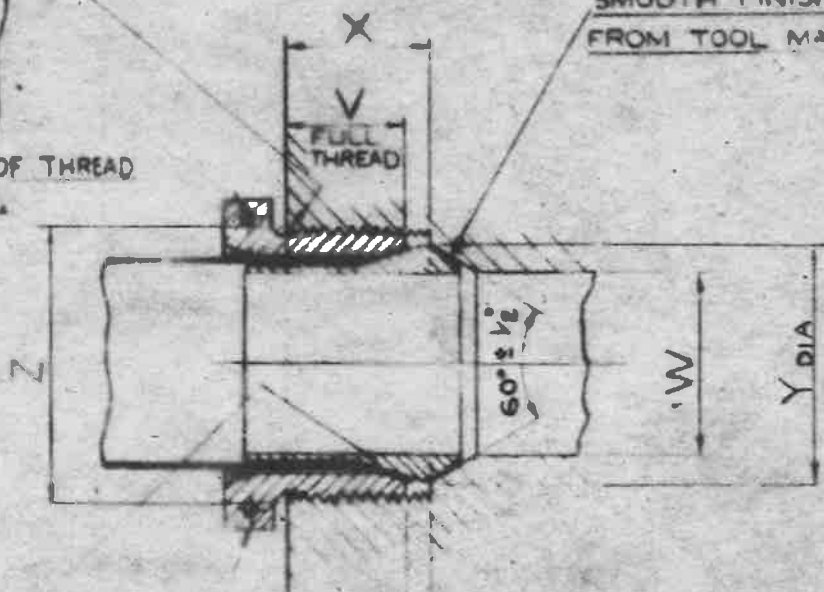
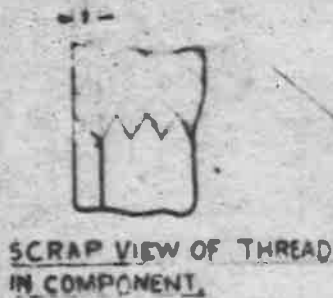


45° CHAMFER TO
EDGE OF THREAD

MINISTRY OF
AIRCRAFT PRODUCTION **AGS No 1219**

SHEET No 1 / **No OF SHEETS 2**



AGS
1142

AGS
1218

2-THREAD RUN-OUT
FOR PIPE SIZES $\frac{3}{16}$ " O/D TO $\frac{7}{8}$ " O/D ONLY
SEE NOTE MARKED * FOR PIPE SIZES
OVER $\frac{7}{8}$ " BSP

O/D OF PIPE TO BE CONNECTED.	Z	Y	X	W	V
	BSP THREAD	± 0	$\pm .005$	DRILL	$\pm .005$
$\frac{3}{16}$ "	$\frac{1}{8}$ "	.27	.52	$\frac{3}{32}$ "	.45
$\frac{1}{4}$ "	$\frac{1}{4}$ "	.39	.60	$\frac{5}{32}$ "	.50
$\frac{5}{16}$ "	19 TPI WHIT FORM 60 9D	.46	.64	$\frac{3}{16}$ "	.54
$\frac{3}{8}$ "	$\frac{3}{8}$ "	.52	.65	$\frac{1}{2}$ "	.55
$\frac{7}{16}$ "	14 TPI WHIT FORM 75 9/D	.57	.74	$\frac{5}{16}$ "	.60
$\frac{1}{2}$ "	$\frac{1}{2}$ "	.62	.78	$\frac{3}{8}$ "	.62
$\frac{5}{8}$ "	$\frac{5}{8}$ "	.76	.76	$\frac{1}{2}$ "	.62
$\frac{3}{4}$ "	$\frac{3}{4}$ "	.86	.82	$\frac{5}{8}$ "	.68
$\frac{7}{8}$ "	$\frac{7}{8}$ "	1.03	.82	$\frac{3}{4}$ "	.68
* 1"		1.12	.87	$\frac{7}{8}$ "	.69
* $\frac{1}{4}$ "	$\frac{1}{4}$ "	1.40	.87	$\frac{1}{8}$ "	.69
* $\frac{1}{2}$ "	$\frac{1}{2}$ "	1.64	.94	$\frac{3}{8}$ "	.76

