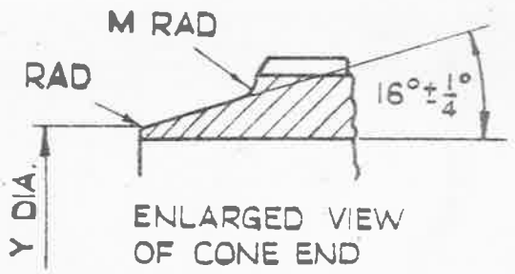
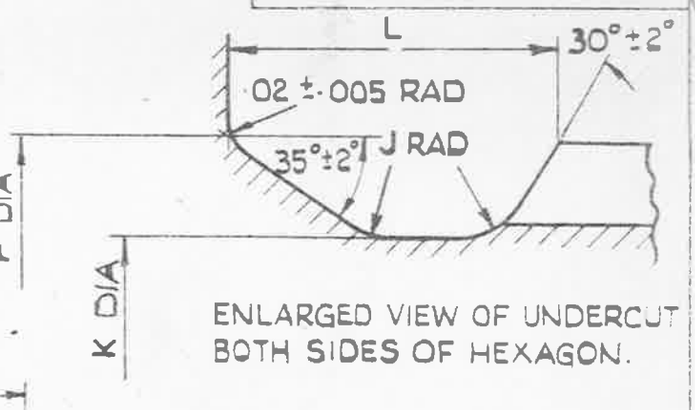
ALL DIMENSIONS ARE IN INCHES.

A.G.S. 1104 SHEET 1

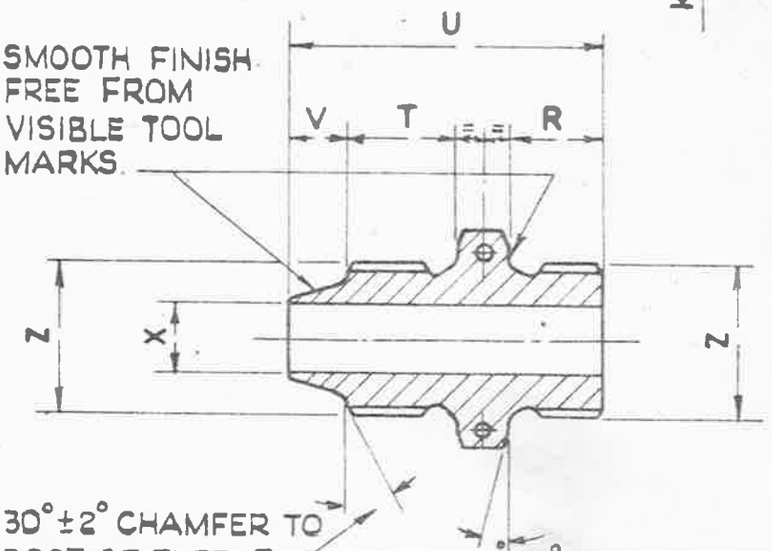


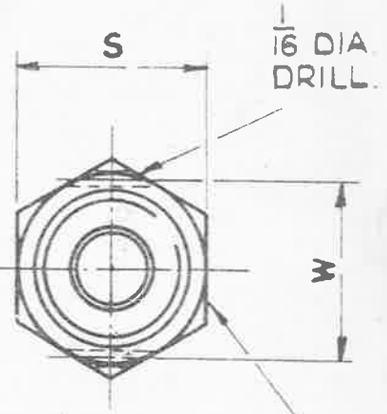
ENLARGED VIEW OF CONE END



ENLARGED VIEW OF UNDERCUT BOTH SIDES OF HEXAGON.

SMOOTH FINISH FREE FROM VISIBLE TOOL MARKS.





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

15°±2° CHAMFER BOTH SIDES OF HEXAGON.

A.G.S. 1104 - * TO BE LEGIBLY & DURABLY MARKED ON THIS OR OPPOSITE FACE (* MARK.)

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

ALL SHARP EDGES AND BURRS TO BE REMOVED.

MARK	O/D OF PIPE	Z B.S.P. THREAD	Y +·010 -0	X DRILL	W ±·01	V +·01 -0	U ±·01	T ±·01	S MIN.	S MAX.	R ±·01	P +0 -·01	M ±·005	L +·01 -0	K +0 -·005	J ±·005
A	3/16	1/8	·160	3/32	·54	·22	1·25	·43	·595	·600	·35	·39	·03	·10	·330	·02
B	1/4	1/4	·224	5/32	·67	·28	1·34	·46	·705	·710	·35	·52	·04	·14	·440	·03
B B	5/16	19 T.P.I. 60°	·267	3/16	·79	·32	1·45	·48	·815	·820	·40	·60	·04	·14	·525	·03
C	3/8	3/8	·333	1/4	·92	·32	1·52	·53	·915	·920	·40	·66	·04	·14	·580	·03
C C	7/16	14 T.P.I. 75°	·377	5/16	·96	·32	1·62	·57	1·002	1·010	·45	·75	·06	·18	·650	·04
D	1/2	1/2	·438	3/8	·96	·32	1·70	·60	1·002	1·010	·50	·83	·06	·18	·720	·04

MATERIAL :- LIGHT ALLOY TO SPEC: D.T.D. 423 (LATEST ISSUE)

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

NOTES :- SCREW THREADS TO B.S. SPEC: 84 (LATEST ISSUE) MEDIUM FIT, TRUNCATED. FOR DIAMETERS, TOLERANCES & TRUNCATED DIMENSIONS OF MARKS BB & CC SEE A.G.S. 100 SHEET 5.

