

AGS 1011		A	B	C	D	E
1	400 CUB. INS.	(.064) 16 S.W.G.	2.475"	.25"	16.5"	4.95"
2	620 CUB. INS.	(.08") 14 S.W.G.	3.705"	.26"	9.0"	7.57"
3	1000 CUB. INS.	(.08") 14 S.W.G.	3.75"	0	18.0"	7.5 ⁻⁰ / ₊₀₆

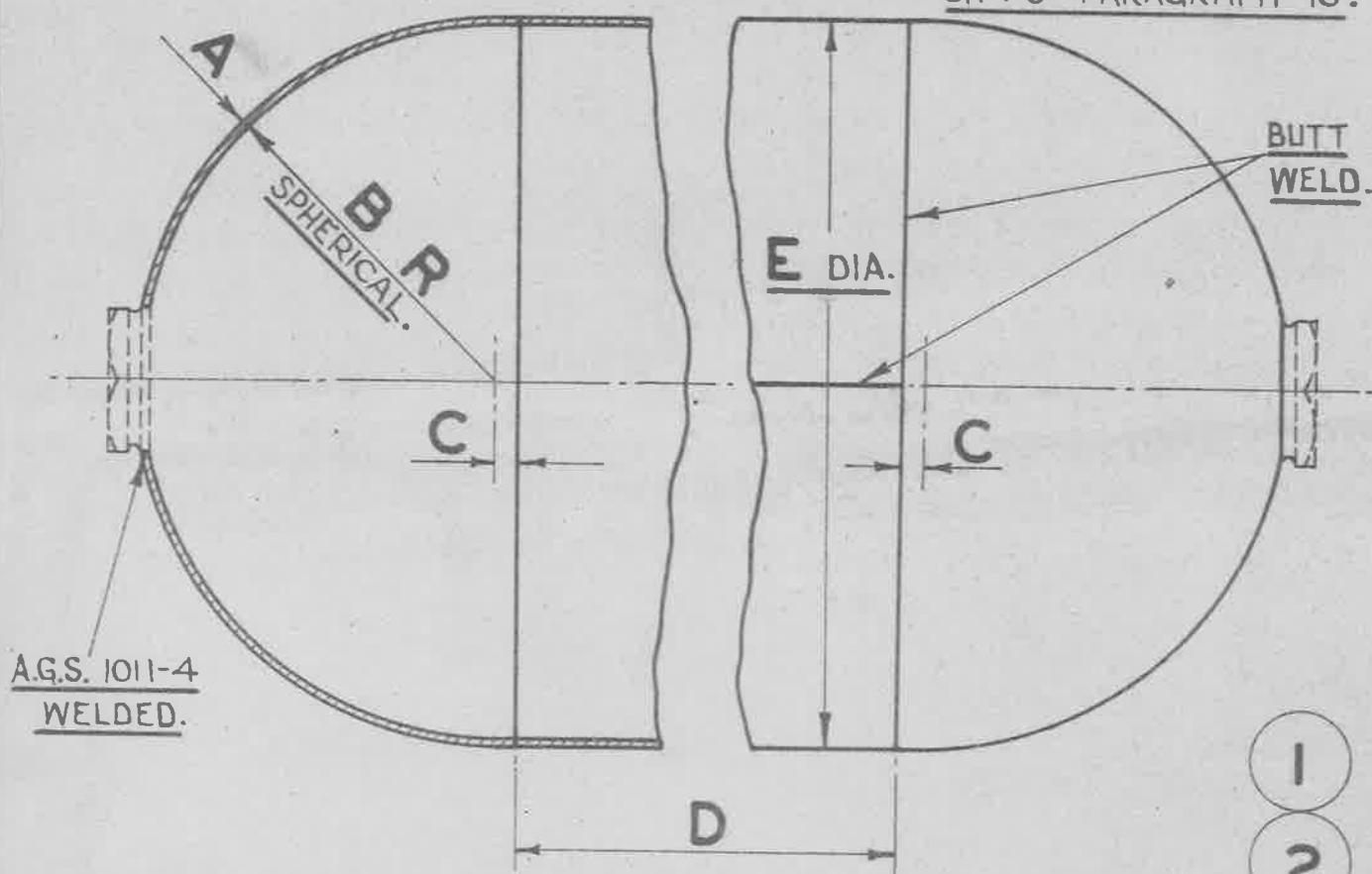
MINISTRY OF
AIRCRAFT
PRODUCTION.

