

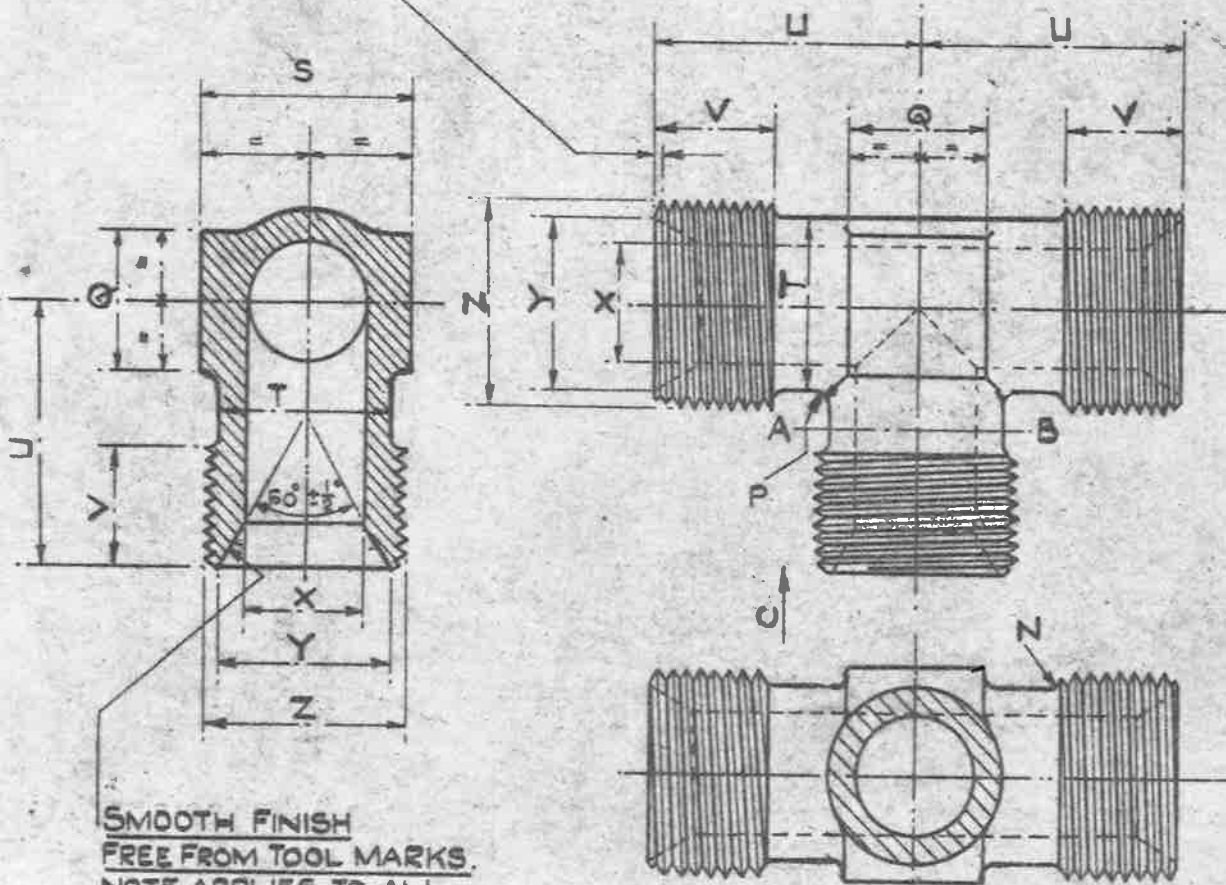
SEE A.G.S. 100
FOR GENERAL
INFORMATION.

45° CHAMFER TO ROOT
OF THREAD.
NOTE APPLIES TO ALL
BRANCHES.

MINISTRY OF
SUPPLY

AGS.No. 1119

SHEET No. | NO. OF SHEETS |



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

SECTIONAL VIEW ON A.B. IN
DIRECTION OF ARROW C.

