



AGS.1107-\* TO BE LEGIBLY & DURABLY MARKED ON THIS OR OPPOSITE FACE. (\* MARK)

SMOOTH FINISH FREE FROM VISIBLE TOOL MARKS.

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 BS SPEC: N° 84 (LATEST ISSUE)  
 MEDIUM FIT, TRUNCATED. FOR DIAMETERS. TOLERANCES AND TRUNCATED DIMENSIONS OF THREADS FOR 5/16" & 7/16" B.S.P. SEE A.G.S. 100 SHEET 5.  
 FOR ARRANGEMENT OF PIPE JOINT, SEE A.G.S. 1101  
 WORKING PRESSURE:- 3,000 LB./SQ. IN. FOR SIZES UP TO 1" B.S.P.

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

ENLARGED VIEW OF UNDERCUT.

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT

TITLE:- PIPE COUPLINGS. (LIGHT ALLOY) REDUCING CONE UNION. SM856

DRAWN c.T.Reynolds.

TRACED J.ASTON 15.9.45

ISSUE No	2	3	4	5	6
ALTERN. No	MOD No	A.S. No	AS/AGS	AS/ACS	AS/ACS
	AGS/609	AGS/417	663	969	988

CHECKED [Signature]

APPROVED [Signature] 29/1/45

MARK	% DIA OF PIPE	Y	X	W	V	U	T	S		R	Q	P	N	M	L	K	J	H	G	F	E	D	C	B	A
		B.S.P. THREAD +0.010 -0	DRILL	+0.01 -0	+0.01 -0	+0.01 -0		MIN	MAX	B.S.P. THREAD	+0.10 -0	DRILL	+0.01 -0	+0.01 -0	DIA DRILL	+0 -0.005	+0 -0.005	+0 -0.01	+0 -0.005	+0 -0.005	+0 -0.01	+0.01 -0	+0 -0	+0 -0	
A	1" x 3/4	1" 4	5/32	.67	.28	1.67	.46	.705	.710	1" 8	.160	3/32	.22	.43	1" 16	.04	.440	.52	.03	.330	.39	.14	.01	.10	.01
B	5/16 x 3/16	19 T.P.I. 60% D	3/16	.79	.32	1.73	.48	.815	.820	1" 8	.160	3/32	.22	.43	1" 16	.04	.525	.60	.03	.330	.39	.14	.01	.10	.01
C	5/16 x 1/4	19 T.P.I. 60% D	3/16	.79	.32	1.82	.48	.815	.820	1" 4	.224	5/32	.28	.46	1" 16	.04	.525	.60	.04	.440	.52	.14	.01	.14	.01
D	3/8 x 1/2	3" 8	1/4	.92	.32	1.78	.53	.915	.920	1" 8	.160	3/32	.22	.43	1" 16	.04	.580	.66	.03	.330	.39	.14	.01	.10	.01
E	3/8 x 1/4	3" 8	1/4	.92	.32	1.87	.53	.915	.920	1" 4	.224	5/32	.28	.46	1" 16	.04	.580	.66	.04	.440	.52	.14	.01	.14	.01
F	3/8 x 5/16	3" 8	1/4	.92	.32	1.93	.53	.915	.920	19 T.P.I. 60% D	.267	3/16	.32	.48	1" 16	.04	.580	.66	.04	.440	.52	.14	.01	.14	.01
G	7/16 x 1/2	14 T.P.I. 75% D	5/16	.96	.32	1.91	.57	1.002	1.010	1" 4	.224	5/32	.28	.46	1" 16	.06	.650	.75	.04	.440	.52	.18	.015	.14	.01
H	7/16 x 5/16	14 T.P.I. 75% D	5/16	.96	.32	1.97	.57	1.002	1.010	19 T.P.I. 60% D	.267	3/16	.32	.48	1" 16	.06	.650	.75	.04	.440	.52	.18	.015	.14	.01
J	7/16 x 3/8	14 T.P.I. 75% D	5/16	.96	.32	2.02	.57	1.002	1.010	3" 8	.333	1" 4	.32	.53	1" 16	.06	.650	.75	.04	.440	.52	.18	.015	.14	.01
K	1" x 1/2	1" 2	3/8	.96	.32	1.94	.60	1.002	1.010	1" 4	.224	5/32	.28	.46	1" 16	.06	.720	.83	.04	.440	.52	.18	.015	.14	.01
L	1" x 5/16	1" 2	3/8	.96	.32	2.00	.60	1.002	1.010	19 T.P.I. 60% D	.267	3/16	.32	.48	1" 16	.06	.720	.83	.04	.440	.52	.18	.015	.14	.01
M	1" x 3/8	1" 2	3/8	.96	.32	2.05	.60	1.002	1.010	3" 8	.333	1" 4	.32	.53	1" 16	.06	.720	.83	.04	.440	.52	.18	.015	.14	.01
N	1" x 7/16	1" 2	3/8	.96	.32	2.09	.60	1.002	1.010	14 T.P.I. 75% D	.377	5/16	.32	.57	1" 16	.06	.720	.83	.06	.650	.75	.18	.015	.18	.015

ISSUED BY  
 ROYAL AIRCRAFT  
 ESTABLISHMENT.