NOTE - SCREW THREADS TO BS SPEC No 84 - 1940 MEDIUM FIT

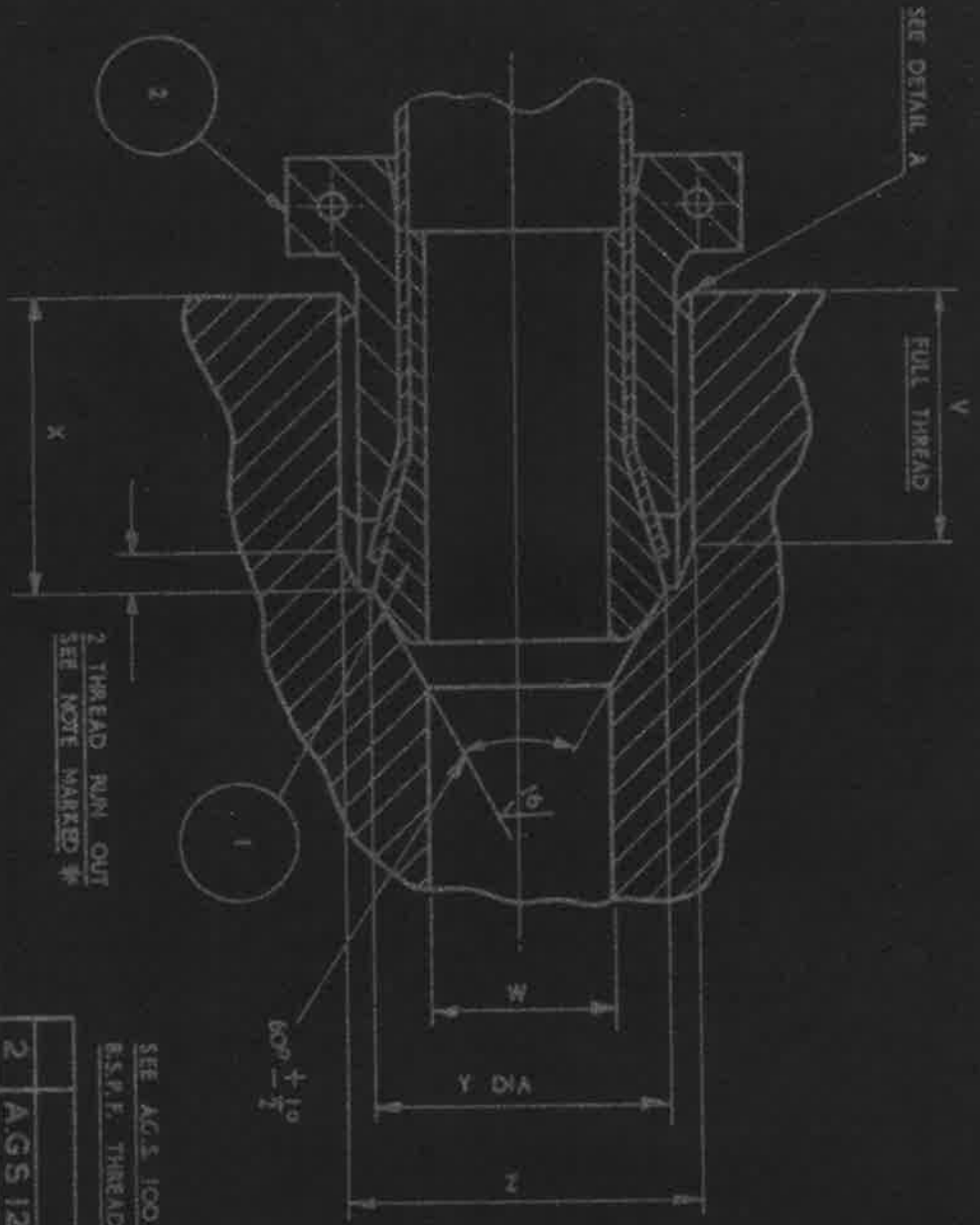
* FOR SIZES OVER $\frac{7}{8}$ " BSP THE HOLE IN THE COMPONENT
MUST BE PLUG TAPPED TO THE BOTTOM AND AGS 905
MARKS H, J, R, K USED TO TAKE THE PLACE OF AGS 1218

