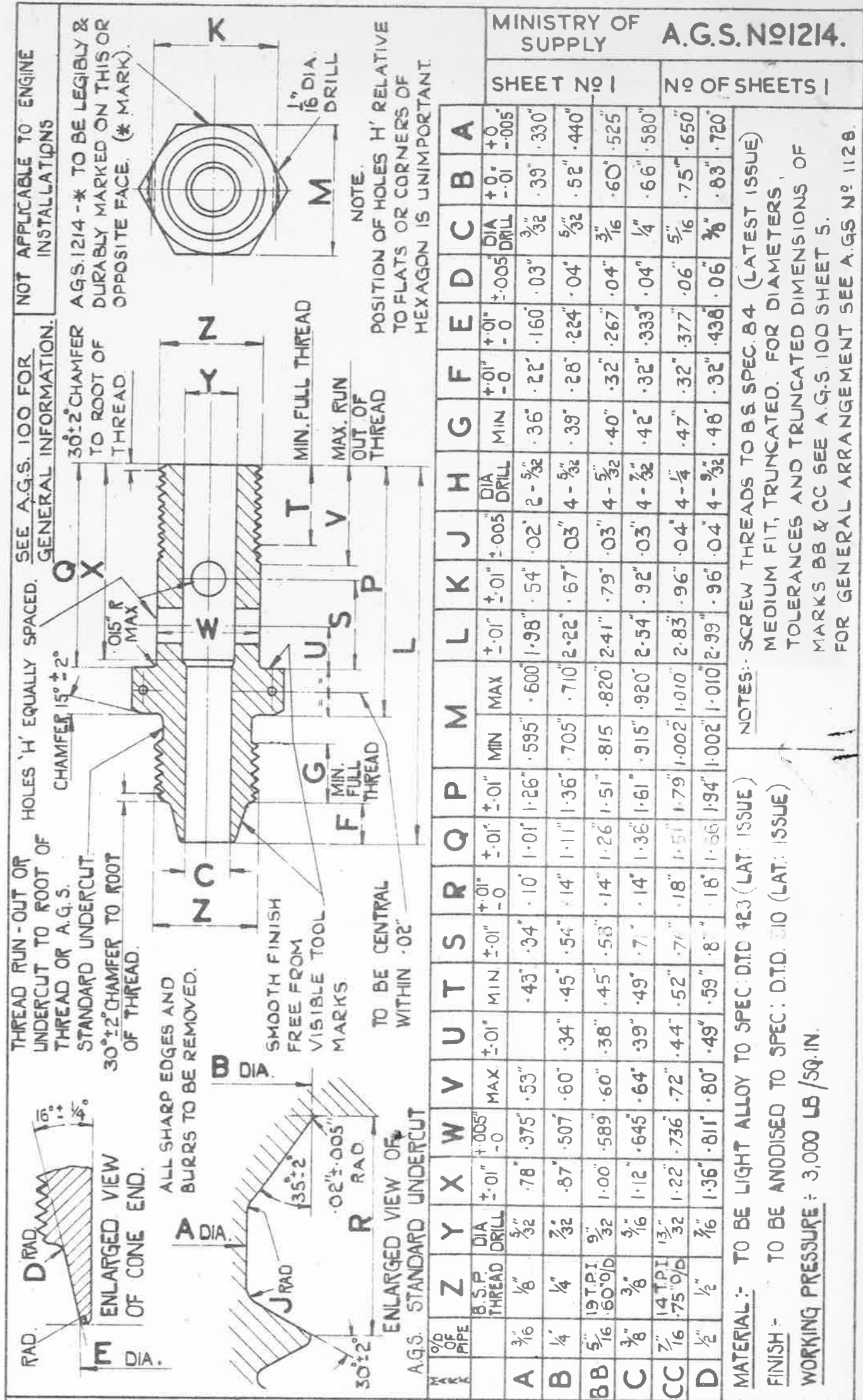


26.10.46
REV: A99.68



ISSUED BY THE
ROYAL AIRCRAFT
ESTABLISHMENT

TITLE: PIPE COUPLINGS (LIGHT ALLOY RANGE)
LIGHT ALLOY BANJO BOLT WITH CONE
HEAD CONNECTION. SM 856

DRAWN
C.T. Reynolds.
TRACED
B.E.H.
30-9-46

ISSUE NO	1	2	3	4	5
ALTERN. NO	MOD. A.G.S./633	MOD. A.G.S./660	AS/AGS 969	AS/AGS 988	

CHECKED
W. Moor
APPROVED
W. Moor 3/10/46

NOT APPLICABLE TO ENGINE INSTALLATIONS
AGS.1214 - * TO BE LEGIBLY & DURABLY MARKED ON THIS OR OPPOSITE FACE. (* MARK).

MINISTRY OF SUPPLY
SHEET No 1
No OF SHEETS 1
A.G.S. No 1214.

HOLES 'H' EQUALLY SPACED. SEE A.G.S. 100 FOR GENERAL INFORMATION.
30°±2° CHAMFER TO ROOT OF THREAD.
MIN. FULL THREAD
MAX. RUN OUT OF THREAD
CHAMFER 15°±2°
0.05" R MAX
MIN. FULL THREAD
SMOOTH FINISH FREE FROM VISIBLE TOOL MARKS
TO BE CENTRAL WITHIN .02"
ENLARGED VIEW OF CONE END.
ENLARGED VIEW OF A.G.S. STANDARD UNDERCUT.
ALL SHARP EDGES AND BURRS TO BE REMOVED.
ENLARGED VIEW OF A.G.S. STANDARD UNDERCUT.

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

	Z	Y	X	W	V	U	T	S	R	Q	P	M	L	K	J	H	G	F	E	D	C	B	A
