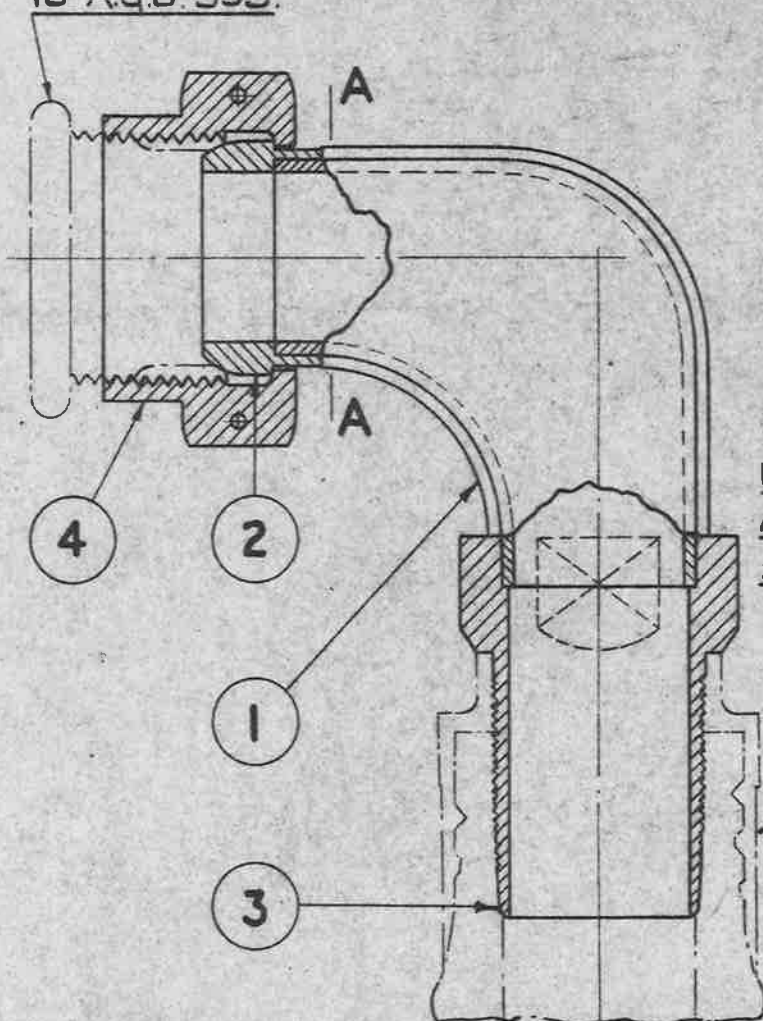


THE FOLLOWING DRAWING IS TO BE ISSUED WITH THIS AGS.:-
AGS.1231.

THE APPROPRIATE PROTECTION
PLUG FOR THESE 90° END FITTINGS
IS AGS. 595.



SECTION AA
ELBOW TO BE ASSEMBLED
AND ALUMINIUM BRAZED
AS SHOWN.

USE FERRULE A.G.S.1233
WHEN ASSEMBLING 90°
END FITTINGS TO
FLEXIBLE HOSE.

EACH ASSEMBLY TO BE PRESSURE TESTED
TO 120 P.S.I., AND THERE SHALL BE NO
SIGNS OF LEAKAGE

PARTS REQUIRED FOR ONE COMPLETE 90° END FITTING

ITEM N°	A.G.S. N°	DESCRIPTION	N° OFF	REMARKS
1	1234 SHTS. 2 & 3	ELBOW	1	
2	1234 SHI 4.	NIPPLE	1	
3	1234 SHTS 5 & 6	TAILPIECE	1	
4	1231 SHI 1	UNION NUT	1	

