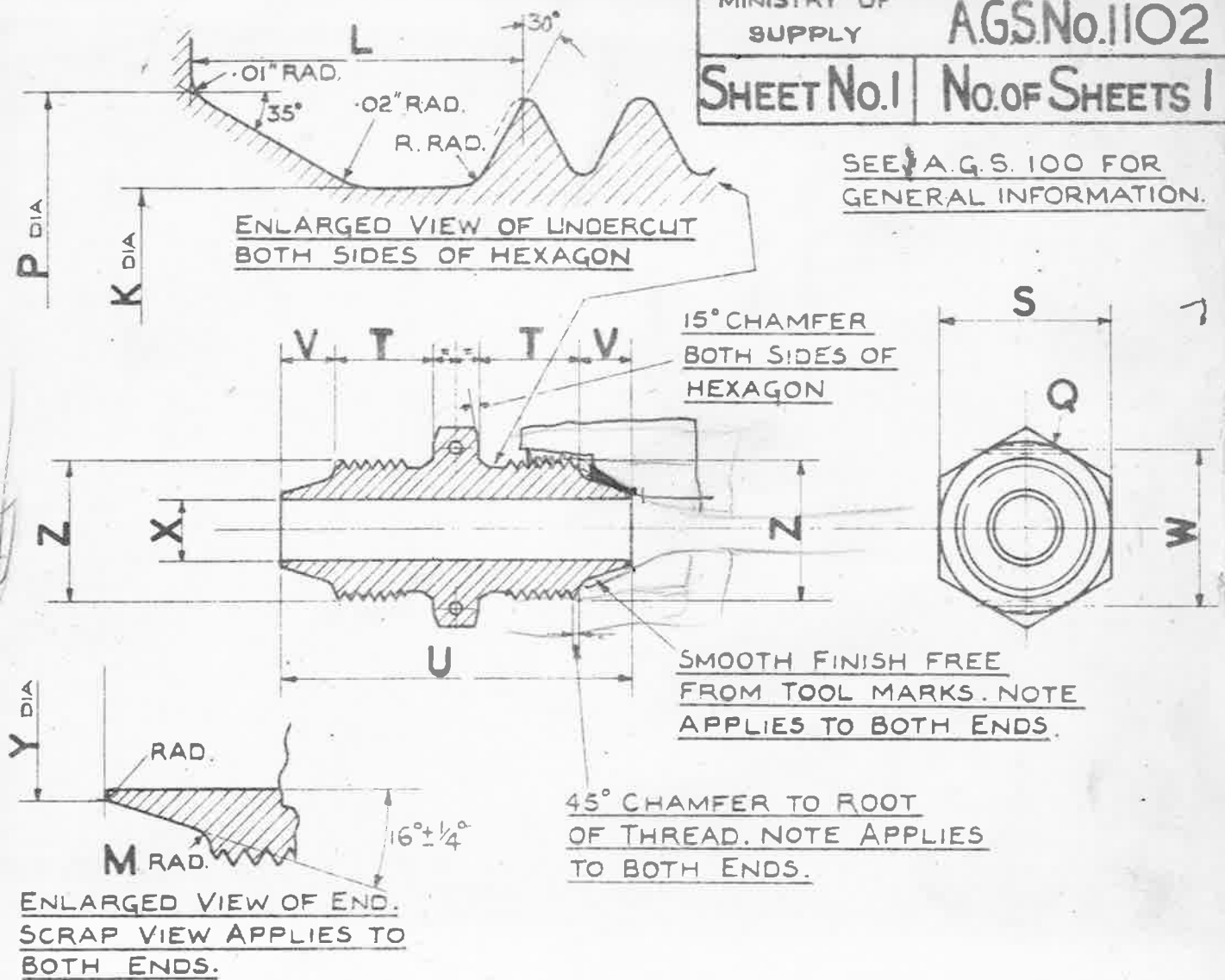


SEE A.G.S. 100 FOR
GENERAL INFORMATION.



MARK	O/D OF PIPE	Z	Y	X	W	V	U	T	S	R	Q	P	M	L	K	
		B.S.P. THREAD	+0.010 -0	DRILL	±.01"	+0.01" -0	±.01"	±.01"	MIN	MAX	RAD	DRILL	+0 -.01"	RAD	+0.01" -0	+0 -.005
A	3/16"	1/8"	.160"	3/32"	.54"	.22"	1.55"	.43"	.595"	.600"	.01"	1/16"	.39"	.03"	.10"	.330"
B	1/4"	1/4"	.224"	5/32"	.67"	.28"	1.73"	.46"	.705"	.710"	.01"	1/16"	.52"	.04"	.14"	.440"
B.B.	5/16"	19.T.P.I. 60% B	.267"	3/16"	.79"	.32"	1.85"	.48"	.815"	.820"	.01"	1/16"	.60"	.04"	.14"	.525"
C	3/8"	3/8"	.333"	1/4"	.92"	.32"	1.97"	.53"	.915"	.920"	.01"	1/16"	.66"	.04"	.14"	.580"
C.C.	7/16"	14.T.P.I. 75% B	.377"	5/16"	.96"	.32"	2.06"	.57"	1.002"	1.010"	.015"	1/16"	.75"	.06"	.18"	.650"
D	1/2"	1/2"	.438"	3/8"	.96"	.32"	2.12"	.60"	1.002"	1.010"	.015"	1/16"	.83"	.06"	.18"	.720"

THE MATERIAL TO BE LIGHT ALLOY TO D.T.D. 423. (LATEST ISSUE).

