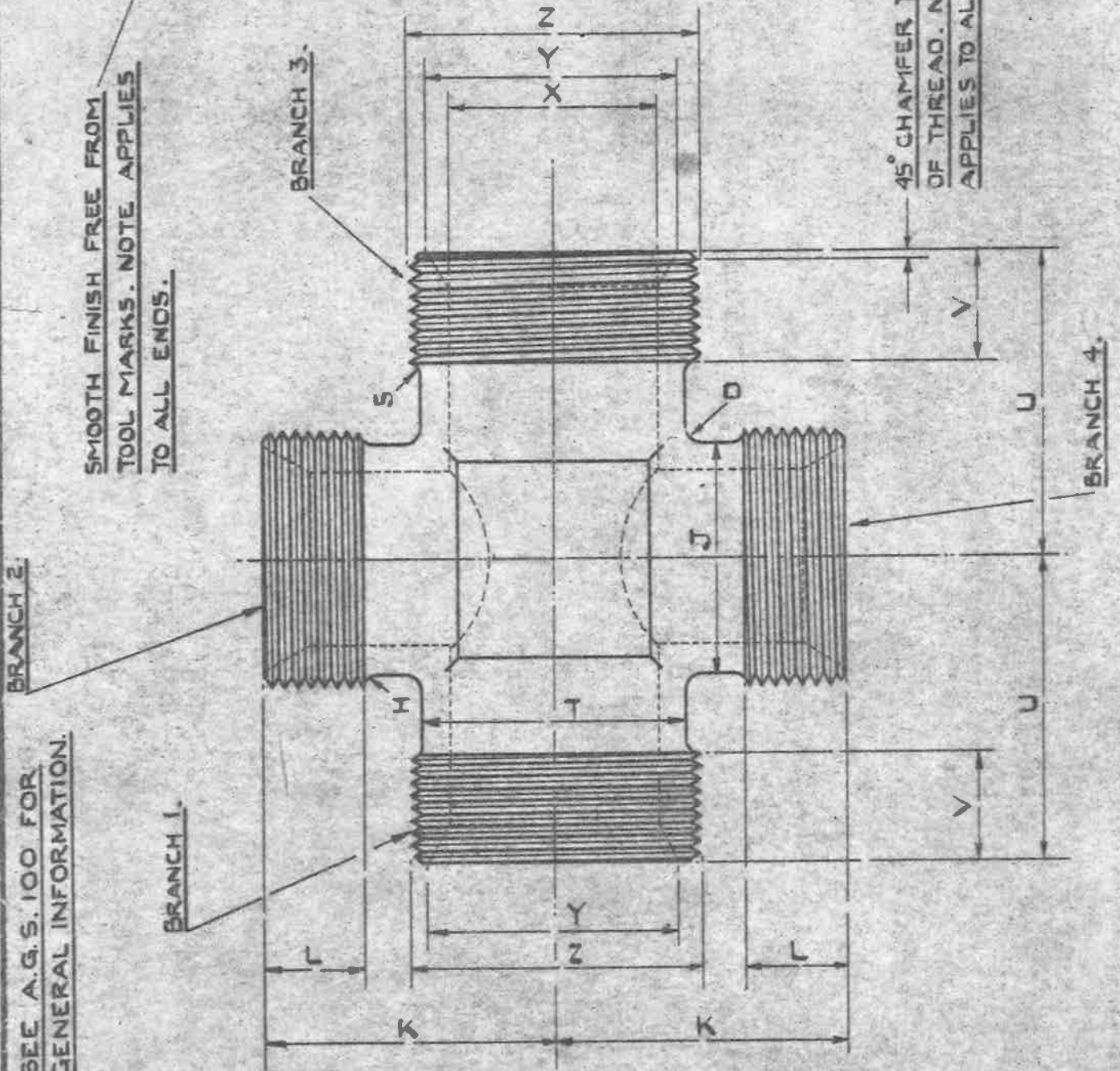


THIS DIMENSION APPLIES TO ALL BRANCHES.

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

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



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

BRANCH 2.

BRANCH 1.

BRANCH 3.

BRANCH 4.

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT.

TITLE:— PIPE COUPLINGS. (LIGHT ALLOY). UNION 4-WAY PIECES (UNEQUAL).

DRAWN. E. M. MEREDETH. TRACED P.W. 29/10/41

ISSUE NO	1	2	2
ALTERS NO	MOD. AS/ACE	AS/ACE	SM 854

CHECKED [Signature] APPROVED [Signature] 7.11.41

(P)

12-10-42
Res. 493.62.

