

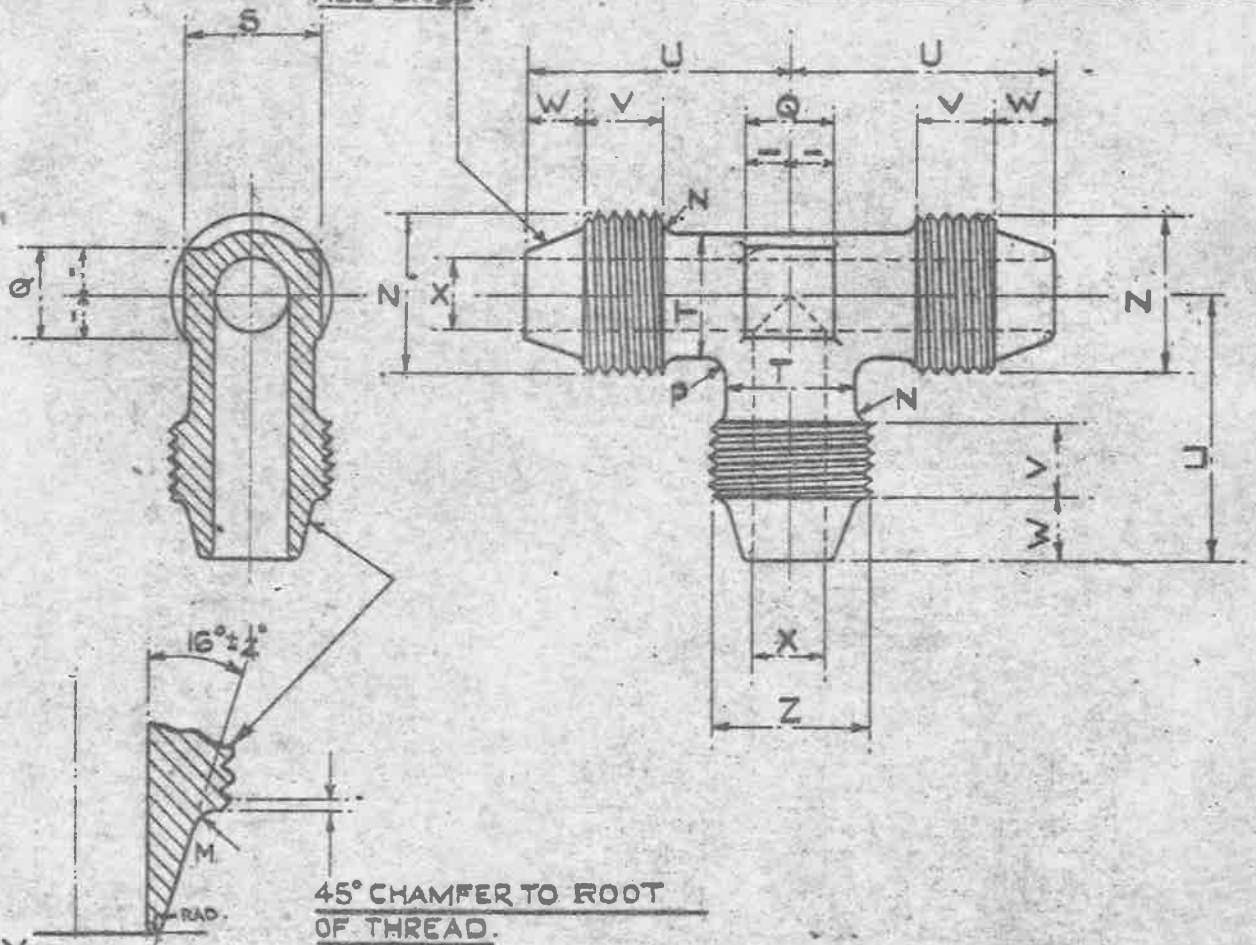
SEE A.G.S. 100
FOR GENERAL
INFORMATION.

SMOOTH FINISH FREE
FROM TOOL MARKS.
NOTE APPLIES TO
ALL ENDS.

MINISTRY OF
SUPPLY

AGS No. 1118

SHEET No. 1 No. OF SHEETS 1



ENLARGED VIEW OF ENDS.

