 | CENTER PLATE | STEEL | 16 1/2 x 5 x 2 | MIL-S-32678-B GRADE D, C.I.P. |
| A | 2 | 1 | PLATE | STEEL | 11 1/2 x 21 1/2 | MIL-S-32678-B GRADE D, C.I.P. |

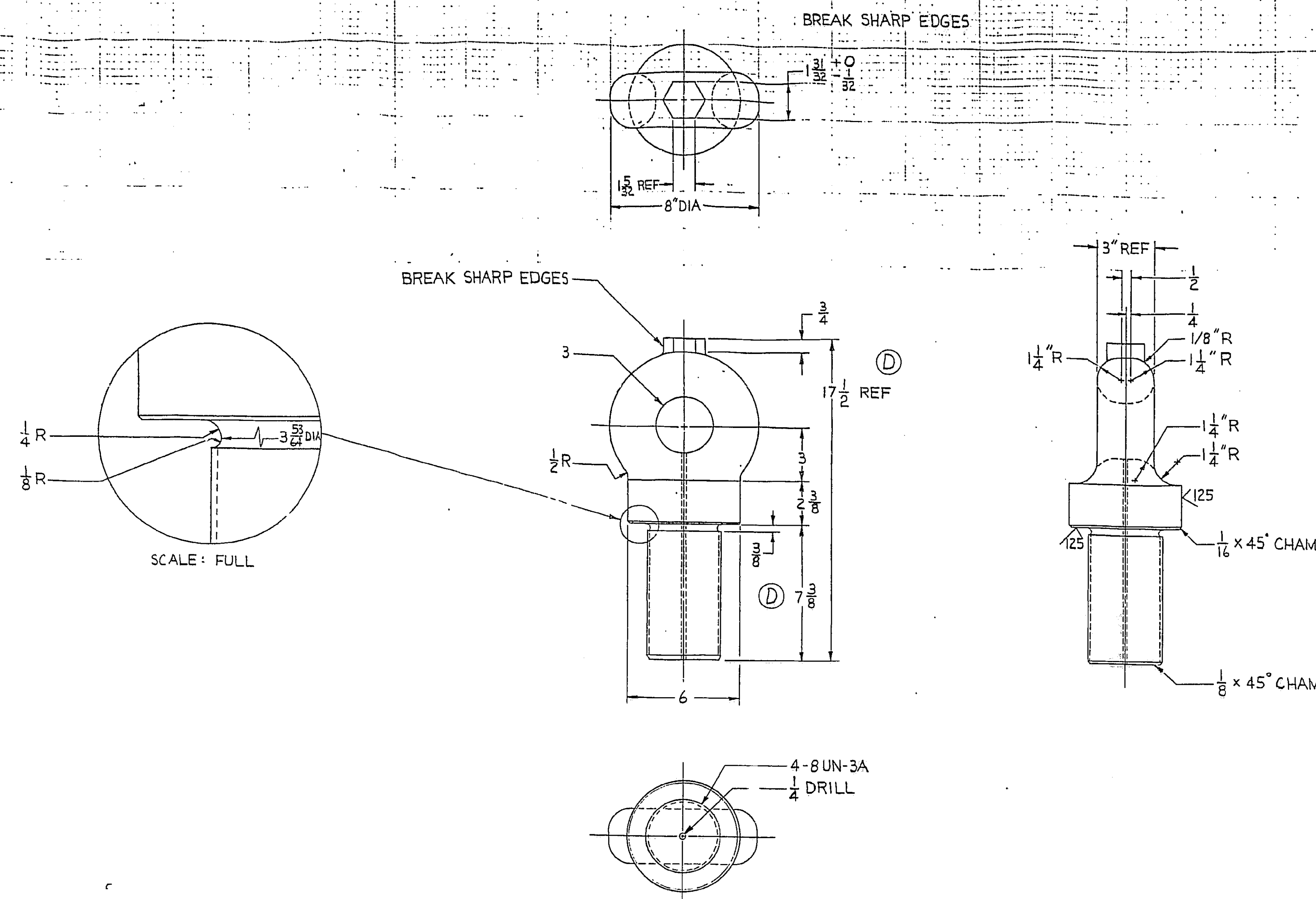
| ASSEMBLY | | | | | | | |
|---|------|-------------|----------|-------------|----------|------|---------|
| ITEM NO. | QTY. | CODE IDENT. | PART NO. | DESCRIPTION | MATERIAL | SIZE | REMARKS |
| PARTS LIST | | | | | | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS: 1/16, 1/8, 1/4, 3/8, 1/2, 5/8, 3/4, 7/8, 1, 1 1/4, 1 1/2, 1 3/4, 1 7/8, 2, 2 1/4, 2 1/2, 2 3/4, 3, 3 1/4, 3 1/2, 3 3/4, 4, 4 1/4, 4 1/2, 4 3/4, 5, 5 1/4, 5 1/2, 5 3/4, 6, 6 1/4, 6 1/2, 6 3/4, 7, 7 1/4, 7 1/2, 7 3/4, 8, 8 1/4, 8 1/2, 8 3/4, 9, 9 1/4, 9 1/2, 9 3/4, 10, 10 1/4, 10 1/2, 10 3/4, 11, 11 1/4, 11 1/2, 11 3/4, 12, 12 1/4, 12 1/2, 12 3/4, 13, 13 1/4, 13 1/2, 13 3/4, 14, 14 1/4, 14 1/2, 14 3/4, 15, 15 1/4, 15 1/2, 15 3/4, 16, 16 1/4, 16 1/2, 16 3/4, 17, 17 1/4, 17 1/2, 17 3/4, 18, 18 1/4, 18 1/2, 18 3/4, 19, 19 1/4, 19 1/2, 19 3/4, 20, 20 1/4, 20 1/2, 20 3/4, 21, 21 1/4, 21 1/2, 21 3/4, 22, 22 1/4, 22 1/2, 22 3/4, 23, 23 1/4, 23 1/2, 23 3/4, 24, 24 1/4, 24 1/2, 24 3/4, 25, 25 1/4, 25 1/2, 25 3/4, 26, 26 1/4, 26 1/2, 26 3/4, 27, 27 1/4, 27 1/2, 27 3/4, 28, 28 1/4, 28 1/2, 28 3/4, 29, 29 1/4, 29 1/2, 29 3/4, 30, 30 1/4, 30 1/2, 30 3/4, 31, 31 1/4, 31 1/2, 31 3/4, 32, 32 1/4, 32 1/2, 32 3/4, 33, 33 1/4, 33 1/2, 33 3/4, 34, 34 1/4, 34 1/2, 34 3/4, 35, 35 1/4, 35 1/2, 35 3/4, 36, 36 1/4, 36 1/2, 36 3/4, 37, 37 1/4, 37 1/2, 37 3/4, 38, 38 1/4, 38 1/2, 38 3/4, 39, 39 1/4, 39 1/2, 39 3/4, 40, 40 1/4, 40 1/2, 40 3/4, 41, 41 1/4, 41 1/2, 41 3/4, 42, 42 1/4, 42 1/2, 42 3/4, 43, 43 1/4, 43 1/2, 43 3/4, 44, 44 1/4, 44 1/2, 44 3/4, 45, 45 1/4, 45 1/2, 45 3/4, 46, 46 1/4, 46 1/2, 46 3/4, 47, 47 1/4, 47 1/2, 47 3/4, 48, 48 1/4, 48 1/2, 48 3/4, 49, 49 1/4, 49 1/2, 49 3/4, 50, 50 1/4, 50 1/2, 50 3/4, 51, 51 1/4, 51 1/2, 51 3/4, 52, 52 1/4, 52 1/2, 52 3/4, 53, 53 1/4, 53 1/2, 53 3/4, 54, 54 1/4, 54 1/2, 54 3/4, 55, 55 1/4, 55 1/2, 55 3/4, 56, 56 1/4, 56 1/2, 56 3/4, 57, 57 1/4, 57 1/2, 57 3/4, 58, 58 1/4, 58 1/2, 58 3/4, 59, 59 1/4, 59 1/2, 59 3/4, 60, 60 1/4, 60 1/2, 60 3/4, 61, 61 1/4, 61 1/2, 61 3/4, 62, 62 1/4, 62 1/2, 62 3/4, 63, 63 1/4, 63 1/2, 63 3/4, 64, 64 1/4, 64 1/2, 64 3/4, 65, 65 1/4, 65 1/2, 65 3/4, 66, 66 1/4, 66 1/2, 66 3/4, 67, 67 1/4, 67 1/2, 67 3/4, 68, 68 1/4, 68 1/2, 68 3/4, 69, 69 1/4, 69 1/2, 69 3/4, 70, 70 1/4, 70 1/2, 