TITLE:- PIPES COUPLINGS.  
 (EIGHT ALLOYS)  
 REDUCING CONE UNION.  
 ISSUE No X 2

DRAWN  
 C.T.Reynolds.  
 TRACED  
 J.R.ASTON  
 14-9-45  
 CHECKED  
 APPROVED

MARK	% DIA OF PIPE	Z	Y	X	W	V	U	T	S		R	Q	P	N	M	L	K	J	H	G	F	E	D	C	B	A
		B.S.P. THREAD	+0.10 -0	DRILL	+0.01 -0	+0.01 -0	+0.01 -0	+0.01 -0	MIN	MAX	B.S.P. THREAD	+0.10 -0	DRILL	+0.01 -0	+0.01 -0	DIA DRILL	+0 -0.005	+0 -0.005	+0 -0.01	+0 -0.005	+0 -0.005	+0 -0.01	+0.01 -0	+0.01 -0	+0.01 -0	+0.01 -0
A	1" x 3/16	1" 4	.224	5/32	.67	.28	1.67	.46	.705	.710	1" 8	.160	3/32	.22	.43	1 1/16	.04	.440	.52	.03	.330	.39	.14	.03	.10	.02
B	5/16 x 3/16	19 T.P.I. 60% D	.267	3/16	.79	.32	1.73	.48	.815	.820	1" 8	.160	3/32	.22	.43	1 1/16	.04	.525	.60	.03	.330	.39	.14	.03	.10	.02
C	5/16 x 1/4	19 T.P.I. 60% D	.267	3/16	.79	.32	1.82	.48	.815	.820	1" 4	.224	5/32	.28	.46	1 1/16	.04	.525	.60	.04	.440	.52	.14	.03	.14	.03
D	3/8 x 3/16	3" 8	.333	1" 4	.92	.32	1.78	.53	.915	.920	1" 8	.160	3/32	.22	.43	1 1/16	.04	.580	.66	.03	.330	.39	.14	.03	.10	.02
E	3/8 x 1/4	3" 8	.333	1" 4	.92	.32	1.87	.53	.915	.920	1" 4	.224	5/32	.28	.46	1 1/16	.04	.580	.66	.04	.440	.52	.14	.03	.14	.03
F	3/8 x 5/16	3" 8	.333	1" 4	.92	.32	1.93	.53	.915	.920	19 T.P.I. 60% D	.267	3/16	.32	.48	1 1/16	.04	.580	.66	.04	.525	.60	.14	.03	.14	.03
G	7/16 x 1/4	14 T.P.I. 75% D	.377	5/16	.96	.32	1.91	.57	1.002	1.010	1" 4	.224	5/32	.28	.46	1 1/16	.06	.650	.75	.04	.440	.52	.18	.04	.14	.03
H	7/16 x 5/16	14 T.P.I. 75% D	.377	5/16	.96	.32	1.97	.57	1.002	1.010	19 T.P.I. 60% D	.267	3/16	.32	.48	1 1/16	.06	.650	.75	.04	.525	.60	.18	.04	.14	.03
J	7/16 x 3/8	14 T.P.I. 75% D	.377	5/16	.96	.32	2.02	.57	1.002	1.010	3" 8	.333	1" 4	.32	.53	1 1/16	.06	.650	.75	.04	.580	.66	.18	.04	.14	.03
K	1" x 1/4	1" 2	.438	3/8	.96	.32	1.94	.60	1.002	1.010	1" 4	.224	5/32	.28	.46	1 1/16	.06	.720	.83	.04	.440	.52	.18	.04	.14	.03
L	1" x 5/16	1" 2	.438	3/8	.96	.32	2.00	.60	1.002	1.010	19 T.P.I. 60% D	.267	3/16	.32	.48	1 1/16	.06	.720	.83	.04	.525	.60	.18	.04	.14	.03
M	1" x 3/8	1" 2	.438	3/8	.96	.32	2.05	.60	1.002	1.010	3" 8	.333	1" 4	.32	.53	1 1/16	.06	.720	.83	.04	.580	.66	.18	.04	.14	.03
N	1" x 7/16	1" 2	.438	3/8	.96	.32	2.09	.60	1.002	1.010	14 T.P.I. 75% D	.377	5/16	.32	.57	1 1/16	.06	.720	.83	.06	.650	.75	.18	.04	.18	.04

ISSUED BY  
ROYAL AIRCRAFT  
ESTABLISHMENT.

TITLE:- PIPER COUPLINGS.  
(LIGHT ALLOY).  
REDUCING CONE UNION.

DRAWN  
C.T.Reynolds.

