

Weld with nut  
in position

Smooth finish  
free from  
tool marks.

45° chamfer to  
root of thread

Smooth finish  
free from  
tool marks.

This edge to be  
slightly rounded.

AGS  
1158

360  
250

MARK	DIA. OF PIPE	Z	Y	X	V	U	T	S	Q	P	M	USE NUT AGS 1158 MARK.
		B.S.P. THREAD	±.005"	DIA. DRILL	±.01"	±.03 -0	±.01"	±.005"	±.005 -0	±.01"	±.03 -0	
A	3/16"	1/8"	.295"	5/32"	.35"	.95"	.25"	.21"	.33"	.13"	.70"	A
B	1/4"	1/4"	.410"	1/4"	.35"	1.00"	.35"	.32"	.44"	.15"	.80"	B
B.B.	5/16"	10 T.P.I. WHIT. FORM. 60" O.D.	.480"	5/16"	.40"	1.05"	.42"	.33"	.51"	.17"	.85"	B.B.
C	3/8"	3/8"	.550"	3/8"	.40"	1.10"	.48"	.44"	.57"	.19"	.95"	C
CC	7/16"	14 T.P.I. WHIT. FORM. 75" O.D.	.600"	13/32"	.45"	1.15"	.52"	.48"	.64"	.21"	1.05"	CC
D	1/2"	1/2"	.690"	7/16"	.50"	1.20"	.58"	.56"	.71"	.23"	1.10"	D
E	5/8"	5/8"	.760"	9/16"	.55"	1.35"	.68"	.62"	.805"	.25"	1.20"	E
F	3/4"	3/4"	.900"	11/16"	.61"	1.40"	.82"	.76"	.94"	.25"	1.30"	F
G	7/8"	7/8"	1.040"	13/16"	.65"	1.50"	.96"	.90"	1.08"	.25"	1.40"	G
H	1"	1"	1.130"	29/32"	.65"	1.65"	1.06"	1.00"	1.18"	.30"	1.55"	H
J	1 1/4"	1 1/4"	1.450"	1 3/16"	.65"	1.90"	1.35"	1.26"	1.50"	.35"	1.75"	J
K	1 1/2"	1 1/2"	1.680"	1 7/16"	.70"	2.10"	1.60"	1.52"	1.75"	.35"	1.90"	K

The material to be steel B.S. Spec. 970 E.N. 14. (Latest issue)

FINISH - to be zinc or cadmium plated to D.T.D. 903 or 904 (latest issues) after welding.

NOTES - Screw threads to B.S. Spec. No 84-1940 (latest issue) medium fit, truncated threads table 27.

For arrangement of pipe joint see A.G.S. No 1101.

MAXIMUM WORKING PRESSURES - 3000 lb/sq. inch for sizes 3/16" to 1/2" B.S.P.  
500 lb/sq. inch for sizes 5/8" to 1" B.S.P.  
200 lb/sq. inch for sizes 1 1/4" to 1 1/2" B.S.P.

TEST PRESSURES - To be tested for leakage after welding to a pressure of 4,500 lb/sq. inch for sizes 3/16" to 1/2" B.S.P.  
750 lb/sq. inch for sizes 5/8" to 1" B.S.P. and 300 lb/sq. inch for sizes 1 1/4" and 1 1/2" B.S.P.

ISSUED BY DRAWING OFFICE. DIRECTORATE OF TECHNICAL DEVELOPMENT	TITLE - PIPE COUPLING 90° WELDED UNION ELBOWS (3/16" TO 1 1/2")				DRAWN BY C. F. REYNOLDS	RETRACTED M. A. B.
	ISSUE N°	1				