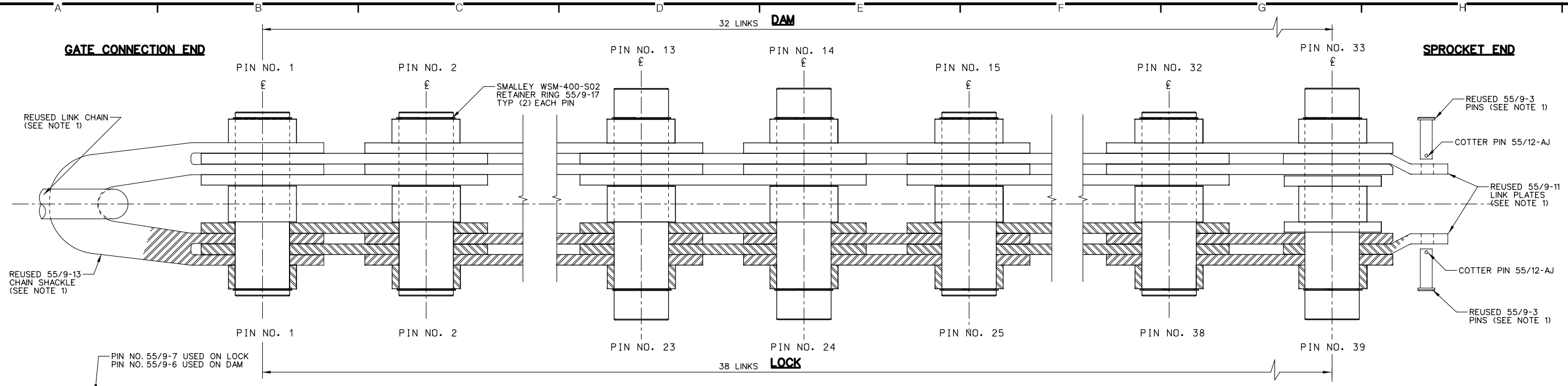
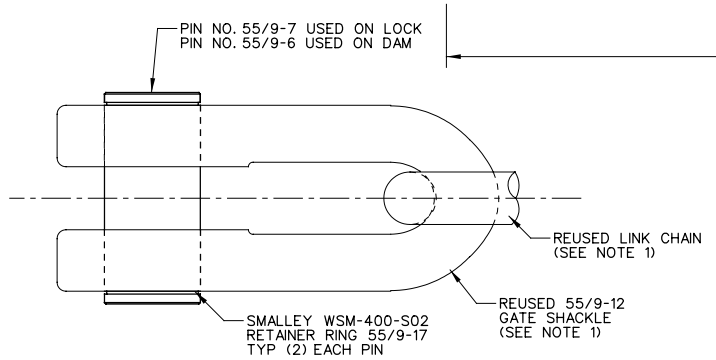


NEW CHAIN ASSEMBLY

TOTAL WT. OF CHAIN ASSEMBLY EACH (SEE B.O.M.)
SCALE: 3" = 1'-0"



NORMAL PIN

LOCK GATE CONNECTION
SCALE: 1/4" = 1'-0"

NOTES:

1. SEE REFERENCE DRAWING M-L-STA-55/9 FOR DIMENSIONS OF REUSED PARTS.
2. PIN LAYOUT EACH CHAIN ASSEMBLY:

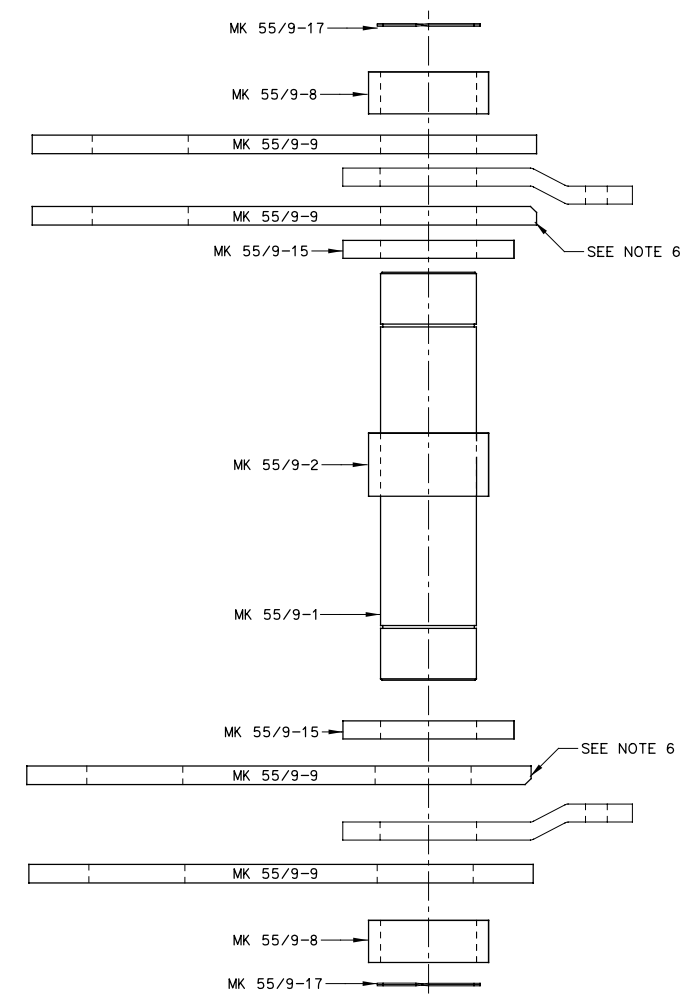
   DAM CHAIN PINS NUMBERED CONSECUTIVELY AS FOLLOWS:

