

SIG. RES. ASS. 68.

MINISTRY OF SUPPLY

AGS.No. 1/20

SHEET No. 1

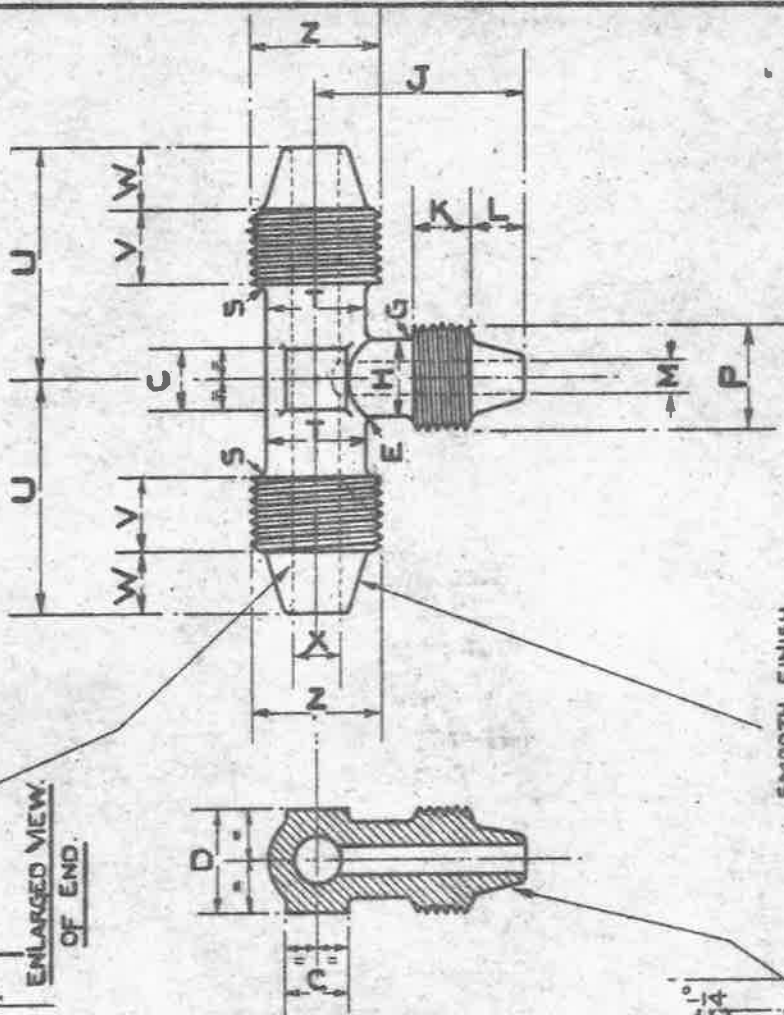
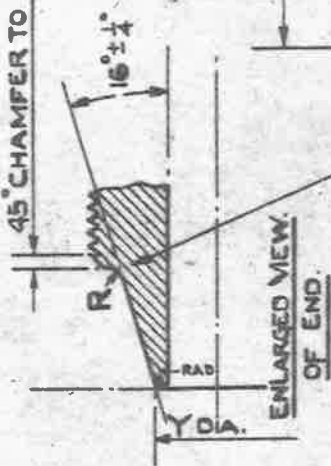
No. OF SHEETS 3

MARKS 6 TO 10.

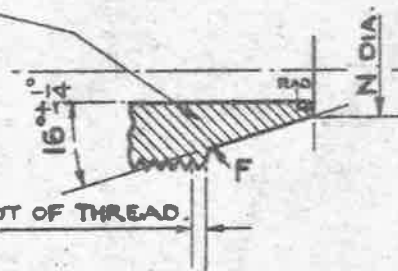
MARKS 1 TO 5, 11 TO 13.

