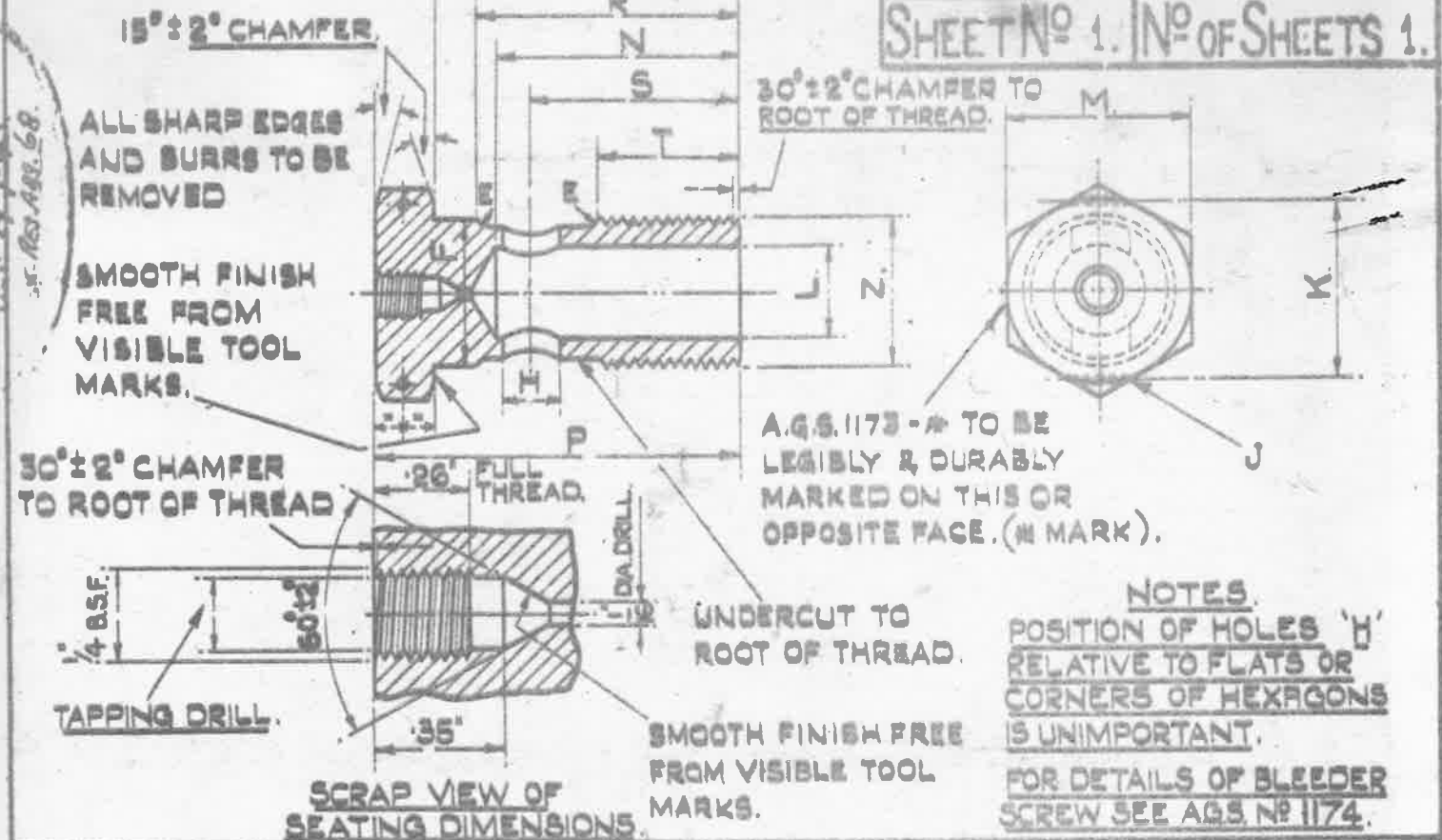


UNLIMITED DIMENSIONS $\pm .01$ "

MINISTRY OF SUPPLY

AGS. No 1173.

SHEET No 1. No OF SHEETS 1.



NOTES.
 POSITION OF HOLES 'H' RELATIVE TO FLATS OR CORNERS OF HEXAGONS IS UNIMPORTANT.
 FOR DETAILS OF BLEEDER SCREW SEE AGS. No 1174.

