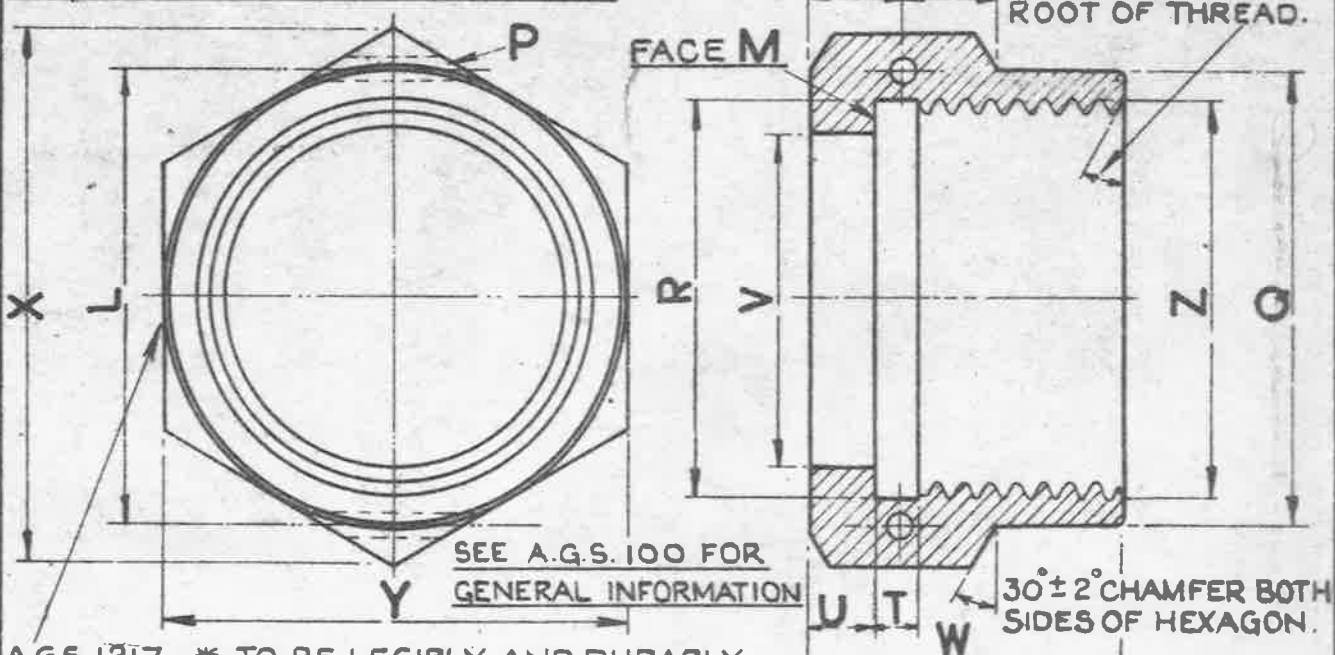


THE THREAD UNDERCUT MAY BE OMITTED WHEN BORE Z IS THREAD MILLED. THE THREAD IS TO BE FULL FORM TO WITHIN A MAXIMUM OF .060" FROM THE INNER FACE 'M' FOR MARKS BB TO M. FOR MARKS A & B THE THREAD TO BE FULL FORM TO WITHIN A MAXIMUM OF .010" FROM THE INNER FACE 'M'. OTHERWISE THE UNDERCUT AS SHOWN MUST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

MINISTRY OF SUPPLY. A.G.S. 1217.
SHEET NO 1 NO OF SHEETS 1

16.12.46
7/ST/MS/2



AGS. 1217 - * 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.	$\pm .01$ "	$\pm .005$ "	$\pm .005$ "	$\pm .01$ "	$\pm .01$ "	$\pm .010$ " $\pm .0$ "	$\pm .01$ " $\pm .0$ "	DIA. DRILL	$\pm .01$ "
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"	.67"
BB	60% X 19 TPI	.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% X 14 TPI	.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"	1.19"	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:- BRASS TO B.S. SPEC. 249 OR 251 (LATEST ISSUE)
FINISH:- CADMIUM PLATE TO SPEC. D.T.D. 904 (LATEST ISSUE), ALTERNATIVELY, ELECTRO-TIN TO SPEC. D.T.D. 924 (LATEST ISSUE)
NOTE:- SCREW THREADS TO B.S. SPEC. 84 (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. (BRASS.)				DRAWN K. Wilson	TRACED S.D. 21-1-47
	ISSUE NO	5	6	7		
	ALTERN NO	AS/AGS 834c	AS/AGS 970	AS/AGS 988	MS/AGS 994	CHECKED C.T. Reynolds

