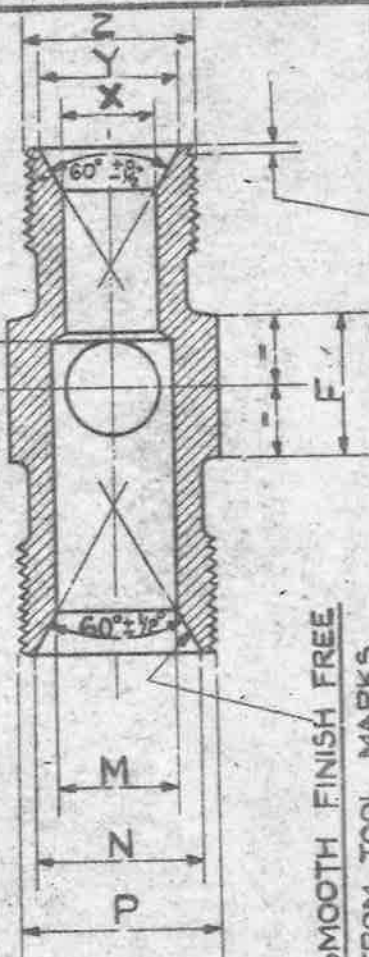


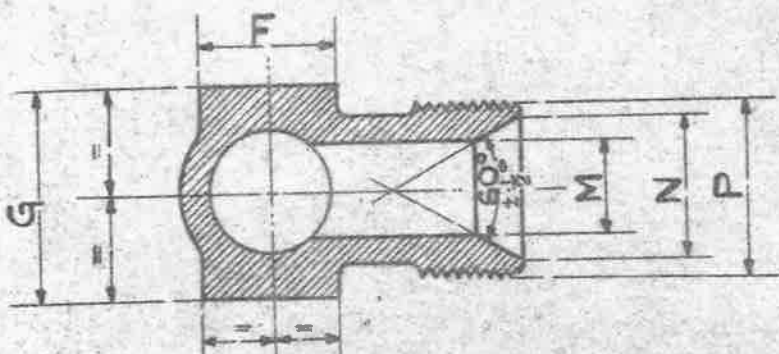
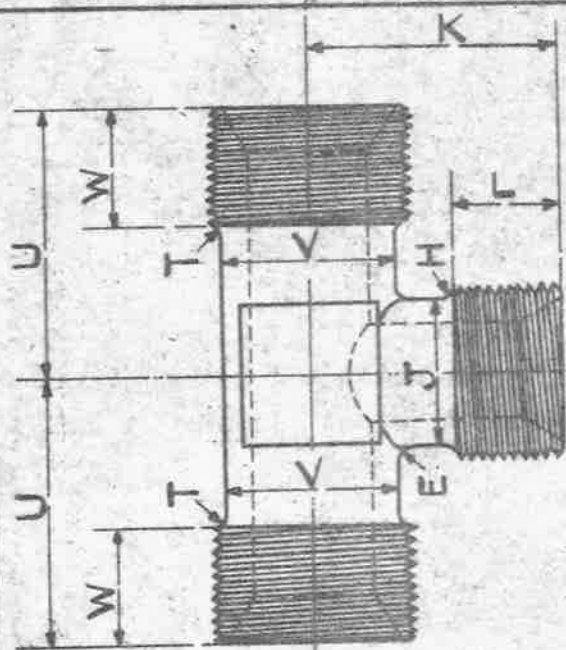
$\frac{1}{2}X \pm 0.03$



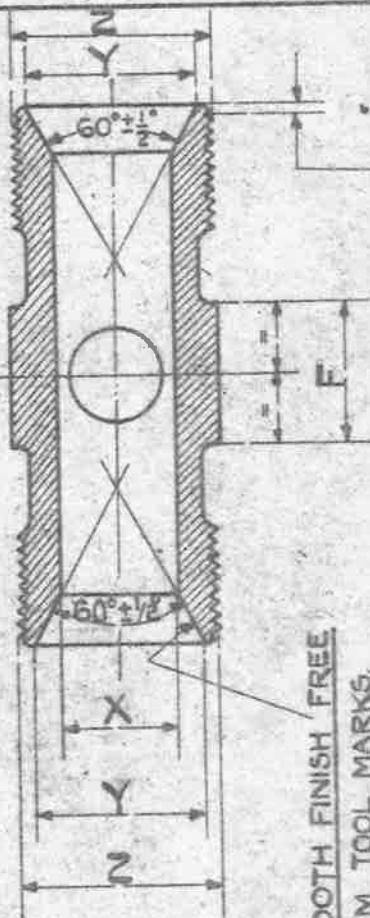
45° CHAMFER TO ROOT OF THREAD. NOTE APPLIES TO ALL BRANCHES

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

MARKS 5 TO 8.



