

THE THREAD UNDERCUT MAY BE OMITTED WHEN BORE 'Z' IS THREADED. 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.

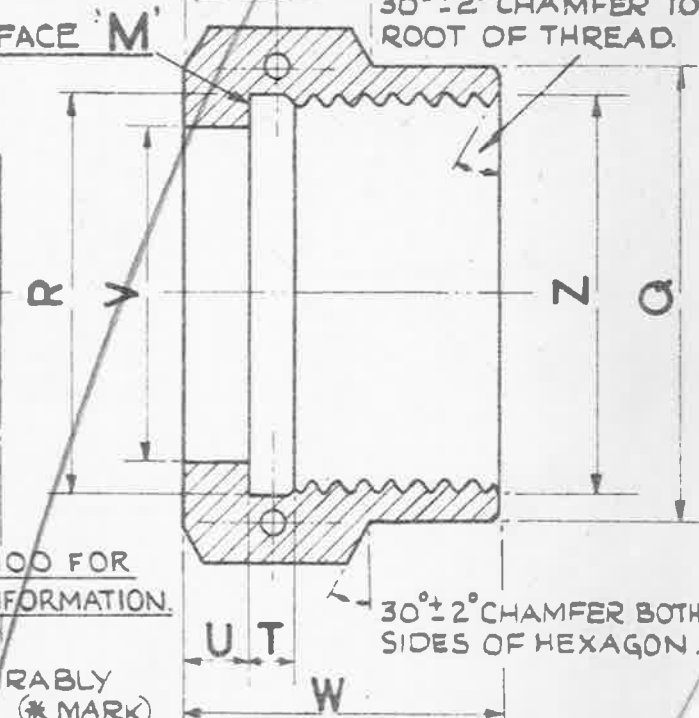
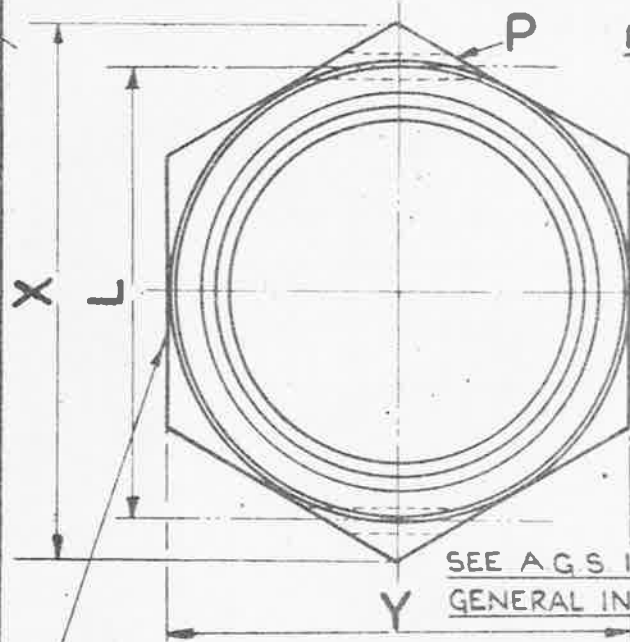
MINISTRY OF SUPPLY.

A.G.S. 1216.

SHEET No 1

No OF SHEETS 1

16.12.46
7/87400/2



ALL SHARP EDGES & BURRS TO BE REMOVED.
30°±2° CHAMFER TO ROOT OF THREAD.

30°±2° CHAMFER BOTH SIDES OF HEXAGON.

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

A.G.S. 1216 - * TO BE LEGIBLY AND DURABLY MARKED ON THIS OR OPPOSITE FACE (* MARK)