AGS. N^o 1011.

SHT. N^o 1 N^o OF SH^{TS} 5

NOTE :-

ATTENTION IS DRAWN TO
SHT. 5 PARAGRAPH 10.

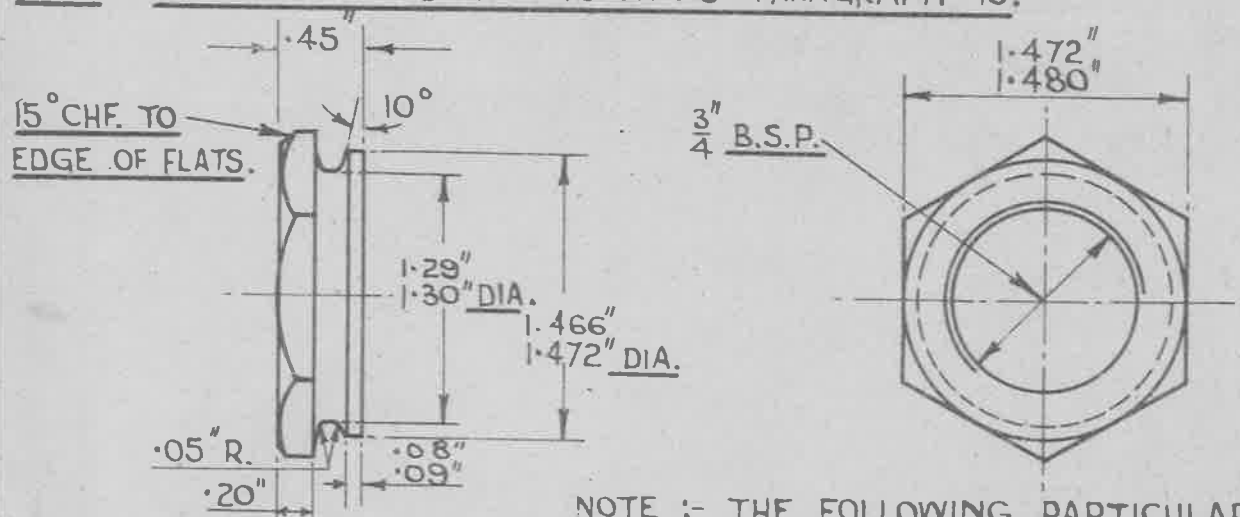



FOR FINISH & MARKING SEE SHT. 5 OF THIS A.G.S.

MAT^{ls}:- STEEL SPEC. D.T.D. 124 (SOFTENED CONDITION) LATEST ISSUE.

BODY.

NOTE :- ATTENTION IS DRAWN TO SHT. 5 PARAGRAPH 10.



NOTE :- THE FOLLOWING PARTICULARS ARE
TO BE STAMPED ROUND FLATS OF
HEXAGON. REF. N^o A  M
SERIAL N^o & MAKERS NAME

SCREW THREADS TO B.S. SPEC. 84-1940 MEDIUM FIT, TRUNCATED THREADS

TO AMENDMENT N^o 3-1945 UNLIMITED DIMENSIONS $\pm .01$ "

MATERIAL :- M. STEEL B.S. SPEC. S.21

TAPPED BOSS.

ISSUED BY THE
ROYAL AIRCRAFT
ESTABLISHMENT.

TITLE :-
STANDARD COMPRESSED AIR
BOTTLE DETAILS.