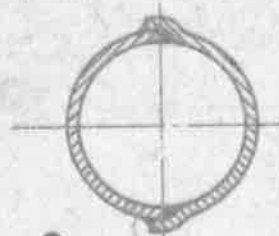
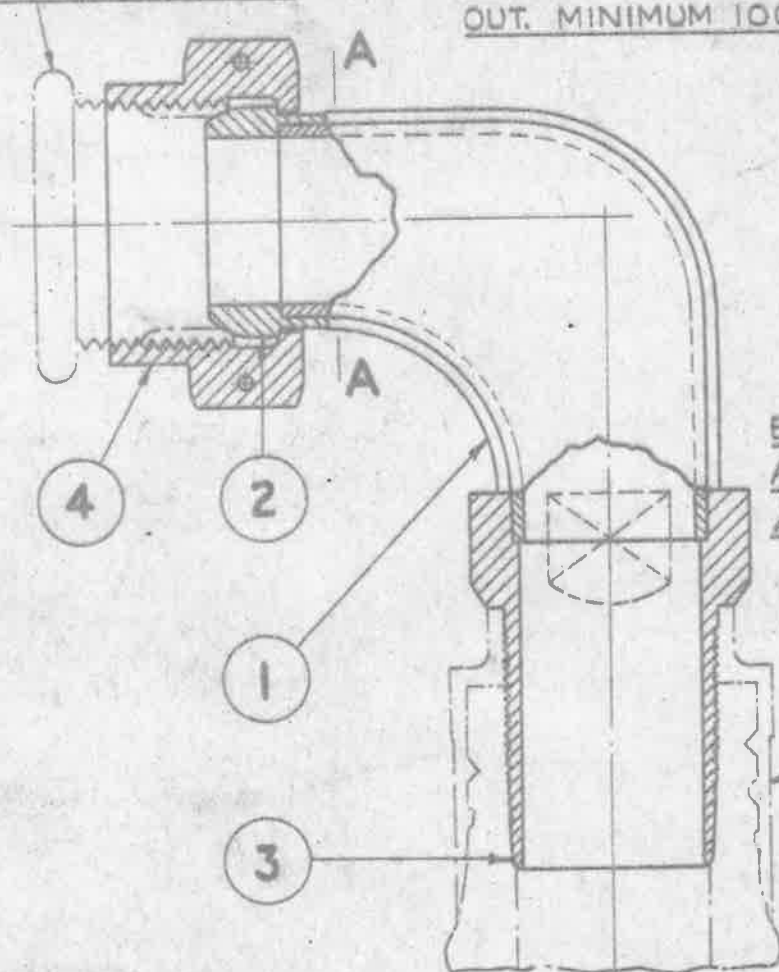
FINISH:- ANODISE TO SPEC: D.T.D. 910 PART 3 (LATEST ISSUE)

TITLE:- GENERAL ASSEMBLY, RE-USABLE 90° END FITTINGS FOR NON-FIRE RESISTANT HOSE TO SPEC. N° D.T.D. (R.D.I.) 3951	ISSUE	1	SR293			
	ALT. N°	MOD/AGS 840				
MINISTRY OF SUPPLY APPLICATIONS FOR A.G.S. SHEETS TO:- ATR 4 A. THAMES HOUSE, MILLBANK, S.W.1. GENERAL INQUIRIES TO:- A.D.S.A.E. THAM'S HOUSE, MILLBANK, S.W.1.	R.A.E. APPROVAL		A.D.S.A.E. APPROVAL			
	SIGNATURE	DATE	SIGNATURE	DATE		
	<i>C. S. R. E. W.</i>	30.8.51	<i>G. I. F. G. M. L. E. R.</i>	4/9/51		
	SHEET NO	1	A.G.S. N° 1234			
	NO OF SHEETS	6				

THE FOLLOWING DRAWING IS TO BE ISSUED WITH THIS AG.S.:-
AG.S. 1231.

THE APPROPRIATE PROTECTION PLUG FOR THESE 90° END FITTINGS IS AG.S. 595.

NOTE:- AFTER THE BRAZING OPERATION, UNION NUT AG.S. 1231 IS TO HAVE A SMALL AREA ON ONE HEXAGON FLAT POLISHED, TO REMOVE ANODIC TREATMENT, AND A HARDNESS CHECK CARRIED OUT. MINIMUM 100 VPN OR EQUIVALENT.



