

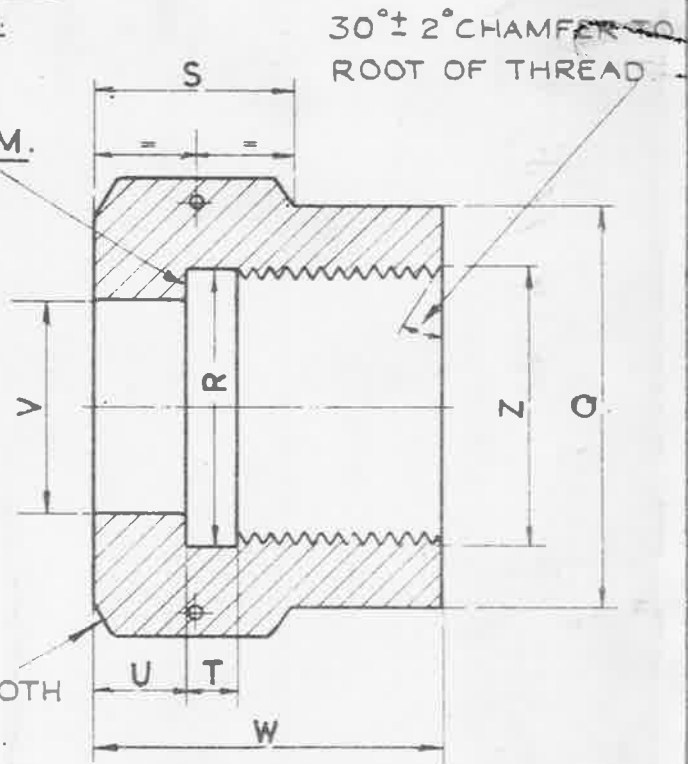
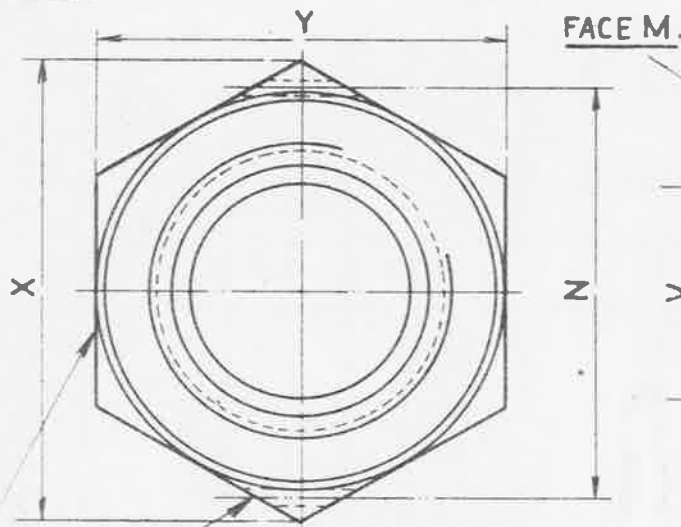
THE THREAD UNDERCUT MAY BE OMITTED WHEN BORE Z' IS THREAD MILLED. THE THREAD IS TO BE FULL FORM TO WITHIN A MAXIMUM OF .060" FROM THE INNER FACE M' FOR MARKS BB TO M. FOR MARKS A & B. THE THREAD TO BE FULL FORM TO WITHIN A MAXIMUM OF .010" FROM THE INNER FACE M. OTHERWISE THE UNDERCUT AS SHOWN MUST BE ADHERED TO.

MINISTRY OF SUPPLY

AGS.No.1187.

SHEET No. 1

No. OF SHEETS 1



30° ± 2° CHAMFER BOTH SIDES OF HEXAGON.

AGS 1187 - * TO BE LEGIBLY AND DURABLY MARKED ON THIS OR OPPOSITE FACE. (* MARK)

ALL SHARP EDGES AND BURRS TO BE REMOVED.

