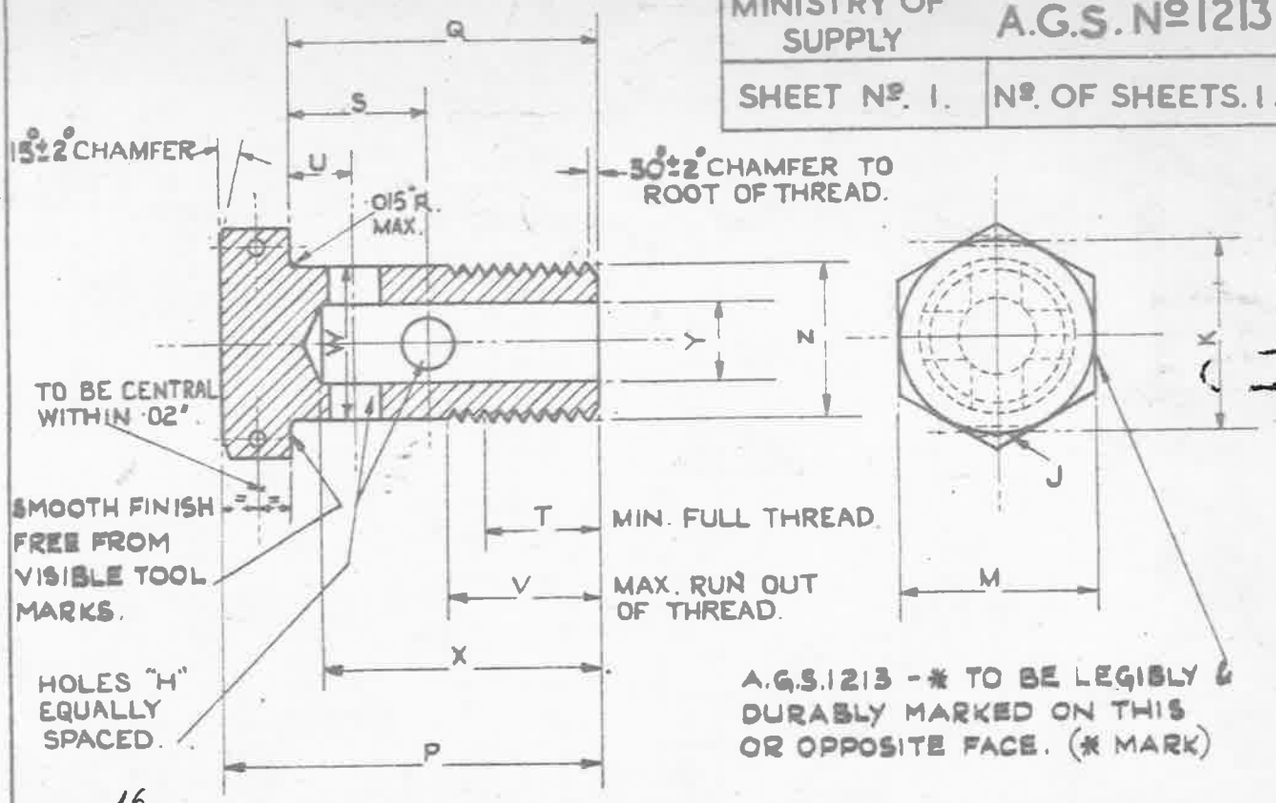
MINISTRY OF SUPPLY	A.G.S. Nº 1213.
SHEET Nº. 1.	Nº. OF SHEETS. 1.

26.10.46
Res: A48,68.



·16
·49

NOT APPLICABLE TO ENGINE INSTALLATIONS.

ALL SHARP EDGES AND BURRS TO BE REMOVED.

NOTE.
POSITION OF HOLES 'H' RELATIVE TO FLATS OR CORNERS OF HEXAGON IS UNIMPORTANT.