SECTION AA
ELBOW TO BE ASSEMBLED AND ALUMINIUM BRAZED AS SHOWN.

USE FERRULE AG.S. 1233 WHEN ASSEMBLING 90° END FITTINGS TO FLEXIBLE HOSE.

EACH ASSEMBLY TO BE PRESSURE TESTED TO 120 P.S.I., AND THERE SHALL BE NO SIGNS OF LEAKAGE

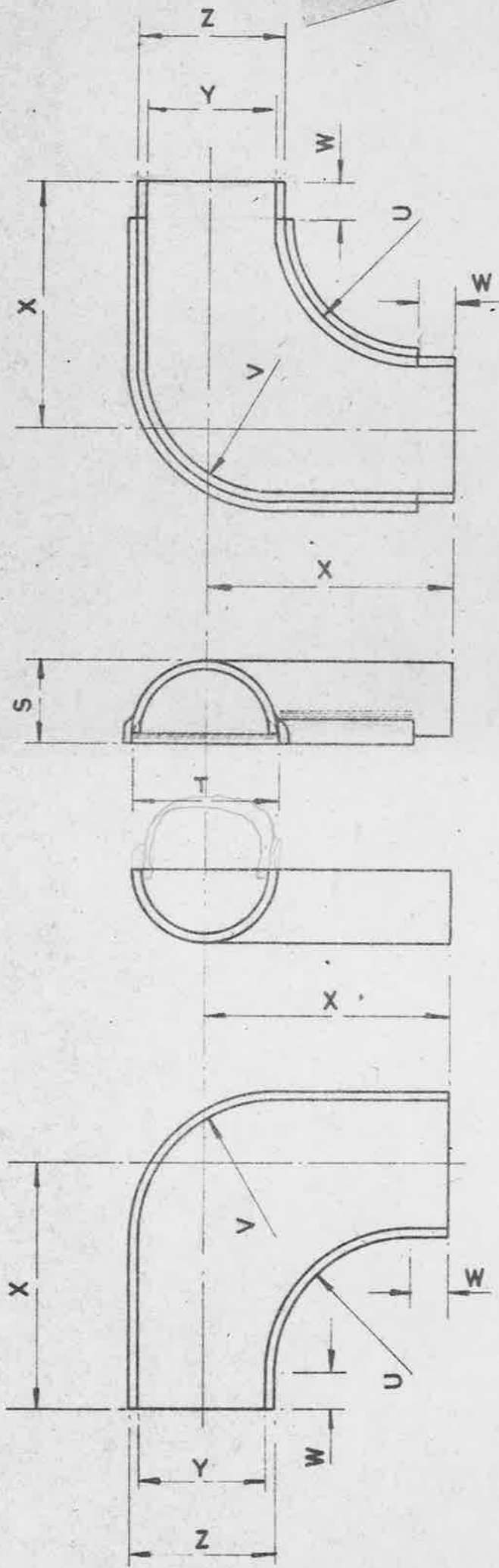
PARTS REQUIRED FOR ONE COMPLETE 90° END FITTING

ITEM N°	A.G.S. N°	DESCRIPTION	N° OFF	REMARKS
1	1234 SHTS 2 & 3	ELBOW	1	
2	1234 SHT 4.	NIPPLE	1	
3	1234 SHTS 5 & 6	TAILPIECE	1	
4	1231 SHI 1	UNION NUT	1	

FINISH:- ANODISE TO SPEC: D.T.D. 910 PART 3 (LATEST ISSUE)