ISSUE N^o 1 2
ALTERN. N^o MOD. 65/265

DRAWN

TRACED

E.R. 6-8-48

CHECKED

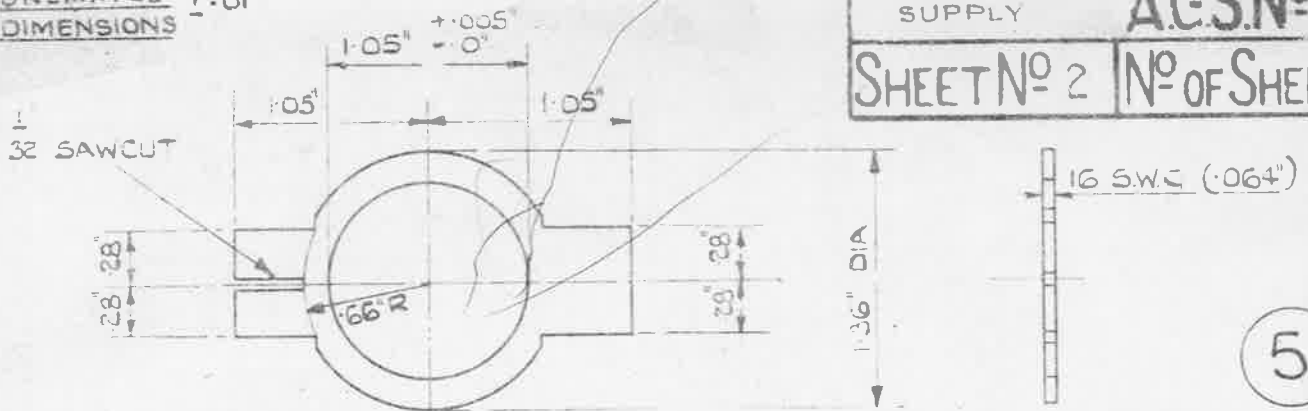
APPROVED

UNLIMITED DIMENSIONS ±.01

MINISTRY OF SUPPLY

ACS.N^o1011

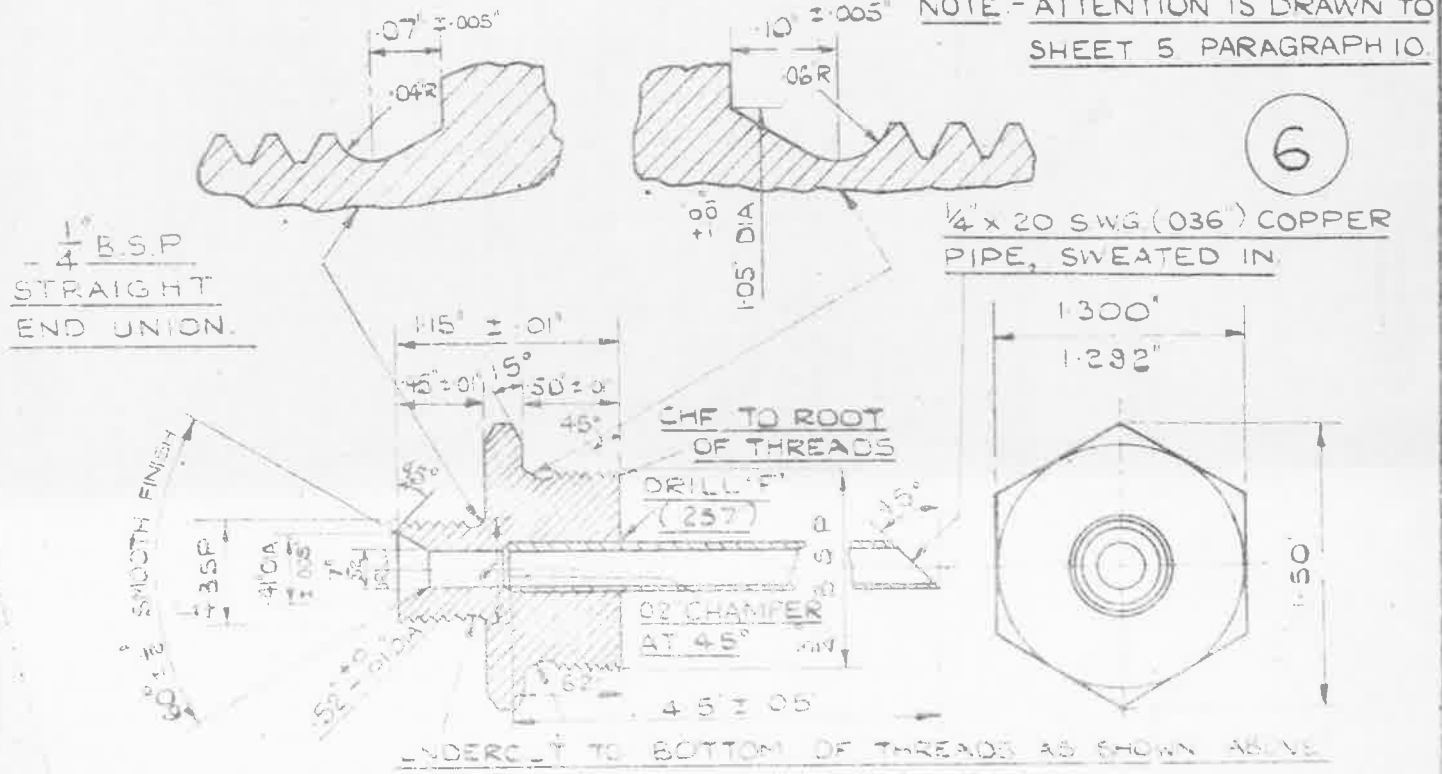
SHEET N^o 2 N^o OF SHEETS



