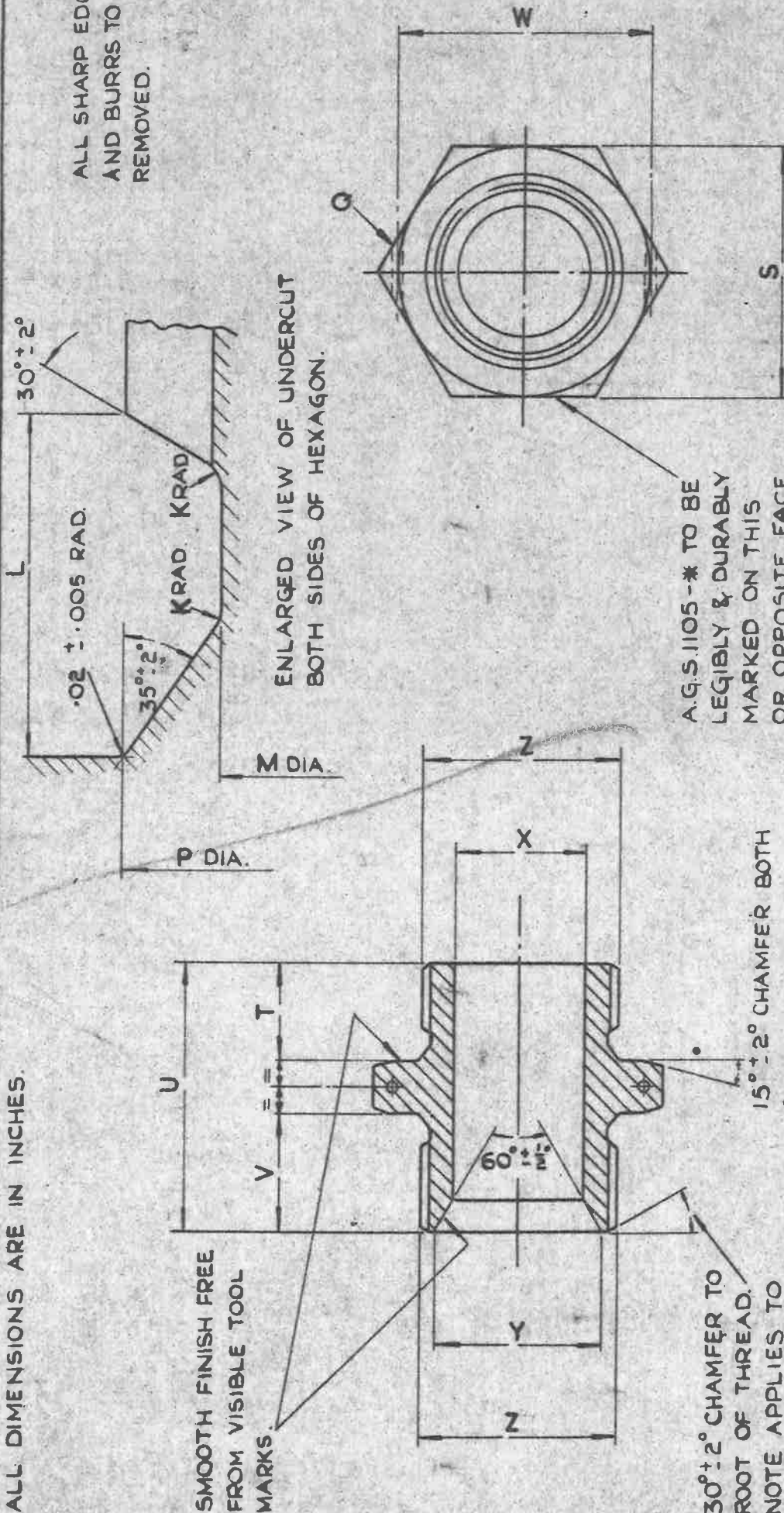


ALL DIMENSIONS ARE IN INCHES.

ALL SHARP EDGES AND BURRS TO BE REMOVED.



ENLARGED VIEW OF UNDERCUT BOTH SIDES OF HEXAGON.

A.G.S.1105-* TO BE LEGIBLY & DURABLY MARKED ON THIS OR OPPOSITE FACE. (* MARK)

15°±2° CHAMFER BOTH SIDES OF HEXAGON.

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

SMOOTH FINISH FREE FROM VISIBLE TOOL MARKS.