MARK	O/D OF PIPE	Z	Y	X	W	V	U	T	S	Q	P	M		K	J	H
		B.S.P. THREAD	DIA. DRILL	±·01"	+·005" −0	MAX.	±·01"	MIN.	±·01"	±·01"	±·01"	MIN.	MAX.	±·01"	DIA. DRILL	DIA. DRILL
A	3/16"	1/8"	5/32"	·78"	·375"	·53"		·43"	·34"	1·01"	1·36"	·595"	·600"	·54"	1/16"	2 - 5/32"
B	1/4"	1/4"	7/32"	·87"	·507"	·60"	·34"	·45"	·54"	1·11"	1·44"	·705"	·710"	·67"	1/16"	4 - 5/32"
BB	5/16"	19 T.P.I. 60° O/D	9/32"	1·00"	·589"	·60"	·38"	·45"	·58"	1·26"	1·60"	·815"	·820"	·79"	1/16"	4 - 5/32"
C	3/8"	3/8"	5/16"	1·12"	·645"	·64"	·39"	·49"	·71"	1·36"	1·70"	·915"	·920"	·92"	1/16"	4 - 7/32"
CC	7/16"	14 T.P.I. ·75" O/D	13/32"	1·22"	·736"	·72"	·44"	·52"	·76"	1·51"	1·85"	1·002"	1·010"	·96"	1/16"	4 - 1/4"
D	1/2"	1/2"	7/16"	1·36"	·811"	·80"	·49"	·59"	·87"	1·66"	1·98"	1·002"	1·010"	·96"	1/16"	4 - 9/32"
E	5/8"	5/8"	9/16"	1·41"	·888"	·80"	·53"	·59"	·94"	1·76"	2·10"	1·092"	1·100"	1·06"	1/16"	4 - 5/16"
F	3/4"	3/4"	11/16"	1·59"	1·027"	·85"	·56"	·65"	·99"	1·96"	2·31"	1·292"	1·300"	1·26"	·076" (№48)	4 - 13/32"
G	7/8"	7/8"	13/16"	1·81"	1·175"	·90"	·62"	·69"	1·06"	2·16"	2·55"	1·382"	1·390"	1·37"	·076" (№48)	4 - 7/16"
H	1"	1"	15/16"	2·11"	1·291"	1·00"	·69"	·75"	1·34"	2·54"	2·91"	1·658"	1·670"	1·68"	·076" (№48)	4 - 17/32"

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

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

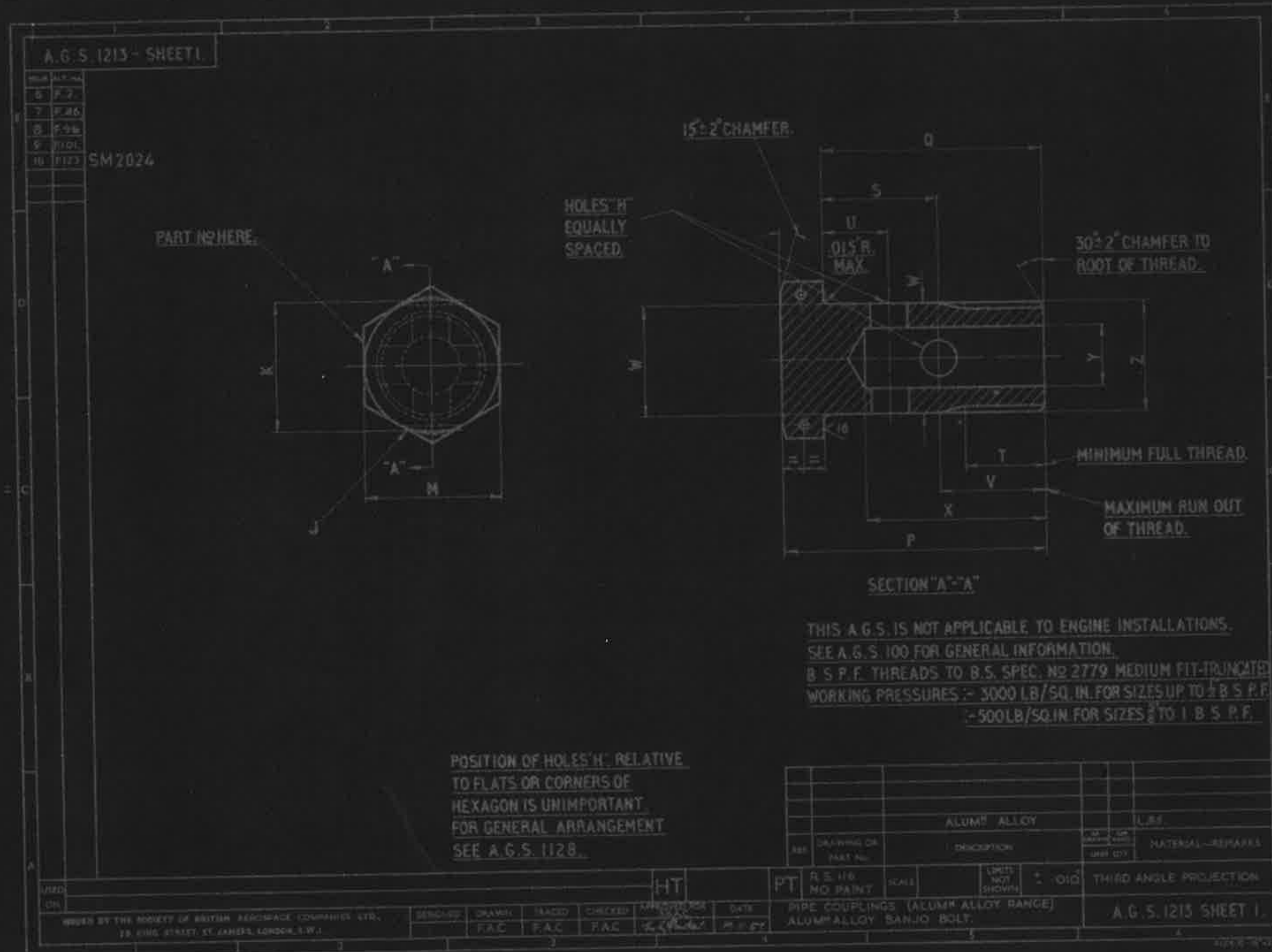
NOTES:- SCREW THREADS TO B.S. SPEC. 84 (LATEST ISSUE) MEDIUM FIT, TRUNCATED. FOR DIAMETERS, TOLERANCES AND TRUNCATED DIMENSIONS OF MARKS BB & CC SEE A.G.S. 100 SHEET 5.