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

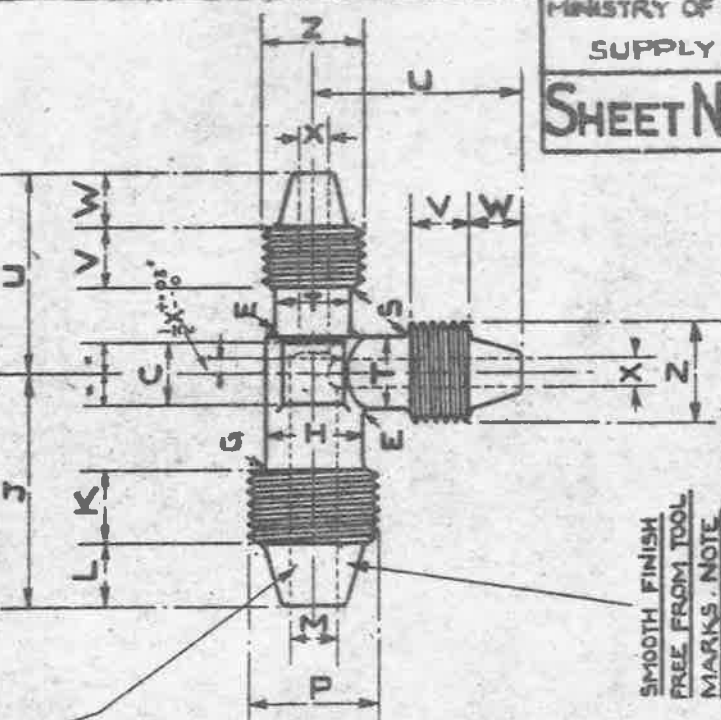
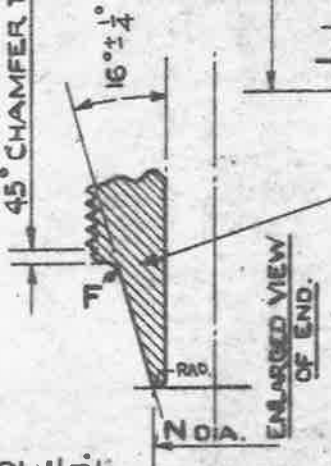
45° CHAMFER TO ROOT OF THREAD.



45° CHAMFER TO ROOT OF THREAD.



45° CHAMFER TO ROOT OF THREAD.



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

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT

TITLE:- PIPE COUPLINGS. (LIGHT ALLOY) CONE TEES UNEQUAL.

DRAWN C.T. Reynolds. TRACED P.W. 26/9/41.

ISSUE No	1	2	3	3
ALTER <sup>N</sup> No	MOD AGS 449	MOD/AGS 672	AS/AGS 988	SM 856

CHECKED APPROVED  
*[Signature]* *[Signature]*  
 7. 11. 41

DIMENSIONS FOR REMAINING BRANCH.

DIMENSIONS FOR EQUAL BRANCHES.

MARK	SIZE OF TEE % OF PIPES	DIMENSIONS FOR REMAINING BRANCH.										DIMENSIONS FOR EQUAL BRANCHES.									
		Z	Y	X	W	V	U	T	S	R	P	N	M	L	K	J	H	G	F	E	D
1	1" x 1" x 3/4"	B.S.P. THREAD 1"	224	5/32	.28	.30	1.05	.37	.04	1"	.160	3/32	.22	.30	.98	.28	.04	.03	.06	.413	.25
2	5/16 x 5/16 x 3/16"	19 T.P.I. WHIT FORM 60% D	.267	3/16	.32	.34	1.15	.40	.04	1"	.160	3/32	.22	.30	1.02	.28	.04	.03	.10	.440	.27
3	3/8 x 3/8 x 1/4"	3/8	.333	1/4	.32	.37	1.25	.48	.04	1/4	.224	5/32	.28	.30	1.11	.37	.05	.04	.10	.520	.30
4	7/16 x 7/16 x 5/16"	14 T.P.I. WHIT FORM 75% D	.377	5/16	.32	.39	1.32	.56	.06	19 T.P.I. WHIT FORM 60% D	.267	3/16	.32	.34	1.24	.40	.06	.04	.10	.595	.40
5	1 1/2 x 1" x 3/8"	1 1/2	.438	3/8	.32	.40	1.37	.65	.06	3/8	.333	1/4	.32	.37	1.35	.48	.06	.04	.10	.705	.45
6	1" x 3/4 x 3/16"	1"	.160	3/32	.22	.30	.98	.28	.03	1/4	.224	5/32	.28	.30	1.05	.37	.05	.04	.06	.410	.25
7	5/16 x 3/16 x 3/16"	1"	.160	3/32	.22	.30	1.02	.28	.03	19 T.P.I. WHIT FORM 60% D	.267	3/16	.32	.34	1.15	.40	.06	.04	.10	.440	.27
8	3/8 x 1/4 x 1/4"	1"	.224	5/32	.28	.30	1.11	.37	.04	3/8	.333	1/4	.32	.37	1.26	.48	.06	.04	.10	.520	.30
9	7/16 x 5/16 x 3/16"	19 T.P.I. WHIT FORM 60% D	.267	3/16	.32	.34	1.24	.40	.04	14 T.P.I. WHIT FORM 75% D	.377	5/16	.32	.39	1.32	.56	.06	.06	.10	.595	.40
10	1 1/2 x 3/8 x 3/8"	3/8	.333	1/4	.32	.37	1.35	.48	.04	1"	.438	3/8	.32	.40	1.37	.65	.08	.06	.10	.705	.45