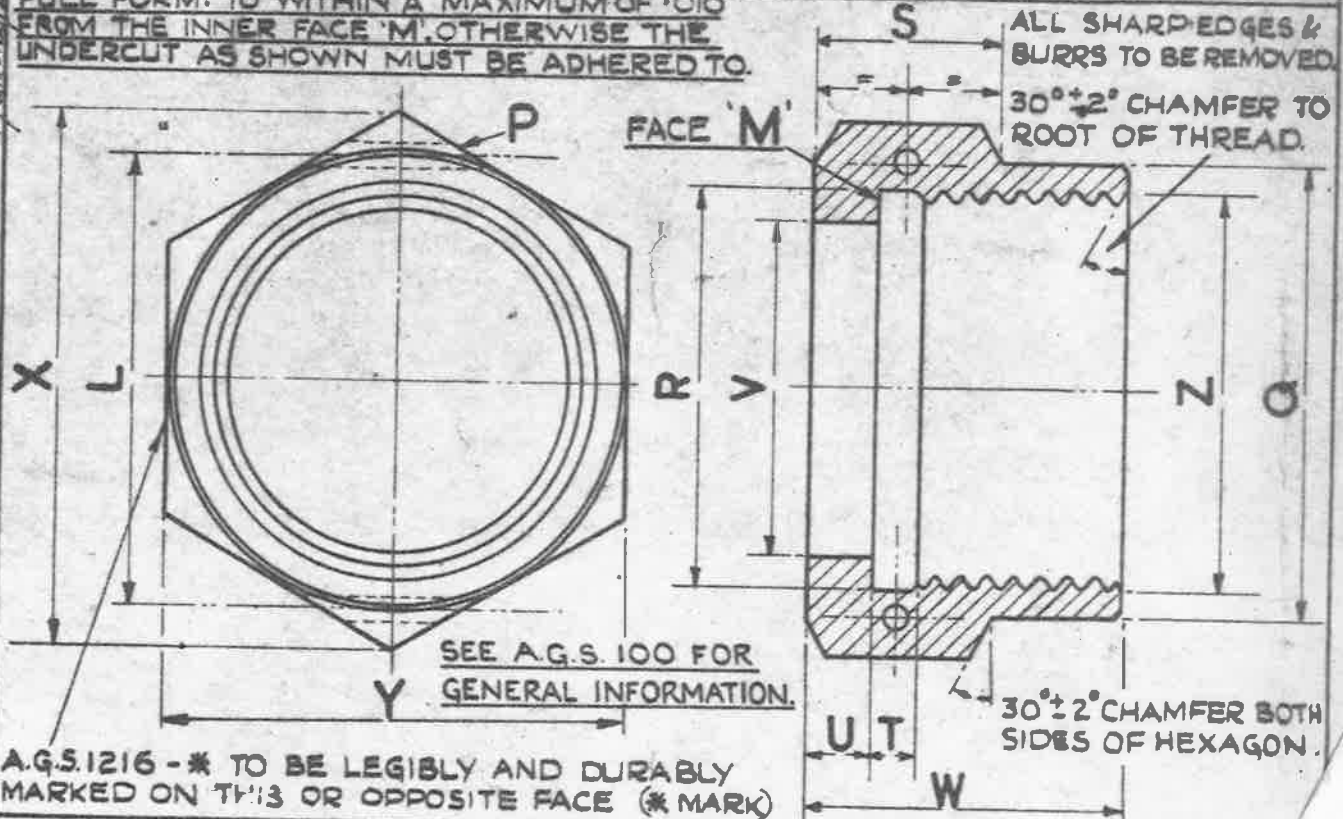
| MARK | Z | Y | | X | W | V | U | T | S | R | Q | P | L |
|------|----------------------------------|--------|--------|---------|-------------|--------------|--------------|-------------|-------------|--------------|----------|------------------|-------------|
| | B.S.P. THREAD | MAX. | MIN. | APPROX. | +0 -0.01 | +0 -0.005 | +0 -0.005 | +0 -0.01 | +0 -0.01 | +0.010 -0 | +0 -0 | DIA. DRILL | +0 -0.01 |
| A | 1/8" | .525" | .520" | .610" | .45" | .270" | .120" | .07" | .26" | .383" | .49" | 1/16" | .48" |
| B | 1/4" | .710" | .705" | .820" | .51" | .370" | .130" | .07" | .30" | .518" | .64" | 1/16" | .51" |
| BB | .60 ^{0/D} x19 T.P.I. | .820" | .815" | .950" | .57" | .440" | .140" | .10" | .34" | .600" | .72" | 1/16" | .79" |
| C | 3/8" | .820" | .815" | .950" | .60" | .500" | .140" | .10" | .35" | .656" | .78" | 1/16" | .79" |
| CC | .75 ^{0/D} x14 T.P.I. | .920" | .915" | 1.060" | .65" | .540" | .150" | .10" | .38" | .750" | .88" | 1/16" | .92" |
| D | 1/2" | 1.010" | 1.002" | 1.170" | .70" | .620" | .150" | .12" | .41" | .825" | .97" | 1/16" | .96" |
| E | 5/8" | 1.100" | 1.092" | 1.270" | .76" | .740" | .160" | .12" | .44" | .902" | 1.06" | 1/16" | 1.06" |
| F | 3/4" | 1.200" | 1.192" | 1.390" | .82" | .870" | .170" | .12" | .48" | 1.041" | 1.20" | 1/16" | 1.17" |
| G | 7/8" | 1.390" | 1.382" | 1.610" | .93" | 1.000" | .180" | .12" | .54" | 1.189" | 1.35" | .076" (No 48) | 1.37" |
| H | 1" | 1.480" | 1.468" | 1.710" | 1.01" | 1.110" | .190" | .18" | .59" | 1.309" | 1.45" | .076" (No 48) | 1.47" |
| J | 1 1/4" | 1.860" | 1.845" | 2.150" | 1.02" | 1.400" | .200" | .18" | .61" | 1.650" | 1.83" | .076" (No 48) | 1.90" |
| K | 1 1/2" | 2.220" | 2.200" | 2.560" | 1.13" | 1.665" | .210" | .18" | .68" | 1.882" | 2.09" | .076" (No 48) | 2.14" |
| L | 1 3/4" | 2.410" | 2.390" | 2.78" | 1.15" | 1.90" | .220" | .25" | .70" | 2.116" | 2.37" | .076" (No 48) | 2.36" |
| M | 2" | 2.760" | 2.735" | 3.19" | 1.25" | 2.13" | .230" | .28" | .72" | 2.347" | 2.64" | .076" (No 48) | 2.77" |

