

MARK	% OF PIPE	Z	Y	X	W	V	U	T	S	Q	P	M	L
		B.S.P. THREAD.	+0.010 -0	DRILL	± .01"	+ .01" -0	± .01"	± .01"	MAX: MIN:	DIA. DRILL	DRILL LENGTH ± .01"		± .01"
A.	3/16"	1/8"	.160"	3/32"	.48"	.22"	.95"	.57"	.525" .520"	1/16"	.70"	.03"	.70"
B.	1/4"	1/4"	.224"	5/32"	.54"	.28"	1.05"	.62"	.600" .595"	1/16"	.80"	.04"	.80"
B.B.	5/16"	19 T.P.I. WHIT. FORM 60° DIA.	.267"	3/16"	.67"	.32"	1.15"	.72"	.710" .705"	1/16"	.85"	.04"	.90"
C.	3/8"	3/8"	.333"	1/4"	.79"	.32"	1.15"	.72"	.820" .815"	1/16"	.85"	.04"	.90"
C.C.	7/16"	14 T.P.I. WHIT. FORM 75° DIA.	.377"	5/16"	.92"	.32"	1.30"	.78"	.920" .915"	1/16"	.95"	.06"	1.02"
D.	1/2"	1/2"	.438"	3/8"	.96"	.32"	1.30"	.78"	1.010" 1.002"	1/16"	.95"	.06"	1.02"
E.	5/8"	5/8"	.575"	1/2"	1.06"	.32"	1.35"	.81"	1.100" 1.092"	1/16"	1.00"	.06"	1.05"
F.	3/4"	3/4"	.70"	5/8"	1.17"	.32"	1.40"	.86"	1.200" 1.192"	1/16"	1.00"	.06"	1.10"
G.	7/8"	7/8"	.82"	3/4"	1.37"	.32"	1.50"	.91"	1.390" 1.382"	.076" (No 48)	1.00"	.06"	1.15"
H.	1"	1"	.945"	7/8"	1.68"	.34"	1.50"	.87"	1.670" 1.658"	.076" (No 48)	1.00"	.06"	1.15"
J.	1 1/4"	1 1/4"	1.20"	1 1/8"	2.03"	.34"	1.50"	.82"	2.050" 2.035"	.076" (No 48)	1.00"	.08"	1.10"
K.	1 1/2"	1 1/2"	1.45"	1 3/8"	2.14"	.34"	1.65"	.97"	2.220" 2.200"	.076" (No 48)	1.00"	.08"	1.25"

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

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

SCREW THREADS TO B.S. SPEC: No 84 - 1940

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

FOR ARRANGEMENT OF PIPE JOINT, SEE A.G.S. No 1101.

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

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

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

ISSUED BY
ROYAL
AIRCRAFT
ESTABLISHMENT

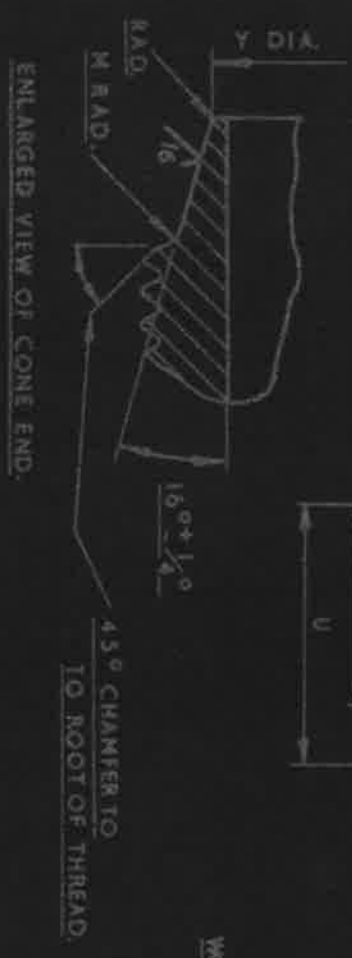
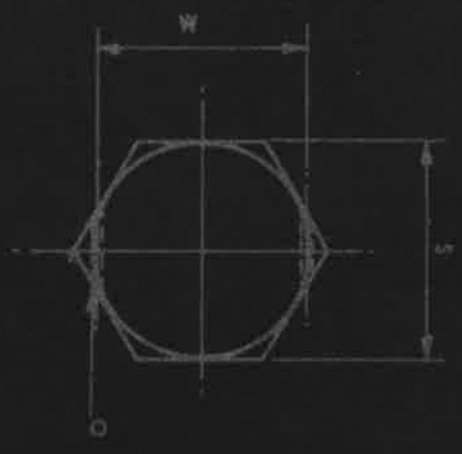
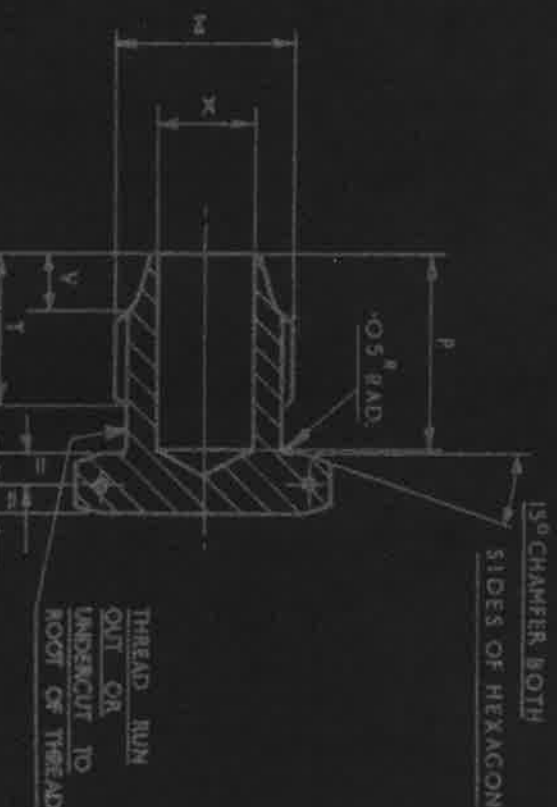
TITLE:- PIPE COUPLINGS
CONE PLUGS (3/16" TO 1 1/2")