MARK	O/D OF PIPE	Z	T	S	R	Q	P	N	M	L	K	J	H	F	E	
	B.S.P. THREAD	$\pm .02$ - 0	$\pm .01$	$\pm .01$	$\pm .01$	$\pm .01$	$\pm .01$	$\pm .01$	MIN	MAX	DRILL	$\pm .01$	DRILL	DRILL	$\pm .005$ - 0	$\pm .005$
A	3/16"	1/8"	.53"	.72"	.83"	1.01"	1.36"	.81"	.595"	.600"	5/32"	.54"	1/16"	9/64"	.375"	.04"
B	1/4"	1/4"	.53"	.75"	.93"	1.11"	1.44"	.87"	.705"	.710"	7/32"	.67"	1/16"	3/16"	.507"	.05"
BB	5/16"	19 T.P.I. 60" O/D	.60"	.88"	1.06"	1.26"	1.60"	1.00"	.815"	.820"	5/16"	.79"	1/16"	13/64"	.589"	.06"
C	3/8"	3/8"	.60"	.95"	1.16"	1.36"	1.70"	1.09"	.915"	.920"	3/8"	.92"	1/16"	15/64"	.645"	.06"
CC	7/16"	14 T.P.I. 75" O/D	.68"	1.05"	1.28"	1.51"	1.85"	1.21"	1.002"	1.010"	7/16"	.96"	1/16"	17/64"	.736"	.06"
D	1/2"	1/2"	.73"	1.14"	1.43"	1.66"	1.98"	1.32"	1.002"	1.010"	1/2"	.96"	1/16"	5/16"	.811"	.06"
E	5/8"	5/8"	.73"	1.20"	1.53"	1.76"	2.10"	1.43"	1.092"	1.100"	9/16"	1.06"	1/16"	15/32"	.888"	.06"
F	3/4"	3/4"	.83"	1.33"	1.68"	1.96"	2.31"	1.60"	1.292"	1.300"	11/16"	1.26"	.076" (No 48)	1/2"	1.027"	.06"
G	7/8"	7/8"	.88"	1.48"	1.88"	2.16"	2.55"	1.80"	1.382"	1.390"	13/16"	1.37"	.076" (No 48)	19/32"	1.175"	.06"
H	1"	1"	.97"	1.72"	2.22"	2.54"	2.91"	2.09"	1.658"	1.670"	15/16"	1.68"	.076" (No 48)	11/16"	1.291"	.06"

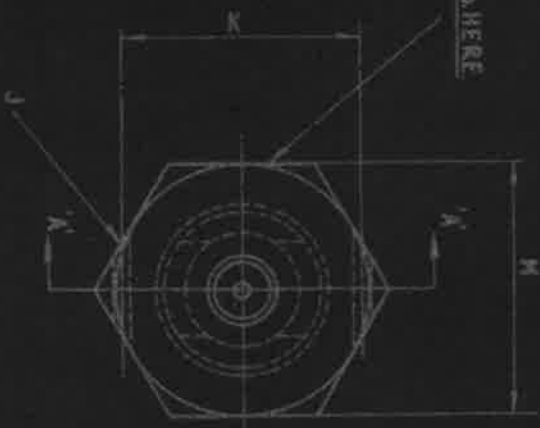
THE MATERIAL TO BE STEEL TO B.S. SPEC. S. 94 (LATEST ISSUE).
 NOTES :- FINISH :- TO BE CADMIUM PLATED TO D.T.D. 904 (LATEST ISSUE).
 SCREW THREADS TO B.S. SPEC. B 4. (LATEST ISSUE).
 EXTERNAL THREADS - MEDIUM FIT, TRUNCATED, FOR DIAMETERS, TOLERANCES AND TRUNCATED DIMENSIONS OF MARKS BB & CC SEE AGS. 100 SHEET 5.
 INTERNAL THREADS - FREE FIT.
 WORKING PRESSURES :- 3,000 LB/SQ. IN. FOR SIZES UP TO 1/2" B.S.P.
 500 LB/SQ. IN. FOR SIZES 3/8" TO 1" B.S.P.

ISSUED BY THE ROYAL AIRCRAFT ESTABLISHMENT	TITLE: - PIPE COUPLINGS FOR LIGHT ALLOY RANGE. BANJO BOLT 3/16" TO 1" WITH HOLE FOR BLEEDER SCREW.				DRAWN.	TRACED
	ISSUE No	1	2	3	4	C.T. Reynolds
ALTERS No	AGS 474	AGS 673	AGS 663	AGS 969	CHECKED	APPROVED.
					<i>[Signature]</i>	<i>[Signature]</i> 17.3.43

AGS. 1173 SHEET 1.

REV. NO. 1
 DATE 1/1/73
 SM2024

PART NUMBER

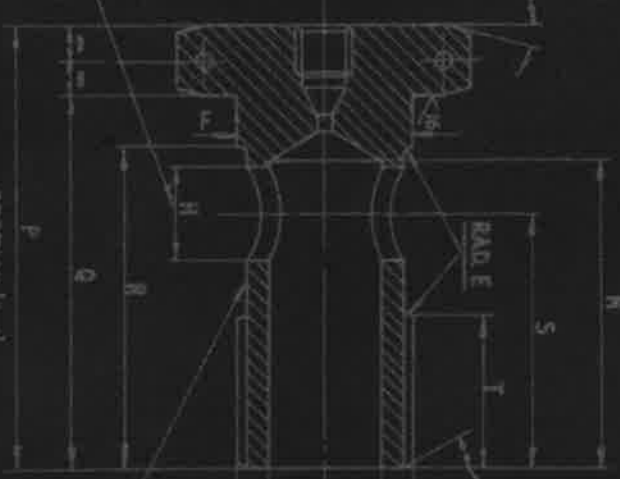


$15^\circ \pm 2^\circ$ CHAMFER EACH SIDE OF HEXAGON.