FOR GENERAL ARRANGEMENT SEE A.G.S. Nº 1128.

WORKING PRESSURES:- 3,000 LB/SQ IN. FOR SIZES UP TO 1/2" B.S.P.
500 LB./SQ. IN. FOR SIZES 5/8" TO 1" B.S.P.

ISSUED BY THE ROYAL AIRCRAFT ESTABLISHMENT	TITLE:- PIPE COUPLINGS, (LIGHT ALLOY RANGE) LIGHT ALLOY BANJO BOLT.				DRAWN	TRACED
					C.T. Reynolds.	S.A.W.J. SEPT. '46
	ISSUE Nº	2	3	4	CHECKED	APPROVED
	ALTERN. Nº	MOD. AGS/633	MOD. Nº AGS/660	AS/ACS 969		

31-10-46 23-4-47 SM836


A.G.S. 1213 - SHEET 1.
SM2024
PART No HERE.
"A"
"A"
J
K
M
HOLES "H" EQUALLY SPACED.
15°±2° CHAMFER.
Q
S
U
.015"R. MAX.
W
30°±2° CHAMFER TO ROOT OF THREAD.
Y
Z
16
T
MINIMUM FULL THREAD.
V
MAXIMUM RUN OUT OF THREAD.
X
P
SECTION "A"-"A"
THIS A.G.S. IS NOT APPLICABLE TO ENGINE INSTALLATIONS.
SEE A.G.S. 100 FOR GENERAL INFORMATION.
B.S.P.F. THREADS TO B.S. SPEC. No 2779 MEDIUM FIT-TRUNCATED
WORKING PRESSURES :- 3000 LB/SQ. IN. FOR SIZES UP TO ½ B.S.P.F.
:- 500 LB/SQ. IN. FOR SIZES ⅝ TO 1 B.S.P.F.
POSITION OF HOLES "H" RELATIVE TO FLATS OR CORNERS OF HEXAGON IS UNIMPORTANT.
FOR GENERAL ARRANGEMENT SEE A.G.S. 1128.
ALUMN ALLOY
L.84
MATERIAL—REMARKS
HT
PT
R.S. 116 NO PAINT
SCALE
LIMITS NOT SHOWN ± .010
THIRD ANGLE PROJECTION
DRAWN F.A.C.
TRACED F.A.C.
CHECKED F.A.C.
PIPE COUPLINGS (ALUMN ALLOY RANGE)
ALUMN ALLOY BANJO BOLT.
A.G.S. 1213 SHEET 1.

