

UNLIMITED DIMENSIONS ±.01"

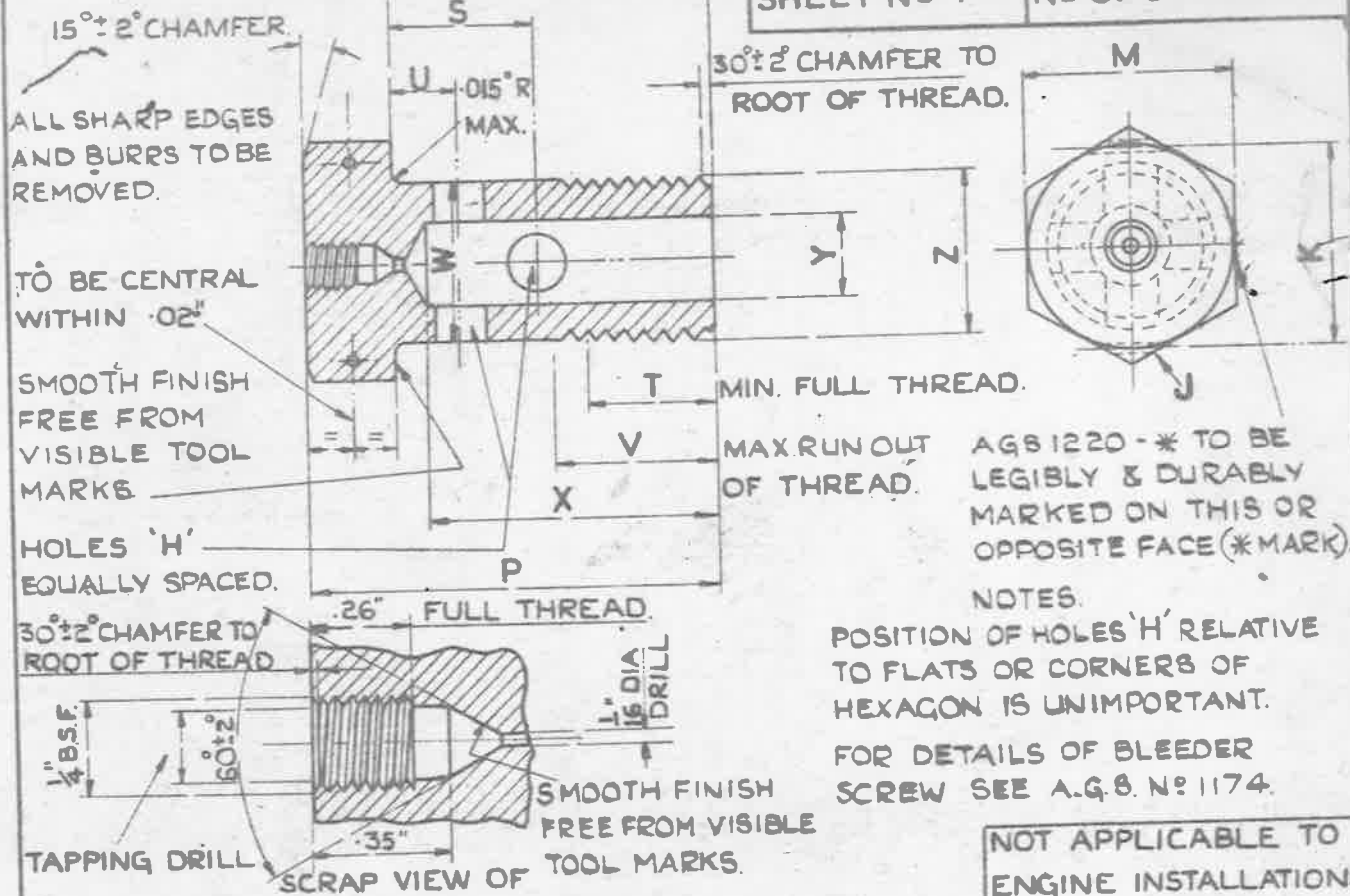
MINISTRY OF SUPPLY

A.G.S. NO 1220

SHEET NO 1

NO OF SHEETS 1

26.10.46
Rev. 199.68.



AGS 1220 - * TO BE LEGIBLY & DURABLY MARKED ON THIS OR OPPOSITE FACE (* MARK).