ISSUED BY ROYAL AIRCRAFT ESTAB	TITLE - DIMENSIONS OF TAPPED HOLES IN COMPONENTS FOR CONNECTING AGS PIPE COUPLINGS DIRECT (2-THREAD RUN-OUT)				APPROVED
	SCALE	1			
DATE	1				

INFORMATION ON AGS 905, 1218 AND 1219

- 1 AGS 1219 SHEET 1 SHOWS THE GENERAL ARRANGEMENT OF PIPE TO COMPONENT JOINTS, AVOIDING THE USE OF ADAPTOR AGS 1104 OR 1105. IT ALSO GIVES PARTICULARS OF THE TAPPED HOLES REQUIRED IN COMPONENTS FOR THIS TYPE OF JOINT.
- 2 MANUFACTURERS USING THIS SCHEME WILL TAP COMPONENTS TO DIMENSIONS ON AGS 1219 SHEET 1 AND WILL ASSEMBLE PARTS IN ACCORDANCE WITH THAT DRAWING.
- 3 THE DIRECT SCHEME CAN BE USED FOR ALL SIZES OF PIPES, BUT FOR SIZES OVER 2" BSP THE HOLE IN COMPONENT MUST BE PLUG TAPPED BY MANUFACTURERS, AND THE APPROPRIATE MARK OF AGS 905 WILL BE USED (MARK H, J OR K).
- 4 MANUFACTURERS WHO ARE UNABLE TO USE THE DIRECT SCHEME (AGS 1219 SHEET 1) ON ACCOUNT OF SPACE OR OTHER LIMITATIONS MAY CONTINUE TO USE THE EARLIER SCHEME WHICH EMPLOYS THE ADAPTOR AGS 1104.

ISSUED BY ROYAL AERONAUTICAL ESTABLISHMENT	TITLE - DIMENSIONS OF TAPPED HOLES IN COMPONENTS FOR CONNECTING AGS PIPE COUPLINGS DIRECT (2" THREAD RUN-OUT)		DRAWN BY	CHECKED BY	SCALE
	APPROVED BY	DATE			



* FOR PIPE SIZES 3/8" O.D. TO 7/8" O.D. ONLY FOR SIZES OVER 7/8" B.S.P.F. THE HOLE IN THE COMPONENT MUST BE PLUG TAPPED TO THE BOTTOM AND A.G.S. 905 MARKS H J AND K USED TO TAKE THE PLACE OF A.G.S. 1218

SEE AGS 100 FOR GENERAL INFORMATION
B.S.P.F. THREADS TO B.S. SPEC. 2779 MEDIUM FIT

REF.	DRAWING OR PART No.	DESCRIPTION	LIMITS NOT SHOWN	AT DRAWING HAND UNIT QTY	MATERIAL - REMARKS
2	AGS 1218	INNER SLEEVE			
1	AGS 1142	ADAPTOR NIPPLE			

DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR S.B.A.C.	DATE
F.A.C.	F.A.C.	F.A.C.	F.A.C.	<i>H.G. Fisher</i>	12.9.58

ISSUED BY THE SOCIETY OF BRITISH AEROSPACE COMPANIES LTD.,
20, KING STREET, ST. JAMERS, LONDON, S.W.1.