% OF PIPE	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1 1/8	1 1/4	1 1/2	1 3/4	1 7/8	2	2 1/8	2 1/4	2 1/2	2 3/4	3	3 1/8	3 1/4
B.S.P. THREAD	1/8	1/4	3/8	1/2	5/8	3/4	7/8	1	1 1/8	1 1/4	1 1/2	1 3/4	1 7/8	2	2 1/8	2 1/4	2 1/2	2 3/4	3	3 1/8	3 1/4	3 1/2	
DIA. DRILL	3/32	1/16	3/32	1/16	1/8	3/32	1/16	3/32	1/16	3/32	1/16	3/32	1/16	3/32	1/16	3/32	1/16	3/32	1/16	3/32	1/16	3/32	1/16
MIN																							
MAX																							
DIA. DRILL																							
MIN																							
MAX																							
DIA. DRILL																							
MIN																							
MAX																							

NOTES: SCREW THREADS TO BS SPEC. B4 (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.

MATERIAL: TO BE LIGHT ALLOY TO SPEC. D.T.D. 423 (LAT. ISSUE)
FINISH: TO BE ANODISED TO SPEC. D.T.D. 310 (LAT. ISSUE)
WORKING PRESSURE: 3,000 LB/SQ. IN.

A.G.S. 1214 SHEET I.

7 F.2.
8 F.26
9 W.4E
10 F.9E
11 F.12D
12 F.12A

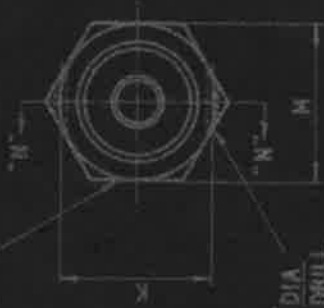
SM 2024

RAD. D RAD.



ENLARGED VIEW OF CONE END.

PART NO HERE.



A DIA. DRILL



ENLARGED VIEW OF UNDERCUT.

POSITION OF HOLES "H" RELATIVE TO FLATS OR CORNERS OF HEXAGON IS UNIMPORTANT. HOLES "H" EQUALLY SPACED.