POSITION OF HOLES $1/16$ " RELATIVE TO FLATS OR CORNERS OF HEXAGONS IS UNIFORM.



SCRAM VIEW OF SEATING DIMENSIONS.



SECTION A-A

$30^\circ \pm 2^\circ$ CHAMFER TO ROOT OF THREAD

UNDERCUT TO ROOT OF THREAD

FOR DETAILS OF BLEEDER SCREW SEE AGS.1174
 USE THREADS TO B.S.Q.4 FREE FIT
 SEE AGS.100 FOR GENERAL INFORMATION.
 FOR GENERAL ARRANGEMENT SEE AGS.100.
 BSPE THREADS TO BS.2779 MEDIUM FIT TRUNCATED.
 WORKING PRESSURES: 3000 LB. SQ. IN. FOR SIZES UP TO $1/2$ " BSPE
 5000 LB. SQ. IN. FOR SIZES $5/8$ " TO 1 " BSPE

REV.	DESCRIPTION	DATE	BY	CHECKED

FIRST CORNER FOR ALUMINUM ALLOY RANGE
 BAKED BOLT $7/16$ TO $1/2$ " BSPE WITH HOLE
 FOR BLEEDER SCREW

AGS. 1173 SHEET 1.

DESIGNED BY THE ROYAL AIR FORCE ENGINEERING ESTABLISHMENT
 IN THE INTEREST OF DEFENSE, LONDON, E.T. 11.

AGS. 1173 - SHEET 2

SM2027

MARK	O/DIA OF PIPE	E	F	H		J		K	L		M	N	P	Q	R	S	T	Z
				DRILL	DRILL	DRILL	DRILL											
A	3/16	.045 .035	.380 .375	9/64	1/16	.550 .530	5/32	.600 .595	.820 .800	1.370 1.350	1.010 1.000	.840 .830	.730 .710	.550 .530	1/8	BSPF THREAD		
B	1/4	.055 .045	.512 .507	3/16	1/16	.680 .660	7/32	.710 .705	.880 .860	1.450 1.430	1.110 1.100	.940 .930	.760 .740	.550 .530	1/4	19 TPI 6C O/DIA WHIT (BS64)		
B-B	5/16	.065 .055	.594 .589	13/64	1/16	.800 .780	5/16	.820 .815	1.010 .990	1.610 1.590	1.260 1.250	1.070 1.060	.890 .870	.620 .600	3/8	14 TPI 75 O/DIA WHIT (BS64)		
C	3/8	.065 .055	.650 .645	15/64	1/16	.930 .910	3/8	.920 .915	1.100 1.080	1.710 1.690	1.360 1.350	1.170 1.160	.960 .940	.620 .600	3/8			
C-C	7/16	.065 .055	.741 .736	17/64	1/16	.970 .950	7/16	1.010 1.002	1.220 1.200	1.860 1.840	1.510 1.500	1.290 1.280	.700 .680					
D	1/2	.065 .055	.816 .811	5/16	1/16	.970 .950	1/2	1.010 1.002	1.330 1.310	1.990 1.970	1.660 1.650	1.440 1.430	.750 .730					
E	5/8	.065 .055	.893 .888	13/32	1/16	1.070 1.050	9/16	1.100 1.092	1.440 1.420	2.110 2.090	1.760 1.750	1.540 1.530	.750 .730					
F	3/4	.065 .055	1.032 1.027	1/2	1/16	1.270 1.250	11/16	1.300 1.292	1.610 1.590	2.320 2.300	1.960 1.950	1.690 1.680	.850 .830					
G	7/8	.065 .055	1.180 1.175	19/32	1/16	1.380 1.360	13/16	1.390 1.382	1.810 1.790	2.560 2.540	2.160 2.150	1.890 1.880	.900 .880					
H	1"	.065 .055	1.296 1.291	11/16	1/16	1.690 1.670	15/16	1.670 1.658	2.100 2.080	2.920 2.900	2.540 2.530	2.230 2.220	.990 .970					

DESIGNED BY THE SOCIETY OF BRITISH ALUMINIUM ENGINEERS LTD.
18, OVAL STREET, ST. JAMES'S, LONDON, E.W.1

HT

PIPE COUPLINGS FOR ALUMINUM ALLOY RANGE BANJO BOLT 3/16 TO 1" BSPF WITH HOLE FOR BLEEDER SCREW.

AGS 1173 - SHEET 2