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

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

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

TITLE: PIPE COUPLINGS (LIGHT ALLOY), UNION ADAPTOR, 3/16 TO 2 1/2.

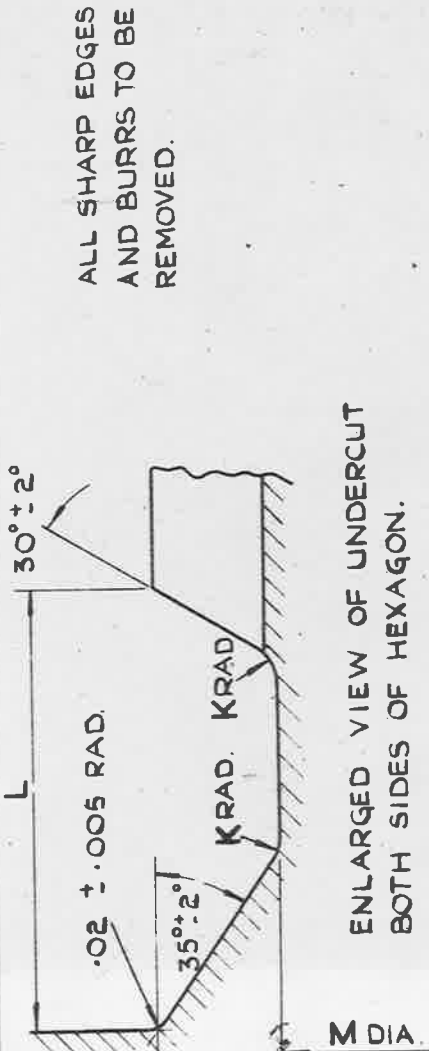
ISSUE 8 6
ALT.NO. MOD/AGS 960 MOD/ACS 987

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.

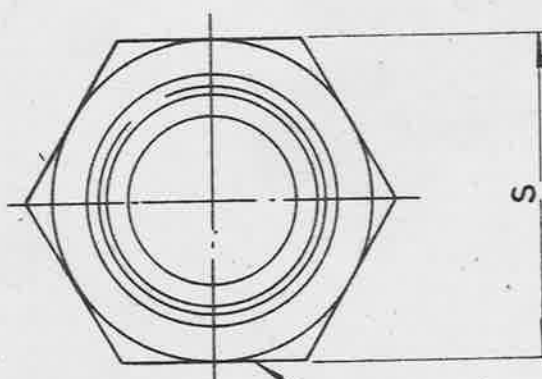
R.A.E. APPROVAL
SIGNATURE DATE
A.D.S.A.E. APPROVAL
SIGNATURE DATE