SECTION "N-N"

THIS A.G.S. IS NOT APPLICABLE TO ENGINE INSTALLATIONS. WORKING PRESSURE - 3000 LB/50. MM. B.S.F. THREADS TO B.S. SPEC. NO. 2779 MEDIUM FIT TRUNCATED. SEE A.G.S. 100 FOR GENERAL INFORMATION FOR GENERAL ARRANGEMENT SEE A.G.S. 1128.

NO.	DATE	HT	PT	R.S. NO.	NO. PAINT	PT	ALUMIN. ALLOY	DESCRIPTION	ALUMIN. ALLOY	DESCRIPTION	THIRD ANGLE PROJECTION

ISSUED BY THE SOCIETY OF BRITISH AEROSPACE COMMERCIAL LTD.
25, KING STREET ST. JAMES, LONDON, E.W.1.

AG.S. 1214. SHEET 2.

UNIT PART No.
 I.I. ECOL SM2027

MARK	O/DIA OF PIPE	A	B	C	D	E	F	G		H	J	K	L	M	P	Q	R	S	T		U	V	W	X	Y	Z	
								MIN.	DRILL DIA.										MIN.	MAX.							
A	3/16	.330 .325	.590 .580	3/32	.035 .025	.170 .160	.230 .220	3/32 2/32	.550 .530	.600 .595	.600 .595	1.990 1.970	1.990 1.970	.600 .595	1.270 1.250	1.020 1.000	.110 .100	.350 .330	.430	.380 .375	.790 .770	5/8					
B	1/4	.440 .435	.520 .510	5/32	.045 .035	.234 .224	.290 .280	4/32 3/32	.680 .660	.710 .705	.710 .705	2.230 2.210	2.230 2.210	.710 .705	1.370 1.350	1.120 1.100	.150 .140	.550 .530	.450	.512 .507	.880 .860	7/32					
B-B	5/16	.525 .520	.600 .590	5/16	.045 .035	.277 .267	.330 .320	4/32 3/32	.800 .780	.820 .815	.820 .815	2.420 2.400	2.420 2.400	.820 .815	1.320 1.300	1.270 1.250	.150 .140	.590 .570	.450	.594 .589	1.010 .990	9/32					
C	3/8	.580 .575	.660 .650	1/4	.045 .035	.343 .333	.330 .320	7/32 4/32	.950 .910	.920 .915	.920 .915	2.530 2.530	2.530 2.530	.920 .915	1.620 1.600	1.370 1.350	.150 .140	.720 .700	.490	.650 .645	1.130 1.110	5/16					
C-C	7/16	.650 .645	.750 .740	5/16	.065 .055	.397 .377	.330 .320	1/4 4/32	.970 .950	1.000 1.002	1.000 1.002	2.840 2.820	2.840 2.820	1.000 1.002	1.800 1.780	1.520 1.500	.190 .180	.770 .750	.520	.741 .736	1.230 1.210	15/32					
D	1/2	.720 .715	.830 .820	3/8	.065 .055	.448 .438	.330 .320	9/32 4/32	.970 .950	1.010 1.002	1.010 1.002	3.00 2.980	3.00 2.980	1.010 1.002	1.950 1.930	1.670 1.650	.190 .180	.880 .860	.590	.816 .811	1.370 1.350	7/16					

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

NO.	DESCRIPTION	SCALE	UNITS NOT SHOWN	MATERIAL—REMARKS

DESIGNED BY THE SOCIETY OF BRITISH ALUMINIUM INDUSTRIES LTD., 10, KING STREET, ST. JAMES'S, LONDON, S.W.1.	DESIGNED	DRAWN	TRACED	CHECKED	DATE	DATE	HT	PT
	F.A.C.	F.A.C.	F.A.C.	F.A.C.	M/D/Y	M/D/Y		
PIPE COUPLINGS (ALUMINUM ALLOY RANGE) ALUMINUM ALLOY BANJO BOLT WITH CONE HEAD CONNECTOR							AG.S. 1214 SHEET 2.	

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