   a) PIN NO'S 55/9-5 PIN'S #1 TO #12 INCL. AND #15 TO #32 INCL.
   b) PIN NO'S 55/9-1 PIN'S #13, #14 AND #33.

   LOCK CHAIN PINS NUMBERED CONSECUTIVELY AS FOLLOWS

   a) PIN NO'S 55/9-5 PIN'S #1 TO #11 INCL. AND #13 TO #22 INCL. AND #25 TO #38 INCL.
   b) PIN NO'S 55/9-1 PIN'S #12, #23, #24 AND #39.
3. TWO CHAIN ASSEMBLIES REQUIRED PER GATE.
   TEN(10) CHAIN ASSEMBLIES FURNISHED UNDER THIS CONTRACT.
4. WEIGHTS SHOWN ARE ESTIMATED. CONTRACTOR TO MEASURE / SUBMIT WEIGHT OF CHAIN ASSEMBLY TO NEAREST (+/-5 LB ACCURACY.
5. CHAMFER / RADIUS ALL SHARP EDGES 0.02" APPROXIMATE.
6. SEE SPECIFICATIONS FOR RELATED MACHINING AND MATERIAL REQUIREMENTS.

   CHAMFER INNER EDGE OF INNER END SIDE BARS 1/4" X 45 DEG. TO CLEAR REUSED LINK PLATE BEND.



PIN ASSEMBLY

FOR REFERENCE ONLY
SCALE: NONE

BILL OF MATERIALS

ITEM	MARK NUMBER	DESCRIPTION	MATERIAL / MFGR	WEIGHT EACH LBS.	QTY. FOR 2 LOCK GATES	QTY FOR 3 DAM GATES	QUANTITY OF SPARES EACH	TOTAL QUANTITY EACH	SUB TOTAL WEIGHT FURNISHED	NOTES
1	55/9-1	LONG PIN	ASTM A564 XM-25 COND H1050	5.9	16	18	2	36	212.40	
2	55/9-2	SPACER SLEEVE	ASTM B505 UNS C95500 HT	5.2	156	198	4	358	187.20	
3	55/9-5	NORMAL PIN	ASTM A564 XM-25 COND H1050	48	140	180	4	324	15552.00	
4	55/9-6	NORMAL PIN	ASTM A564 XM-25 COND H1050	45.5	0	6	1	7	318.50	
5	55/9-7	NORMAL PIN	ASTM A564 XM-25 COND H1050	31.2	4	0	1	5	156.00	
6	55/9-8	COLLAR	ASTM B505 UNS C95500 HT	3.5	312	396	8	716	2506.00	
7	55/9-9	SIDE BAR	ASTM B505 UNS C95500 HT	17	608	768	4	1380	23460.00	
8	55/9-15	SPACER WASHER	ASTM B505 UNS C95500 HT	6.3	8	12	0	20	126.00	
9	55/9-17	RETAINER RING	SMALLEY WSM-400-S02	0.075	320	408	50	778	58.35	
10	55/12-AJ	COTTER PIN 3/16 X 2.5" LONG	302/304 STAINLESS STEEL	0.1	16	24	4	44	4.40	
11										
					TOTAL WEIGHT OF PARTS FURNISHED (POUNDS)				42581	

US Army Corps of Engineers
St. Paul District

Symbol	Description	Date	Appr.

DESIGNED: MSK | CHECKED: MSK | DRAWN: FJB | DESIGNED: | CHECKED:
SCALE: | DATE: JUL/2004
CADD FILE NAME: MBPM455029.DGN
SOLICITATION NO.: W912ES-04-0-0020
APPROVING OFFICIAL:

DEPARTMENT OF THE ARMY
ST. PAUL, MINNESOTA
CORPS OF ENGINEERS
ST. PAUL DISTRICT

CONSTRUCTION DRAWING
LSAF - CHAIN SUPPLY CONTRACT
TAINTER GATE OPERATING MACH.
TAINTER GATE CHAIN
ASSEMBLY - BILL OF MATERIAL

DRAWING NUMBER:
M-LG-55/029

SHT 3 OF 4