

Revised 1 June, 1944
Revised 24 August, 1944

SEA ANCHOR

SPECIFICATION

Sea anchor shall be conical shaped and when completed shall be of the following dimension length to be 70 inches, with a tolerance of 2 inches plus or minus, diameter at mouth 36 inches, diameter at apex about 4 inches. To be constructed of No. 4 hard equal sections joined by flat seam(s) with the raw edges folded under so as to prevent raveling. The seam(s) shall be not less than 2-1/2" wide and shall be secured by machine cable. Such as one seam near the apex, provided the sewing is done in a seamanlike manner and that strength equal to the machine stitching is provided. There shall be four bails equidistant around the mouth, which shall be of extra heavy cotton webbing 2 inches wide conforming to U. S. Army Specification No. 6-185C dated 1 October, 1941 laid on the outside over the longitudinal seam(s) and attached to the sea anchor by at least 3 rows of stitching. The bails shall extend from the apex, as illustrated on the drawing, to a distance of about 4-1/2 feet beyond the mouth of the sea anchor at which point they will pass through a 1/2 inch swivel, designed for this purpose, and be carried to the apex on the opposite side. The bails shall be reinforced with a piece of the same kind of webbing, about 8 inches long, to form a wearing surface where the bails pass through the swivel. It is extremely important that all parts of the webbing forming the bails be of equal length and be securely stitched or seized with good marline close under the swivel. Alternate bails will terminate in a loop the apex, by folding the end back under its own parts.

A lanyard of 6 thread rope about 24 inches long shall be spliced into each of these loops for securing the oil container, thus preventing its loss when the anchor is tripped. There shall also be lanyard of 12 thread rope 2-1/2 fathoms long spliced into one of the above-mentioned loops, all eye splices to have four tucks and be further secured by palm and needle whippings. All ends of rope shall be finished with palm and needle whippings.

The mouth of the sea anchor shall be made with a seam 3 inches deep with the raw edge turned under and the seam secured by machine stitching near the edge. Cotton webbing, the same as used for the bails, shall be attached over the 3 inch seam close to the mouth, on the outside of the sea anchor and over the bails and be secured by 3 rows of machine stitching; the ends shall be lapped at least 3 inches. The apex end of the sea anchor shall be reinforced on the inside with a 4 inch tabling of the same duck flat stitched at both edges after all raw edges have been turned under. At a point approximately 4 inches from the apex, a ring made of the bail webbing material shall be attached to the outside of the sea anchor over the bails and be secured in the same manner as the webbing at the mouth.

All machine stitching shall be made with 4 ply, No. 10/4 heavy cotton thread conforming to Federal Specification V-T-276b Type IIIA, tensile strength (minimum) 11

pounds, using not less than 4 stitches to the inch. Thread of greater strength may be used if desirable. All hand sewing shall be with four parts 6-ply sail twine well waxed. All metal fittings, unless made of non-corrosive material, shall be heavily galvanized by the hot dipped process.

For manufacturers to secure approval, it will be necessary for them to submit a sample, constructed as outlined above. The sample, as well as all sea anchors constructed shall be stenciled with the manufacturer's name and address together with an identifying number or other marking and date of approval, for example:

Sea Anchor Type _____
John Jones Canvas and Rope Co., New York, N.Y.
Approved by U.S.C.G., 4 April, 1942