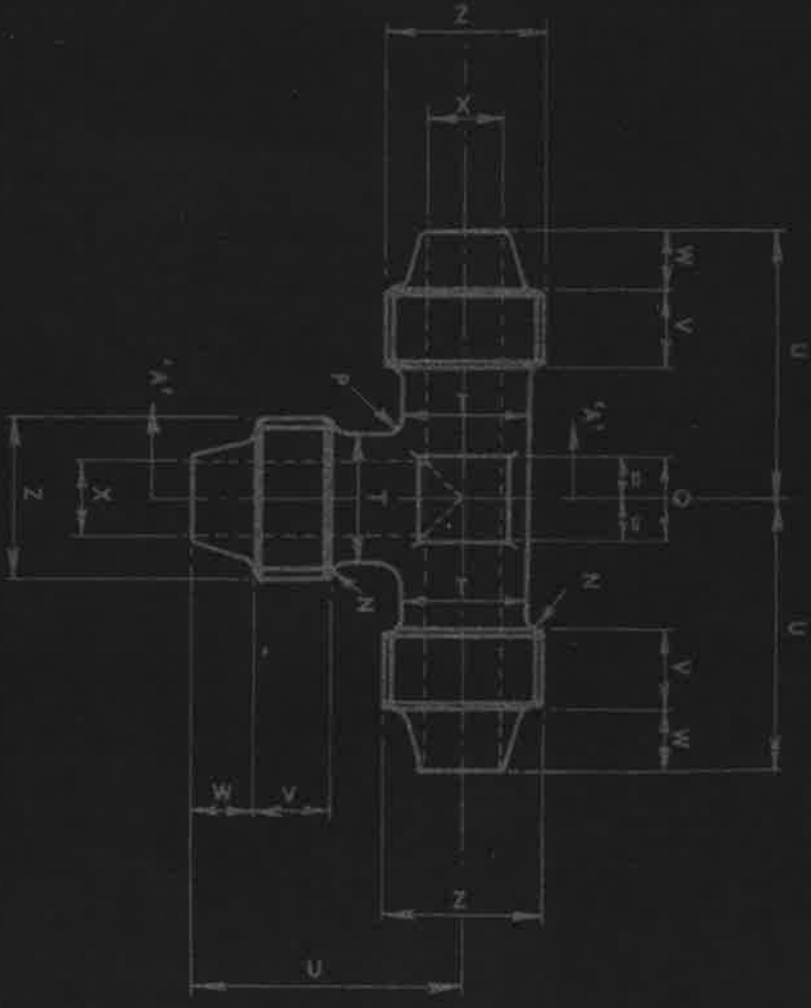
MARK	% OF PIPE.	Z	Y	X	W	V	U	T	S	Q	P RAD	N RAD	M RAD.
		B.S.P THREAD	+0.010 -0	DIA DRILL	+0.01 -0	+0.01 -0	+0.01 -0	+0.04 -0.01	MIN MAX	±0.01			
A	3/16	1/8	.160	3/32	.22	.30	.90	.28	.321 .324	.20	.06	.04	.03
B	1/4	1/4	.224	5/32	.28	.30	1.05	.37	.410 .413	.25	.08	.05	.04
BB	5/16	19 T.P.I. WHIT. FORM 60% 3/8	.267	3/16	.32	.34	1.15	.40	.440 .445	.27	.10	.06	.04
C	3/8	3/8	.333	1/4	.32	.37	1.25	.48	.520 .525	.30	.10	.06	.04
CC	7/16	14 T.P.I. WHIT. FORM 75% 5/8	.377	5/16	.32	.39	1.32	.56	.595 .600	.40	.10	.06	.06
D	1/2	1/2	.438	3/8	.32	.40	1.37	.65	.705 .710	.45	.10	.08	.06

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

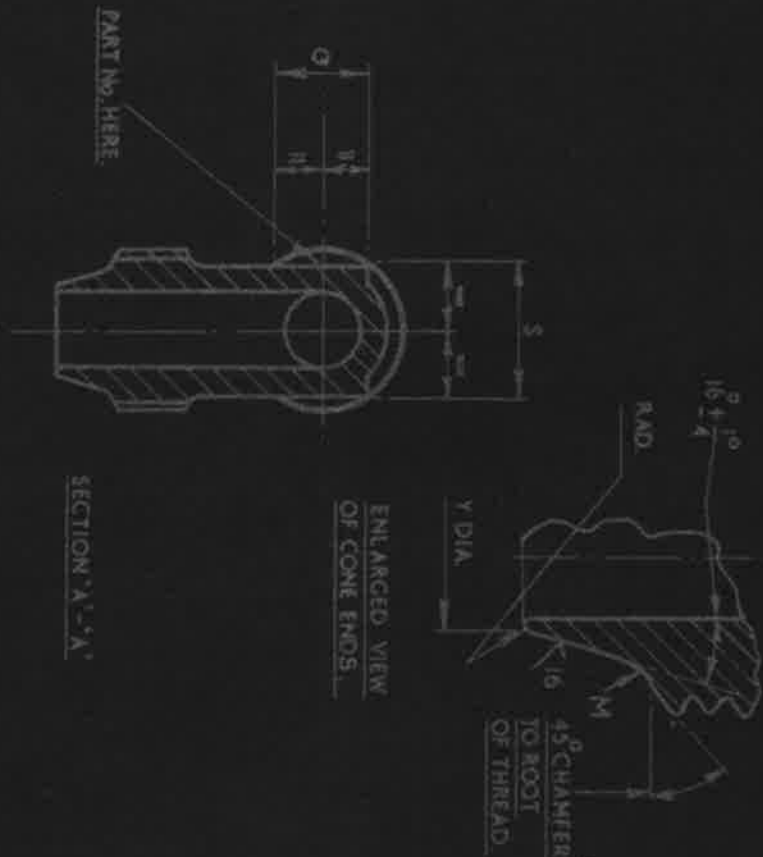
FINISH : TO BE ANODISED TO SPEC: D.T.D. 910 (LATEST ISSUE).