70 3/4, 71, 71 1/4, 71 1/2, 71 3/4, 72, 72 1/4, 72 1/2, 72 3/4, 73, 73 1/4, 73 1/2, 73 3/4, 74, 74 1/4, 74 1/2, 74 3/4, 75, 75 1/4, 75 1/2, 75 3/4, 76, 76 1/4, 76 1/2, 76 3/4, 77, 77 1/4, 77 1/2, 77 3/4, 78, 78 1/4, 78 1/2, 78 3/4, 79, 79 1/4, 79 1/2, 79 3/4, 80, 80 1/4, 80 1/2, 80 3/4, 81, 81 1/4, 81 1/2, 81 3/4, 82, 82 1/4, 82 1/2, 82 3/4, 83, 83 1/4, 83 1/2, 83 3/4, 84, 84 1/4, 84 1/2, 84 3/4, 85, 85 1/4, 85 1/2, 85 3/4, 86, 86 1/4, 86 1/2, 86 3/4, 87, 87 1/4, 87 1/2, 87 3/4, 88, 88 1/4, 88 1/2, 88 3/4, 89, 89 1/4, 89 1/2, 89 3/4, 90, 90 1/4, 90 1/2, 90 3/4, 91, 91 1/4, 91 1/2, 91 3/4, 92, 92 1/4, 92 1/2, 92 3/4, 93, 93 1/4, 93 1/2, 93 3/4, 94, 94 1/4, 94 1/2, 94 3/4, 95, 95 1/4, 95 1/2, 95 3/4, 96, 96 1/4, 96 1/2, 96 3/4, 97, 97 1/4, 97 1/2, 97 3/4, 98, 98 1/4, 98 1/2, 98 3/4, 99, 99 1/4, 99 1/2, 99 3/4, 100, 100 1/4, 100 1/2, 100 3/4, 101, 101 1/4, 101 1/2, 101 3/4, 102, 102 1/4, 102 1/2, 102 3/4, 103, 103 1/4, 103 1/2, 103 3/4, 104, 104 1/4, 104 1/2, 104 3/4, 105, 105 1/4, 105 1/2, 105 3/4, 106, 106 1/4, 106 1/2, 106 3/4, 107, 107 1/4, 107 1/2, 107 3/4, 108, 108 1/4, 108 1/2, 108 3/4, 109, 109 1/4, 109 1/2, 109 3/4, 110, 110 1/4, 110 1/2, 110 3/4, 111, 111 1/4, 111 1/2, 111 3/4, 112, 112 1/4, 112 1/2, 112 3/4, 113, 113 1/4, 113 1/2, 113 3/4, 114, 114 1/4, 114 1/2, 114 3/4, 115, 115 1/4, 115 1/2, 115 3/4, 116, 116 1/4, 116 1/2, 116 3/4, 117, 117 1/4, 117 1/2, 117 3/4, 118, 118 1/4, 118 1/2, 118 3/4, 119, 119 1/4, 119 1/2, 119 3/4, 120, 120 1/4, 120 1/2, 120 3/4, 121, 121 1/4, 121 1/2, 121 3/4, 122, 122 1/4, 122 1/2, 122 3/4, 123, 123 1/4, 123 1/2, 123 3/4, 124, 124 1/4, 124 1/2, 124 3/4, 125, 125 1/4, 125 1/2, 125 3/4, 126, 126 1/4, 126 1/2, 126 3/4, 127, 127 1/4, 127 1/2, 127 3/4, 128, 128 1/4, 128 1/2, 128 3/4, 129, 129 1/4, 129 1/2, 129 3/4, 130, 130 1/4, 130 1/2, 130 3/4, 131, 131 1/4, 131 1/2, 131 3/4, 132, 132 1/4, 132 1/2, 132 3/4, 133, 133 1/4, 133 1/2, 133 3/4, 134, 134 1/4, 134 1/2, 134 3/4, 135, 135 1/4, 135 1/2, 135 3/4, 136, 136 1/4, 136 1/2, 136 3/4, 137, 137 1/4, 137 1/2, 137 3/4, 138, 138 1/4, 138 1/2, 138 3/4, 139, 139 1/4, 139 1/2, 139 3/4, 140, 140 1/4, 140 1/2, 140 3/4, 141, 141 1/4, 141 1/2, 141 3/4, 142, 142 1/4, 142 1/2, 142 3/4, 143, 143 1/4, 143 1/2, 143 3/4, 144, 144 1/4, 144 1/2, 144 3/4, 145, 145 1/4, 145 1/2, 145 3/4, 146, 146 1/4, 146 1/2, 146 3/4, 147, 147 1/4, 147 1/2, 147 3/4, 148, 148 1/4, 148 1/2, 148 3/4, 149, 149 1/4, 149 1/2, 149 3/4, 150, 150 1/4, 150 