MATERIAL:- STEEL TO B.S. SPEC. S.1. (LATEST ISSUE)
FINISH:- CADMIUM PLATE TO SPEC. D.T.D. 904 (LATEST ISSUE)
NOTE:- SCREW THREADS TO B.S. SPEC. B4 (LATEST ISSUE) MEDIUM FIT. FOR DIAMETERS AND TOLERANCES OF MARKS BB & CC SEE A.G.S.100. SHT.5.

| | | | | | |
|---|--------------------------------------|------------|------------|-------------------|---|
| ISSUED BY THE ROYAL AIRCRAFT ESTABLISHMENT. | TITLE:- STANDARD UNION NUTS. (STEEL) | | | DRAWN K.Wilson | TRACED S.J. 14-1-47. |
| | ISSUE No. | 5 | 6 | 6 | CHECKED |
| | ALTER. No. | AS/AGS 970 | AS/AGS 988 | SM 856 | C.T. Reynolds |
| | | | | | APPROVED <i>[Signature]</i> 26.11.45. |

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.

16.12.46
7/27-10/2



A.G.S. 1216 - * TO BE LEGIBLY AND DURABLY MARKED ON THIS OR OPPOSITE FACE (* MARK)

| MARK | Z | Y | | X | W | V | U | T | S | R | Q | P | L |
|------|--------------------------|--------|--------|--------|--------|----------------|---------|--------|--------|----------------|---------------|------------------|--------|
| | B.S.P. THREAD | MAX. | MIN. | APPROX | + .01" | + 0 - .005" | + .005" | + .01" | + .01" | + .010" - 0 | + .01" - 0 | DIA. DRILL | + .01" |
| A | 1/8" | .525" | .520" | .610" | .45" | .270" | .120" | .07" | .26" | .383" | .49" | 1/16" | .48" |
| B | 1/4" | .710" | .705" | .820" | .51" | .370" | .130" | .07" | .30" | .518" | .64" | 1/16" | .65" |
| BB | .60" O.D. x 19 T.P.I. | .820" | .815" | .950" | .57" | .440" | .140" | .10" | .34" | .600" | .72" | 1/16" | .79" |
| C | 3/8" | .820" | .815" | .950" | .60" | .500" | .140" | .10" | .35" | .656" | .78" | 1/16" | .79" |
| CC | .75" O.D. x 14 T.P.I. | .920" | .915" | 1.060" | .65" | .540" | .150" | .10" | .38" | .750" | .88" | 1/16" | .92" |
| D | 1/2" | 1.010" | 1.002" | 1.170" | .70" | .620" | .150" | .12" | .41" | .825" | .97" | 1/16" | .96" |
| E | 5/8" | 1.100" | 1.092" | 1.270" | .76" | .740" | .160" | .12" | .44" | .902" | 1.06" | 1/16" | 1.06" |
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| M | 2" | 2.760" | 2.735" | 3.19" | 1.25" | 2.13" | .230" | .28" | .72" | 2.347" | 2.64" | .076" (No 48) | 2.77" |

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NOTE :- SCREW THREADS TO B.S. SPEC. B4 (LATEST ISSUE) MEDIUM FIT. FOR DIAMETERS AND TOLERANCES OF MARKS BB & CC SEE A.G.S.100. SHT.5.

| | | | | | | |
|---|---------------------------------------|------------|------------|-------------|--------------|----------------------------------|
| ISSUED BY THE ROYAL AIRCRAFT ESTABLISHMENT. | TITLE :- STANDARD UNION NUTS. (STEEL) | | | | DRAWN | TRACED |
| | ISSUE NO | 5 | 8 | SM 7 27: | K.Wilson. | S.J. 14-1-47. |
| | ALTER. NO | AS/AGS 970 | AS/AGS 988 | MOD/AGS 994 | C.T.Reynolds | APPROVED 1/11/45 26.11.45. |