NOTES:
POSITION OF HOLES 'H' RELATIVE TO FLATS OR CORNERS OF HEXAGON IS UNIMPORTANT.
FOR DETAILS OF BLEEDER SCREW SEE A.G.S. NO 1174.

NOT APPLICABLE TO ENGINE INSTALLATIONS

SEATING DIMENSIONS.

M	K	J	H	P	Q	S	T	U	V	W	X	Y	Z	% OF PIPE	M	K	J	H	
MIN.	MAX.	±.01"	DIA. DRILL	±.01"	±.01"	±.01"	±.01" MIN.	±.01" MAX.	±.01"	±.005" - 0	±.01"	±.01"	B.S.P. DIA. DRILL		MIN.	MAX.	±.01"	DIA. DRILL	
.595"	.600"	.54"	1/16"	1.36"	1.01"	.34"	.43"	.53"	.375"	.78"	5/32"	1/8"	3/16"		.595"	.600"	.54"	1/16"	2 - 5/32"
.705"	.710"	.67"	1/16"	1.44"	1.11"	.54"	.45"	.60"	.507"	.87"	7/32"	1/4"	1/4"		.705"	.710"	.67"	1/16"	4 - 5/32"
.815"	.820"	.79"	1/16"	1.60"	1.26"	.58"	.45"	.60"	.589"	1.00"	9/32"	19T.P.I. 60%	5/16"		.815"	.820"	.79"	1/16"	4 - 5/32"
.915"	.920"	.92"	1/16"	1.70"	1.36"	.71"	.49"	.64"	.645"	1.12"	5/16"	3/8"	3/8"		.915"	.920"	.92"	1/16"	4 - 7/32"
1.002"	1.010"	.96"	1/16"	1.85"	1.51"	.76"	.52"	.72"	.736"	1.22"	13/32"	14T.P.I. 75%	7/16"		1.002"	1.010"	.96"	1/16"	4 - 1/4"
1.002"	1.010"	.96"	1/16"	1.98"	1.66"	.87"	.59"	.80"	.811"	1.36"	7/16"	1/2"	1/2"		1.002"	1.010"	.96"	1/16"	4 - 3/32"
1.092"	1.100"	1.06"	1/16"	2.10"	1.76"	.94"	.59"	.80"	.888"	1.41"	9/16"	5/8"	5/8"		1.092"	1.100"	1.06"	1/16"	4 - 5/16"
1.292"	1.300"	1.26"	.076" (N#48)	2.31"	1.96"	.99"	.65"	.85"	1.027"	1.59"	11/16"	3/4"	3/4"		1.292"	1.300"	1.26"	.076" (N#48)	4 - 13/32"
1.382"	1.390"	1.37"	.076" (N#48)	2.55"	2.16"	1.06"	.69"	.90"	1.175"	1.81"	13/16"	7/8"	7/8"		1.382"	1.390"	1.37"	.076" (N#48)	4 - 7/16"
1.658"	1.670"	1.68"	.076" (N#48)	2.91"	2.54"	1.34"	.75"	.99"	1.291"	2.11"	15/16"	1"	1"		1.658"	1.670"	1.68"	.076" (N#48)	4 - 17/32"