MARK	Ø PIPE	Z	Y	X	V	U	T	S	Q	P	N	
		B.S.P. THREAD	±.005	DIA. DRILL	±.01	±.01	±.04 ±.01	MIN	MAX	±.01	RAD.	RAD.
E	5/8"	5/8"	.76"	1/2"	.55"	1.25"	.77"	.915"	.920"	.58"	.07"	.06"
F	3/4"	3/4"	.90"	5/8"	.61"	1.375"	.91"	1.092"	1.100"	.73"	.07"	.06"
G	7/8"	7/8"	1.04"	3/4"	.65"	1.50"	1.06"	1.192"	1.200"	.875"	.07"	.06"
H	1"	1"	1.13"	7/8"	.65"	1.65"	1.150"	1.382"	1.390"	.95"	.07"	.06"
J	1 1/4"	1 1/4"	1.45"	1 1/8"	.65"	1.88"	1.49"	1.658"	1.670"	1.08"	.10"	.08"
K	1 1/2"	1 1/2"	1.68"	1 3/8"	.70"	2.05"	1.73"	2.035"	2.050"	1.25"	.10"	.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.

FOR ARRANGEMENT OF PIPE JOINT, SEE AG.S. N° 1101.

WORKING PRESSURE :- 500 LB/SQ. IN. FOR SIZES 5/8" TO 1" B.S.P.
200 LB/SQ. IN. FOR SIZES 1/4" & 1/2" B.S.P.

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT	TITLE:- PIPE COUPLINGS, (LIGHT ALLOY) UNION TEE 5/8" TO 1 1/2"					DRAWN C.M. Dunn	TRACED G.N.A. - 210-41.
	ISSUE N°	1	2	3	3	CHECKED J.K. Brasher	APPROVED Jew 7.11.41.
	ALTER N°	MOD 865/449	AS/AGS/ 663	AS/ACS/SM 988	856		

SM2027

ISSUE No. 1

ALT. No. 8

F101

MARK	O/DIA. OF PIPE	N	P	Q	S	T	U	V	X	Y	Z
E	5/8"	.06"	.07"	.590"	.920"	.810"	1.260"	.560"	1"	.765"	5/8"
F	3/4"	.06"	.07"	.740"	1.100"	.950"	1.385"	.620"	5/8"	.905"	3/4"
G	7/8"	.06"	.07"	.885"	1.200"	1.100"	1.510"	.660"	3/4"	1.045"	7/8"
H	1"	.06"	.07"	.960"	1.390"	1.190"	1.660"	.660"	7/8"	1.135"	1"
J	1 1/4"	.06"	.10"	1.090"	1.670"	1.530"	1.890"	.660"	1 1/8"	1.455"	1 1/4"
K	1 1/2"	.06"	.10"	1.260"	2.050"	1.770"	2.060"	.710"	1 3/8"	1.685"	1 1/2"