SEE AGS.100 FOR GENERAL INFORMATION.



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

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

MARKS 1 TO 4.

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT.

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

DRAWN: C.T. Reynolds

TRACED L.L.S. 24.10.41

ISSUE No 1 2 2  
ALTER: No MOD. 1944 AS/ACR SM 856

CHECKED: J.M. Drach

APPROVED: J.W. 7.11.41

12-10-45  
REV. 400.62

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

MARK	DIA OF PIPES.	DIMENSIONS FOR EQUAL BRANCHES.										DIMENSIONS FOR REMAINING BRANCH.							
		Z	Y	X	W	V	U	T	P	N	M	L	K	J	H	G	F	E	
1	3/4 x 5/8	3/4	.90	5/8	.61	.91	1.37	.06	5/8	.76	1/2	.55	1.30	.77	.06	1.092	1.100	.73	.07
2	1" x 3/4	1"	1.13	7/8	.65	1.15	1.65	.06	3/4	.90	5/8	.61	1.50	.91	.06	1.382	1.390	.95	.10
3	1 1/4 x 1 1/4	1 1/4	1.45	1 1/8	.65	1.49	1.86	.06	1"	1.13	7/8	.65	1.78	1.15	.06	1.658	1.670	1.08	.15
4	1 1/2 x 1 1/2	1 1/2	1.68	1 3/8	.70	1.73	2.05	.06	1 1/4	1.45	1 1/8	.65	1.96	1.49	.06	2.035	2.050	1.25	.15
5	3/4 x 5/8	5/8	.76	1/2	.55	.77	1.30	.06	3/4	.90	5/8	.61	1.37	.91	.06	1.092	1.100	.73	.07
6	1" x 3/4	3/4	.90	5/8	.61	.91	1.50	.06	1"	1.13	7/8	.65	1.65	1.15	.06	1.382	1.390	.95	.10
7	1 1/4 x 1 1/4	1"	1.13	7/8	.65	1.15	1.78	.06	1 1/4	1.45	1 1/8	.65	1.88	1.49	.06	1.658	1.670	1.08	.15
8	1 1/2 x 1 1/2	1 1/4	1.45	1 1/8	.65	1.49	1.95	.06	1 1/2	1.68	1 3/8	.70	2.05	1.73	.06	2.035	2.050	1.25	.15

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. No 84 - 1940, MEDIUM FIT TRUNCATED THREADS TO AMENDMENT No. 3 - 1945.

FOR ARRANGEMENT OF PIPE JOINTS SEE AGS. No 1101.

ISSUED BY DRAWING OFFICE  
DIRECTORATE OF  
TECHNICAL DEVELOPMENT  
MINISTRY OF  
AIRCRAFT PRODUCTION.