1/2, 150 3/4, 151, 151 1/4, 151 1/2, 151 3/4, 152, 152 1/4, 152 1/2, 152 3/4, 153, 153 1/4, 153 1/2, 153 3/4, 154, 154 1/4, 154 1/2, 154 3/4, 155, 155 1/4, 155 1/2, 155 3/4, 156, 156 1/4, 156 1/2, 156 3/4, 157, 157 1/4, 157 1/2, 157 3/4, 158, 158 1/4, 158 1/2, 158 3/4, 159, 159 1/4, 159 1/2, 159 3/4, 160, 160 1/4, 160 1/2, 160 3/4, 161, 161 1/4, 161 1/2, 161 3/4, 162, 162 1/4, 162 1/2, 162 3/4, 163, 163 1/4, 163 1/2, 163 3/4, 164, 164 1/4, 164 1/2, 164 3/4, 165, 165 1/4, 165 1/2, 165 3/4, 166, 166 1/4, 166 1/2, 166 3/4, 167, 167 1/4, 167 1/2, 167 3/4, 168, 168 1/4, 168 1/2, 168 3/4, 169, 169 1/4, 169 1/2, 169 3/4, 170, 170 1/4, 170 1/2, 170 3/4, 171, 171 1/4, 171 1/2, 171 3/4, 172, 172 1/4, 172 1/2, 172 3/4, 173, 173 1/4, 173 1/2, 173 3/4, 174, 174 1/4, 174 1/2, 174 3/4, 175, 175 1/4, 175 1/2, 175 3/4, 176, 176 1/4, 176 1/2, 176 3/4, 177, 177 1/4, 177 1/2, 177 3/4, 178, 178 1/4, 178 1/2, 178 3/4, 179, 179 1/4, 179 1/2, 179 3/4, 180, 180 1/4, 180 1/2, 180 3/4, 181, 181 1/4, 181 1/2, 181 3/4, 182, 182 1/4, 182 1/2, 182 3/4, 183, 183 1/4, 183 1/2, 183 3/4, 184, 184 1/4, 184 1/2, 184 3/4, 185, 185 1/4, 185 1/2, 185 3/4, 186, 186 1/4, 186 1/2, 186 3/4, 187, 187 1/4, 187 1/2, 187 3/4, 188, 188 1/4, 188 1/2, 188 3/4, 189, 189 1/4, 189 1/2, 189 3/4, 190, 190 1/4, 190 1/2, 190 3/4, 191, 191 1/4, 191 1/2, 191 3/4, 192, 192 1/4, 192 1/2, 192 3/4, 193, 193 1/4, 193 1/2, 193 3/4, 194, 194 1/4, 194 1/2, 194 3/4, 195, 195 1/4, 195 1/2, 195 3/4, 196, 196 1/4, 196 1/2, 196 3/4, 197, 197 1/4, 197 1/2, 197 3/4, 198, 198 1/4, 198 1/2, 198 3/4, 199, 199 1/4, 199 1/2, 199 3/4, 200, 200 1/4, 200 1/2, 200 3/4, 201, 201 1/4, 201 1/2, 201 3/4, 202, 202 1/4, 202 1/2, 202 3/4, 203, 203 1/4, 203 1/2, 203 3/4, 204, 204 1/4, 204 1/2, 204 3/4, 205, 205 1/4, 205 1/2, 205 3/4, 206, 206 1/4, 206 1/2, 206 3/4, 207, 207 1/4, 207 1/2, 207 3/4, 208, 208 1/4, 208 1/2, 208 3/4, 209, 209 1/4, 209 1/2, 209 3/4, 210, 210 1/4, 210 1/2, 210 3/4, 211, 211 1/4, 211 1/2, 211 3/4, 212, 212 1/4, 212 1/2, 212 3/4, 213, 213 1/4, 213 1/2, 213 3/4, 214, 214 1/4, 214 1/2, 214 3/4, 215, 215 1/4, 215 1/2, 215 3/4, 216, 216 1/4, 216 1/2, 216 3/4, 217, 217 1/4, 217 1/2, 217 3/4, 218, 218 1/4, 218 1/2, 218 3/4, 219, 219 1/4, 219 1/2, 219 3/4, 220, 220 1/4, 220 1/2, 220 3/4, 221, 221 1/4, 221 1/2, 221 3/4, 222, 222 1/4, 222 1/2, 222 3/4, 223, 223 1/4, 223 1/2, 223 3/4, 224, 224 1/4, 224 1/2, 224 3/4, 225, 225 1/4, 225 1/2, 225 3/4, 226, 226 1/4, 226 1/2, 