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

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

WORKING PRESSURE :- 3,000 LB./SQ. IN. FOR SIZES UP TO 1/2" B.S.P.

SCREW THREADS TO B.S. SPEC. N° 84 - 1940, MEDIUM FIT, TRUNCATED THREADS TO AMENDMENT N° 3-1945

NOTES :-

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT

TITLE:- PIPE COUPLINGS.  
(LIGHT ALLOY)  
CONE TEES, UNEQUAL.

ISSUE No 2  
ALTERNATIVE No 4

MOD AGS 449  
AS/AGS/ 663

MOD AGS 672  
AS/AGS 877

SM495

DRAWN C.T. Reynolds  
TRACED P.W. 1-10-41.  
CHECKED A. J. Barker  
APPROVED P.W. 7.11.41.

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

NOTE:- FOR MATERIAL, FINISH & GENERAL NOTES, SEE SHEET. 2.

MARK	SIZE OF TEE % OF PIPES	DIMENSIONS FOR EQUAL BRANCHES										DIMENSIONS FOR REMAINING BRANCH											
		Z	Y	X	W	V	U	T	S	R	P	N	M	L	K	J	H	G	F	E	D	C	
11	$\frac{3}{8} \times \frac{3}{8} \times \frac{3}{16}$	B.S.P. THREAD -0	+010 DIA. DRILL -0	+01 DIA. DRILL -0	+01 DIA. DRILL -0	+01 DIA. DRILL -0	+01 DIA. DRILL -0	+04 DIA. DRILL -01			B.S.P. THREAD -0	+010 DIA. DRILL -0	+01 DIA. DRILL -0	+01 DIA. DRILL -0	+01 DIA. DRILL -0	+04 DIA. DRILL -01					MIN. MAX.		
		$\frac{3}{8}$	.333	$\frac{1}{4}$	.32	.37	1.25	.48	.06	.04	$\frac{1}{8}$	$\frac{3}{32}$	.22	.30	.05	.28	.04	.03	.10	.520	.525	.30	
12	$\frac{7}{16} \times \frac{7}{16} \times \frac{3}{16}$	14 T.P.I. WHIT. FORM .75% <sub>D</sub>	.377	$\frac{5}{16}$	.32	.39	1.32	.56	.06	.06	$\frac{1}{8}$	$\frac{3}{32}$	.22	.30	.10	.28	.04	.03	.10	.595	.600	.40	
13	$\frac{1}{2} \times \frac{1}{2} \times \frac{3}{16}$	$\frac{1}{2}$	.438	$\frac{3}{8}$	.32	.40	1.37	.65	.08	.06	$\frac{1}{8}$	$\frac{3}{32}$	.22	.30	.13	.28	.04	.03	.10	.705	.710	.45	

