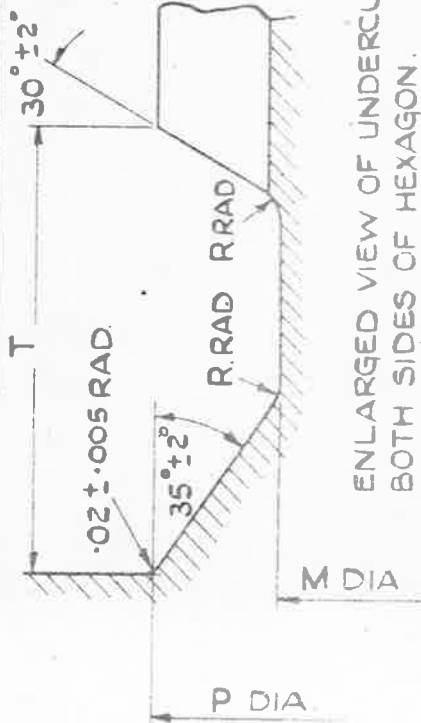


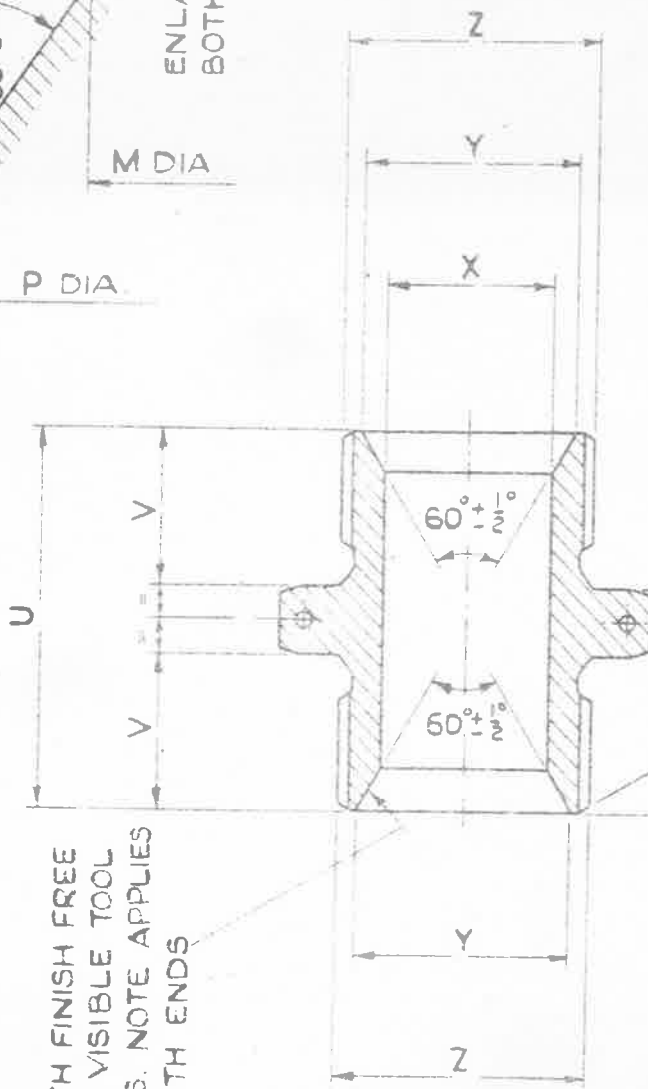
ALL DIMENSIONS ARE IN INCHES.

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

SMOOTH FINISH FREE FROM VISIBLE TOOL MARKS. NOTE APPLIES TO BOTH ENDS

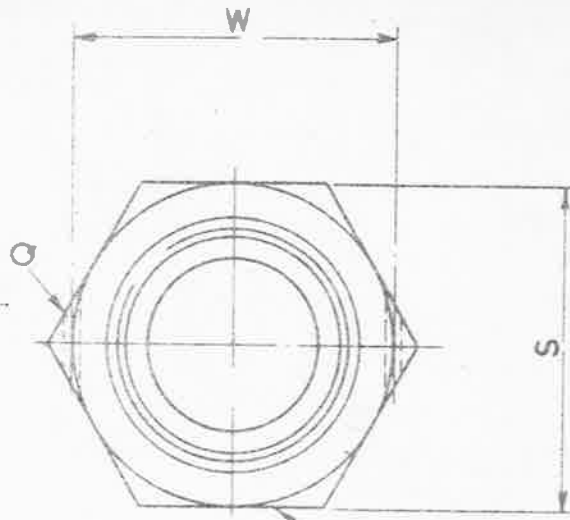


ENLARGED VIEW OF UNDERCUT BOTH SIDES OF HEXAGON.