226 3/4, 227, 227 1/4, 227 1/2, 227 3/4, 228, 228 1/4, 228 1/2, 228 3/4, 229, 229 1/4, 229 1/2, 229 3/4, 230, 230 1/4, 230 1/2, 230 3/4, 231, 231 1/4, 231 1/2, 231 3/4, 232, 232 1/4, 232 1/2, 232 3/4, 233, 233 1/4, 233 1/2, 233 3/4, 234, 234 1/4, 234 1/2, 234 3/4, 235, 235 1/4, 235 1/2, 235 3/4, 236, 236 1/4, 236 1/2, 236 3/4, 237, 237 1/4, 237 1/2, 237 3/4, 238, 238 1/4, 238 1/2, 238 3/4, 239, 239 1/4, 239 1/2, 239 3/4, 240, 240 1/4, 240 1/2, 240 3/4, 241, 241 1/4, 241 1/2, 241 3/4, 242, 242 1/4, 242 1/2, 242 3/4, 243, 243 1/4, 243 1/2, 243 3/4, 244, 244 1/4, 244 1/2, 244 3/4, 245, 245 1/4, 245 1/2, 245 3/4, 246, 246 1/4, 246 1/2, 246 3/4, 247, 247 1/4, 247 1/2, 247 3/4, 248, 248 1/4, 248 1/2, 248 3/4, 249, 249 1/4, 249 1/2, 249 3/4, 250, 250 1/4, 250 1/2, 250 3/4, 251, 251 1/4, 251 1/2, 251 3/4, 252, 252 1/4, 252 1/2, 252 3/4, 253, 253 1/4, 253 1/2, 253 3/4, 254, 254 1/4, 254 1/2, 254 3/4, 255, 255 1/4, 255 1/2, 255 3/4, 256, 256 1/4, 256 1/2, 256 3/4, 257, 257 1/4, 257 1/2, 257 3/4, 258, 258 1/4, 258 1/2, 258 3/4, 259, 259 1/4, 259 1/2, 259 3/4, 260, 260 1/4, 260 1/2, 260 3/4, 261, 261 1/4, 261 1/2, 261 3/4, 262, 262 1/4, 262 1/2, 262 3/4, 263, 263 1/4, 263 1/2, 263 3/4, 264, 264 1/4, 264 1/2, 264 3/4, 265, 265 1/4, 265 1/2, 265 3/4, 266, 266 1/4, 266 1/2, 266 3/4, 267, 267 1/4, 267 1/2, 267 3/4, 268, 268 1/4, 268 1/2, 268 3/4, 269, 269 1/4, 269 1/2, 269 3/4, 270, 270 1/4, 270 1/2, 270 3/4, 271, 271 1/4, 271 1/2, 271 3/4, 272, 272 1/4, 272 1/2, 272 3/4, 273, 273 1/4, 273 1/2, 273 3/4, 274, 274 1/4, 274 1/2, 274 3/4, 275, 275 1/4, 275 1/2, 275 3/4, 276, 276 1/4, 276 1/2, 276 3/4, 277, 277 1/4, 277 1/2, 277 3/4, 278, 278 1/4, 278 1/2, 278 3/4, 279, 279 1/4, 279 1/2, 279 3/4, 280, 280 1/4, 280 1/2, 280 3/4, 281, 281 1/4, 281 1/2, 281 3/4, 282, 282 1/4, 282 1/2, 282 3/4, 283, 283 1/4, 283 1/2, 283 3/4, 284, 284 1/4, 284 1/2, 284 3/4, 285, 285 1/4, 285 1/2, 285 3/4, 286, 286 1/4, 286 1/2, 286 3/4, 287, 287 1/4, 287 1/2, 287 3/4, 288, 288 1/4, 288 1/2, 288 3/4, 289, 289 1/4, 289 1/2, 289 3/4, 290, 290 1/4, 290 1/2, 290 3/4, 291, 291 1/4, 291 1/2, 291 3/4, 292, 292 1/4, 292 1/2, 292 3/4, 293, 293 1/4, 293 1/2, 293 3/4, 294, 294 1/4, 294 1/2, 294 3/4, 295, 295 1/4, 295 1/2, 295 3/4, 296, 296 1/4, 296 1/2, 296 3/4, 297, 297 1/4, 297 1/2, 297 3/4, 298, 298 1/4, 298 1/2, 298 3/4, 299, 299 1/4, 299 1/2, 299 3/4, 300, 300 1/4, 300 1/2, 300 3/4, 301, 301 1/4, 301 1/2, 301 3/4, 302, 302 1/4, 302 1/2, 302 