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

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

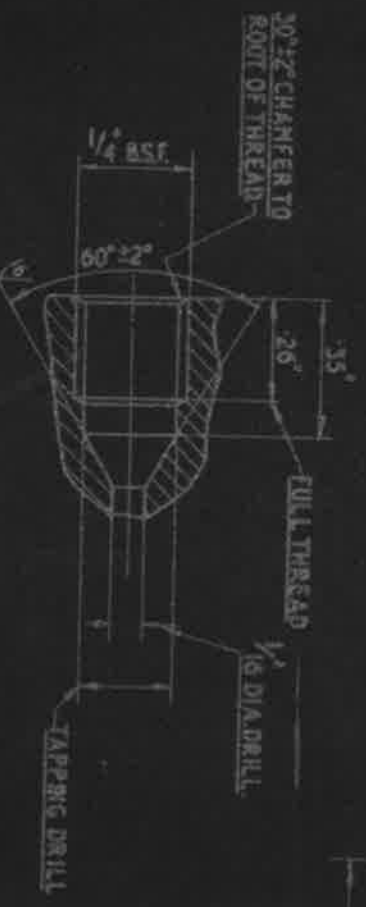
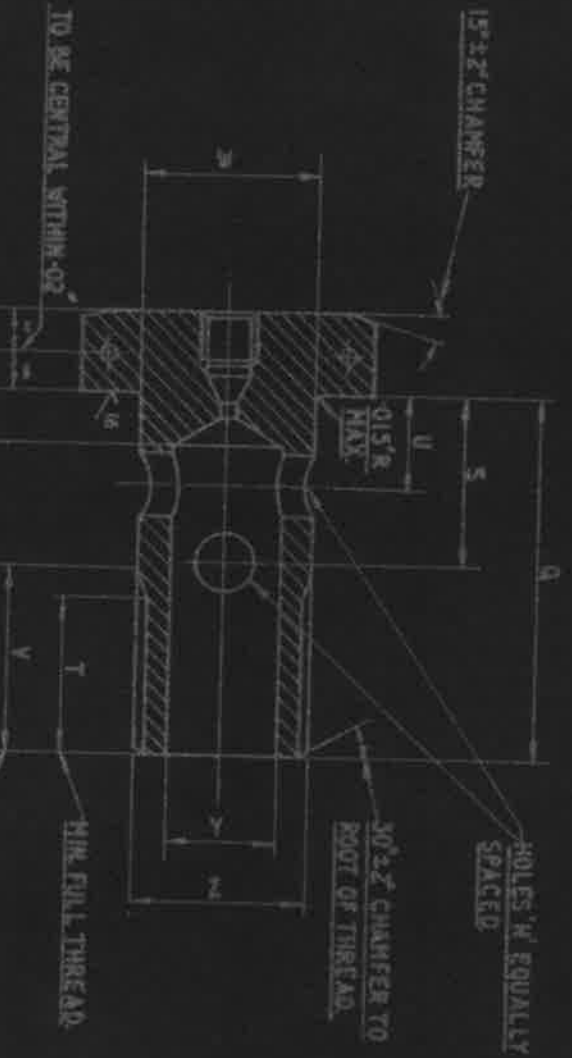
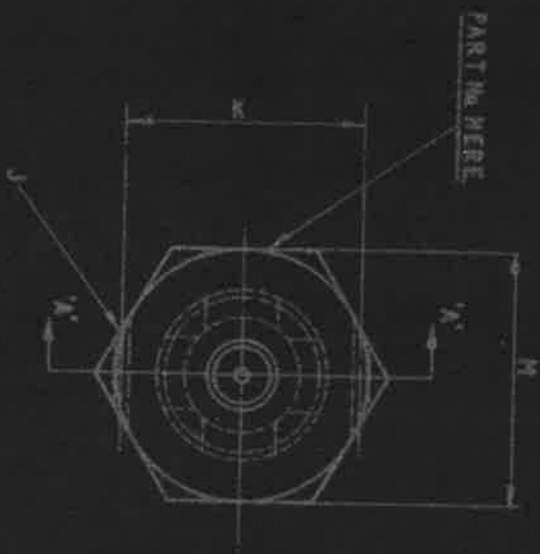
NOTES:- SCREW THREADS TO B.S. SPEC. 84 (LATEST ISSUE).
EXTERNAL THREADS - MEDIUM FIT, TRUNCATED, FOR DIAMETERS, TOLERANCES AND TRUNCATED DIMENSIONS OF MARKS BB & CC SEE A.G.S. 100 SHEET 5. INTERNAL THREADS - FREE FIT.

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 WITH HOLE FOR BLEEDER SCREW.			DRAWN: C.T. Reynolds.	TRACED: I.D. 31-9-46.
	ISSUE NO: 1	2	3	CHECKED: [Signature]	APPROVED: [Signature] 2/10/46
	ALTERN NO: MOD. AGS/633	MOD. NO. AGS/660	AS/AGS 969		

ACS 1220 SHEET 1

1	REV	
2	REV	
3	REV	
4	REV	
5	REV	
6	REV	
7	REV	
8	REV	
9	REV	
10	REV	



SCRAP VIEW OF SEATING DIMENSIONS.