30° ± 2° CHAMFER TO ROOT OF THREAD NOTE APPLIES TO BOTH ENDS

15° ± 2° CHAMFER BOTH SIDES OF HEXAGON



AGS 1103 - * TO BE LEGIBLY & DURABLY MARKED ON THIS OR OPPOSITE FACE (* MARK)

MATERIAL:- LIGHT ALLOY TO SPEC: DTD 423 (LATEST ISSUE)

FINISH:- ANODISE TO SPEC: DTD 910 (LATEST ISSUE)

NOTE:- SCREW THREADS TO BS SPEC: B4 (LATEST ISSUE) MEDIUM FIT, TRUNCATED FOR DIAMETERS AND TOLERANCES OF MARKS BB & CC, AND TRUNCATED DIMENSIONS OF MARKS BB, CC, L, M & P SEE AGS 100 SHEET 5

TITLE PIPE COUPLINGS, (LIGHT ALLOY), UNION BODY, 3/16 TO 2 1/2"

ISSUE	3	6	6
ALT. NO.	MONAGS 960	AS/AGS 988	SM 856

MINISTRY OF SUPPLY
APPLICATIONS FOR A.G.S. SHEETS TO AT.P4, BLOCK 'E', CHESSINGTON, SURREY.
GENERAL ENQUIRIES TO: AD/SAE, ST. GILES COLONY, 1-13 ST. GILES HIGH STREET, LONDON W3 2

RAE APPROVAL	
SIGNATURE	DATE
<i>[Signature]</i>	13.10.53
AND SAE APPROVAL	
SIGNATURE	DATE
<i>[Signature]</i>	27.12.53

NUMBER OF SHEETS 2.

A.G.S. No. 1103. SHEET 1.

ALL DIMENSIONS ARE IN INCHES.

A.G.S. 1103. SHEET 2.

MARK	O/DIA. OF PIPE	Z B.S.P. THREAD	Y ±.005	X DRILL OR BORE	W ±.01	V ±.01	U ±.015	T +01 -0	S		R ±.005	Q DRILL	P +0 -.01	M +0 -.005	WORKING PRESSURE LB./SQ. IN.
									MIN.	MAX.					
A	3/16	1/8	.295	3/32	.54	.45	1.15	.10	.595	.600	.02	1/16	.39	.330	3,000
B	1/4	1/4	.410	5/32	.67	.45	1.18	.14	.705	.710	.03	1/16	.52	.440	3,000
BB	5/16	19 T.P.I. .60 O/D	.480	3/16	.79	.52	1.29	.14	.815	.820	.03	1/16	.60	.525	3,000
C	3/8	3/8	.550	1/4	.92	.52	1.31	.14	.915	.920	.03	1/16	.66	.580	3,000
CC	7/16	14 T.P.I. .75 O/D	.600	5/16	.96	.55	1.38	.18	1.002	1.010	.04	1/16	.75	.650	3,000
D	1/2	1/2	.690	3/8	.96	.65	1.58	.18	1.002	1.010	.04	1/16	.83	.720	3,000
E	5/8	5/8	.760	1/2	1.06	.70	1.70	.18	1.092	1.100	.04	1/16	.91	.800	500
F	3/4	3/4	.900	5/8	1.26	.75	1.80	.18	1.292	1.300	.04	.076 (No 48)	1.05	.940	500
G	7/8	7/8	1.040	3/4	1.37	.80	1.95	.18	1.382	1.390	.04	.076 (No 48)	1.19	1.085	500
H	1	1	1.130	7/8	1.68	.80	1.95	.23	1.658	1.670	.05	.076 (No 48)	1.31	1.180	500
J	1 1/4	1 1/4	1.450	1 1/8	2.03	.83	2.06	.23	2.035	2.050	.05	.076 (No 48)	1.66	1.520	200
K	1 1/2	1 1/2	1.680	1 3/8	2.14	.85	2.10	.23	2.200	2.220	.05	.076 (No 48)	1.89	1.750	200
L	1 3/4	1 3/4	1.920	1 5/8	2.36	.95	2.35	.23	2.390	2.410	.05	.076 (No 48)	2.12	1.990	200
M	2	2	2.150	1 7/8	2.77	1.00	2.50	.23	2.735	2.760	.05	.076 (No 48)	2.35	2.220	200
N															
P	2 1/2	2 1/2	2.750	2 3/8	3.40	1.10	2.70	.23	3.320	3.340	.05	.076 (No 48)	2.97	2.830	100

TITLE PIPE COUPLINGS, (LIGHT ALLOY), UNION BODY, 3/16 TO 2 1/2. ISSUE 5M 720

ALT. NO. MOD. AGS. 960

MINISTRY OF SUPPLY
 APPLICATIONS FOR A.G.S. SHEETS TO:
 PATRICK BLOCKER, CHIEF AGS. SHEETS TO:
 GENERAL ENQUIRIES TO:
 A.D. SAE, ST. GILES COLTAT, 1-13
 ST. GILES HIGH STREET, LONDON WC2

RAE APPROVAL
 SIGNATURE DATE
 A.D. SAE APPROVAL
 SIGNATURE DATE

NUMBER OF SHEETS 2.

A.G.S. No. 1103. SHEET 2.

A.G.S. 1103 - SHEET 1.

1	8
2	10
3	11
4	12
5	13
6	14
7	15
8	16
9	17
10	18
11	19
12	20

SM.2024

PART N° HERE.