TITLE:- GENERAL ASSEMBLY, RE-USABLE 90° END FITTINGS FOR NON-FIRE RESISTANT HOSE TO SPEC. N° Q.T.D. (R.D.I) 3951 MINISTRY OF SUPPLY APPLICATIONS FOR A.G.S. SHEETS TO:- ATR4A, THAMES HOUSE, MILLBANK, S.W.1. GENERAL INQUIRIES TO:- A.D.S.A.E. THAMES HOUSE, MILLBANK, S.W.1.	ISSUE	X	2					
	ALT. N°	840	985					
	R.A.E. APPROVAL		A.D.S.A.E. APPROVAL					
	SIGNATURE	DATE	SIGNATURE	DATE				
		<i>C. S. R. E. W. I.</i>	30.8.51	<i>G. I. F. A. M. I. E. R.</i>	4/9/51			
SHEET N°	1	A.G.S. N°		1234				
N° OF SHEETS	6							

AG.S. 1234/* TO BE LEGIBLY AND DURABLY MARKED ON OUTSIDE OF ELBOW IN A CENTRAL POSITION (* MARK N^o.)



ALL SHARP EDGES AND BURRS TO BE REMOVED.

MATERIAL:- ALUMINIUM SHEET TO B.S. SPEC: L.16. (LATEST ISSUE)

NOTE:- FOR GENERAL ASSEMBLY OF HOSE FITTINGS SEE AG.S. 1234 SHEET 1.

TITLE ELBOW-RE-USABLE 90° END FITTINGS FOR NON-FIRE RESISTANT HOSE TO SPEC. N^o D.T.D. (R.D.I.) 3951

ISSUE 1

SR293

ALT.N^o MOD/AGS 840

MINISTRY OF SUPPLY

R.A.E APPROVAL

A.D.S.AE APPROVAL

APPLICATIONS FOR A.G.S. SHEETS TO: A.T.P.4A. THAMES HOUSE, MILLBANK, S.W.1.

SIGNATURE *C.S. Rowell*

DATE 30.8.51

SIGNATURE *G.T. Tanton*

DATE 4/9/51

GENERAL INQUIRIES TO:- A.D.S.AE. THAMES HOUSE, MILLBANK, S.W.1.

SHEET N^o 2

2

N^o OF SHEETS 6

6

A.G.S. N^o 1234

MARK	I/DIA. OF HOSE	Z	Y	X	W	V	U	T	S
A	1/8"						RAD.		
B	1/4"	.250"	.156"	.500"	.187"	.1563"	.1875"	.250"	.156"
C	3/8"	.375"	.250"	.750"	.250"	.3125"	.3125"	.375"	.250"
D	1/2"	.500"	.375"	.937"	.250"	.4375"	.4375"	.500"	.312"
E	5/8"	.625"	.500"	1.125"	.250"	.5625"	.5625"	.625"	.375"
F	3/4"	.750"	.625"	1.312"	.250"	.6875"	.6875"	.750"	.437"
G	7/8"								
H	1"	1.000"	.875"	1.687"	.250"	.9375"	.9375"	1.000"	.562"
J	1 1/4"	1.250"	1.062"	2.062"	.250"	1.1563"	1.1875"	1.250"	.687"
K	1 1/2"	1.500"	1.312"	2.437"	.250"	1.4062"	1.4375"	1.500"	.812"
L	1 3/4"								
M	2"	2.000"	1.812"	3.187"	.250"	1.9062"	1.9375"	2.000"	1.062"
P	2 1/2"								