MATERIAL:-
TO BE COPPER TO B.S.
SPEC: 899 (LATEST ISSUE).

TAB WASHER

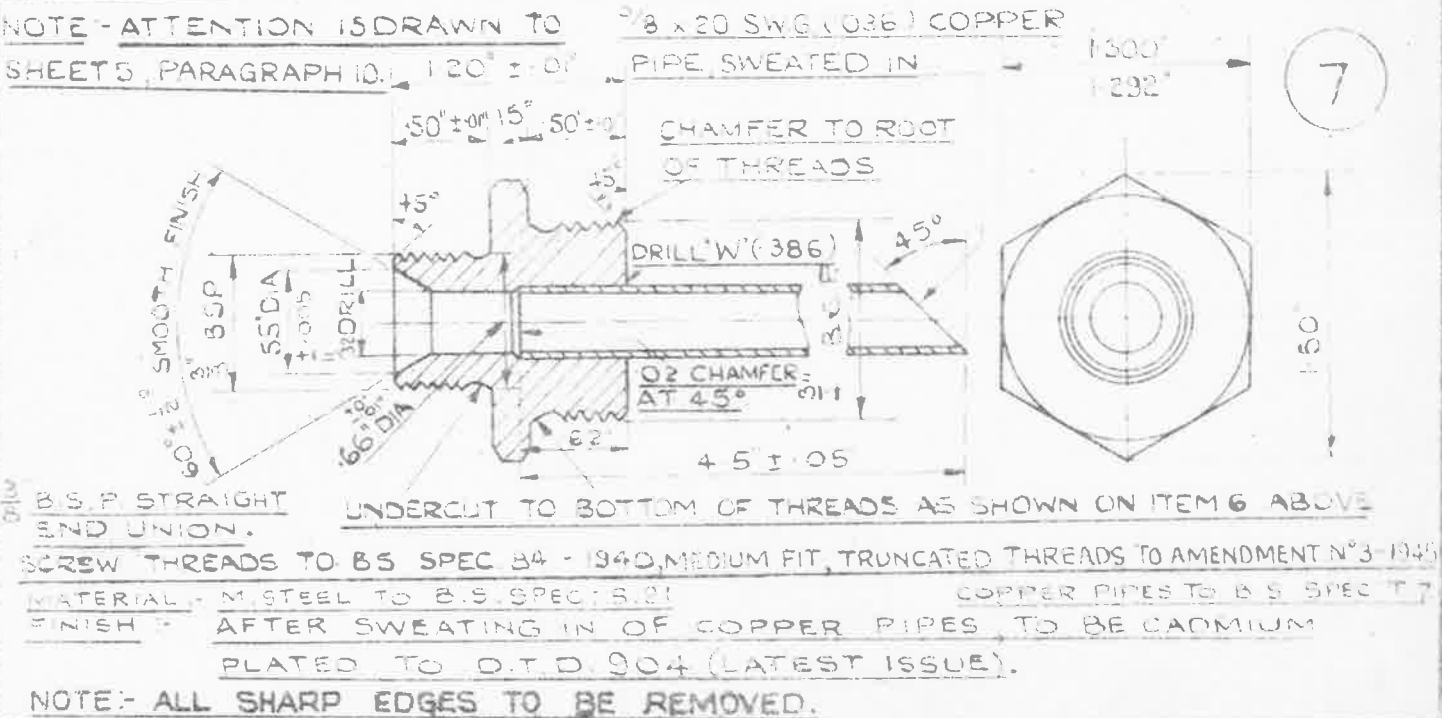
FINISH:- TO BE CADMIUM PLATED TO
SPEC: D.T.D. 904 (LATEST ISSUE) ALTERNATIVELY
ELECTRO-TIN, TO SPEC: D.T.D. 924 (LATEST ISSUE)