MARK OF PIPES.	DIMENSIONS FOR BRANCHES 1 & 3.										DIMENSIONS FOR BRANCHES 2 & 4.						
	Z	Y	X	V	U	T	S	P	N	M	L	K	J	H	F	E	D
	B. S. P. THREAD	DIA. DRILL	DIA. DRILL	DIA. DRILL	DIA. DRILL	DIA. DRILL	B. S. P. THREAD	B. S. P. THREAD	DIA. DRILL	DIA. DRILL	DIA. DRILL	DIA. DRILL	DIA. DRILL	DIA. DRILL	MIN. MAX.	±.01" RAD.	±.01" RAD.
1	3/4	.90	5/8	.61	1.375	.91	5/8	5/8	1/2	1/2	.55	1.30	.77	.06	1.092	1.100	.73 .07
2	7/8	1.04	3/4	.65	1.50	1.06	5/8	5/8	1/2	1/2	.55	1.39	.77	.06	1.192	1.20	.80 .07
3	1"	1.13	7/8	.65	1.66	1.15	5/8	5/8	1/2	1/2	.55	1.45	.77	.06	1.382	1.39	.95 .07
4	1" x 3/4"	1.13	7/8	.65	1.66	1.15	3/4	3/4	9/8	9/8	.61	1.50	.91	.06	1.382	1.39	.95 .10
5	1 1/4 x 7/8"	1.45	1 1/8	.65	1.88	1.49	7/8	7/8	3/4	3/4	.65	1.72	1.06	.06	1.658	1.670	1.08 .15
6	1 1/4 x 1"	1.45	1 1/8	.65	1.88	1.49	1"	1"	7/8	7/8	.65	1.78	1.15	.06	1.658	1.670	1.08 .15
7	1 1/2 x 1"	1.68	1 1/8	.70	2.05	1.73	1"	1"	3/8	3/8	.65	1.90	1.15	.06	2.035	2.050	1.25 .15
8	1 1/2 x 1 1/4"	1.68	1 3/8	.70	2.05	1.73	1 1/4	1 1/4	1 1/8	1 1/8	.65	1.95	1.49	.06	2.035	2.050	1.25 .15

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

NOTES: SCREW THREADS TO B.S. SPEC. N984 - 1940.

MEDIUM FIT, TRUNCATED THREADS. TO AMENDMENT No 3 1945

FOR ARRANGEMENT OF PIPE JOINTS SEE A.G.S. No 1101.

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

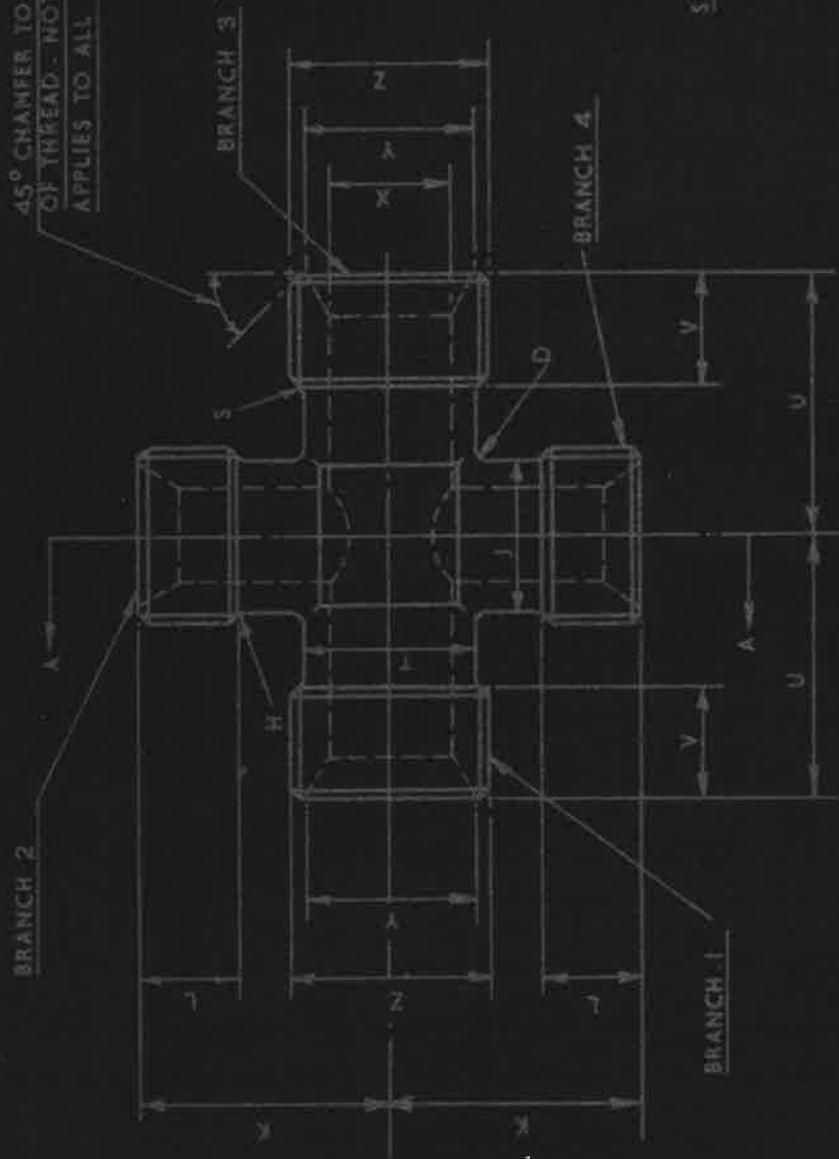
200 LB/SQ. IN. FOR SIZES 1/4" & 1/2" B.S.P.