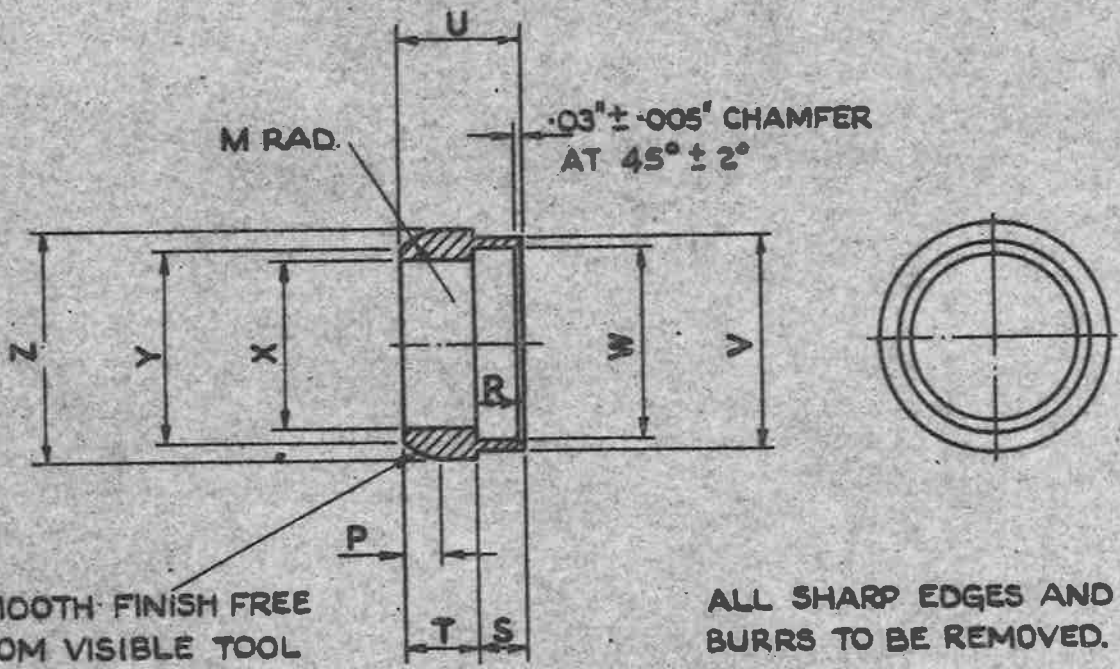
TITLE: ELBOW-RE-USABLE 90° END FITTINGS FOR NON-FIRE RESISTANT HOSE TO SPEC: N° DTD. (R.D.1) 3951

MINISTRY OF SUPPLY

APPLICATIONS FOR A.G.S. SHEETS TO: ATR 4A, THAMES HOUSE, MILLBANK, SW.1.

GENERAL INQUIRIES TO: A D S A E, THAMES HOUSE, MILLBANK, SW.1.

ISSUE	X	2
ALT. N°	MOD/AGS/AS/AGS	840 882
R.A.E. APPROVAL		AD S.A.E. APPROVAL
SIGNATURE	DATE	SIGNATURE DATE
<i>C.S. Kelly</i>	30.8.51.	<i>C.T. Gumbler</i> 4/9/51
SHEET NO	3	A.G.S. N° 1234
N° OF SHEETS	6	