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

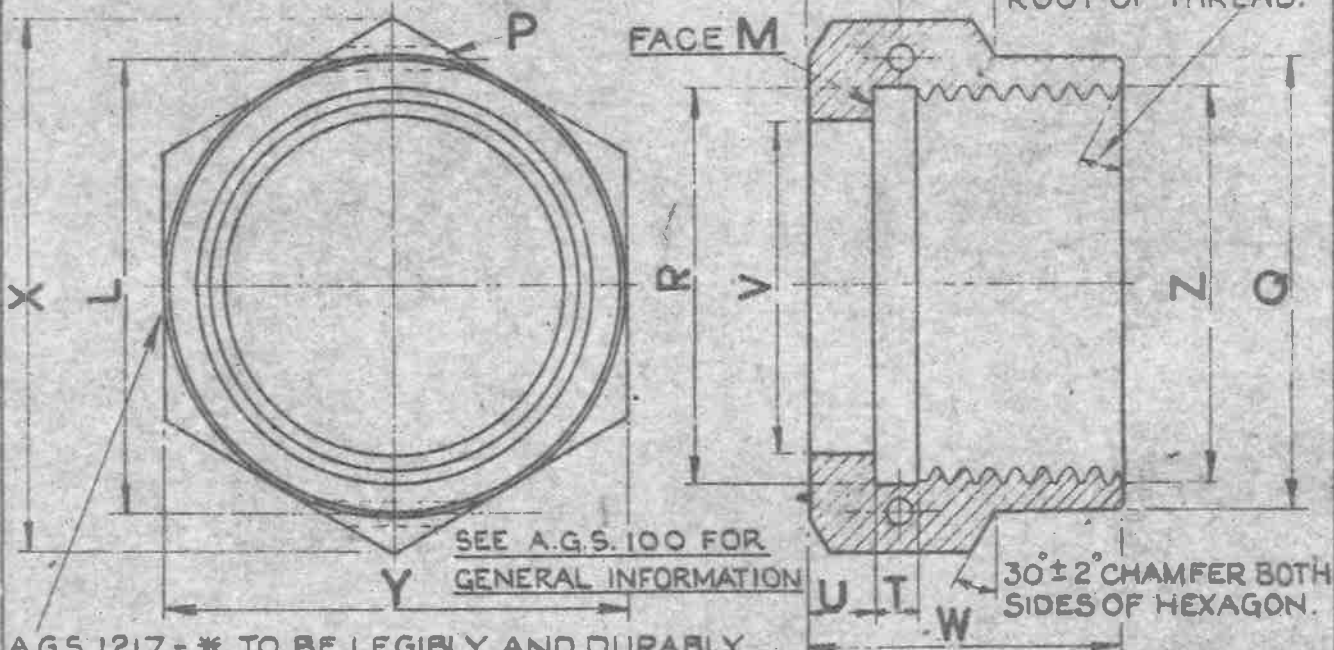
A.G.S. 1217.

SHEET NO 1

NO OF SHEETS 1

ALL SHARP EDGES & BURRS TO BE REMOVED.

30° ± 2° CHAMFER TO ROOT OF THREAD.



AGS. 1217 - * TO BE LEGIBLY AND DURABLY MARKED ON THIS OR OPPOSITE FACE. (* MARK)

OBSOLESCE - FOR SUPERSEDING ITEMS SEE A.G.S. 1101.

MARK	Z B.S.P. THREAD	Y MAX.	Y MIN.	X APPROX	W ±.01"	V +.005 -.005	U ±.01"	T ±.01"	S +.010 -.010	R +.01"	Q +.01"	P DIA DRILL	L ±.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"	.67"
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MATERIAL: BRASS TO B.S. SPEC. 249 OR 251 (LATEST ISSUE)

FINISH: CADMIUM PLATE TO SPEC. D.T.D. 904 (LATEST ISSUE), ALTERNATIVELY, ELECTRO-TIN TO SPEC. D.T.D. 924 (LATEST ISSUE)

NOTE: SCREW THREADS TO B.S. SPEC. 84 (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. (BRASS.)		DRAWN K. Wilson	TRACED I.D. 21-1-47
	ISSUE NO	9	CHECKED	APPROVED
	ALTERN NO	MOO/AGS 1016	C.T. Reynolds	26.11.45