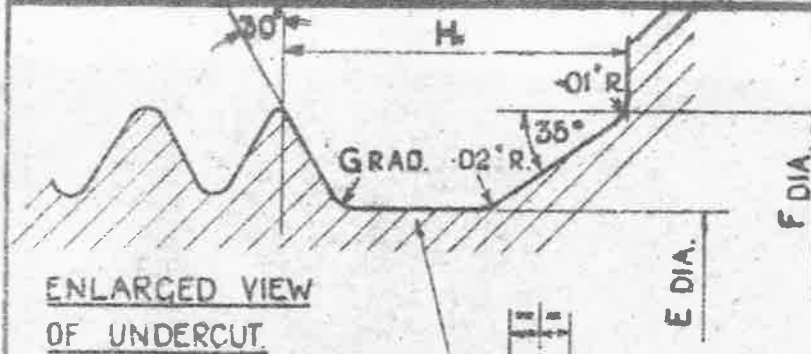
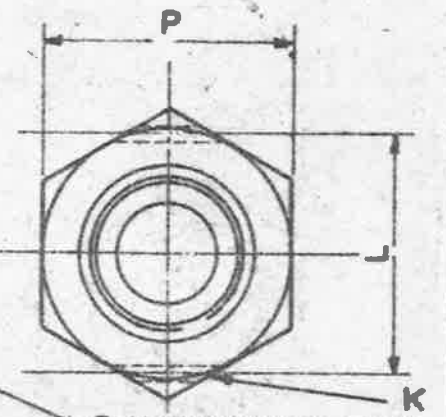
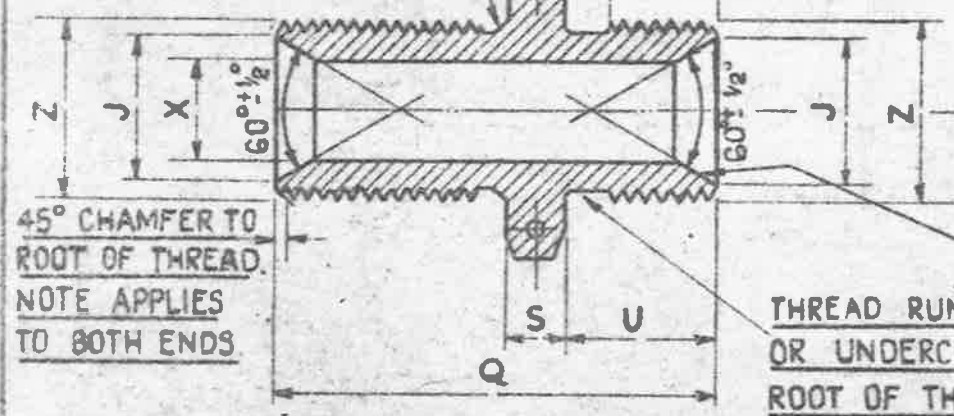


SEE A.G.S. 100 FOR GENERAL INFORMATION.



ENLARGED VIEW OF UNDERCUT

15° CHAMFER ON BOTH SIDES OF HEXAGON.



THREAD RUN-OUT OR UNDERCUT TO ROOT OF THREAD.

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

MARK	O/D OF PIPES	Z	X	FULL Y THREAD	U	S	Q	P	L	K	J	H	G	F	E
		B.S.P. THREAD	DIA. DRILL	+ .01 - .01	+ .01 - 0	+ .01 - .01	+ .01 - .01	MIN. MAX.	+ .01 - .01	DIA. DRILL	+ .005 - 0	+ .01 - 0		+ 0 - .01	+ 0 - .005
A	3/16	1/8	3/32	.33	.47	.25	1.70	.595 .600	.54	1/16	.295	.10	.01	.39	.330
B	1/4	1/4	5/32	.35	.52	.25	1.81	.705 .710	.67	1/16	.410	.14	.01	.52	.440
BB	3/16	19 T.P.I. 60%0	3/16	.40	.57	.25	1.92	.815 .820	.79	1/16	.480	.14	.01	.60	.525
C	3/8	3/8	1/4	.40	.59	.27	1.96	.915 .920	.92	1/16	.550	.14	.01	.66	.580
CC	7/16	14 T.P.I. 76%0	5/16	.45	.67	.28	2.14	1.002 1.010	.96	1/16	.600	.18	.015	.75	.650
D	1/2	1/2	3/8	.53	.75	.28	2.31	1.092 1.100	1.06	1/16	.690	.18	.015	.83	.720
E	5/8	5/8	1/2	.55	.78	.30	2.40	1.292 1.300	1.26	.076" (N° 48)	.760	.18	.015	.91	.800
F	3/4	3/4	5/8	.55	.78	.30	2.40	1.382 1.390	1.37	.076" (N° 48)	.900	.18	.015	1.05	.940
G	7/8	7/8	3/4	.65	.88	.35	2.65	1.658 1.670	1.68	.076" (N° 48)	1.040	.18	.015	1.19	1.085
H	1	1	7/8	.70	.98	.35	2.90	1.845 1.860	1.90	.076" (N° 48)	1.130	.23	.02	1.31	1.180
J	1 1/4	1 1/4	1 1/8	.70	.98	.40	2.95	2.200 2.220	2.14	.076" (N° 48)	1.450	.23	.02	1.66	1.520
K	1 1/2	1 1/2	1 3/8	.70	.98	.40	2.95	2.555 2.580	2.56	.076" (N° 48)	1.680	.23	.02	1.89	1.750

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. N° 84-1940.