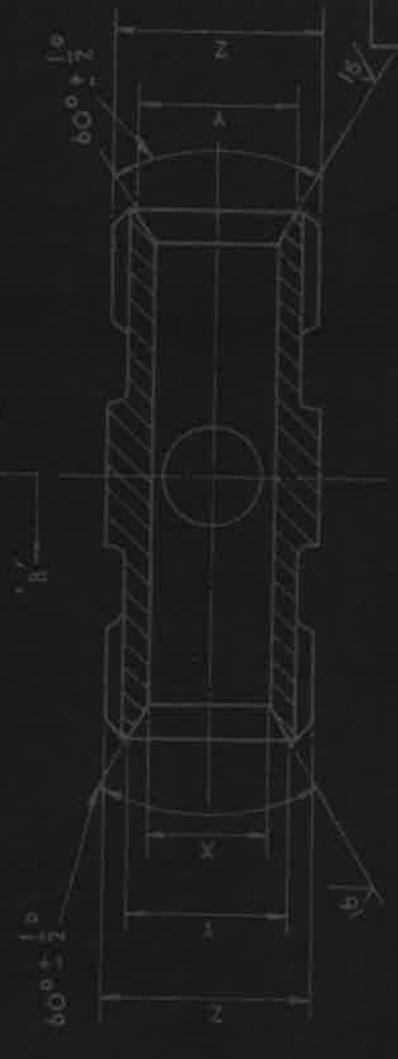
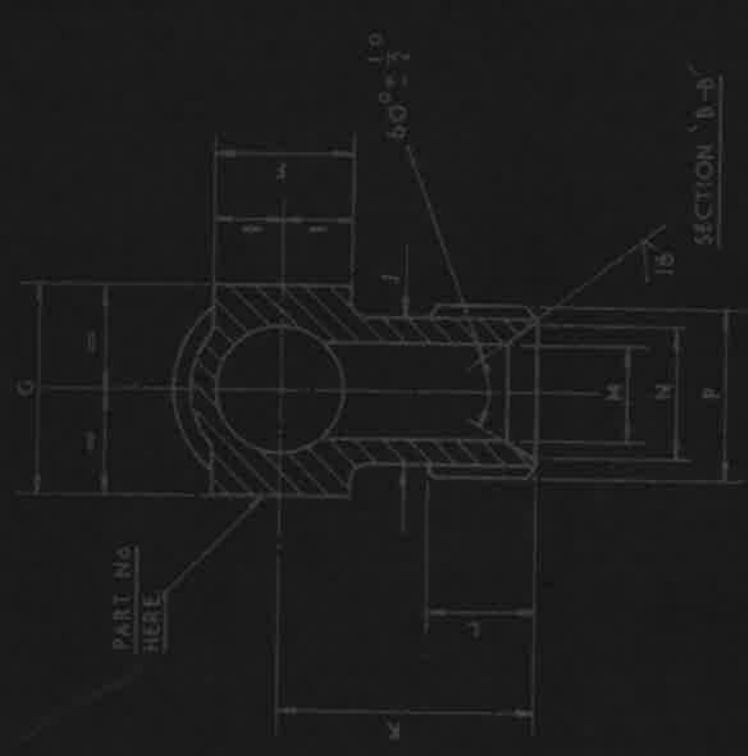
TITLE :- PIPE COUPLINGS,  
(LIGHT ALLOY),  
UNION TEES, UNEQUAL.

ISSUE No 2  
ALTER No 200, 45/AGS, 205, 449, 663

DRAWN.  
C.T. Reynolds  
CHECKED  
Hobbes

TRACED  
27-10-45

MARKS 1 TO 4



SEE A.G.S. 100 FOR GENERAL INFORMATION  
 B.S.P. THREADS TO B.S. SPECN. 2779 MEDIUM FIT TRUNCATED.  
 FOR ARRANGEMENT OF PIPE JOINT SEE A.G.S. 1101.  
 WORKING PRESSURE: 500 LB./SQ. IN. FOR SIZES 1/2" TO 1 1/2" B.S.P.  
 200 LB./SQ. IN. FOR SIZES 1 1/4" TO 1 1/2" B.S.P.

ISSUE	ALT. No.	5M2024 F121 F123
3	F2	
4	F46	
5	F96	
7	F101	
8	F123	

DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR	DATE
	F.A.C.	F.A.C.	F.A.C.	S.G.A.C.	27.1.58

REF.	DRAWING OR PART No.	ALUM. ALLOY	DESCRIPTION

HT	PT	R.S.116	SCALE	LIMITS NOT SHOWN

AS DRAWN	UNIT QTY	L.85.