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

TITLE:- PIPE COUPLINGS.
(LIGHT ALLOY).
UNION 4 - WAY PIECES, (UNEQUAL).
ISSUE No 2
ALTERN No 1
MOD AS AGS
AGS 449 663

DRAWN F. W. MEREDITH
CHECKED J. W. MARCHES

45° CHAMFER TO ROOT OF THREAD - NOTE APPLIES TO ALL ENDS.



SECTION 'A-A'



60° ± 1/2

THIS DIMENSION APPLIES TO ALL BRANCHES.

SM2024

SEE A.G.S. 100 FOR GENERAL INFORMATION
 B.S.P.F. THREADS TO B.S. SPEC. 2779 MEDIUM FIT TRUNCATED,
 WORKING PRESSURE - 500 LB/50 IN. FOR SIZES 5/8 TO 1 1/8 B.S.P.F.
 200 LB/50 IN. FOR SIZES 1 1/4 TO 1 1/2 B.S.P.F.

ISSUE	ALT. No.
3	F.2
4	F.46
5	F.96
6	F.101
7	F.123

USED ON	REF.	DRAWING OR PART No.	DESCRIPTION	AS DRAWN UNIT QTY	OFF HAND UNIT QTY	MATERIAL - REMARKS
DESIGNED	HT	PT	R.S. 116 PAINT	LIMITS NOT SHOWN		THIRD ANGLE PROJECTION
TRACED						
CHECKED						
APPROVED FOR S.E.A.C.						
DATE						
DESIGNED	F.A.C.	F.A.C.	F.A.C.			
TRACED						
CHECKED						
APPROVED FOR S.E.A.C.						
DATE						
ISSUED BY THE SOCIETY OF BRITISH AEROSPACE COMPANIES LTD., 29, KING STREET, ST. JAMES'S, LONDON, S.W.1.						
			PIPE COUPLINGS (ALUM. ALLOY) UNION 4-WAY PIECE (UNEQUAL).			
						A.G.S. 1126. SHEET. 1.

A.G.S. 1126.— SHEET 2.

SM2027

NO.	DIMENSIONS FOR BRANCHES 2 AND 4										DIMENSIONS FOR BRANCHES 1 AND 3							
	DIA OF PIPES	D RAD.	E	F	H RAD.	J	K	L	M DRILL DIA	N	P BS.P.F.	S RAD.	T	U	V	X DRILL DIA	Y	Z BS.P.F.
1	3/4 X 5/8	.07	.74 -72	1-100 -092	.06	.81 -76	1-31 -29	.56 -54	1/2	.765 -755	5/8	.06	.95 -90	1-385 -365	.62 -60	5/8	.905 -895	5/4
2	7/8 X 5/8	.07	.81 -79	1-20 -192	.06	.81 -76	1-40 -38	.56 -54	1/2	.765 -755	5/8	.06	1-100 -105	1-51 -49	.66 -64	3/4	1-045 -1035	7/8
3	1" X 5/8	.07	.96 -94	1-39 -382	.06	.81 -76	1-46 -44	.56 -54	1/2	.765 -755	5/8	.06	1-19 -14	1-66 -64	.66 -64	7/8	1-135 -125	1"
4	1" X 3/4	.10	.96 -94	1-39 -382	.06	.95 -90	1-51 -49	.62 -60	5/8	.905 -895	3/4	.06	1-19 -14	1-66 -64	.66 -64	7/8	1-135 -125	1"
5	1 1/4 X 7/8	.15	1-09 -1-07	1-670 -1-658	.06	1-10 -1-05	1-73 -71	.66 -64	3/4	1-045 -1-035	7/8	.06	1-53 -1-48	1-89 -1-87	.66 -64	1/8	1-455 -1-445	1 1/4
6	1 1/2 X 1 1/4	.15	1-09 -1-07	1-670 -1-658	.06	1-19 -1-14	1-79 -77	.66 -64	7/8	1-135 -1-125	1"	.06	1-53 -1-48	1-89 -1-87	.66 -64	1/8	1-455 -1-445	1 1/4
7	1 1/2 X 1"	.15	1-26 -1-24	2-050 -2-035	.06	1-19 -1-14	1-91 -89	.66 -64	7/8	1-135 -1-125	1"	.06	1-77 -1-72	2-06 -2-04	.71 -69	3/8	1-685 -1-675	1 1/2
8	1 1/2 X 1 1/4	.15	1-26 -1-24	2-050 -2-035	.06	1-53 -1-48	1-96 -94	.66 -64	1/8	1-455 -1-445	1 1/4	.06	1-77 -1-72	2-06 -2-04	.71 -69	3/8	1-685 -1-675	1 1/2

DESIGNED	DRAWN	TRACED	CHECKED	DATE	HT	PT	SCALE	DESCRIPTION	MATERIAL	REMARKS
DESIGNED BY THE SOCIETY OF BRITISH AIRCRAFT ENGINEERS LTD. 18, KING STREET, ST. JAMES'S, LONDON, W.1.										
THIS IS A PHOTOGRAPHIC REDUCTION. DRAWING MUST NOT BE SCALED.										
A.G.S. 1126—SHEET 2.										