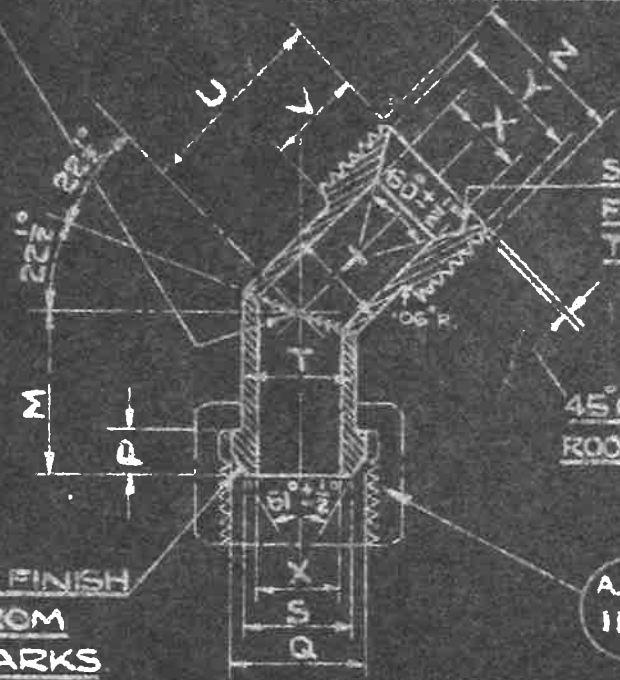


WELD WITH NUT IN POSITION



THIS EDGE TO BE SLIGHTLY ROUNDED

SMOOTH FINISH FREE FROM TOOL MARKS



SMOOTH FINISH FREE FROM TOOL MARKS

45° CHAMFER TO ROOT OF THREAD

AGS 1158

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	+0.03 -0	±.01	±.005	+0.005 -0	±.01	+0.03 -0	
A	3/16"	1/8"	.295"	5/32"	.35"	.60"	.25"	.21"	.33"	.13"	.50"	A
B	1/4"	1/4"	.410"	1/4"	.35"	.70"	.35"	.32"	.44"	.15"	.55"	B
BB	5/16"	15 T.P.I. WHIT. FORM 60° P/O	.480"	5/16"	.40"	.75"	.42"	.38"	.51"	.17"	.60"	BB
C	3/8"	8 T.P.I. WHIT. FORM 60° P/O	.550"	3/8"	.40"	.80"	.48"	.44"	.57"	.19"	.65"	C
CC	7/16"	14 T.P.I. WHIT. FORM 60° P/O	.600"	3/8"	.45"	.90"	.52"	.48"	.64"	.21"	.75"	CC
D	1/2"	12 T.P.I. WHIT. FORM 60° P/O	.690"	7/16"	.50"	1.00"	.58"	.56"	.71"	.23"	.85"	D
E	5/8"	10 T.P.I. WHIT. FORM 60° P/O	.760"	1/2"	.55"	1.10"	.68"	.62"	.805"	.25"	.90"	E
F	3/4"	8 T.P.I. WHIT. FORM 60° P/O	.900"	1/2"	.61"	1.20"	.82"	.76"	.94"	.25"	.95"	F
G	7/8"	7 T.P.I. WHIT. FORM 60° P/O	1.040"	5/8"	.65"	1.30"	.96"	.90"	1.08"	.25"	1.00"	G
H	1"	6 T.P.I. WHIT. FORM 60° P/O	1.30"	3/4"	.65"	1.35"	1.08"	1.00"	1.19"	.30"	1.10"	H
J	1 1/4"	4 T.P.I. WHIT. FORM 60° P/O	1.450"	7/8"	.65"	1.45"	1.35"	1.26"	1.50"	.35"	1.25"	J
K	1 1/2"	3 T.P.I. WHIT. FORM 60° P/O	1.680"	7/8"	.70"	1.60"	1.60"	1.52"	1.75"	.35"	1.35"	K

THE MATERIAL TO BE STEEL TO B.S. SPEC. 970 E_n 14. (LATEST ISSUE)
 FINISH: - TO BE ZINC OR CADMIUM PLATED TO D.T.D. 903 OR 904 (LATEST ISSUE) AFTER WELDING

NOTES: - SCREW THREADS TO B.S. SPEC. No 81-1940 (LATEST ISSUE) MEDIUM FIT, TRUNCATED THREADS, TABLE 27
 FOR ARRANGEMENT OF PIPE JOINT, SEE A.G.S. No 1101.

MAXIMUM WORKING PRESSURES: - 1,000 LB/SQ. IN. FOR SIZES 3/16" 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 1/4" & 1 1/2" B.S.P.

TEST PRESSURES: - TO BE TESTED FOR LEAKAGE AFTER WELDING TO A PRESSURE OF 4,500 LB/SQ. IN. FOR SIZES 3/16" TO 1/2" B.S.P., 750 LB/SQ. IN. FOR SIZES 5/8" TO 1" B.S.P. & 300 LB/SQ. IN. FOR SIZES 1 1/4" & 1 1/2" B.S.P.

ISSUED BY DRAWING OFFICE TITLE: - PIPE COUPLINGS.
 DIRECTORATE OF TECHNICAL DEVELOPMENT
 45° WELDED UNION ELBOW (1/2" TO 1 1/2")
 DRAWN: T Reynolds
 CHECKED: [Signature]
 APPROVED: [Signature]