MARK.	Z	Y		X	W	V	U	T	S	R	O	P	N
		MAX.	MIN.										
				ABOUT	±.01"	+ .000 -.005"	±.005"	±.01"	±.01"	+ .010" -.000"	+ .010" -.000"	DRILL DIA.	±.01"
A	1/8 B.S.P.	.525"	.520"	.61"	.45"	.27"	.12"	.07"	.26"	.383"	.49"	1/16"	.48"
B	1/4 B.S.P.	.710"	.705"	.82"	.51"	.37"	.13"	.07"	.30"	.518"	.64"	1/16"	.67"
BB	19 T.P.I. .60% D.	.820"	.815"	.95"	.57"	.44"	.14"	.10"	.34"	.600"	.72"	1/16"	.79"
C	3/8 B.S.P.	.820"	.815"	.95"	.60"	.50"	.14"	.10"	.35"	.656"	.78"	1/16"	.79"
CC	14 T.P.I. .75% D.	.920"	.915"	1.06"	.65"	.54"	.15"	.10"	.38"	.750"	.88"	1/16"	.92"
D	1/2 B.S.P.	1.010"	1.002"	1.17"	.70"	.62"	.15"	.12"	.41"	.825"	.97"	1/16"	.96"
E	5/8 B.S.P.	1.100"	1.092"	1.27"	.76"	.74"	.16"	.12"	.44"	.902"	1.06"	1/16"	1.06"
F	3/4 B.S.P.	1.300"	1.292"	1.50"	.82"	.87"	.17"	.12"	.48"	1.041"	1.20"	Nº 48 .076"	1.26"
G	7/8 B.S.P.	1.390"	1.382"	1.61"	.93"	1.00"	.18"	.12"	.54"	1.189"	1.35"	Nº 48 .076"	1.37"
H	1" B.S.P.	1.670"	1.658"	1.93"	1.01"	1.11"	.19"	.18"	.59"	1.309"	1.45"	Nº 48 .076"	1.68"
J	1 1/4 B.S.P.	2.050"	2.035"	2.37"	1.02"	1.40"	.20"	.18"	.61"	1.650"	1.83"	Nº 48 .076"	2.05"
K	1 1/2 B.S.P.	2.220"	2.200"	2.56"	1.13"	1.665"	.21"	.18"	.68"	1.882"	2.09"	Nº 48 .076"	2.14"
L	1 3/4 B.S.P.	2.580"	2.555"	2.98"	1.15"	1.90"	.22"	.25"	.70"	2.116"	2.37"	Nº 48 .076"	2.66"
M	2" B.S.P.	2.760"	2.735"	3.19"	1.25"	2.13"	.23"	.28"	.72"	2.347"	2.64"	Nº 48 .076"	2.77"

NOTE:- SCREW THREADS TO B.S. SPEC. 84 (LATEST ISSUE) MEDIUM FIT. FOR DIAMETERS AND TOLERANCES OF MARKS BB & CC SEE AGS 100 SHEET 5

MATERIAL:- LIGHT ALLOY TO SPEC. D.T.D. 423 (LATEST ISSUE)

FINISH:- ANODISE TO SPEC. D.T.D. 910 (LATEST ISSUE)

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT.	TITLE:- STANDARD UNION NUTS. (LIGHT ALLOY).				DRAWN R.H.	TRACED DW 21-9-45
	ISSUE Nº 7	8			CHECKED M.H.	APPROVED M.H.
	ALTER Nº 5/370	AS/AGS 970				

RES. AGS. 145

THE THREAD UNDERCUT MAY BE OMITTED WHEN BORE Z IS THREAD MILLED. THE THREAD IS TO BE FULL FORM TO WITHIN A MAXIMUM OF .060" FROM THE INNER FACE M FOR MARKS BB TO M. FOR MARKS A & B. THE THREAD TO BE FULL FORM TO WITHIN A MAXIMUM OF .010" FROM THE INNER FACE M. OTHERWISE THE UNDERCUT AS SHOWN MUST BE ADHERED TO.