ISSUED BY THE  
ROYAL AIRCRAFT  
ESTABLISHMENT

TITLE:- PIPE COUPLINGS (LIGHT ALLOY)  
CONE TEES UNEQUAL

DRAWN  
C.T. Reynolds  
TRACED  
PMB.20-6-47

ISSUE NO

19  
47  
2

CHECKED

APPROVED

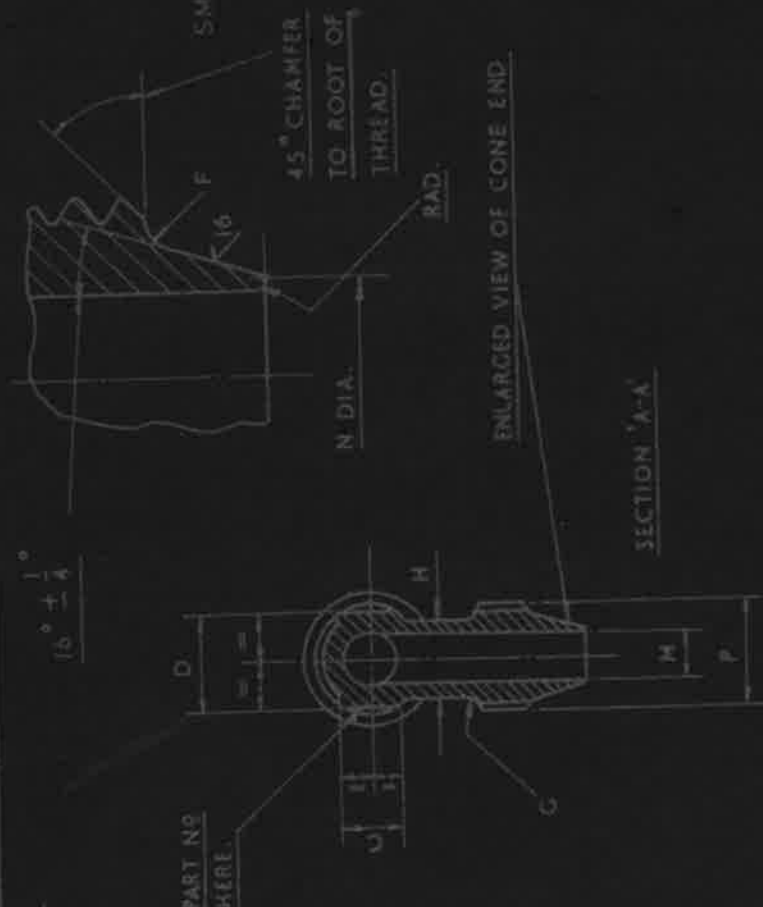
ALTERN NO

MOD  
AGS/672  
AS/AGS  
877

*[Signature]*

*[Signature]*  
22 7 47

MARKS 1 TO 5, 11 TO 13



SEE A.G.S. 100 FOR GENERAL INFORMATION.  
 B.S.P.F. THREAD TO B.S. SPEC. NO. 2779. MEDIUM FIT TRUNCATED.  
 FOR ARRANGEMENT OF PIPE JOINT SEE A.G.S. 1101.  
 WORKING PRESSURE: 3000 LB / SQ. IN.