NUMBER OF SHEETS 2

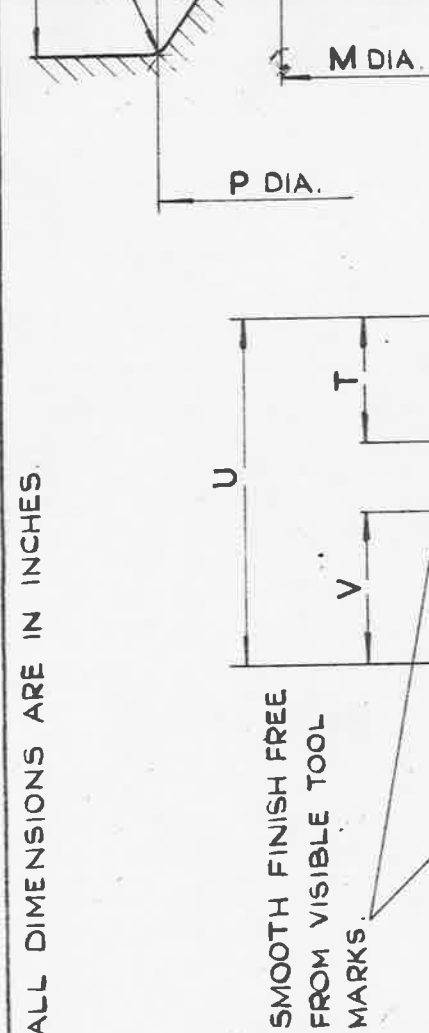
A.G.S. NO. 1105 SHEET 1



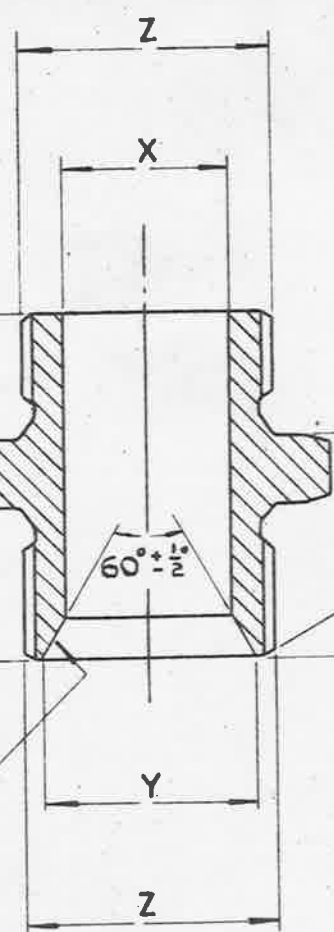
ENLARGED VIEW OF UNDERCUT BOTH SIDES OF HEXAGON.



A.G.S. 1105-* TO BE LEGIBLY & DURABLY MARKED IN POSITION SHOWN. (* MARK)



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.

ALL DIMENSIONS ARE IN INCHES.

ALL SHARP EDGES AND BURRS TO BE REMOVED.

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

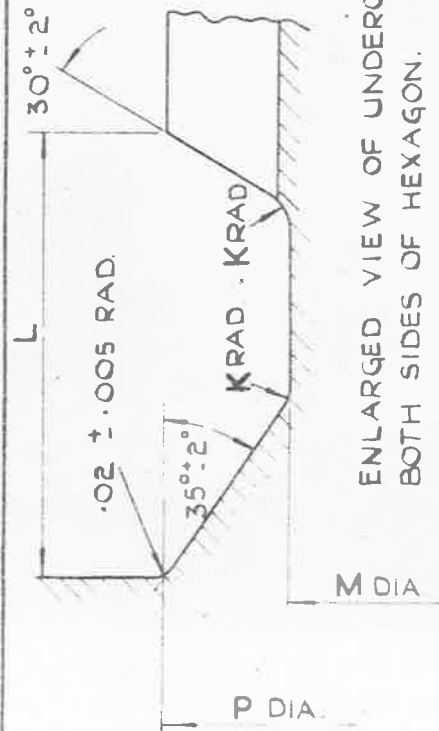
FINISH:- ANODISE TO SPEC: D.T.D. 910 (LATEST ISSUE)

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

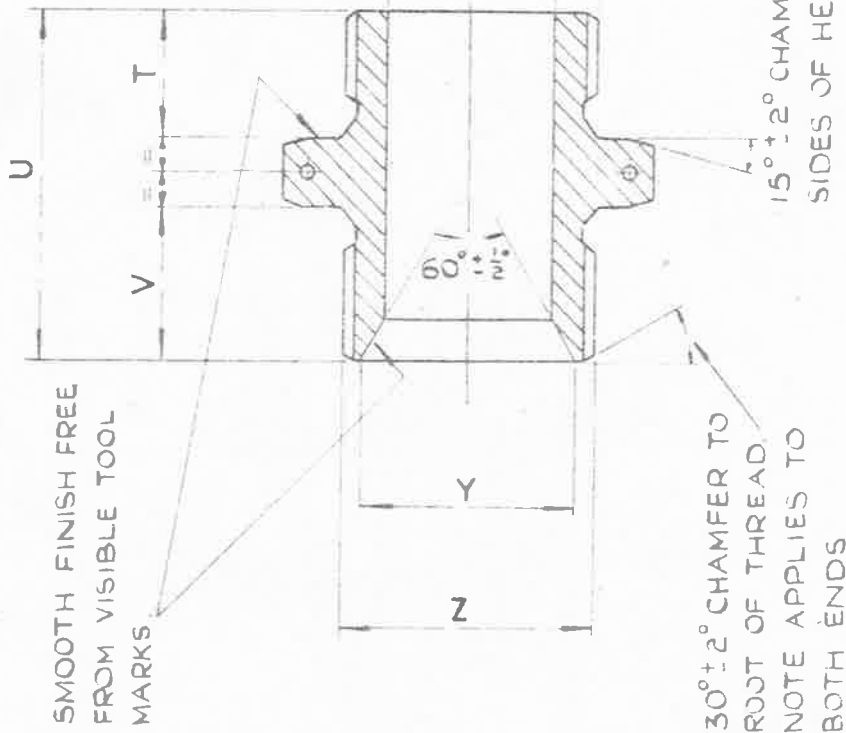
TITLE: PIPE COUPLINGS (LIGHT ALLOY), UNION ADAPTOR, $\frac{3}{16}$ TO $2\frac{1}{2}$ "		ISSUE	5					
		ALT. NO.	MOD/AGS 360					
MINISTRY OF SUPPLY APPLICATIONS FOR A.G.S. SHEETS TO: A.T.P.4, BLOCK 'E', CHESSINGTON, SURREY. GENERAL ENQUIRIES TO:- A.D./S.A.E. ST. GILES' COURT, 1-13 ST. GILES HIGH STREET, LONDON W.C.2.		R.A.E. APPROVAL		NUMBER OF SHEETS		A.G.S. No. 1105 SHEET 1		
		SIGNATURE	DATE	2				
		A.D.S.A.E. APPROVAL						
		SIGNATURE	DATE					
			13-10-53					
			27-10-53					
ORIGINAL APPROVAL DATE 7.11.41								