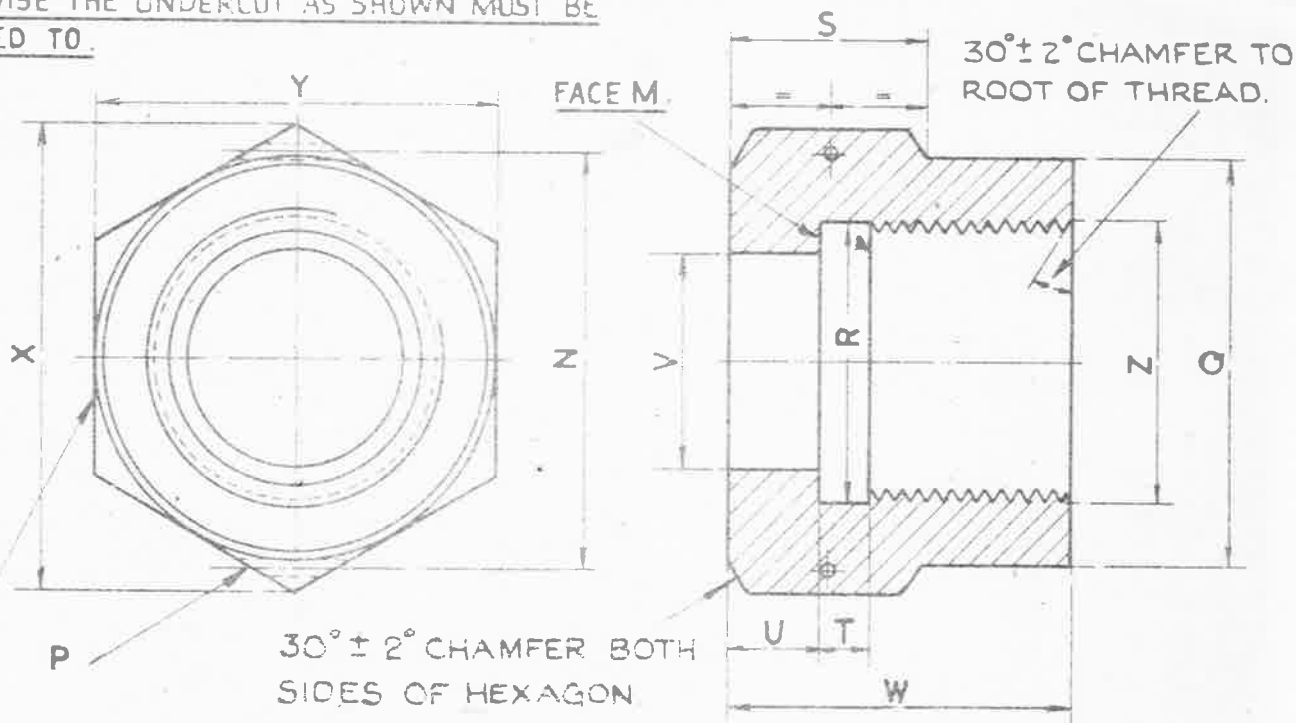
MINISTRY OF SUPPLY

AGS.No. 1187.

SHEET No. 1

No. OF SHEETS 1

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



A.G.S. 1187 - * TO BE LEGIBLY AND DURABLY MARKED ON THIS OR OPPOSITE FACE. (* MARK)

ALL SHARP EDGES AND BURRS TO BE REMOVED.

MARK.	Z	Y		X	W	V	U	T	S	R	O	P	N
		MAX.	MIN.										
				ABOUT	±.01"	+ .000 - .005"	±.005"	±.01"	±.01"	+ .010" - .000	+ .010" - .000	DRILL DIA	±.01"
A	1/8 B.S.P.	.525"	.520"	.61"	.45"	.27"	.12"	.07"	.26"	.383"	.49"	1/16"	.48"
B	1/4 B.S.P.	.710"	.705"	.82"	.51"	.37"	.13"	.07"	.30"	.518"	.64"	1/16"	.67"
BB	19 T.P.I. .60°/D.	.820"	.815"	.95"	.57"	.44"	.14"	.10"	.34"	.600"	.72"	1/16"	.79"
C	3/8 B.S.P.	.820"	.815"	.95"	.60"	.50"	.14"	.10"	.35"	.656"	.78"	1/16"	.79"
CC	14 T.P.I. .75°/D.	.920"	.915"	1.06"	.65"	.54"	.15"	.10"	.38"	.750"	.88"	1/16"	.92"
D	1/2 B.S.P.	1.010"	1.002"	1.17"	.70"	.62"	.15"	.12"	.41"	.825"	.97"	1/16"	.96"
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NOTE:- SCREW THREADS TO BS SPEC 54 (LATEST ISSUE) MEDIUM FIT. FOR DIAMETERS AND TOLERANCES OF MARKS BB & CC SEE A.G.S. 100 SHT 5

MATERIAL:- LIGHT ALLOY TO SPEC DTD 423 (LATEST ISSUE)

FINISH:- ANODISE TO SPEC DTD 910 (LATEST ISSUE)

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT.	TITLE:- STANDARD UNION NUTS. (LIGHT ALLOY).				DRAWN <i>R.H.</i>	TRACED DW 21-9-45
	ISSUE NO	3	9	9	CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>
ALTERS NO	1970	1998	SM 850			