ISSUE	ALT. No.
2	F.2.
3	E.123

DIMENSIONS OF TAPPED HOLES IN COMPONENTS FOR CONNECTING AGS PIPE COUPLINGS DIRECT

AGS. 1219-SHT. 1.

AGS. 1219 SHT 2

SM2027

INFORMATION ON AGS. 905, 1218 AND 1219

AGS. 1219 SHEET 1 SHOWS THE GENERAL ARRANGEMENT OF PIPE TO COMPONENT JOINTS, AVOIDING THE USE OF ADAPTOR AGS. 1104 OR 1105. IT ALSO GIVES PARTICULARS OF THE TAPPED HOLES REQUIRED IN COMPONENTS FOR THIS TYPE OF JOINT.

MANUFACTURERS USING THIS SCHEME WILL TAP COMPONENTS TO DIMENSIONS ON AGS. 1219 SHEET 1 AND WILL ASSEMBLE PARTS IN ACCORDANCE WITH THAT DRAWING.

THE DIRECT SCHEME CAN BE USED FOR ALL SIZES OF PIPES, BUT FOR SIZES OVER 7/8" B.S.P.F. THE HOLE IN THE COMPONENT MUST BE PLUG-TAPPED BY MANUFACTURERS, AND THE APPROPRIATE MARK OF AGS. 905 WILL BE USED (MARK 'H' OR 'K').

MANUFACTURERS WHO ARE UNABLE TO USE THE DIRECT SCHEME (AGS. 1219 SHEET 1) ON ACCOUNT OF SPACE OR OTHER LIMITATIONS, MAY CONTINUE TO USE THE EARLIER SCHEME WHICH EMPLOYS THE ADAPTOR AGS. 1104.

O/D. OF PIPE TO BE CONNECTED	Y	W		X	Y	Z
		DRILL				
3"	.455"	3/32"	.525"	.270"	.270"	1"
1/2"	.445"	3/32"	.515"	.260"	.260"	8
1"	.505"	5/32"	.605"	.390"	.390"	1"
4"	.495"	3/2"	.595"	.380"	.380"	4
5"	.545"	3/16"	.645"	.460"	.460"	1/2" T.R.L.
1/2"	.535"	1/8"	.635"	.450"	.450"	.60" O/D. W.H.T. (B.S. 84)
3"	.555"	1"	.655"	.520"	.520"	3"
8"	.545"	4"	.645"	.510"	.510"	8
7"	.605"	5"	.745"	.570"	.570"	1/4" T.P.I.
1/2"	.595"	1/2"	.735"	.560"	.560"	.75" O/D. W.H.T. (B.S. 84)
1"	.625"	3/8"	.755"	.620"	.620"	1"
2"	.615"	8"	.745"	.610"	.610"	2"
3"	.625"	1"	.765"	.760"	.760"	5"
8"	.615"	2"	.755"	.750"	.750"	8
3"	.685"	5"	.825"	.860"	.860"	3"
4"	.675"	6"	.815"	.850"	.850"	4"
7"	.685"	3"	.825"	1.030"	1.030"	7"
8"	.675"	4"	.815"	1.020"	1.020"	8
1"	.695"	7"	.875"	1.120"	1.120"	1"
1"	.685"	8"	.865"	1.110"	1.110"	1"
1/4"	.695"	1"	.875"	1.400"	1.400"	1/4"
1/4"	.685"	1/8"	.865"	1.390"	1.390"	1/4"
1/2"	.765"	1 3/8"	.945"	1.640"	1.640"	1 1/2"
1/2"	.755"	1 1/8"	.935"	1.630"	1.630"	1 1/2"

DESIGNED BY THE SOCIETY OF AUTOMATIC LABORATORY ADMINISTRATION LTD., 18, KING STREET, ST. ALBANS, HERTS., ENGLAND, U.K.V.I.

HT

PT

DATE

SCALE

DESCRIPTION

AGS. 1219 SHT. 2

MATERIAL - ALUMINUM