1/4 B.S.P.
STRAIGHT
END UNION.

1/4 x 20 SWG (0.036") COPPER
PIPE, SWEATED IN.

SCREW THREADS TO BS SPEC 84 - 1940, MEDIUM FIT, TRUNCATED THREADS TO AMEND N^o 3 - 1945
MATERIAL:- M STEEL BS SPEC 921
FINISH:- AFTER SWEATING IN OF COPPER PIPES, TO BE CADMIUM PLATED
TO SPEC. D.T.D. 904 (LATEST ISSUE).
NOTE:- ALL SHARP EDGES TO BE REMOVED.



B.S.P. STRAIGHT
END UNION.

3/8 x 20 SWG (0.036) COPPER
PIPE SWEATED IN.

SCREW THREADS TO BS SPEC 84 - 1940, MEDIUM FIT, TRUNCATED THREADS TO AMEND N^o 3 - 1945
MATERIAL:- M STEEL TO B.S. SPEC: 921
FINISH:- AFTER SWEATING IN OF COPPER PIPES, TO BE CADMIUM
PLATED TO D.T.D. 904 (LATEST ISSUE).
NOTE:- ALL SHARP EDGES TO BE REMOVED.

ISSUED BY THE ROYAL AIRCRAFT ESTABLISHMENT	TITLE - STANDARD COMPRESSED AIR BOTTLE DETAILS		DRAWN: <i>Sheth</i>	TRACED 200
	ISSUE N ^o	2	CHECKED <i>Sharma</i>	APPROVED 11-1-44
	ALTERN N ^o	577		200

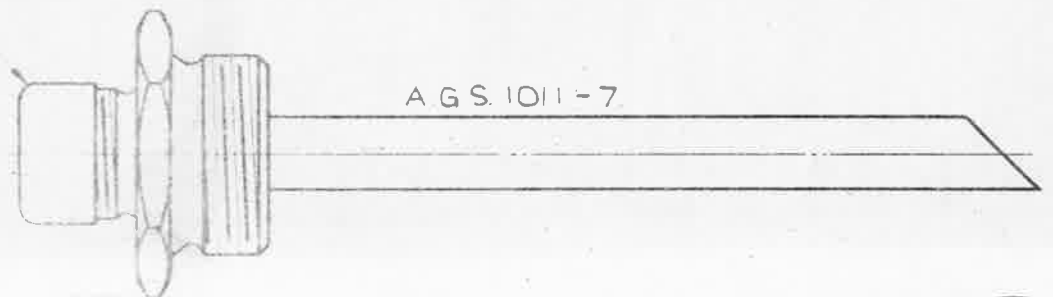
PROTECTION CAP A G S 597-B



AGS 1011-6.