ISSUE No 1 2 3 4 5

ALTER No MOD AGS 449 MODN AGS 1609 G 502 877 SM 446

DRAWN. TRACED
C.T. Reynolds. MH. 1-6-42

CHECKED APPROVED
2-5-42



BS PIPE THREADS TO BS SPEC. 2779 MEDIUM FIT TRUNCATED FOR ARRANGEMENT OF PIPE JOINTS SEE AGS. 1101
 WORKING PRESSURE - 3000 LB/SQ. IN. FOR SIZES UP TO 1/2" B.S.P.F.
 500 LB/SQ. IN. FOR SIZES 5/8" TO 1" B.S.P.F.
 200 LB/SQ. IN. FOR SIZES 1 1/4" TO 1 1/2" B.S.P.F.

ENLARGED VIEW OF CONE END.

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

SM 2024

DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR	DATE
	F.A.C.	F.A.C.	F.A.C.	<i>H. G. F. A. C.</i>	12.2.58

REF.	DRAWING OR PART No.	DESCRIPTION	LIMITS NOT SHOWN	AS DRAWN UNIT QTY	MATERIAL - REMARKS
		ALUMM. ALLOY.			E.85.
		THIRD ANGLE PROJECTION			

USED ON	DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR	DATE
		F.A.C.	F.A.C.	F.A.C.	<i>H. G. F. A. C.</i>	12.2.58

HT	PT	R.S. 116 NO. PAINT	SCALE	LIMITS 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, CONE PLUGS
 (3/16 TO 1 1/2")
 A.G.S. 1143 SHEET 1

AGS 1143 SHEET 2

SM2027

MARK	O/D OF PIPE	L	M	P		Q	S	T	U	V	W	X		Y	Z
				DRILL LENGTH	DRILL DIA.							DRILL DIA.	DRILL THREAD		
A	3/16	.71°	.03°	.71°	.69°	1/16	.525°	.58°	.96°	.23°	.49°	3/32	.170°	1/8	
B	1/4	.81°	.04°	.81°	.79°	1/16	.600°	.63°	1.06°	.29°	.55°	5/32	.234°	1/4	
B.R	5/16	.91°	.04°	.86°	.84°	1/16	.710°	.75°	1.16°	.35°	.68°	3/16	.277°	19/32	
C	3/8	.91°	.04°	.86°	.84°	1/16	.820°	.75°	1.16°	.35°	.80°	1/4	.345°	10/32	
CC	7/16	1.03°	.06°	.96°	.94°	1/16	.920°	.79°	1.31°	.35°	.95°	5/16	.387°	14/32	
D	1/2	1.03°	.06°	.96°	.94°	1/16	1.010°	.79°	1.31°	.35°	.97°	3/8	.448°	1/2	
E	5/8	1.06°	.06°	1.01°	.99°	1/16	1.100°	.82°	1.36°	.35°	1.07°	1/2	.585°	5/8	
F	3/4	1.11°	.06°	1.01°	.99°	1/16	1.200°	.87°	1.41°	.35°	1.18°	5/8	.710°	3/4	
G	7/8	1.16°	.06°	1.01°	.99°	Ne 4/8	1.390°	.92°	1.51°	.35°	1.38°	3/4	.850°	7/8	
H	1	1.16°	.06°	1.01°	.99°	Ne 4/8	1.670°	.88°	1.51°	.35°	1.69°	7/8	.955°	1	
J	1 1/4	1.11°	.08°	1.01°	.99°	Ne 4/8	2.050°	.85°	1.51°	.35°	2.04°	1 1/8	1.210°	1 1/4	
K	1 1/2	1.26°	.08°	1.01°	.99°	Ne 4/8	2.220°	.98°	1.66°	.35°	2.15°	1 3/8	1.460°	1 1/2	

MARKS BY THE SURVEYOR NATIONAL ROYALTY COMPANY, ST. LOUIS, MO.

DATE: 12-28-28

AGS 1143 SHEET 2

DRAWING OR PART NO. _____ DATE _____
 CHECKED BY _____
 PARTIAL - 4/11/30