TRACED  
J.R.ASTON  
14-9-45

ISSUE No X Z 3  
ALTERN No 300 Z# AGS/609 AS/AGS 877 AS/AGS 969

CHECKED  
*[Signature]*

APPROVED  
*[Signature]* 27/10/45

AGS 1107 SHEET 1

REV	DATE	BY	CHKD
8	1/23		
5	2/26		
10	7/96		
11	8/04		
12	11/11		

SM2026

PART NO. HERE



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



15°-2' CHAMFER ON BOTH SIDES OF HEXAGON

SEE AGS 1100 FOR GENERAL INFORMATION  
BS PE THREADS TO BS SPEC. NO. 2779 MEDIUM FIT-TURNED  
FOR ARRANGEMENT OF PIPE JOINT SEE AGS 1101  
WORKING PRESSURE 5000 LBS. SQ. IN.

REV	DATE	BY	CHKD	REVISIONS	HT	PT	AGS 1107 SHEET 1
8	1/23						
5	2/26						
10	7/96						
11	8/04						
12	11/11						

SM2027

AGS. 1107-SHEET. 2.

MARK OF PIPE	A	B	C	D	E	F	G	H	J	K	L		M	N	P		Q	R	S	T	U	V	W	X	Y	Z	
											DRILL DIA.	DRILL DIA.			DRILL DIA.	DRILL DIA.											BSPF THD.
A	1/2 X 1/16	1/2 X 1/16	1/2 X 1/16	1/2 X 1/16	1/2 X 1/16	1/2 X 1/16	1/2 X 1/16	1/2 X 1/16	1/2 X 1/16	1/2 X 1/16	1/2 X 1/16	1/2	1/16	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2
B	3/8 X 1/16	3/8 X 1/16	3/8 X 1/16	3/8 X 1/16	3/8 X 1/16	3/8 X 1/16	3/8 X 1/16	3/8 X 1/16	3/8 X 1/16	3/8 X 1/16	3/8	1/16	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	
C	1/2 X 1/8	1/2 X 1/8	1/2 X 1/8	1/2 X 1/8	1/2 X 1/8	1/2 X 1/8	1/2 X 1/8	1/2 X 1/8	1/2 X 1/8	1/2 X 1/8	1/2	1/8	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	
D	3/4 X 1/8	3/4 X 1/8	3/4 X 1/8	3/4 X 1/8	3/4 X 1/8	3/4 X 1/8	3/4 X 1/8	3/4 X 1/8	3/4 X 1/8	3/4 X 1/8	3/4	1/8	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	
E	1/2 X 1/4	1/2 X 1/4	1/2 X 1/4	1/2 X 1/4	1/2 X 1/4	1/2 X 1/4	1/2 X 1/4	1/2 X 1/4	1/2 X 1/4	1/2 X 1/4	1/2	1/4	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	
F	3/8 X 1/4	3/8 X 1/4	3/8 X 1/4	3/8 X 1/4	3/8 X 1/4	3/8 X 1/4	3/8 X 1/4	3/8 X 1/4	3/8 X 1/4	3/8 X 1/4	3/8	1/4	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8	
G	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2	3/8	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	
H	3/4 X 3/8	3/4 X 3/8	3/4 X 3/8	3/4 X 3/8	3/4 X 3/8	3/4 X 3/8	3/4 X 3/8	3/4 X 3/8	3/4 X 3/8	3/4 X 3/8	3/4	3/8	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	
J	1/2 X 1/2	1/2 X 1/2	1/2 X 1/2	1/2 X 1/2	1/2 X 1/2	1/2 X 1/2	1/2 X 1/2	1/2 X 1/2	1/2 X 1/2	1/2 X 1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	
K	3/4 X 1/2	3/4 X 1/2	3/4 X 1/2	3/4 X 1/2	3/4 X 1/2	3/4 X 1/2	3/4 X 1/2	3/4 X 1/2	3/4 X 1/2	3/4 X 1/2	3/4	1/2	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	
L	1/2 X 3/4	1/2 X 3/4	1/2 X 3/4	1/2 X 3/4	1/2 X 3/4	1/2 X 3/4	1/2 X 3/4	1/2 X 3/4	1/2 X 3/4	1/2 X 3/4	1/2	3/4	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	
M	3/4 X 3/4	3/4 X 3/4	3/4 X 3/4	3/4 X 3/4	3/4 X 3/4	3/4 X 3/4	3/4 X 3/4	3/4 X 3/4	3/4 X 3/4	3/4 X 3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	
N	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2 X 3/8	1/2	3/8	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	

IN COLUMN 'R' MARKS 'F', 'H', 'L' AND 'N' THREADS AND IN COLUMN 'Z' MARKS 'B', 'C', 'H' AND 'J' THREADS TO BE TO SPEC NO. 84. WHITWORTH FORM.

DESIGNED BY THE SOCIETY OF STEEL ENGINEERS LTD. 15, GERRARD STREET, ST. MARTIN, LONDON, W.C.2.	DESIGNED	DRAWN	TRACED	CHECKED	DATE	HT	PT	DESCRIPTION	LIMIT	MATERIAL
	F.A.C.	F.A.C.	F.A.C.	F.A.C.	12/7/57			PIPE COUPLINGS (ALUMINUM ALLOY) REDUCING CONE UNION	1/2000	AGS. 1107-SHEET 2

THIS IS A PHOTOGRAPHIC REDUCTION DRAWING MUST NOT BE SCALED