A.G.S. 1213.-SHEET 2.

ISSUE	ALT. No.
1	
2	FIG 1

SM 2027

MARK	O/DIA. OF PIPE	H DRILL DIA.	J DRILL DIA.	K	M	P	Q	S	T MIN.	U	V MAX.	W	X	Y DRILL DIA.	Z B.S.P.F. THREAD
A	3/16"	2-5/32"	1/16"	.550" .530"	.600" .595"	1.370" 1.350"	1.020" 1.000"	.350" .330"	.430"		.530"	.380" .375"	.790" .770"	5/32"	1/8"
B	1/4"	4-5/32"	1/16"	.680" .660"	.710" .705"	1.450" 1.430"	1.120" 1.100"	.550" .530"	.450"	.350" .330"	.600"	.512" .507"	.880" .860"	7/32"	1/4"
B-B	5/16"	4-5/32"	1/16"	.800" .780"	.820" .815"	1.610" 1.590"	1.270" 1.250"	.590" .570"	.450"	.390" .370"	.600"	.594" .589"	1.010" .990"	9/32"	19 T.P.I. 60° o/o
C	3/8"	4-7/32"	1/16"	.930" .910"	.920" .915"	1.710" 1.690"	1.370" 1.350"	.720" .700"	.490"	.400" .380"	.640"	.650" .645"	1.130" 1.110"	5/16"	3/8"
C-C	7/16"	4-1/4"	1/16"	.970" .950"	1.010" 1.002"	1.840" 1.860"	1.520" 1.500"	.770" .750"	.520"	.450" .430"	.720"	.741" .736"	1.230" 1.210"	13/32"	14 T.P.I. 75° o/o
D	1/2"	4-9/32"	1/16"	.970" .950"	1.010" 1.002"	1.990" 1.970"	1.670" 1.650"	.880" .860"	.590"	.500" .480"	.800"	.816" 811"	1.370" 1.350"	7/16"	1/2"
E	5/8"	4-5/16"	1/16"	1.070" 1.050"	1.100" 1.092"	2.110" 2.090"	1.770" 1.750"	.950" .930"	.590"	.540" .520"	.800"	.893" .888"	1.420" 1.400"	9/16"	5/8"
F	3/4"	4-13/32"	.076" (No 48.)	1.270" 1.250"	1.300" 1.292"	2.320" 2.300"	1.970" 1.950"	1.000" .980"	.650"	.570" .550"	.850	1.032" 1.027"	1.600" 1.580"	11/16"	3/4"
G	7/8"	4-7/16"	.076" (No 48.)	1.380" 1.360"	1.390" 1.382"	2.560" 2.540"	2.170" 2.150"	1.070" 1.050"	.690"	.630" .610"	.900	1.180" 1.175"	1.820" 1.800"	13/16"	7/8"
H	1"	4-17/32"	.076" (No 48.)	1.690" 1.670"	1.670" 1.658"	2.920" 2.900"	2.550" 2.530"	1.350" 1.330"	.750"	.700" .680"	1.00"	1.296" 1.291"	2.120" 2.100"	15/16"	1"

ON MARKS 'B'-'B' AND 'C'-'C': THREADS TO BE TO B.S. SPEC. No 84, WHITWORTH FORM.

REF.	DRAWING OR PART No.	DESCRIPTION	AS REQUIRED	UNIT QTY	MATERIAL—REMARKS

USED ON HT PT SCALE UNITS NOT SHOWN

ISSUED BY THE SOCIETY OF BRITISH AIRCRAFT CONSTRUCTORS LTD., 20, KING STREET, ST. JAMES'S, LONDON, S.W.1.

DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR S.B.A.C.	DATE
	F.A.C.	F.A.C.	F.A.C.		19.4.57

PIPE COUPLINGS (ALUM.M ALLOY RANGE)
LIGHT ALLOY BANJO BOLT

A.G.S. 1213-SHEET 2.

THIS IS A PHOTOGRAPHIC REDUCTION. DRAWING MUST NOT BE SCALED.

SIZE C - 18" x 24"