MATERIAL - REMARKS	THIRD ANGLE PROJECTION

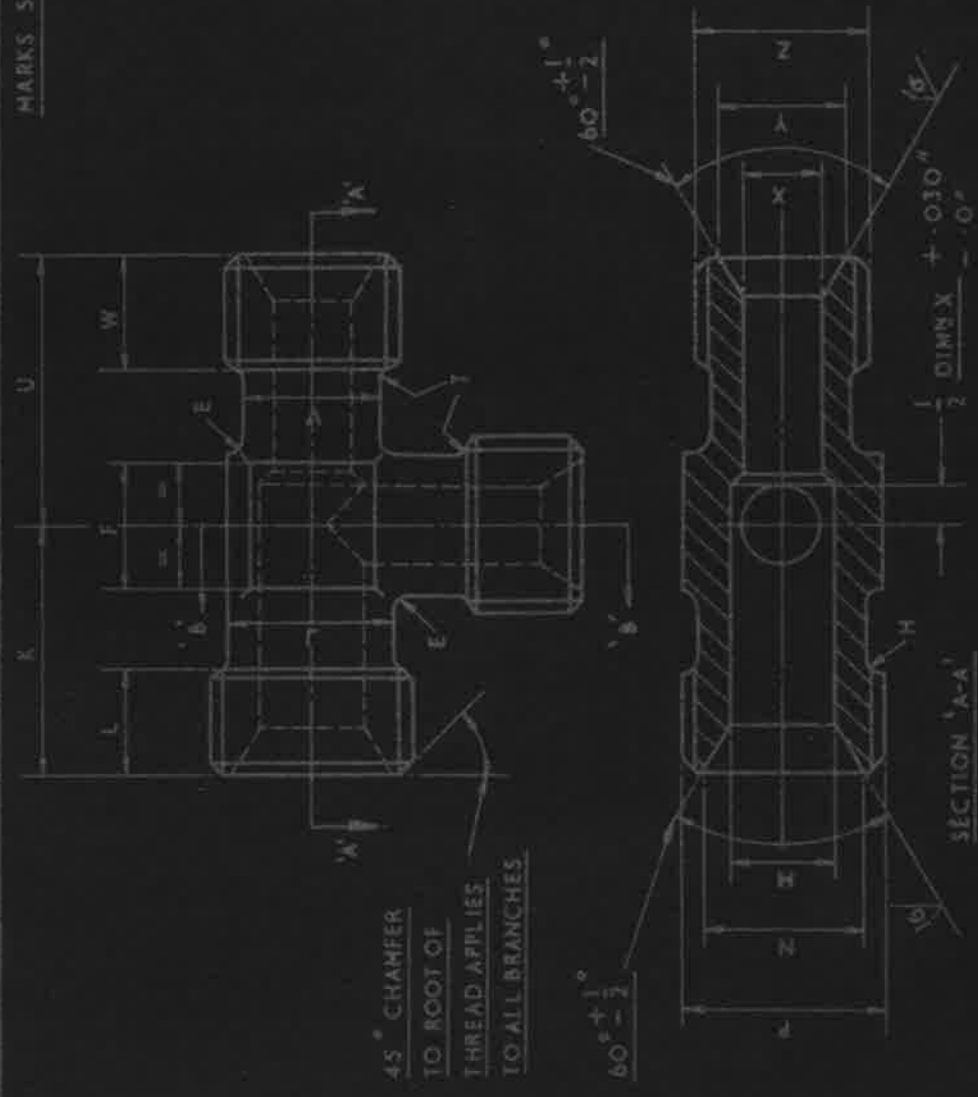
  

ISSUED BY THE SOCIETY OF BRITISH AEROSPACE COMPANIES LTD., 29, KING STREET, ST. JAMES'S, LONDON, S.W.1.	PIPE COUPLINGS (ALUMINUM ALLOY) UNION TEE UNEQUAL.	A.G.S. 1121 SHEET L.
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ISSUE	ALT. No.
4	F. 2
5	F. 46
6	F. 96
7	F. 101
8	F. 123

SM 2024

MARKS S TO B



45° CHAMFER TO ROOT OF THREAD APPLIES TO ALL BRANCHES

SEE A.G.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.G.S. 1101  
 WORKING PRESSURE: 500 L.B. SQ. IN. FOR SIZES 5/8" TO 1" B.S.P.F.  
 200 L.B. SQ. IN. FOR SIZES 1 1/4" TO 1 1/2" B.S.P.F.

USED ON	REF.	DRAWING OR PART No.	ALUM <sup>m</sup> ALLOY	AS DRAWN	100% HARD	L.B.S.	MATERIAL - REMARKS
DESIGNED	HT	PT	R.S. 116	SCALE	LIMITS NOT SHOWN	THIRD ANGLE PROJECTION	
DRAWN		F.A.C.	PAINT				
CHECKED		F.A.C.	DESCRIPTION				
TRACED		F.A.C.	UNIT QTY				
APPROVED FOR		DATE	PIPE COUPLINGS. (ALUM <sup>m</sup> ALLOY)				
S.B.A.C.		27.1.58	UNION TEE (UNEQUAL).				
ISSUED BY THE SOCIETY OF BRITISH AEROSPACE COMPANIES LTD., 29, KING STREET, ST. JAMES'S, LONDON, S.W.1.							
A.G.S. 1121 - SHEET 2							