6A

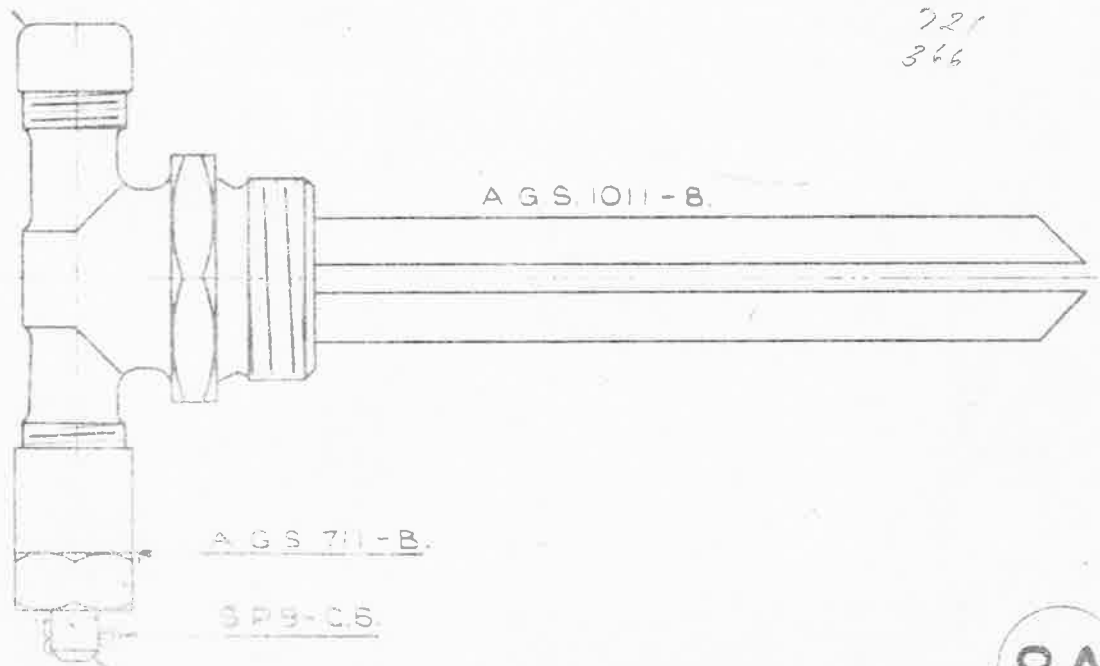
PROTECTION CAP A G S 597 -C



AGS 1011-7.

7A

PROTECTION CAP A G S 597 -B



AGS 1011-8.

AGS 711-B.

SP9-C5.