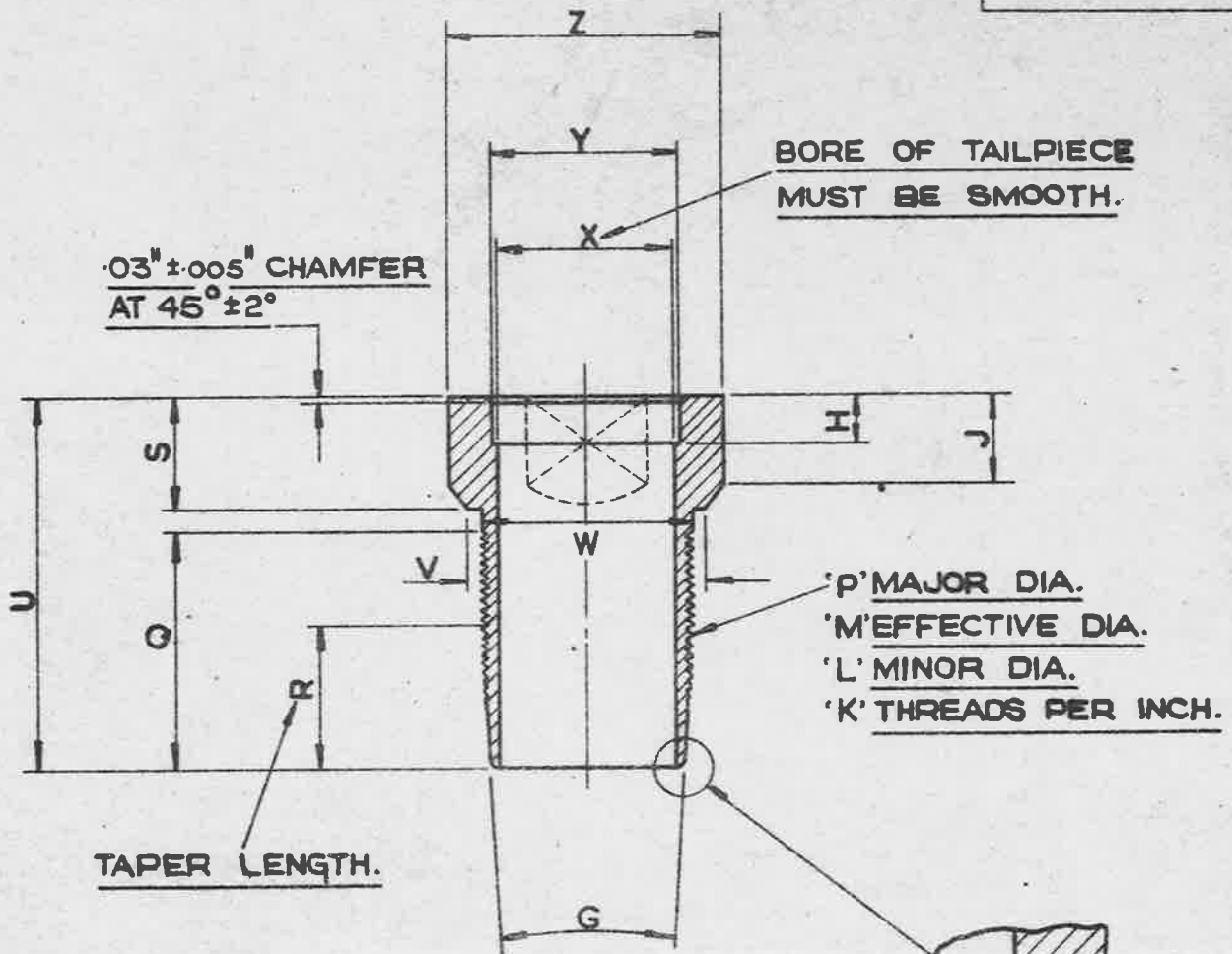
SMOOTH FINISH FREE FROM VISIBLE TOOL MARKS.

ALL SHARP EDGES AND BURRS TO BE REMOVED.

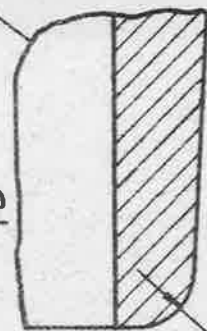
MARK	I/DIA OF HOSE	Z	Y	X	W	V	U	T	S	R	P	M
		$^{+001}_{-004}$ "	± 005 "	± 005 "	$^{+010}_{-0}$ "	± 001 "	± 005 "	± 005 "	± 005 "	± 005 "	± 005 "	± 005 "
A	1/8"											
B	1/4"	.450"	.260"	.167"	.250"	.359"	.562"	.312"	.250"	.187"	.187"	.375"
C	3/8"	.588"	.385"	.250"	.375"	.484"	.562"	.312"	.250"	.250"	.187"	.375"
D	1/2"	.733"	.510"	.375"	.500"	.609"	.562"	.312"	.250"	.250"	.187"	.375"
E	5/8"	.910"	.635"	.500"	.625"	.723"	.625"	.375"	.250"	.250"	.187"	.375"
F	3/4"	.949"	.760"	.625"	.750"	.868"	.625"	.375"	.250"	.250"	.187"	.375"
G	7/8"											
H	1"	1.192"	1.010"	.875"	1.000"	1.109"	.625"	.375"	.250"	.250"	.187"	.375"
J	1 1/4"	1.533"	1.260"	1.062"	1.250"	1.375"	.625"	.375"	.250"	.250"	.268"	.800"
K	1 1/2"	1.765"	1.510"	1.312"	1.500"	1.625"	.687"	.375"	.312"	.250"	.227"	.937"
L	1 3/4"											
M	2"	2.230"	2.010"	1.812"	2.000"	2.125"	.750"	.500"	.250"	.250"	.200"	1.216"
P	2 1/2"											