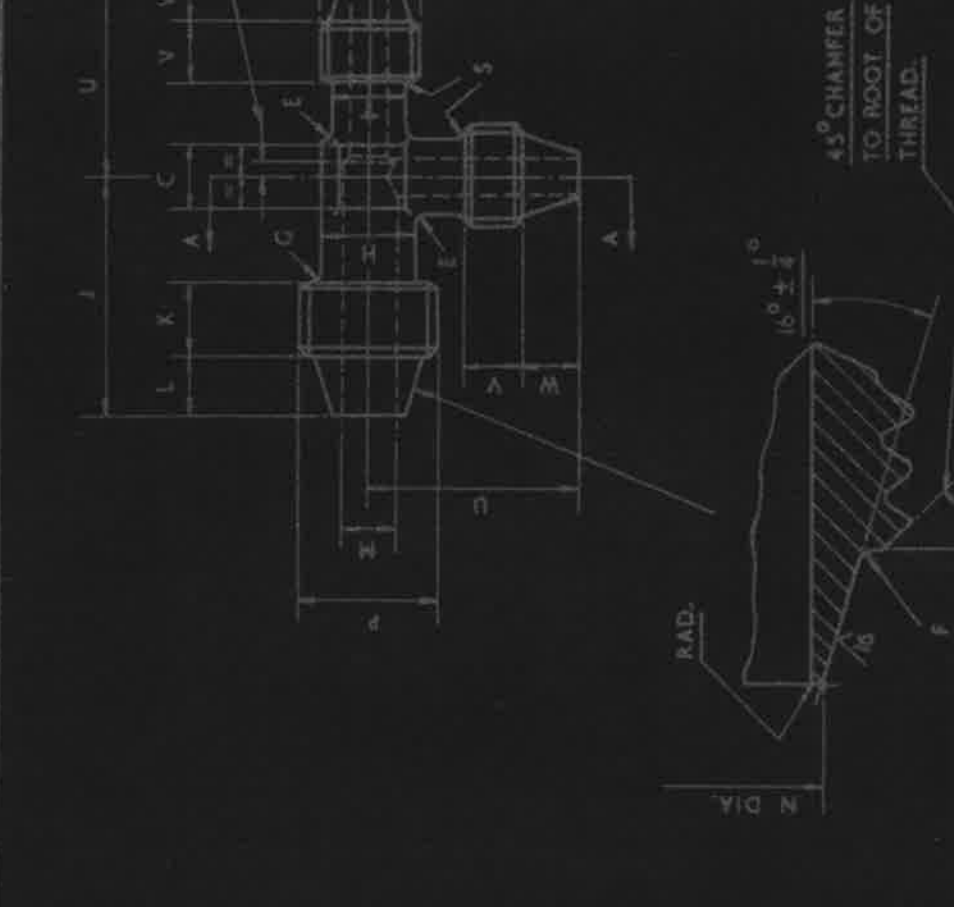
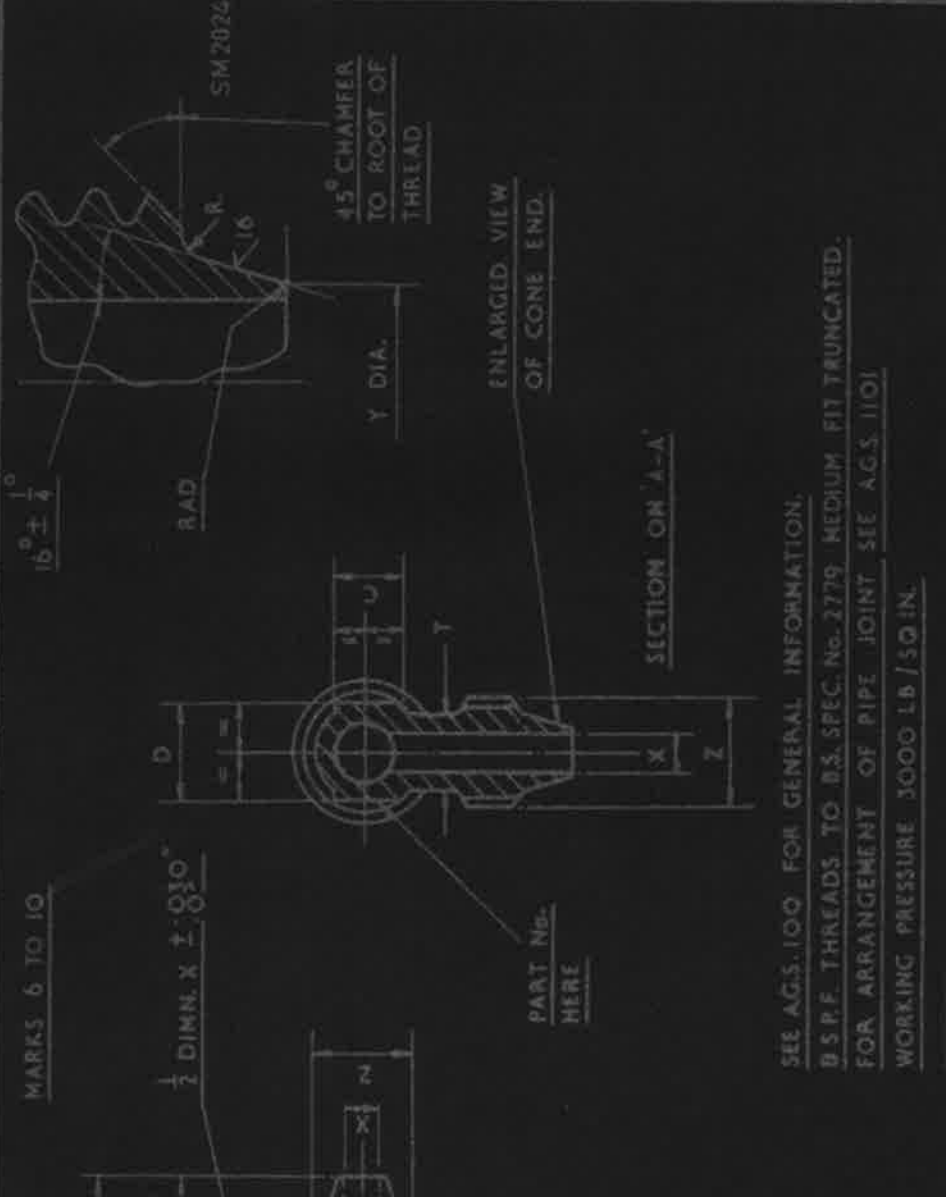
ENLARGED VIEW OF CONE END

DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR S.B.A.C.	DATE	HT	PT	RS. 116. NO. PAINT	SCALE	LIMITS NOT SHOWN	DESCRIPTION	AT DRAWING UNIT QTY	OPP. HAND	MATERIAL - REMARKS
F.A.C.	F.A.C.	F.A.C.	F.A.C.	<i>Hgf. Wk.</i>	27.1.58						ALUMM ALLOY			L. 85.
PIPE COUPLINGS. (ALUMM ALLOY)											THIRD ANGLE PROJECTION			
CONE TEE (UNEQUAL).											A.G.S. 1120 - SHEET 1			

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

SIZE B3-B\*10

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



SEE AGS.100 FOR GENERAL INFORMATION.  
 B.S.P. THREADS TO B.S. SPEC. No. 2779 MEDIUM FIT TRUNCATED.  
 FOR ARRANGEMENT OF PIPE JOINT SEE AGS.1101  
 WORKING PRESSURE 3000 LB/50 IN.

DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR	DATE
	F.A.C.	F.A.C.	F.A.C.	<i>W.B. Parker</i>	27.1.58

USED ON	REF.	DRAWING OR PART No.	HT	PT	R.S.I16. NO. PAINT	SCALE	LIMITS NOT SHOWN	DESCRIPTION	AS DRAWN UNIT QTY	MATERIAL - REMARKS
								ALUMM ALLOY		L.85.
								PIPE COUPLINGS (ALUMM ALLOY) CONE TEE (UNEQUAL).		
										THIRD ANGLE PROJECTION
										AG.S.1120 SHEET 2

A.G.S. 1120 - SHEET 3.