WORKING PRESSURE :- 3,000 LB/SQ.IN. FOR SIZES UP TO ½ B.S.P.

TITLE :- PIPE COUPLINGS, (LIGHT ALLOY), CONE ADAPTOR, 3/16 TO ½

ISSUE	7	8	8
ALT. No.	MOD/AGS 987	AS/ACS 988	SM 856

MINISTRY OF SUPPLY

APPLICATIONS FOR A.G.S. SHEETS TO:- A.T.P.4, BLOCK E, CHESSINGTON, SURREY.
GENERAL ENQUIRIES TO:- A.D.S.A.E., ST. GILES' COURT, 1-13 ST. GILES HIGH STREET, LONDON W.C.2

R.A.E. APPROVAL

SIGNATURE	DATE
H. Brewer	9·2·55

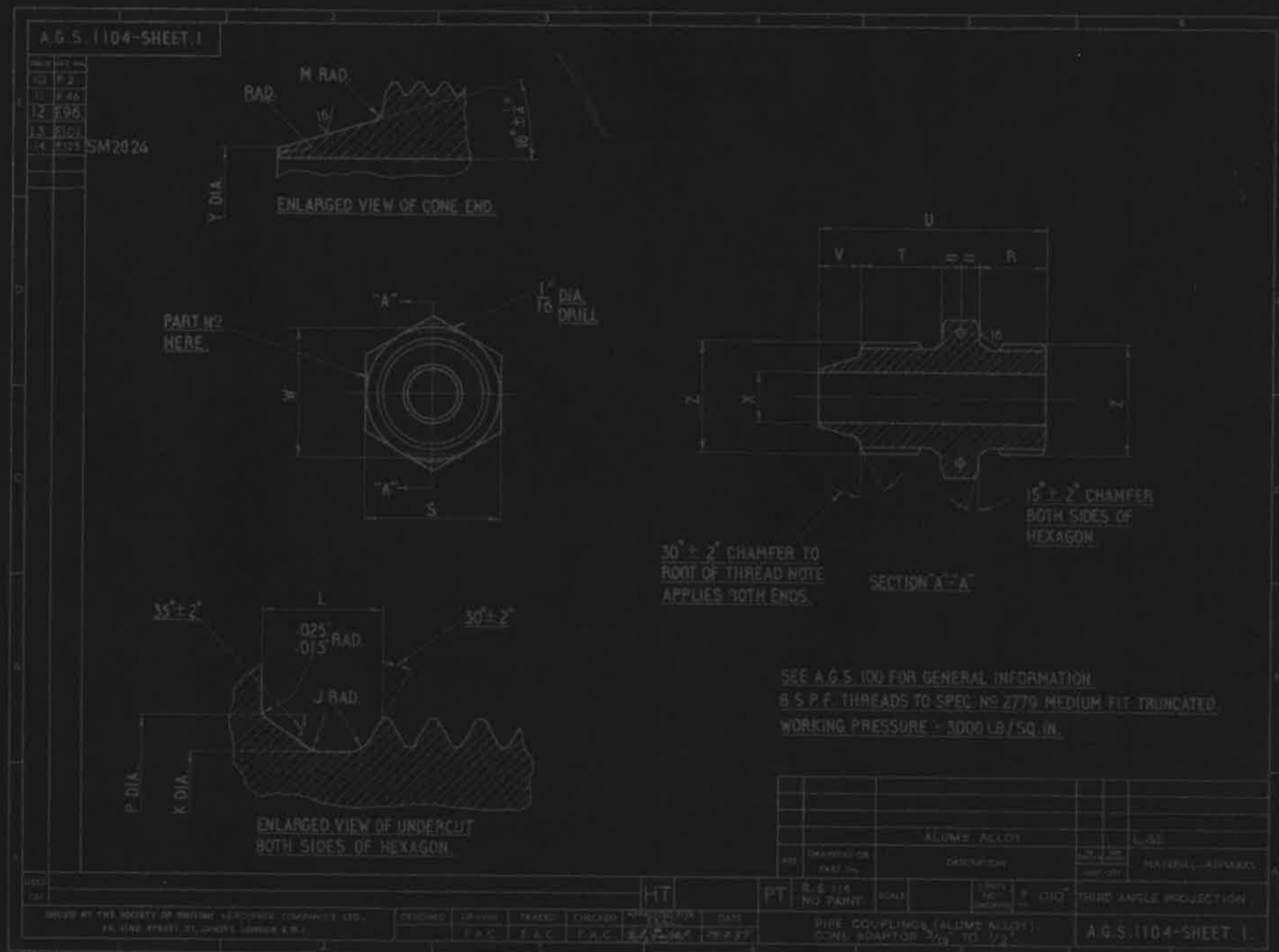
A.D.S.A.E. APPROVAL

SIGNATURE	DATE
T. Tainton	18/2/55

NUMBER OF SHEETS 1

A.G.S. No. 1104 SHEET 1

ORIGINAL APPROVAL DATE 7·11·41


A.G.S. 1104-SHEET 1
SM2024
M RAD.
RAD.
Y DIA.
ENLARGED VIEW OF CONE END.
PART Nº HERE.
"A"
1/16" DIA. DRILL
S
U
V
T
R
Z
X
15° ± 2° CHAMFER BOTH SIDES OF HEXAGON.
30° ± 2° CHAMFER TO ROOT OF THREAD NOTE APPLIES BOTH ENDS.
SECTION "A"-"A"
33° ± 2°
L
.025" .015" RAD.
J RAD.
30° ± 2°
P DIA.
K DIA.
ENLARGED VIEW OF UNDERCUT BOTH SIDES OF HEXAGON.
SEE A.G.S. 100 FOR GENERAL INFORMATION.
B.S.P.F. THREADS TO SPEC. Nº 2779 MEDIUM FIT TRUNCATED.
WORKING PRESSURE - 3000 LB/SQ. IN.
ALUMS. ALLOY
L.46
MATERIAL
DESCRIPTION
HT
PT
NO PAINT
THIRD ANGLE PROJECTION
PIPE COUPLINGS (ALUMS. ALLOY) CONE ADAPTOR
A.G.S. 1104-SHEET 1.

A.G.S. 1104-SHEET. 2.

SM2027

MARK	O/DIA. OF PIPES	J	K	L	M	P	R	S	T	U	V	W	X DRILL DIA.	Y	Z B.S.P.E THREAD
A	3/16"	·025" ·015"	·330" ·325"	·110" ·100"	·035" ·025"	·390" ·380"	·360" ·340"	·600" ·595"	·440" ·420"	1·260" 1·240"	·230" ·220"	·550" ·530"	3/32"	·170" ·160"	1/8"