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

SECTION 'A-A'

THIS AGS IS NOT APPLICABLE TO ENGINE INSTALLATIONS, FOR DETAILS OF BLEEDER SCREW SEE AGS. 1174, B.S.F. THREADS TO B.S. 4 FREE FILE. SEE AGS. 100 FOR GENERAL INFORMATION FOR GENERAL ARRANGEMENT SEE AGS. 100. B.S.F. THREADS TO B.S. 279, MEDIUM FIT INDICATED. WORKING PRESSURES: 3000 LBS. IN FOR SIZES UP TO 1/2" BSPF, 5000 LBS. IN FOR SIZES 3/8" TO 1" BSPF.

HT	PT	HT	HT	HT	HT	HT	HT	HT	HT	HT	HT	HT	HT	HT	HT	HT	HT	HT	HT	HT	
DESIGNED	DATE	DESIGNED	DATE	DESIGNED	DATE	DESIGNED	DATE	DESIGNED	DATE	DESIGNED	DATE	DESIGNED	DATE	DESIGNED	DATE	DESIGNED	DATE	DESIGNED	DATE	DESIGNED	DATE

ALLOY	ALUMINUM	ALLOY	ALUMINUM
TEMPER	T6	TEMPER	T6
FINISH	ANODIZED	FINISH	ANODIZED
DRILL	1/8" DIA.	DRILL	1/8" DIA.
THREAD	B.S.F.	THREAD	B.S.F.
SIZE	1/2"	SIZE	1/2"

AGS 1220 SHEET 2

MARK	O/DIA OF PIPE	H	J	K	M	P	Q	S	T		U	V		W	X	Y	Z
									MIN.	MAX.		DRILL	B.S.P.F. THREAD				
A	3/16	2-5/32	1/16	.550	.600	1.370	1.020	.350	.430	—	.530	.380	.790	5/32	1/8		
B	1/4	4-5/32	1/16	.680	.710	1.450	1.120	.550	.450	.350	.600	.512	.880	7/32	1/4		
B-B	5/16	4-5/32	1/16	.800	.820	1.610	1.270	.590	.450	.390	.600	.594	1.010	9/32	19 T.P.I. 60 O/DIA WHIT (BS94)		
C	3/8	4-7/32	1/16	.930	.920	1.710	1.370	.720	.490	.400	.640	.645	1.130	5/16	5/8		
C-C	7/16	4-1/4	1/16	.970	1.010	1.860	1.520	.770	.520	.450	.720	.741	1.230	13/32	14 T.P.I. 75 O/DIA WHIT (BS94)		
D	1/2	4-9/32	1/16	.950	1.002	1.970	1.500	.860	.590	.500	.800	.816	1.370	7/16	1/2		
E	5/8	4-5/16	1/16	1.070	1.100	2.110	1.770	.950	.590	.540	.800	.893	1.420	9/16	5/8		
F	3/4	4-13/32	No. 48 (O76 DIA)	1.270	1.300	2.320	1.970	1.000	.650	.570	.850	1.032	1.600	11/16	3/4		
G	7/8	4-7/16	No. 48 (O76 DIA)	1.380	1.390	2.560	2.170	1.070	.690	.630	.900	1.180	1.820	13/16	7/8		
H	1	4-17/32	No. 48 (O76 DIA)	1.690	1.670	2.920	2.550	1.350	.750	.700	1.000	1.296	2.120	15/16	1		

DESIGNED BY THE SOCIETY OF BENTON ALUMINUM INDUSTRIES LTD.,
28, KING STREET, ST. ALBERT, LONDON, S.W. 1.

HT

PIPE COUPLINGS FOR ALUMINUM ALLOY
RANGE: ALUMINUM ALLOY BANJO BOLT 3/16
TO 1/8" S.P.F. WITH HOLE FOR BLEEDER SCREW

AGS 1220 SHEET 2