SM2027

M A R K	SIZE OF TEE Ø/DIA Ø/PIPES	DIMENSIONS FOR REMAINING BRANCH.										DIMENSIONS FOR EQUAL BRANCHES.									
		C	D	E	F	G	H	J	K	L	M	N	P	R	S	T	U	V	W	X	Y
		RAD.	RAD.	RAD.	RAD.	RAD.				DRILL DIA.	DRILL DIA.	B.S.P.E THD.	RAD.	RAD.					DRILL DIA.		B.S.P.E THD.
1	1" x 1/2" x 1/2"	.413"	.410"	.06"	.05"	.04"	.320"	.990"	.310"	.230"	.170"	1/8"	.04"	.05"	.410"	.060"	.310"	.290"	5/32"	.234"	1/4"
2	1 1/2" x 1" x 1"	.445"	.440"	.10"	.03"	.04"	.320"	.970"	.310"	.220"	.160"	1/8"	.04"	.05"	.360"	.040"	.290"	.280"	5/32"	.224"	1/4"
3	2" x 1 1/2" x 1 1/2"	.525"	.520"	.10"	.04"	.05"	.410"	.120"	.310"	.290"	.234"	1/4"	.04"	.06"	.440"	.160"	.350"	.330"	3/16"	.277"	19 TPI 60% WHIT. (B.S. 84)
4	2 1/2" x 2" x 2"	.600"	.595"	.10"	.04"	.06"	.440"	.250"	.350"	.330"	.277"	1/2"	.06"	.06"	.520"	.330"	.400"	.380"	5/16"	.387"	14 TPI 75% WHIT. (B.S. 84)
5	3" x 2 1/2" x 2 1/2"	.710"	.705"	.10"	.04"	.06"	.520"	.360"	.380"	.330"	.267"	3/8"	.06"	.08"	.690"	.410"	.380"	.360"	3/8"	.448"	14 TPI 75% WHIT. (B.S. 84)
6	3 1/2" x 3" x 3"	.813"	.810"	.06"	.04"	.05"	.410"	.060"	.310"	.290"	.234"	1/2"	.05"	.04"	.640"	.360"	.390"	.370"	1/2"	.438"	1/2"
7	4" x 3" x 3"	.880"	.875"	.10"	.04"	.06"	.440"	.160"	.350"	.330"	.224"	3/4"	.06"	.06"	.720"	.440"	.410"	.390"	3/4"	.477"	19 TPI 60% WHIT. (B.S. 84)
8	5" x 4" x 4"	.930"	.925"	.10"	.04"	.06"	.520"	.260"	.380"	.330"	.267"	7/8"	.06"	.08"	.800"	.470"	.440"	.420"	7/8"	.527"	19 TPI 60% WHIT. (B.S. 84)
9	6" x 5" x 5"	.990"	.985"	.10"	.06"	.06"	.600"	.330"	.400"	.330"	.224"	1"	.06"	.06"	.880"	.550"	.520"	.500"	1"	.577"	14 TPI 75% WHIT. (B.S. 84)
10	8" x 6" x 6"	.110"	.105"	.10"	.06"	.08"	.690"	.380"	.460"	.380"	.267"	1 1/8"	.06"	.08"	.960"	.640"	.610"	.590"	1 1/8"	.648"	14 TPI 75% WHIT. (B.S. 84)
11	10" x 8" x 8"	.125"	.120"	.10"	.05"	.04"	.820"	.460"	.540"	.460"	.230"	1 1/4"	.05"	.04"	.1100"	.720"	.690"	.670"	1 1/4"	.718"	19 TPI 60% WHIT. (B.S. 84)
12	12" x 10" x 10"	.140"	.135"	.10"	.03"	.04"	.900"	.510"	.600"	.510"	.230"	1 1/2"	.03"	.04"	.1200"	.800"	.770"	.750"	1 1/2"	.740"	14 TPI 75% WHIT. (B.S. 84)
13	14" x 12" x 12"	.155"	.150"	.10"	.05"	.04"	.1000"	.570"	.670"	.570"	.230"	1 3/4"	.05"	.04"	.1300"	.880"	.850"	.830"	1 3/4"	.820"	19 TPI 60% WHIT. (B.S. 84)

DESIGNED	DRAWN	TRAISED	CHECKED	APPROVED FOR	DATE	HT	PT	SCALE	DESCRIPTION	MATERIAL	REMARKS
DESIGNED BY THE SOCIETY OF BRITISH AIRBRIST ENGINEERS LTD., 19, KING STREET, ST. JAMES'S, LONDON, S.W.1.										PIPE COUPLINGS (ALUM. B. ALLOY) CONE TEES UNEQUAL.	
										A.G.S. 1120 - SHEET 3.	

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