B	1/4"	·035" ·025"	·440" ·435"	·150" ·140"	·045" ·035"	·520" ·510"	·360" ·340"	·710" ·705"	·470" ·450"	1·350" 1·330"	·290" ·280"	·680" ·660"	5/32"	·234" ·224"	1/4"
B-B	5/16"	·035" ·025"	·525" ·520"	·150" ·140"	·045" ·035"	·600" ·590"	·410" ·390"	·820" ·815"	·490" ·470"	1·460" 1·440"	·330" ·320"	·800" ·780"	3/16"	·277" ·267"	19 T.P.I. ·60" O/D.
C	3/8"	·035" ·025"	·580" ·575"	·150" ·140"	·045" ·035"	·660" ·650"	·410" ·390"	·920" ·915"	·540" ·520"	1·530" 1·510"	·330" ·320"	·930" ·910"	1/4"	·343" ·333"	3/8"
C-C	7/16"	·045" ·035"	·650" ·645"	·190" ·180"	·065" ·055"	·750" ·740"	·460" ·440"	1·010" 1·002"	·580" ·560"	1·630" 1·610"	·330" ·320"	·970" ·950"	5/16"	·387" ·377"	14 T.P.I. ·75" O/D.
D	1/2"	·045" ·035"	·720" ·715"	·190" ·180"	·065" ·055"	·830" ·820"	·510" ·490"	1·010" 1·002"	·610" ·590"	1·710" 1·690"	·330" ·320"	·970" ·950"	3/8"	·448" ·438"	1/2"

ON MARKS 'B B' AND 'C C' THREADS TO BE TO B.S. SPEC. Nº 84. WHITWORTH FORM.

REF.	DRAWING OR PART No.	DESCRIPTION	No. REQUIRED	PER MACHINE	UNIT QTY	MATERIAL—REMARKS

USED ON

HT PT

ISSUED BY THE SOCIETY OF BRITISH AIRCRAFT CONSTRUCTORS LTD., 29, KING STREET, ST. JAMES'S, LONDON, S.W.1.

DESIGNED	DRAWN	TRACED	CHECKED	APPROVED F.S.C.	DATE
	F.A.C.	F.A.C.	F.A.C.		19-11-57

SCALE — LIMITS NOT SHOWN

PIPE COUPLINGS (ALUMIN ALLOY) CONE ADAPTOR 3/16 TO 1/2

A.G.S. 1104 SHEET. 2.

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

SIZE C - 18" x 30"