SIZE B3-8-13

MARK	DIA. OF PIPES	DIMNS FOR REMAINING BRANCH											DIMNS FOR EQUAL BRANCHES					
		E RAD.	F	G	H RAD.	J	K	L	M DRILL DIA.	N	P B.S.P.F. THREAD	T RAD.	U	V	W	X DRILL DIA.	Y	Z B.S.P.F. THREAD
1	$3\frac{1}{4} \times 3\frac{3}{4} \times 5\frac{5}{8}$	.07"	.740" .720"	1.100" 1.092"	.060"	.810" .760"	1.310" 1.290"	.560" .540"	$1\frac{1}{2}$ "	.765" .755"	$5\frac{5}{8}$ "	.06"	1.380" 1.360"	.950" .900"	.620" .600"	$5\frac{5}{8}$ "	.905" .895"	$3\frac{3}{4}$ "
2	$1\frac{1}{4} \times 1\frac{1}{4} \times 3\frac{3}{4}$	.10"	.960" .940"	1.390" 1.382"	.060"	.950" .900"	1.510" 1.490"	.620" .600"	$5\frac{5}{8}$ "	.905" .895"	$3\frac{3}{4}$ "	.06"	1.660" 1.640"	1.190" 1.140"	.660" .640"	$7\frac{7}{8}$ "	1.135" 1.125"	1"
3	$1\frac{1}{4} \times 1\frac{1}{4} \times 1\frac{1}{4}$	.15"	1.090" 1.070"	1.670" 1.658"	.060"	1.190" 1.140"	1.790" 1.770"	.660" .640"	$7\frac{7}{8}$ "	1.135" 1.125"	1"	.06"	1.890" 1.870"	1.530" 1.480"	.660" .640"	$1\frac{1}{8}$ "	1.455" 1.445"	$1\frac{1}{4}$ "
4	$1\frac{1}{2} \times 1\frac{1}{2} \times 1\frac{1}{4}$	.15"	1.260" 1.240"	2.050" 2.035"	.060"	1.530" 1.480"	1.960" 1.940"	.660" .640"	$1\frac{1}{8}$ "	1.455" 1.445"	$1\frac{1}{4}$ "	.06"	2.060" 2.040"	1.770" 1.720"	.710" .690"	$3\frac{3}{8}$ "	1.685" 1.675"	$1\frac{1}{2}$ "
5	$3\frac{1}{4} \times 3\frac{1}{4} \times 5\frac{5}{8}$	.07"	.740" .720"	1.100" 1.092"	.060"	.950" .900"	1.380" 1.360"	.620" .600"	$5\frac{5}{8}$ "	.905" .895"	$3\frac{3}{4}$ "	.06"	1.310" 1.290"	.810" .760"	.560" .540"	$1\frac{1}{2}$ "	.765" .755"	$5\frac{5}{8}$ "
6	$1\frac{1}{4} \times 3\frac{3}{4} \times 3\frac{3}{4}$	.10"	.960" .940"	1.390" 1.382"	.060"	1.190" 1.140"	1.660" 1.640"	.660" .640"	$7\frac{7}{8}$ "	1.135" 1.125"	1"	.06"	1.510" 1.490"	.950" .900"	.620" .600"	$5\frac{5}{8}$ "	.905" .895"	$3\frac{3}{4}$ "
7	$1\frac{1}{4} \times 1\frac{1}{4} \times 1\frac{1}{4}$	.15"	1.090" 1.070"	1.670" 1.658"	.060"	1.530" 1.480"	1.890" 1.870"	.660" .640"	$1\frac{1}{8}$ "	1.455" 1.445"	$1\frac{1}{4}$ "	.06"	1.790" 1.770"	1.190" 1.140"	.660" .640"	$7\frac{7}{8}$ "	1.135" 1.125"	1"
8	$1\frac{1}{2} \times 1\frac{1}{2} \times 1\frac{1}{4}$	.15"	1.260" 1.240"	2.050" 2.035"	.060"	1.770" 1.720"	2.060" 2.040"	.710" .690"	$3\frac{3}{8}$ "	1.685" 1.675"	$1\frac{1}{2}$ "	.06"	1.960" 1.940"	1.530" 1.480"	.660" .640"	$1\frac{1}{8}$ "	1.455" 1.445"	$1\frac{1}{4}$ "

USED ON

DESIGNED DRAWN TRACED CHECKED APPROVED FOR DATE  
F.A.C F.A.C F.A.C. *Ag Parker* 27.1.58

HT

DESCRIPTION

SCALE

LIMITS NOT SHOWN

PIPE COUPLINGS (ALUM<sup>m</sup> ALLOY)  
UNION TEES (UNEQUAL)

A.G.S. 1121.SHEET.3

SIZE B.3.-B\*13