USED	ON	REF.	DRAWING OR PART No.	DESCRIPTION	MATERIAL - REMARKS

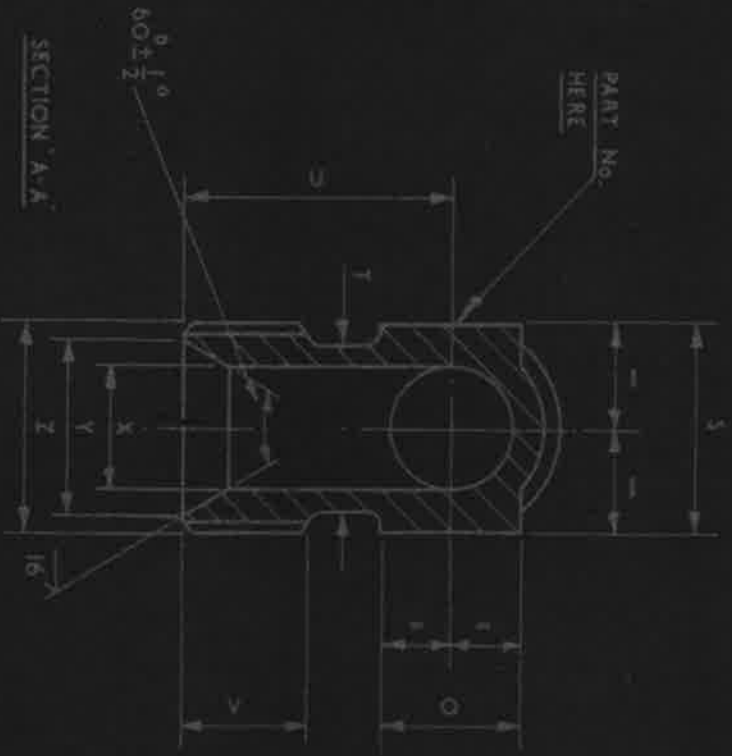
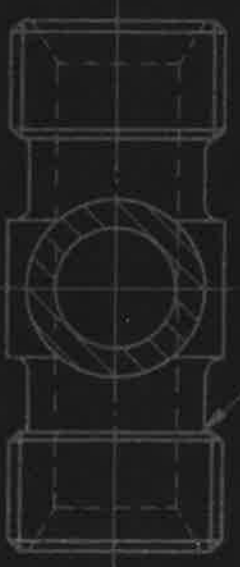
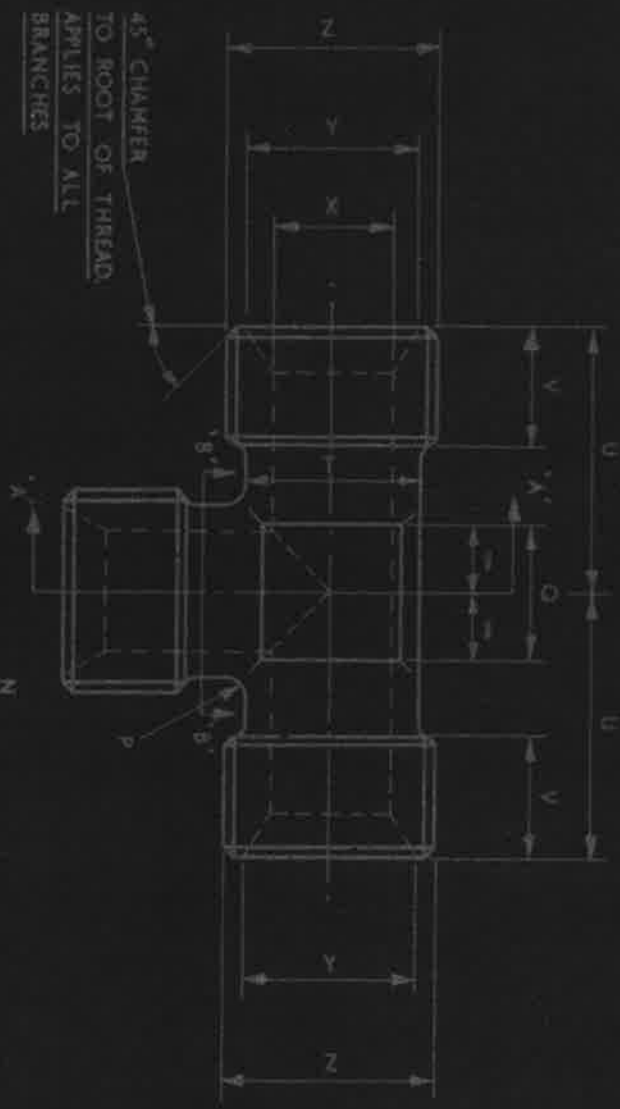
DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR	DATE
	F.A.C.	F.A.C.	F.A.C.	<i>[Signature]</i>	27/1/58

HT	PT	SCALE	LIMITS NOT SHOWN
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ISSUED BY THE SOCIETY OF BRITISH AIRCRAFT CONSTRUCTORS LTD.,
 29, KING STREET, ST. JAMES'S, LONDON, S.W.1.

PIPE COUPLINGS (ALUMINUM ALLOY)
 UNION TEE 5/8" TO 1 1/2"

A.G.S. 1119. SHEET 2.



SEE A.C.S. 100 FOR GENERAL INFORMATION.
 B.S.P.F. THREADS TO B.S. SPEC. 2779 MEDIUM FIT TRUNCATED.
 FOR ARRANGEMENT OF PIPE JOINT SEE A.C.S. 1101.
 WORKING PRESSURE: SOULB./SQ. IN. FOR SIZES $\frac{5}{8}$ TO $1\frac{1}{2}$ B.S.P.F.
 200LB./SQ. IN. FOR SIZES $1\frac{1}{4}$ TO $1\frac{1}{2}$ B.S.P.F.

ISSUE	ALT. No.
5	F.2.
6	F.46
7	F.96
8	E101
9	F.123

SM2024

USED ON	DRAWN	TRACED	CHECKED	APPROVED FOR	DATE
	F.A.C.	F.A.C.	F.A.C.	S.B.A.C.	27/1/58

REF.	DRAWING OR PART No.	DESCRIPTION	UNIT	OF DRAWING HAND UNIT	MATERIAL - REMARKS
		ALUMINUM ALLOY			L.85.

DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR	DATE
	F.A.C.	F.A.C.	F.A.C.	S.B.A.C.	27/1/58

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

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

PIPE COUPLINGS (ALUMINUM ALLOY)
 UNION TEE $\frac{5}{8}$ TO $1\frac{1}{2}$.

AGS. 1119 SHEET 1