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

FOR GENERAL ARRANGEMENT, SEE A.G.S. N° 1144.

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

500 LB/D" FOR SIZES 3/8" TO 1" B.S.P.

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

ISSUED BY
ROYAL
AIRCRAFT
ESTABLISHMENT

TITLE:- PIPE COUPLINGS (LIGHT ALLOY)
HEXAGON BULKHEAD UNION BODY (3/16" TO 1 1/2").

DRAWN
C.T. Reynolds.
TRACED
MT. 18.945.

ISSUE N°	2	3	4	5	6
ALTER. N°	1	2	3	4	5

CHECKED
APPROVED
SM 856

A.G.S. 1140 SHEET 1

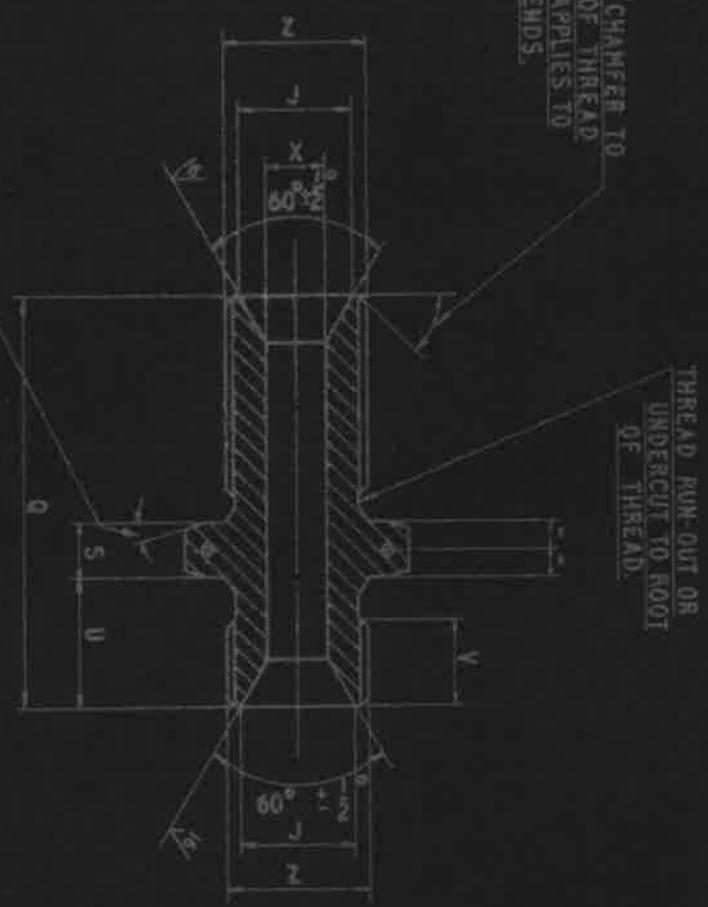
REVISED	DATE	BY
8	F. 4.2	
9	F. 4.0	
10	5.96	
11	6.06	
12	11.23	

SM 2024

PART NO. HERE

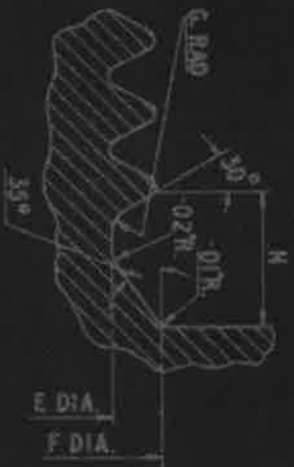


45° CHAMFER TO ROOT OF THREAD
NOTE APPLIES TO BOTH ENDS.



THREAD RUN-OUT OR UNDERCUT TO ROOT OF THREAD.

15° CHAMFER ON BOTH SIDES OF HEXAGON.



ENLARGED VIEW OF UNDERCUT

WORKING PRESSURE:- 3000 LB./SQ. IN. FOR SIZES UP TO 1/2" O.S.P.F.
500 LB./SQ. IN. FOR SIZES 5/8" TO 1" O.S.P.F.
200 LB./SQ. IN. FOR SIZES 1 1/4" TO 1 1/2" O.S.P.F.

O.S.P.F. THREADS TO B.S. SPEC. 2779 MEDIUM FIT TRUNCATED.
SEE A.G.S. 100 FOR GENERAL INFORMATION.
FOR GENERAL ARRANGEMENT SEE A.G.S. 144

HT	PT	ALLOY	FINISH	SCALE	PROJECTION
		ALUMINUM		1:1	THIRD ANGLE

DESIGNED BY	DESIGNED	DESIGNED	DESIGNED	DESIGNED	DESIGNED	DESIGNED	DESIGNED	DESIGNED	DESIGNED

STANDARD SPECIFICATIONS FOR PIPE AND FITTINGS... A.G.S. 1140 SHEET 1