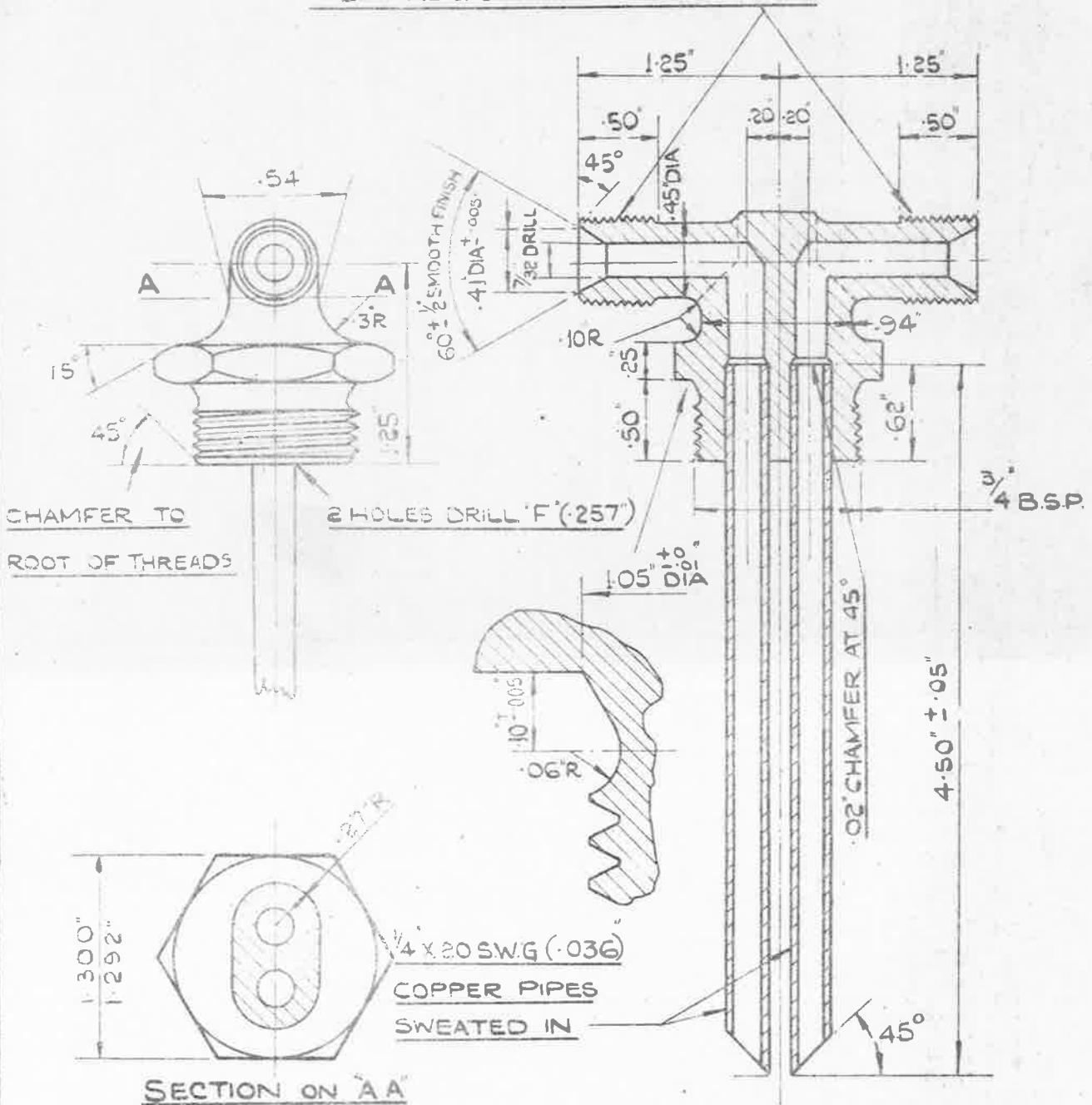
AGS 140-B

853 GR
142 343
298
721
366

8A

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT	TITLE - STANDARD COMPRESSED AIR BOTTLE - AS DRAWN FROM STORES				DRAWN <i>Shibbey</i>	TRACED D.E.M.P. <i>86.45</i>
	ISSUE NO <i>2</i>	MOD. NO. <i>AS/AGS</i>	AGS NO. <i>857</i>		CHECKED <i>10/11/45</i>	APPROVED <i>11/16/45</i>

$\frac{1}{4}$ BSP ALIGNMENT TO BE WITHIN 1°



UNLIMITED DIMENSIONS $\pm .01$

ALL SHARP EDGES TO BE REMOVED

SCREW THREADS TO B.S. SPEC 84 1940 MEDIUM

FIT TRUNCATED THREADS TO AMENDMENT N° 3 - 1945.

MATERIAL - BRASS OR GM. B.S SPEC. 218 OR 383 (LATEST ISSUES).

COPPER PIPES B.S. SPEC T7 (LATEST ISSUE).

NOTE: - ATTENTION IS DRAWN TO SHEET 5 PARAGRAPH 10.

FINISH: - AFTER SWEATING IN OF COPPER PIPES TO BE CADMIUM PLATED TO SPEC: D.T.D. 904 (LATEST ISSUE), ALTERNATIVELY ELECTRO-TIN TO SPEC: D.T.D. 924 (LATEST ISSUE).

'T' END UNION

8

ISSUED BY THE ROYAL AIRCRAFT ESTABLISHMENT	TITLE: - STANDARD COMPRESSED AIR BOTTLE - DETAILS			DRAWN. <i>Siphney</i>	TRACED D. KELLY 15 11.44
	ISSUE N°	2	3	CHECKED <i>MAOR</i>	APPROVED <i>[Signature]</i>
	ALTER N°	577	663	857	

SPECIFICATION FOR AIR BOTTLES.