ALL DIMENSIONS ARE IN INCHES.

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



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 1105-* TO BE LEGIBLY & DURABLY MARKED ON THIS OR OPPOSITE FACE. (* MARK)

ALL SHARP EDGES AND BURRS TO BE REMOVED.

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

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

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

TITLE: PIPE COUPLINGS (LIGHT ALLOY), UNION ADAPTOR, $\frac{3}{16}$ TO $2\frac{1}{2}$	ISSUE	8	8	7	7			
	ALTN. NO.	MOD/AGS 960	MOD/ACS 987	AS/ACS 988	SM 856			
MINISTRY OF SUPPLY APPLICATIONS FOR A.G.S. SHEETS TO:- AT: P4, BLOCK 'E', CHESSINGTON, SURREY. GENERAL ENQUIRIES TO:- AD/SAF, ST. GILES COURT, 1-13 ST. GILES HIGH STREET, LONDON W.C.2.	R.A.E. APPROVAL				NUMBER OF SHEETS	A.G.S. No. 1105 SHEET 1		
	SIGNATURE	DATE						
	A.D.S.A.E. APPROVAL							
	SIGNATURE	DATE						

ALL DIMENSIONS IN INCHES

A.G.S. 1105 SHEET 2

MARK	O/DIA. OF PIPE	Z B.S.P. THREAD	Y ±.005	X DRILLOR BORE	W ±.01	V ±.01	U ±.015	T ±.01	S		Q DRILL	P +0 -.01	M +0 -.005	L +01 -0	K ±.005	WORKING PRESSURE LB/SQ. IN.
									MIN.	MAX.						
A	3/16	1/8	.295	3/32	.54	.45	1.05	.35	.595	.600	1/16	.39	.330	.10	.02	3,000
B	1/4	1/4	.410	5/32	.67	.45	1.05	.35	.705	.710	1/16	.52	.440	.14	.03	3,000
BB	5/16	19 T.P.I. .60 O/D	.480	3/16	.79	.52	1.17	.40	.815	.820	1/16	.60	.525	.14	.03	3,000
C	3/8	3/8	.550	1/4	.92	.52	1.19	.40	.915	.920	1/16	.66	.580	.14	.03	3,000
CC	7/16	14 T.P.I. .75 O/D	.600	5/16	.96	.55	1.28	.45	1.002	1.010	1/16	.75	.650	.18	.04	3,000
D	1/2	1/2	.690	3/8	.96	.65	1.43	.50	1.002	1.010	1/16	.83	.720	.18	.04	3,000
E	5/8	5/8	.760	1/2	1.06	.70	1.50	.50	1.092	1.100	1/16	.91	.800	.18	.04	500
F	3/4	3/4	.900	5/8	1.26	.75	1.60	.55	1.292	1.300	.076 (No 48)	1.05	.940	.18	.04	500
G	7/8	7/8	1.040	3/4	1.37	.80	1.75	.60	1.382	1.390	.076 (No 48)	1.19	1.085	.18	.04	500
H	1	1	1.130	7/8	1.68	.80	1.80	.65	1.658	1.670	.076 (No 48)	1.31	1.180	.23	.05	500
J	1 1/4	1 1/4	1.450	1 1/8	2.03	.83	1.98	.75	2.035	2.050	.076 (No 48)	1.66	1.520	.23	.05	200
K	1 1/2	1 1/2	1.680	1 3/8	2.14	.85	2.05	.80	2.200	2.220	.076 (No 48)	1.89	1.750	.23	.05	200
L	1 3/4	1 3/4	1.920	1 5/8	2.36	.95	2.30	.90	2.390	2.410	.076 (No 48)	2.12	1.990	.23	.05	200
M	2	2	2.150	1 7/8	2.77	1.00	2.45	.95	2.735	2.760	.076 (No 48)	2.35	2.220	.23	.05	200
N																
P	2 1/2	2 1/2	2.750	2 3/8	3.40	1.10	2.55	.95	3.320	3.340	.076 (No 48)	2.97	2.830	.23	.05	100