FINISH:- TO BE ANODISED TO SPEC D.T.D 910.(LATEST ISSUE)

NOTES:- SCREW THREADS TO B.S. SPEC N° 84 - 1940.

MEDIUM FIT, TRUNCATED THREADS TO AMENDMENT N° 3 - 1945.

FOR ARRANGEMENT OF PIPE JOINT, SEE A.G.S N° 1101

WORKING PRESSURE:- 3000 LB/SQ IN FOR SIZES UP TO 1/2" B.S.P

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT	TITLE:- PIPE COUPLINGS.(LIGHT ALLOY). CONE UNION BODY, 3/16" TO 1/2"					DRAWN K.Wilson	TRACED 6/11/9-45	
	ISSUE N°	3	4	8	6	6	CHECKED	APPROVED
	ALTER N°	MOD N°	AS/ACS	AS/ACS	AS/ACS	SM	CT Reynolds	1/11/45
		AGS/609	603	877	988	856		

A.G.S. 1102. SHEET. 2.

REVISED 31M 2027

MARK	O/DIA. OF PIPE	K	L	M RAD.	P	Q DRILL RAD.	R RAD.	S	T	U	V	W	X DRILL	Y	Z
															B.S.P.F. THREAD
A	$\frac{3}{16}$	330	110	.03	390	$\frac{1}{16}$.01	.600	.440	1.560	.230	.550	$\frac{3}{32}$.170	$\frac{1}{8}$
B	$\frac{1}{4}$	440	150	.04	520	$\frac{1}{16}$.01	.710	.470	1.740	.290	.680	$\frac{5}{32}$.234	$\frac{1}{4}$
B-B	$\frac{5}{16}$	525	150	.04	600	$\frac{1}{16}$.01	.820	.490	1.860	.330	.800	$\frac{5}{16}$.277	19 TPI
C	$\frac{3}{8}$	580	150	.04	660	$\frac{1}{16}$.01	.920	.540	1.980	.330	.930	$\frac{1}{4}$.343	$\frac{3}{8}$
C-C	$\frac{7}{16}$	650	190	.06	750	$\frac{1}{16}$.015	1.010	.580	2.070	.330	.970	$\frac{5}{16}$.387	14 TPI
D	$\frac{1}{2}$	720	190	.06	830	$\frac{1}{16}$.015	1.010	.610	2.130	.330	.970	$\frac{3}{8}$.448	$\frac{1}{2}$

ON MARKS 'BB' AND 'CC' THREADS TO BE TO B.S. SPEC. NR 84 WHITWORTH FORM.

REF.	DRAWING OR PART No.	DESCRIPTION	SCALE	UNITS (NOT SHOWN)	MATERIAL—REMARKS
		PIPE COUPLING (ALUMINUM ALLOY)			
		CONE UNION BODY			

DESIGNED BY THE SOCIETY OF BRITISH AIRCRAFT ENGINEERS LTD., 25 KING STREET, ST. JAMES'S, LONDON, S.W.1.

A.G.S. 1102-SHEET 2.

THIS IS A PHOTOGRAPHIC REDUCTION. DRAWING MUST NOT BE SCALED.

A. G. S. 1102 - SHEET 1.

REV	DATE	BY	CHKD
10	7-95		
11	7-95		
12	8-95		

SM 2024

PART NO. HERE



ENLARGED VIEW OF UNDERCUT BOTH SIDES OF HEXAGON



ENLARGED VIEW OF END. SCRAP VIEW APPLIES TO BOTH ENDS.

15° CHAMFER BOTH SIDES OF HEXAGON



SECTION X-A

45° CHAMFER TO ROOT OF THREAD NOTE APPLIES TO BOTH SIDES

SEE A. G. S. 1100 FOR GENERAL INFORMATION.
 B. S. P. THREADS TO B. S. SPEC. NO. 2779 MEDIUM FIT TRUNCATED
 WORKING PRESSURE - 3000 LB./SQ. IN.
 FOR ARRANGEMENT OF PIPE JOINT SEE A. G. S. NO. 1101

ITEM NO.	DESCRIPTION	QTY	HT		HT		HT		MATERIAL	FINISH	TOLERANCE
			HT	HT	HT	HT					
1	NUT	1									
2	WASHER	1									
3	SCRAP	2									

A. G. S. 1102 SHEET 1