3/4, 303, 303 1/4, 303 1/2, 303 3/4, 304, 304 1/4, 304 1/2, 304 3/4, 305, 305 1/4, 305 1/2, 305 3/4, 306, 306 1/4, 306 1/2, 306 3/4, 307, 307 1/4, 307 1/2, 307 3/4, 308, 308 1/4, 308 1/2, 308 3/4, 309, 309 1/4, 309 1/2, 309 3/4, 310, 310 1/4, 310 1/2, 310 3/4, 311, 311 1/4, 311 1/2, 311 3/4, 312, 312 1/4, 312 1/2, 312 3/4, 313, 313 1/4, 313 1/2, 313 3/4, 314, 314 1/4, 314 1/2, 314 3/4, 315, 315 1/4, 315 1/2, 315 3/4, 316, 316 1/4, 316 1/2, 316 3/4, 317, 317 1/4, 317 1/2, 317 3/4, 318, 318 1/4, 318 1/2, 318 3/4, 319, 319 1/4, 319 1/2, 319 3/4, 320, 320 1/4, 320 1/2, 320 3/4, 321, 321 1/4, 321 1/2, 321 3/4, 322, 322 1/4, 322 1/2, 322 3/4, 323, 323 1/4, 323 1/2, 323 3/4, 324, 324 1/4, 324 1/2, 324 3/4, 325, 325 1/4, 325 1/2, 325 3/4, 326, 326 1/4, 326 1/2, 326 3/4, 327, 327 1/4, 327 1/2, 327 3/4, 328, 328 1/4, 328 1/2, 328 3/4, 329, 329 1/4, 329 1/2, 329 3/4, 330, 330 1/4, 330 1/2, 330 3/4, 331, 331 1/4, 331 1/2, 331 3/4, 332, 332 1/4, 332 1/2, 332 3/4, 333, 333 1/4, 333 1/2, 333 3/4, 334, 334 1/4, 334 1/2, 334 3/4, 335, 335 1/4, 335 1/2, 335 3/4, 336, 336 1/4, 336 1/2, 336 3/4, 337, 337 1/4, 337 1/2, 337 3/4, 338, 338 1/4, 338 1/2, 338 3/4, 339, 339 1/4, 339 1/2, 339 3/4, 340, 340 1/4, 340 1/2, 340 3/4, 341, 341 1/4, 341 1/2, 341 3/4, 342, 342 1/4, 342 1/2, 342 3/4, 343, 343 1/4, 343 1/2, 343 3/4, 344, 344 1/4, 344 1/2, 344 3/4, 345, 345 1/4, 345 1/2, 345 3/4, 346, 346 1/4, 346 1/2, 346 3/4, 347, 347 1/4, 347 1/2, 347 3/4, 348, 348 1/4, 348 1/2, 348 3/4, 349, 349 1/4, 349 1/2, 349 3/4, 350, 350 1/4, 350 1/2, 350 3/4, 351, 351 1/4, 351 1/2, 351 3/4, 352, 352 1/4, 352 1/2, 352 3/4, 353, 353 1/4, 353 1/2, 353 3/4, 354, 354 1/4, 354 1/2, 354 3/4, 355, 355 1/4, 355 1/2, 355 3/4, 356, 356 1/4, 356 1/2, 356 3/4, 357, 357 1/4, 357 1/2, 357 3/4, 358, 358 1/4, 358 1/2, 358 3/4, 359, 359 1/4, 359 1/2, 359 3/4, 360, 360 1/4, 360 1/2, 360 3/4, 361, 361 1/4, 361 1/2, 361 3/4, 362, 362 1/4, 362 1/2, 362 3/4, 363, 363 1/4, 363 1/2, 363 3/4, 364, 364 1/4, 364 1/2, 364 3/4, 365, 365 1/4, 365 1/2, 365 3/4, 366, 366 1/4, 366 1/2, 366 3/4, 367, 367 1/4, 367 1/2, 367 3/4, 368, 368 1/4, 368 1/2, 368 3/4, 369, 369 1/4, 369 1/2, 369 3/4, 370, 370 1/4, 370 1/2, 370 3/4, 371, 371 1/4, 371 1/2, 371 3/4, 372, 372 1/4, 372 1/2, 372 3/4, 373, 373 1/4, 373 1/2, 373 3/4, 374, 374 1/4, 374 1/2, 374 3/4, 375, 375 1/4, 375 1/2, 375 3/4, 376, 376 1/4, 376 1/2, 376 3/4, 377, 377 1/4, 377 1/2, 377 3/4, 378, 378 1/4, 378 1/2, 378 3/4, 