NOTES :-
SCREW THREADS TO B.S. SPEC N° 84-1940,
MEDIUM FIT, TRUNCATED THREADS TO AMENDMENT N° 3-1945
WORKING PRESSURE :- 3000 L^B/SQ. IN. FOR SIZES UP TO 1/2" B.S.P.
FOR ARRANGEMENT OF PIPE JOINT SEE A.G.S. N° 1101.

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT	TITLE:-	PIPE COUPLINGS.					DRAWN	TRACED
		(LIGHT ALLOY).					E.N. MEREDITH	G.N.A.
		CONE TEE 3/16" TO 1/2"						2-10-41
	ISSUE NO	1	2	3	4	4	CHECKED	APPROVED
	ALTER. NO	MOS 865/449	AS/AGS 663	AS/AGS 877	AS/AGS 988	SM 856	<i>[Signature]</i>	<i>[Signature]</i>



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



B.S.P.F. THREAD TO B.S. SPEC. 1779, MEDIUM, FIT TRUNCATED.
FOR ARRANGEMENT OF PIPE JOINT SEE A.G.S. 1101.
WORKING PRESSURE: 3000 LB/SQ. IN.

ISSUE	ALT. No.
6	F.2.
7	F.46.
8	F.96.
9	F.101.
10	F.123.

DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR	DATE
	F.A.C.	F.A.C.	F.A.C.	S.B.A.C.	12.2.58

REF.	DRAWING OR PART No.	DESCRIPTION	LIMITS NOT SHOWN	MATERIAL - REMARKS
		ALUMIUM ALLOY		L.85.

USED ON	DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR	DATE
		F.A.C.	F.A.C.	F.A.C.	S.B.A.C.	12.2.58

HT	PT	R.S. 116 NO. PAINT	SCALE	LIMITS NOT SHOWN	THIRD ANGLE PROJECTION

ISSUED BY THE SOCIETY OF BRITISH AEROSPACE COMPANIES LTD.,
20, KING STREET, ST. JAMES'S, LONDON, S.W.1.

ISSUE No. 1
 9 F101

MARK.	O/DIA. OF PIPE.	RAD.			Q	S	T	U	V	W	X	Y	Z
		M	N	P									
A	3/16	.03"	.04"	.06"	.210"	.324"	.320"	.910"	.310"	.230"	3/32	.170"	1/8
B	1/4	.04"	.05"	.06"	.260"	.415"	.410"	1.060"	.310"	.290"	5/32	.234"	1/4
B-B	3/16	.04"	.06"	.10"	.280"	.445"	.440"	1.160"	.350"	.330"	3/16	.277"	19 T.P.I. .60"/D
C	3/8	.04"	.06"	.10"	.310"	.525"	.520"	1.260"	.380"	.350"	1/4	.343"	3/8
C-C	7/16	.06"	.06"	.10"	.410"	.600"	.600"	1.330"	.400"	.330"	5/16	.387"	14 T.P.I. .75"/D
D	1/2	.06"	.08"	.10"	.460"	.710"	.690"	1.380"	.410"	.350"	3/8	.448"	1/2

ON MARKS 'B B' AND 'C C' THREADS TO BE TO
 B.S. SPEC. 84 WHITWORTH FORM.

USED ON	DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR S.B.A.C.	DATE	REF.	DRAWING OR PART No.	DESCRIPTION	LIMITS NOT SHOWN	AT DRAWING UNIT	OR HAND QTY	MATERIAL - REMARKS
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F.A.C. F.A.C. F.A.C. *H. J. Palmer* 12.2.58

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

HT PT SCALE LIMITS NOT SHOWN
 PIPE COUPLINGS (ALUMINIUM ALLOY)
 CONE TEE 3/16 TO 1/2
 AG.S.1118. SHEET. 2.