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

ISSUE 2
ALT.NO. 987

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 *H. Brewer* DATE 9.2.55
A.D./S.A.E. APPROVAL
SIGNATURE *G.T. Hamlin* DATE 18/2/55

NUMBER OF SHEETS 2

A.G.S. No. 1105 SHEET 2

ALL DIMENSIONS ARE IN INCHES											A.G.S. 1105		SHEET 2	
MARK	O/DIA. OF PIPE	Z B.S.P. THREAD	Y ±.005	X DRILL OR BORE	V ±.01	U ±.015	T ±.01	S		P +0 -.01	M +0 -.005	L +.01 -0	K ±.005	WORKING PRESSURE LB./SQ. IN.
								MIN.	MAX.					
A	$\frac{3}{16}$	$\frac{1}{8}$	-295	$\frac{3}{32}$.45	1.05	.35	.595	.600	.39	.330	.10	.02	3,000
B	$\frac{1}{4}$	$\frac{1}{4}$.410	$\frac{5}{32}$.45	1.05	.35	.705	.710	.52	.440	.14	.03	3,000
BB	$\frac{5}{16}$	19 T.P.I. .60%	.480	$\frac{3}{16}$.52	1.17	.40	.815	.820	.60	.525	.14	.03	3,000
C	$\frac{3}{8}$	$\frac{3}{8}$.550	$\frac{1}{4}$.52	1.19	.40	.915	.920	.66	.580	.14	.03	3,000
CC	$\frac{7}{16}$	14 T.P.I. .75%	.600	$\frac{5}{16}$.55	1.28	.45	1.002	1.010	.75	.650	.18	.04	3,000
D	$\frac{1}{2}$	$\frac{1}{2}$.690	$\frac{3}{8}$.65	1.43	.50	1.002	1.010	.83	.720	.18	.04	3,000
E	$\frac{5}{8}$	$\frac{5}{8}$.760	$\frac{1}{2}$.70	1.50	.50	1.092	1.100	.91	.800	.18	.04	500
F	$\frac{3}{4}$	$\frac{3}{4}$.900	$\frac{5}{8}$.75	1.60	.55	1.292	1.300	1.05	.940	.18	.04	500
G	$\frac{7}{8}$	$\frac{7}{8}$	1.040	$\frac{3}{4}$.80	1.75	.60	1.382	1.390	1.19	1.085	.18	.04	500
H	1	1	1.130	$\frac{7}{8}$.80	1.80	.65	1.658	1.670	1.31	1.180	.23	.05	500
J	$\frac{1}{4}$	$\frac{1}{4}$	1.450	$\frac{1}{8}$.83	1.98	.75	2.035	2.050	1.66	1.520	.23	.05	200
K	$\frac{1}{2}$	$\frac{1}{2}$	1.680	$\frac{3}{8}$.85	2.05	.80	2.200	2.220	1.89	1.750	.23	.05	200
L	$\frac{3}{4}$	$\frac{3}{4}$	1.920	$\frac{5}{8}$.95	2.30	.90	2.390	2.410	2.12	1.990	.23	.05	200
M	2	2	2.150	$\frac{7}{8}$	1.00	2.45	.95	2.735	2.760	2.35	2.220	.23	.05	200
N														
P	$\frac{1}{2}$	$\frac{1}{2}$	2.750	$\frac{3}{8}$	1.10	2.55	.95	3.320	3.340	2.97	2.830	.23	.05	100

TITLE: - PIPE COUPLINGS (LIGHT ALLOY), UNION ADAPTOR, $\frac{3}{16}$ TO $2\frac{1}{2}$

ISSUE SM 720
ALT. NO. MOD/AGS 960

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
[Signature] 17.10.53
A.D.S.A.E. APPROVAL
SIGNATURE DATE
[Signature] 27.10.53

NUMBER OF SHEETS
2

A.G.S. No.
1105
SHEET 2

A.G.S. 1105. SHEET, I.