379, 379 1/4, 379 1/2, 379 3/4, 380, 380 1/4, 380 1/2, 380 3/4, 381, 381 1/4, 381 1/2, 381 3/4, 382, 382 1/4, 382 1/2, 382 3/4, 383, 383 1/4, 383 1/2, 383 3/4, 384, 384 1/4, 384 1/2, 384 3/4, 385, 385 1/4, 385 1/2, 385 3/4, 386, 386 1/4, 386 1/2, 386 3/4, 387, 387 1/4, 387 1/2, 387 3/4, 388, 388 1/4, 388 1/2, 388 3/4, 389, 389 1/4, 389 1/2, 389 3/4, 390, 390 1/4, 390 1/2, 390 3/4, 391, 391 1/4, 391 1/2, 391 3/4, 392, 392 1/4, 392 1/2, 392 3/4, 393, 393 1/4, 393 1/2, 393 3/4, 394, 394 1/4, 394 1/2, 394 3/4, 395, 395 1/4, 395 1/2, 395 3/4, 396, | | | | | | | |

GENERAL NOTES

1. THE PURPOSE OF THIS DRAWING IS TO FABRICATE A TURNING BRACKET (J-BAR) FOR PROPELLERS, MAI.
2. THE CALCULATED WEIGHT OF THE TURNING BRACKET IS 7200 LB.
3. THE RATED LOAD OF THE TURNING BRACKET IS 75000 LB.
4. ALL DIMENSIONS ARE IN INCHES, UNLESS OTHERWISE SPECIFIED, ALL TOLERANCES SHALL BE AS FOLLOWS:

| RANGE OF DIMENSIONS | TOLERANCES |
|-----------------------|------------|
| UNDER 18 INCHES | $\pm 1/32$ |
| 18 INCHES AND GREATER | $\pm 1/16$ |
5. CHANGING THICKNESS IN MATERIALS WILL RESULT IN HAZARDOUS LIFTING CONDITIONS.
6. PIECE NO. 3 AND 4 MUST BE CONTINUOUS PLATE EACH, NOT MADE OF INDIVIDUAL SECTIONS.
7. REMOVE ALL SHARP EDGES AND BURRS.
8. ALL STRUCTURAL WELDING SHALL BE IAW MIL-STD-1689, CODE 138.2 IS TO PROVIDE SPECIFIC WELDING INSTRUCTIONS.
9. SHOP 26 SHALL VISUALLY INSPECT THE ROOT WELD AND COMPLETED WELD BETWEEN PC 2 & 3, PC 2 & 16 AND PC 2 & 17 EACH PC 4, USING 5X MAGNIFICATION. ACCEPTANCE CRITERIA SHALL COMPLY WITH NAVSEA 0900-LP-003-8000 CHG 2, CLASS 1 WELD.
10. COMPLETED WELDS SHALL BE STRESS RELIEVED IAW MIL-STD-278E PRIOR TO ANY MACHINING OPERATIONS.
11. ASSEMBLY INSTRUCTIONS:
 - A. WELD PC 16 TO PC 2
 - B. INSTALL STRONGBACKS ON TOP OF PC 16 PRIOR TO PRODUCTION WELDING.
 - C. WELD PC 3 TO PC 2 AND PC 16 PRIOR TO WELDING PC 4 TO PC 2 AND PC 16.
 - D. SHOP 41 SHALL FORM PC 7 OVERSIZE AND SHOP 31 SHALL MACHINE PC 7 TO FINAL SIZE.
 - E. INSURE PC 6 FITS SQUARELY (WITHOUT ANY GAPS) BETWEEN PC 4 & 16 PRIOR TO WELDING.
12. LOAD TEST THE TURNING BRACKET TO 110% OF THE RATED LOAD, 82500 LB. CODE 266 WILL PROVIDE TEST PROCEDURE.
13. PREPARATION AND PAINTING OF THE TURNING BRACKET SHALL BE IAW NAVSEA TECHNICAL MANUAL S9806-VD-STM-000, CH 631, CHG 5. PAINT THE TURNING BRACKET WITH ONE COAT OF ZINC CHROMATE PRIMER, TT-P-645, FORMULA 84/47, AND TWO FINISH COATS OF LIGHT GRAY ENAMEL, MIL-E-15090, FORMULA NO. 111.