- 1) THE BOTTLES ARE TO CONFORM TO THE MATERIALS AND DIMENSIONS ON SHEETS 1 TO 4
- 2) THE MATERIAL FOR THE SHELL IS TO BE IN THE SOFTENED CONDITION. THE ASSEMBLY (BARREL, ENDS AND BOSSES) IS TO BE NORMALISED (PARA. 4) AFTER WELDING.
- 3) THE STEEL SHEETS ARE TO BE THOROUGHLY CLEANED BEFORE WELDING, & CARE TAKEN TO ENSURE THAT NO GREASE, PAINT OR OTHER FOREIGN MATTER (WHICH WILL PREVENT ADHESION OF THE ZINC WHEN GALVANISING) IS SUBSEQUENTLY ALLOWED TO GET ON THE SURFACE.
- 4) NORMALISING: PLACE IN NON-OXYDIZING ATMOSPHERE FURNACE PRE-HEATED TO 860°/880°C; ALLOW BOTTLES TO ATTAIN FURNACE TEMPERATURE & SOAK FOR 20 MINUTES AT 860°/880°C. REMOVE FROM FURNACE & COOL FREELY IN STILL AIR.
- 5) AFTER NORMALISING, THE BOTTLES ARE TO BE "RUMBLIED" INSIDE WITH STEEL SHAVINGS TO REMOVE LOOSE WELDING SCALE & THE DUST & SHAVINGS THOROUGHLY CLEANED OUT BEFORE GALVANISING. BOTTLES ARE TO BE INSPECTED & GALVANISED IMMEDIATELY AFTER RUMBLING SO THAT RUSTING MAY NOT OCCUR IN THE INTERVAL BETWEEN RUMBLING & GALVANISING.
- 6) WHEN GALVANISING, BOTTLES MUST BE COMPLETELY & SMOOTHLY COATED, THE COATING TO BE OF EVEN THICKNESS INSIDE & OUTSIDE & REASONABLY FREE FROM BLOBS & LUMPS OF ZINC.
- 7) THREADS AND FACES OF END BOSSES ARE TO BE CLEANED IF NECESSARY AFTER GALVANISING.
- 8) FINISHED BOTTLES ARE TO BE THOROUGHLY CLEANED INSIDE & OUTSIDE & CLOSELY EXAMINED TO SEE THAT THE SURFACES ARE COMPLETELY COATED WITH ZINC. A METHOD OF DETECTING UNCOATED SPOTS IS BY WASHING WITH A HOT 10% SOLUTION OF CAUSTIC SODA & NOTICING WHETHER ANY LOCAL EFFERVESCENCE TAKES PLACE, SUCH EFFERVESCENCE WOULD DENOTE LACK OF COATING AT THE SPOT WHERE IT OCCURS. THE BOTTLES MUST BE RINSED REPEATEDLY WITH CLEAN WATER AFTER BEING TESTED IN THIS WAY IN ORDER TO AVOID TRACES OF CAUSTIC SODA BEING LEFT INSIDE.
- 9) EACH BOTTLE IS TO BE THOROUGHLY DRIED INSIDE & TESTED BY FILLING WITH OIL TO A PRESSURE OF 800 LB. PER SQ. IN. FOR 3 MINUTES
- 10) ALL OPENINGS ARE TO BE BLANKED OFF WITH STANDARD A.G.S. PROTECTIVE CAPS OR PLUGS TO PREVENT INGRESS OF FOREIGN MATTER & TO PROTECT SCREW THREADS AGAINST DAMAGE.
- 11) BOTTLES & FITTINGS ARE TO BE PAINTED GREY IN ACCORDANCE WITH B.S. SPEC. No 349 & TO HAVE THE FOLLOWING WORDING STENCILLED WITH RED PAINT IN 1" LETTERING.

AIR.

TYPE, CAPACITY, ----- * ----- CUB. INS.

MAX. WORKING PRESSURE 450 LB. PER SQ. INCH.

TEST PRESSURE 800 LB. PER SQ. INCH.

MAKERS NAME -----

DATE OF MANUFACTURE -----

*"E.-620", "F.-400", OR "G.-1,000", AS REQUIRED.

ISSUED BY THE ROYAL AIRCRAFT ESTABLISHMENT	TITLE:- STANDARD COMPRESSED AIR BOTTLE				DRAWN. <i>Shirley</i>	TRACED DEPT. 64-25
	ISSUE NO	1	SM 2 ⁴¹⁹		CHECKED <i>John</i>	APPROVED.
	ALTER: NO	100 AGS/577	AS/ASS 857			<i>John</i>