MATERIAL :- ALUMINIUM ALLOY TO SPEC: D.T.D. 346 OR 372, ALTERNATIVELY B.S. SPEC: L.61, L.60, L.59, L.17, OR L.16. (LATEST ISSUES.)

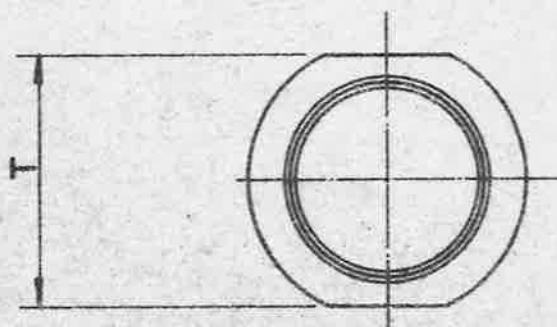
TITLE :- NIPPLE-RE-USABLE 90° END FITTINGS FOR NON-FIRE RESISTANT HOSE TO SPEC: NO D.T.D. (R.D.I) 3951. MINISTRY OF SUPPLY APPLICATIONS FOR A.G.S. SHEETS TO:- RTR4A. THAMES HOUSE, MILLBANK, S.W.1. GENERAL INQUIRIES TO:- A.D.S.A.E. THAMES HOUSE, MILLBANK, S.W.1.	ISSUE	3											
	ALT. NO.	MOD/228 915											
	R.A.E. APPROVAL		AD. S.A.E. APPROVAL										
	SIGNATURE	DATE	SIGNATURE	DATE									
SHEET NO	4	A.G.S. NO 1234.											
NO OF SHEETS	6												



SECTION OF TAILPIECE SHOWING MAXIMUM PERMITTED RADIUS THROUGHOUT RANGE.



.03" RAD. MAX.



ALL SHARP EDGES AND BURRS TO BE REMOVED.

MATERIAL:- ALUMINIUM ALLOY TO SPEC: D.T.D. 346 OR 372 ALTERNATIVELY B.S. SPEC: L.61, L.60, L.59, L17, OR L.16 (LATEST ISSUE.)

NOTE:- SCREW THREADS TO B.S. SPEC: 84 (LATEST ISSUE), MEDIUM FIT.

TITLE TAILPIECE - RE- USABLE 90° END FITTINGS FOR NON-FIRE RESISTANT HOSE TO SPEC. N° D.T.D. (R.D.I.) 3951. MINISTRY OF SUPPLY APPLICATIONS FOR A.G.S. SHEETS TO:- A.T.P.4A. THAMES HOUSE, MILLBANK, S.W.1. GENERAL INQUIRIES TO:- A.D.S.AE. THAMES HOUSE, MILLBANK, S.W.1.	ISSUE	SR 1	Z					
	ALTN. N°	MOD/AGS 640	MOD/AGS 915					
	R.A.E. APPROVAL		A.D. S.A.E. APPROVAL					
	SIGNATURE	DATE	SIGNATURE	DATE				
	<i>C.S. Rand</i>	30-8-51	<i>C.T. Yaxton</i>	4/9/51				
SHEET NO	5	A.G.S. N° 1234.						
NO OF SHEETS	6							

