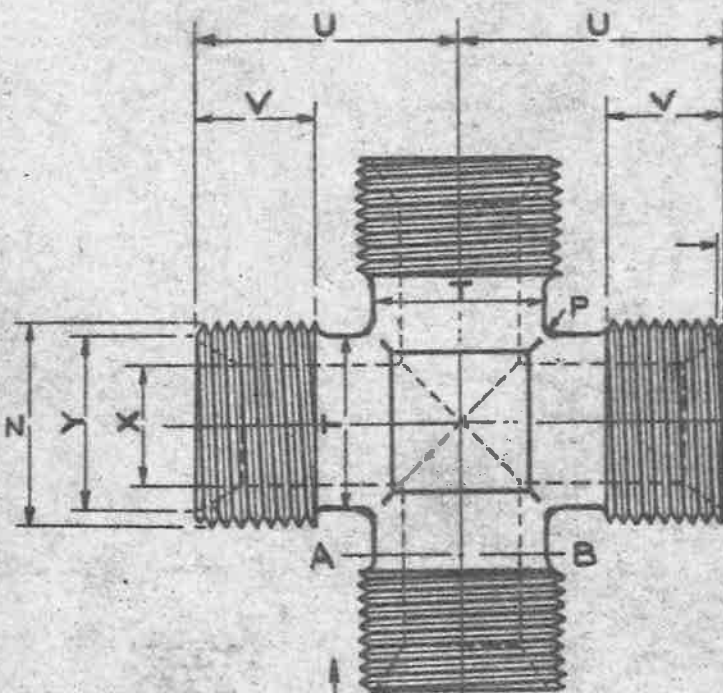
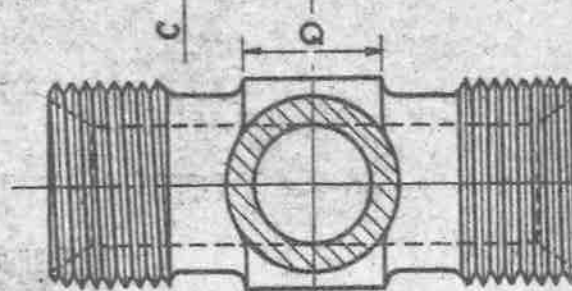


SMOOTH FINISH FREE FROM TOOLMARKS. NOTE APPLIES TO ALL BRANCHES.



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



SECTIONAL VIEW ON AB, IN DIRECTION OF ARROW C.

MARK	DIA OF PIPE.	Z	Y	X	V	U	T	S	Q	P	M
		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' 1.20'	.875'	.07'	.06'
H	1"	1"	1.13'	7/8"	.65'	1.65'	1.15'	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'	.06"
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. NO 84- 1940.

MEDIUM FIT. TRUNCATED THREADS. TO AMENDMENT N°3 - 1945.

FOR ARRANGEMENT OF PIPE JOINT SEE A.G.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 1/4" & 1 1/2" B.S.P.

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT	TITLE:- PIPE COUPLINGS. (LIGHT ALLOY) UNION 4-WAY PIECE, 5/8" TO 1 1/2"				DRAWN C.J.M. DUNN	TRACED P.L.N. 14-10-41
	ISSUE NO	1	2	3	CHECKED J.H. Searles	APPROVED J.H. Searles 7.11.41
	ALTER-N°	MOD. AGS 449	AS/ACS/ 663	AS/ACS/ 988		

MARK	o/b OF PIPE	M	P	O	S	T	U	V	X	Y	Z	ALT. No.	ISSUE
													SM2027
												1	
												8	
												F01	
E	5/8	.06	.07	.390 .570	.920 .915	.81 .76	1.260 1.240	.56 .54	1"	.765 .755	5/8		
F	3/4	.06	.07	.740 .720	1.100 1.092	.95 .90	1.385 1.365	.62 .60	5/8	.905 .895	3/4		
G	7/8	.06	.07	.885 .865	1.200 1.192	1.10 1.05	1.510 1.490	.66 .64	3/4	1.045 1.035	7/8		
H	1"	.06	.07	.960 .940	1.390 1.382	1.19 1.14	1.660 1.640	.66 .64	7/8	1.135 1.125	1"		
J	1 1/4	.06	.10	1.090 1.070	1.670 1.658	1.53 1.48	1.890 1.870	.66 .64	1"	1.455 1.445	1 1/4		
K	1 1/2	.06	.10	1.260 1.240	2.050 2.035	1.77 1.72	2.060 2.040	.71 .69	3/8	1.685 1.675	1 1/2		

DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR S.B.A.C.	DATE	HT	PT	SCALE	LIMITS NOT SHOWN	DESCRIPTION	DRAWING OR PART No.	REF.	DRAWN	UNIT QTY	MATERIAL - REMARKS
					27/1/58					PIPE COUPLINGS. (ALUM ^M ALLOY) UNION 4-WAY PIECE, 5/8 TO 1 1/2.					A.G.S. 1124. SHEET. 2.