14. STENCIL THE FOLLOWING INFORMATION USING ONE-INCH HIGH BLACK LETTERS ON A WHITE BACKGROUND ON A HIGHLY VISIBLE SECTION OF PC 4. SHOP 906.88 SHALL INDICATE EXACT LOCATION.

SER NO. (TO BE ASSIGNED)
 NICN 25-2010-LL-HAL-6103-P2
 DWG NO. 245-611528-C
 PROP DWG NO. SSN-688-245-6308780
 MFR: PHILA. NAVSHIPYD
 RATED LOAD: 75000 LB
 TEST LOAD: 82500 LB
 TEST DATE: (MO-DY-YR)
 WEIGHT (ACTUAL)



④ 4" EYEBOLT-PC NO. 9
SCALE: 1 IN. = 0 FT - 4 IN.

| ITEM NO. | QTY | CODE IDENT. | PART NO. | DESCRIPTION | MATERIAL | SIZE | REMARKS |
|---|---------------|-------------|----------|---|----------|------|---------|
| PARTS LIST | | | | | | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS: 1 ANGLES: 1 DECIMALS: 2 | | | | DEPARTMENT OF THE NAVY PROPELLER MANUFACTURING CENTER PHILADELPHIA NAVAL SHIPYARD | | | |
| MATERIAL | PREPARED | | | | | | |
| | CHECKED | | | | | | |
| | ENGINEER | | | | | | |
| SIZE | SUBMITTED BY: | | | | | | |
| HARDNESS | APPROVED BY: | | | SIZE CODE IDENT. DRAWING NO. | | | |
| | | | | F 53711 245-6111528 | | | |
| | | | | SCALE SHEET 1 of 2 | | | |

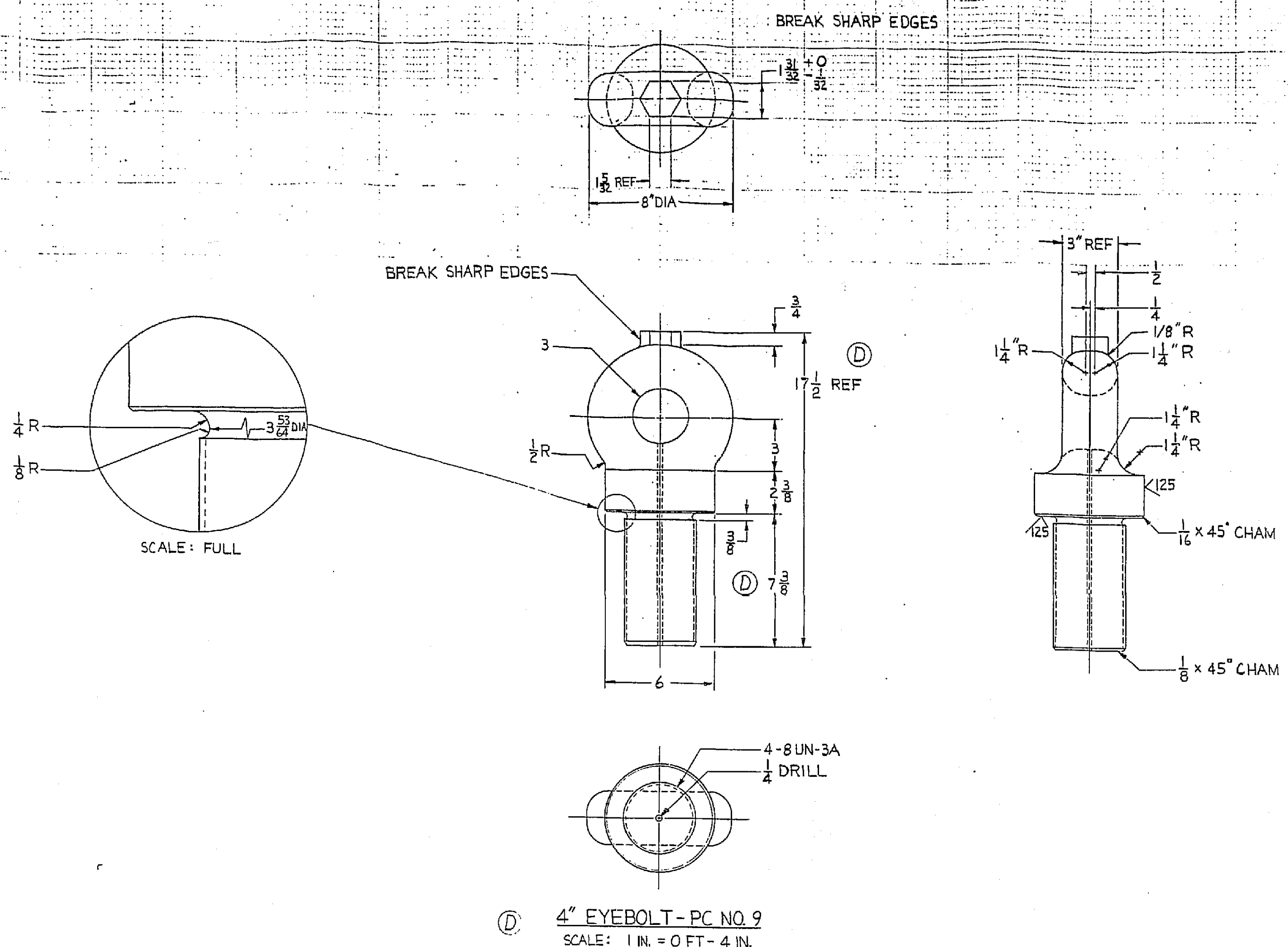
GENERAL NOTES