MARK	I/DIA OF HOSE	Z	Y	X	W	V	U	T		S	R	Q
		±.005"	+0.010" -0	±.005"	±.001"	±.005"	±.005"	MAX	MIN	±.005"	±.005"	±.005"
A	1/8"											
B	1/4"	.500"	.250"	.187"	.359"	.485"	1.687"	.445"	.438"	.437"	.375"	1.157"
C	3/8"	.610"	.375"	.312"	.484"	.610"	1.750"	.525"	.518"	.500"	.750"	1.157"
D	1/2"	.820"	.500"	.437"	.609"	.735"	1.812"	.710"	.702"	.562"	.750"	1.157"
E	5/8"	.950"	.625"	.562"	.723"	.859"	1.812"	.820"	.812"	.562"	.750"	1.157"
F	3/4"	1.060"	.750"	.687"	.868"	1.015"	1.812"	.920"	.912"	.562"	.750"	1.157"
G	7/8"											
H	1"	1.450"	1.000"	.937"	1.109"	1.266"	1.968"	1.500"	1.288"	.594"	.750"	1.282"
J	1 1/4"	1.600"	1.250"	1.125"	1.375"	1.531"	2.375"	1.480"	1.468"	.594"	1.000"	1.688"
K	1 1/2"	1.820"	1.500"	1.375"	1.625"	1.782"	2.500"	1.670"	1.658"	.594"	1.250"	1.813"
L	1 3/4"											
M	2"	2.500"	2.000"	1.875"	2.125"	2.281"	2.719"	2.220"	2.200"	.594"	1.375"	2.032"
P	2 1/2"											

MARK	P			M			L			TH'DS PER INCH	K	J	H	G
	MAJOR DIAMETER			EFFECTIVE DIAMETER			MINOR DIAMETER							
	MAX	TOL.	MIN.	MAX.	TOL.	MIN.	MAX.	TOL.	MIN.					
A														
B	.3590"	.0064"	.3526"	.3344"	.0044"	.3300"	.3098"	.0085"	.3013"	26	.312"	.187"	14°	
C	.4840"	.0064"	.4776"	.4594"	.0044"	.4550"	.4348"	.0085"	.4263"	26	-	.250"	7°	
D	.6090"	.0067"	.6023"	.5844"	.0047"	.5797"	.5598"	.0088"	.5510"	26	.437"	.250"	7°	
E	.7230"	.0067"	.7163"	.6984"	.0047"	.6937"	.6738"	.0088"	.6650"	26	.437"	.250"	7°	
F	.8680"	.0070"	.8610"	.8434"	.0050"	.8384"	.8188"	.0091"	.8097"	26	.437"	.250"	7°	
G														
H	1.1090"	.0070"	1.1020"	1.0844"	.0050"	1.0794"	1.0598"	.0091"	1.0507"	26	.469"	.250"	7°	
J	1.3750"	.0077"	1.3673"	1.3430"	.0055"	1.3375"	1.3110"	.0100"	1.3010"	20	.469"	.250"	7°	
K	1.6250"	.0077"	1.6173"	1.5930"	.0055"	1.5875"	1.5610"	.0100"	1.5510"	20	.469"	.250"	6°	
L														
M	2.1250"	.0080"	2.1170"	2.0930"	.0058"	2.0872"	2.0610"	.0103"	2.0507"	20	.407"	.250"	5°	
P														

Sm 539

TITLE:- TAIL PIECE- RE-USABLE 90° END FITTINGS FOR NON-FIRE RESISTANT HOSE TO SPEC. NO D.T.D. (R.D.I.) 3951

ISSUE *X* 2

ALT. NO. MOD/AGS/AS/ACS 840 882

MINISTRY OF SUPPLY

APPLICATIONS FOR A.G.S. SHEETS TO- ATP.4A. THAMES HOUSE, MILLBANK, S.W.1.

GENERAL INQUIRIES TO:- A.D.S.A.E. THAMES HOUSE, MILLBANK, S.W.1.

R.A.E. APPROVAL SIGNATURE *CSK ewe* DATE 30.8.51.

A.D.S.A.E. APPROVAL SIGNATURE *G.T. Ganton* DATE 4/9/51

SHEET NO 6

NO OF SHEETS 6

A.G.S. NO 1234