SEE A.G.S. 100 FOR GENERAL INFORMATION. B.S.P.F. THREADS TO B.S. SPEC. NO 2779 MEDIUM FIT TUBICATED.

NO.	DESIGN OF PART	A.L.	DATE	PT.	R.	S.	HT.						

MADE BY THE WORKS OF BRITISH NUBRONEX COMPANY LTD. 14 ONE STREET ST. JAMES, LONDON S.W.1.

A.G.S. 1103 - SHEET 1.

AGS. 1103 - SHEET 2.

MARK	O/DIA. OF PIPE	M K	P	Q DRILL	R	S	T	U	V	W	X DRILL OR BORE	Y	Z B.S.P.F. THREAD	WORKING PRESSURE LBS./SQ. IN.												
															A	B	C	D	E	F	G	H	I	J	K	L
A	3/16	330	390	1/16	0.23	600	110	1.65	460	550	3/32	300	1/8	3000												
B	1/4	325	380	1/16	0.15	595	100	1.35	440	530	3/32	290	1/8	3000												
B-B	5/16	440	520	1/16	0.35	710	150	1.95	460	580	5/32	415	1/4	3000												
C	3/8	435	510	1/16	0.25	705	140	1.65	440	560	3/32	405	1/4	3000												
C-C	7/16	525	600	1/16	0.35	820	150	1.95	530	800	3/16	485	19 T.P.I.	3000												
D	1/2	520	590	1/16	0.45	815	140	1.75	510	780	1/4	475	60 T.P.I.	3000												
E	5/8	575	650	1/16	0.55	920	150	1.95	530	810	1/4	535	3/8	3000												
F	3/4	645	740	1/16	0.45	1010	190	1.365	560	970	5/16	605	14 T.P.I.	3000												
G	7/8	720	830	1/16	0.35	1002	180	1.365	540	950	5/16	595	75 T.P.I.	3000												
H	1	715	820	1/16	0.45	1010	190	1.595	600	970	3/8	695	1/2	3000												
J	1 1/4	800	910	1/16	0.45	1002	180	1.365	640	950	3/8	685	1/2	500												
K	1 1/2	795	900	1/16	0.35	1092	180	1.665	690	1050	1/2	735	5/8	500												
L	1 3/4	940	1050	No 48	0.45	1300	190	1.815	760	1270	5/8	905	3/4	500												
M	2	935	1040	(0.076 DIA)	0.35	1292	180	1.785	740	1250	5/8	895	3/4	500												
N	2 1/4	1085	1190	No 48	0.45	1390	190	1.965	810	1380	3/4	1045	7/8	500												
O	2 3/4	1080	1180	(0.076 DIA)	0.35	1382	180	1.935	790	1360	3/4	1035	7/8	500												
P	3	1175	1300	No 48	0.55	1670	240	1.935	810	1390	7/8	1155	1	500												
Q	3 1/4	1320	1460	(0.076 DIA)	0.45	1658	240	1.935	790	1370	7/8	1125	1	500												
R	3 1/2	1355	1500	No 48	0.45	2050	240	2.075	840	2040	1	1455	1 1/4	200												
S	3 3/4	1515	1650	(0.076 DIA)	0.45	2035	240	2.045	820	2020	1 1/8	1445	1 1/4	200												
T	4	1750	1900	No 48	0.55	2220	240	2.115	860	2150	1 1/8	1685	1 1/2	200												
U	4 1/4	1745	1880	(0.076 DIA)	0.45	2200	240	2.085	840	2130	1 1/8	1675	1 1/2	200												
V	4 1/2	1990	2120	No 48	0.55	2410	240	2.365	960	2370	1 5/8	1925	1 3/4	200												
W	4 3/4	1985	2110	(0.076 DIA)	0.45	2390	240	2.335	940	2350	1 5/8	1915	1 3/4	200												
X	5	2220	2350	No 48	0.55	2760	240	2.515	1010	2780	1 7/8	2155	2	200												
Y	5 1/4	2215	2340	(0.076 DIA)	0.45	2735	240	2.485	990	2760	1 7/8	2145	2	200												
Z	5 1/2	2830	2970	No 48	0.55	3340	240	2.715	1110	3410	2 3/8	2755	2 1/2	100												
AA	5 3/4	2825	2960	(0.076 DIA)	0.45	3320	240	2.685	1090	3390	2 3/8	2745	2 1/2	100												

ON MARKS 'BB' AND 'CC' THREADS TO BE
TO B.S. SPEC. NO 84 WHITWORTH FORM.

DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR	DATE
					27.7.52
MEMBER OF THE SOCIETY OF METALLURGICAL ENGINEERS LTD., 16, KING STREET, ST. JAMES'S, LONDON, W.1.					
DRAWING OR PART NO.			SCALES	PIPE COUPLINGS (AT U.M.M. ALLOW)	UNION BODY 3/16 TO 2 1/2"
DESCRIPTION			LIMITS NOT SHOWN		
MATERIAL—REMARKS					
AGS. 1103 - SHEET 2					