1. THE PURPOSE OF THIS DRAWING IS TO FABRICATE A TURNING BRACKET (J-BAR) FOR PROPELLERS.
2. THE CALCULATED WEIGHT OF THE TURNING BRACKET IS 7200 LB.
3. THE RATED LOAD OF THE TURNING BRACKET IS 75000 LB.
4. ALL DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, ALL TOLERANCES SHALL BE AS FOLLOWS:

| RANGE OF DIMENSIONS | TOLERANCES |
|-----------------------|------------|
| UNDER 18 INCHES | $\pm 1/32$ |
| 18 INCHES AND GREATER | $\pm 1/16$ |

5. CHANGING THICKNESS IN MATERIALS WILL RESULT IN HAZARDOUS LIFTING CONDITIONS.
6. PIECE NO. 3 AND 4 MUST BE CONTINUOUS PLATE EACH; NOT MADE OF INDIVIDUAL SECTIONS.
7. REMOVE ALL SHARP EDGES AND BURRS.
8. ALL STRUCTURAL WELDING SHALL BE IAW MIL-STD-1689 CODE 138.2 IS TO PROVIDE SPECIFIC WELDING INSTRUCTIONS.
9. SHOP 26 SHALL VISUALLY INSPECT THE ROOT WELD AND COMPLETED WELD BETWEEN PC 2 & 3, PC 2 & 16 AND PC 2 AND EACH PC 4, USING 5X MAGNIFICATION. ACCEPTANCE CRITERIA SHALL COMPLY WITH NAVSEA 0900-LP-003-8000 CHG 2 CLASS 1 WELD.
10. COMPLETED WELDS SHALL BE STRESS RELIEVED IAW MIL-STD-278E PRIOR TO ANY MACHINING OPERATIONS.
11. ASSEMBLY INSTRUCTIONS:
 - A. WELD PC 16 TO PC 2
 - B. INSTALL STRONGBACKS ON TOP OF PC 16 PRIOR TO PRODUCTION WELDING.
 - C. WELD PC 3 TO PC 2 AND PC 16 PRIOR TO WELDING PC 4 TO PC 2 AND PC 16.
 - D. SHOP 41 SHALL FORM PC 7 OVERSIZE AND SHOP 31 SHALL MACHINE PC 7 TO FINAL SIZE.
 - E. INSURE PC 6 FITS SQUARELY (WITHOUT ANY GAPS) BETWEEN PC 4 & 16 PRIOR TO WELDING.
12. LOAD TEST THE TURNING BRACKET TO 110% OF THE RATED LOAD, 82500 LB. CODE 266 WILL PROVIDE TEST PROCEDURE
13. PREPARATION AND PAINTING OF THE TURNING BRACKET SHALL BE IAW NAVSEA TECHNICAL MANUAL 59806-VD-STM-000, CH 631, CHG 5. PAINT THE TURNING BRACKET WITH ONE COAT OF ZINC CHROMATE PRIMER, TT-P-645, FORMULA 84/47, AND TWO FINISH COATS OF LIGHT GRAY ENAMEL, MIL-E-15090, FORMULA NO. 111.
14. STENCIL THE FOLLOWING INFORMATION USING ONE-INCH HIGH BLACK LETTERS ON A WHITE BACKGROUND ON A HIGHLY VISIBLE SECTION OF PC 4. SHOP 306.88 SHALL INDICATE EXACT LOCATION.

SER NO. (TO BE ASSIGNED)
 NICN 25-2010-LL-HAL-6103-P2
 DWG NO. 245-6111528-C
 PROP DWG NO. SSN-688-245-6308780
 MFR: PHILA. NAVSHIPYD
 RATED LOAD: 75000 LB
 TEST LOAD: 82500 LB
 TEST DATE: (MO-DY-YR)
 WEIGHT (ACTUAL)



④ 4" EYEBOLT - PC NO. 9
 SCALE: 1 IN. = 0 FT - 4 IN.

| ITEM NO. | QTY | CODE IDENT. | PART NO. | DESCRIPTION | MATERIAL | SIZE | REMARKS |
|---|-----|---------------|----------|---|----------|------|---------|
| PARTS LIST | | | | | | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS: 1/16 ANGLES: 1/2 DECIMALS: 1 | | | | DEPARTMENT OF THE NAVY PROPELLER MANUFACTURING CENTER PHILADELPHIA NAVAL SHIPYARD | | | |
| MATERIAL | | PREPARED | | | | | |
| | | CHECKED | | | | | |
| | | ENGINEER | | | | | |
| SIZE | | SUBMITTED BY: | | | | | |
| HARDNESS | | APPROVED BY: | | | | | |
| SIZE CODE IDENT. | | | | DRAWING NO. | | | |
| F 53711 | | | | 245-6111528 | | | |
| SCALE | | | | SHEET | | | |