1	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20

SM 2024



PART N° HERE.

$30^\circ \pm 2^\circ$ CHAMFER TO ROUTE OF THREAD. NOTE APPLIES TO BOTH ENDS.

$1/32$ CHAMFER BOTH SIDES OF HEXAGON.

$60^\circ \pm 1/2^\circ$



SECTION A-A



ENLARGED VIEW OF UNDERCUT BOTH SIDES OF HEXAGON.

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

ALUMINUM ALLOY	ALUMINUM	ALUMINUM ALLOY	ALUMINUM	ALUMINUM ALLOY	ALUMINUM
HT	HT	HT	HT	HT	HT
HT	HT	HT	HT	HT	HT

HT	HT	HT	HT	HT	HT
HT	HT	HT	HT	HT	HT
HT	HT	HT	HT	HT	HT

A.G.S. 1105. SHEET I.

AGS. 1105 - SHEET 2

REVISED BY:
 3 PZ.
 1.2.53/AL

SM2027

MARK	O/DIA. OF PIPE	K	L	M	P	O		S	T	U	V	W	X	Y	Z	WORKING PRESSURE LB./SQ. IN.
						DRILL	DRILL OR BORE									
A	3/16	.025	.110	.330	.390	1/16	.600	.360	1.065	.460	.550	.550	3/32	.300	1/8	3,000
B	1/4	.035	.150	.440	.520	1/16	.710	.360	1.065	.460	.680	.680	5/32	.415	1/4	3,000
B-B	5/16	.035	.150	.525	.600	1/16	.820	.410	1.185	.530	.800	.800	3/16	.405	1/4	3,000
C	3/8	.035	.150	.580	.660	1/16	.920	.410	1.205	.530	.780	.780	3/16	.485	19 T.P.I. 60°/D	3,000
C-C	7/16	.045	.190	.650	.750	1/16	1.010	.460	1.295	.560	.970	.970	5/16	.555	3/8	3,000
D	1/2	.045	.190	.720	.830	1/16	1.002	.440	1.265	.540	.970	.970	5/16	.605	14 T.P.I. 75°/D	3,000
E	5/8	.045	.190	.715	.820	1/16	1.002	.490	1.445	.660	.970	.970	3/8	.685	1/2	3,000
F	3/4	.045	.190	.795	.900	1/16	1.092	.510	1.515	.710	1.070	1.070	1/2	.765	5/8	500
G	7/8	.045	.190	.935	1.040	(No. 48)	1.300	.560	1.615	.760	1.270	1.270	5/8	.905	3/4	500
H	1	.045	.190	.985	1.190	(No. 46)	1.390	.610	1.765	.810	1.380	1.380	3/4	.895	7/8	500
I	1 1/8	.045	.240	1.180	1.310	(No. 48)	1.670	.660	1.815	.810	1.690	1.690	7/8	1.045	1	500
J	1 1/4	.045	.240	1.320	1.500	(No. 48)	2.050	.760	1.995	.840	2.040	2.040	1 1/8	1.125	1 1/4	200
K	1 1/2	.045	.240	1.750	1.890	(No. 48)	2.220	.810	2.065	.860	2.150	2.150	1 1/2	1.455	1 1/2	200
L	1 3/4	.045	.240	1.990	2.120	(No. 48)	2.410	.910	2.315	.960	2.370	2.370	1 3/4	1.685	1 3/4	200
M	2	.045	.240	2.220	2.350	(No. 48)	2.590	.960	2.465	.940	2.550	2.550	1 3/4	1.925	1 3/4	200
N	2 1/2	.045	.240	2.215	2.340	(No. 48)	2.735	.940	2.435	.990	2.780	2.780	1 3/4	2.155	2	200
P	2 1/2	.045	.240	2.850	2.970	(No. 48)	3.340	.960	2.565	1.110	3.410	3.410	2 1/2	2.755	2 1/2	100

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

DESIGNED BY THE SOCIETY OF BRITISH AERONAUTICAL ENGINEERS LTD., 24, CHURCH STREET, ST. JAMES'S, LONDON S.W.1.

HT DATE 17/7/53

PT PIPE COUPLINGS (ALUMINUM ALLOY) UNION ADAPTOR 3/4" TO 2 1/2"

SCALE

DESCRIPTION

MATERIAL - REMARKS

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