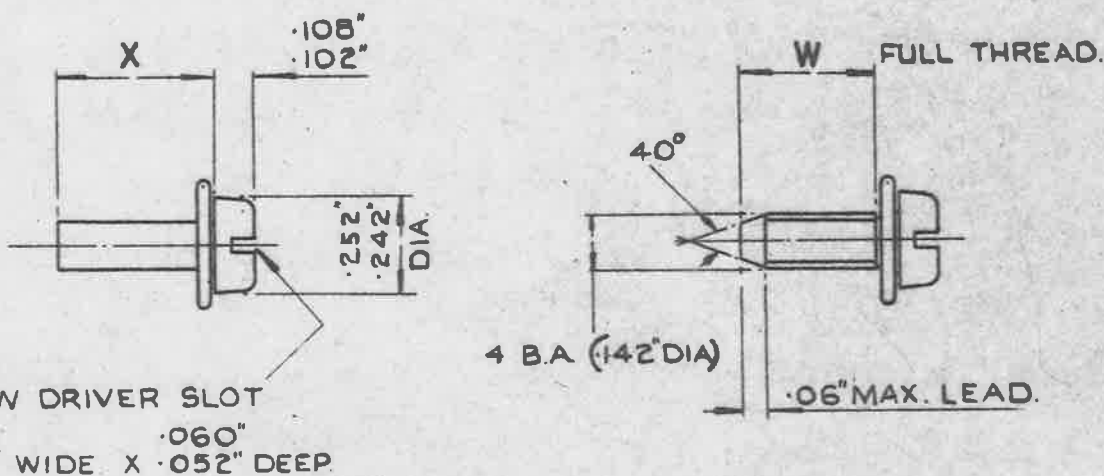


ALTERNATIVE METHOD OF MANUFACTURE WHEN THREADS ARE ROLLED AFTER ASSEMBLY OF WASHER.



ASSEMBLY OF SCREW & WASHER BEFORE ROLLING THREADS.

ASSEMBLY OF SCREW & WASHER AFTER ROLLING THREADS.

| PART N ^o | X | W | E & I 3395 PART N ^o |
|---------------------|------|------|-----------------------------------|
| 1 | .25" | .20" | 6 ^s |
| 2 | .31" | .26" | 4 ^s AND 7 ^s |
| 3 | .40" | .35" | 3 ^s AND 5 ^s |
| 4 | .50" | .45" | 2 ^s * |
| 5 | .62" | .57" | 1 ^s * |

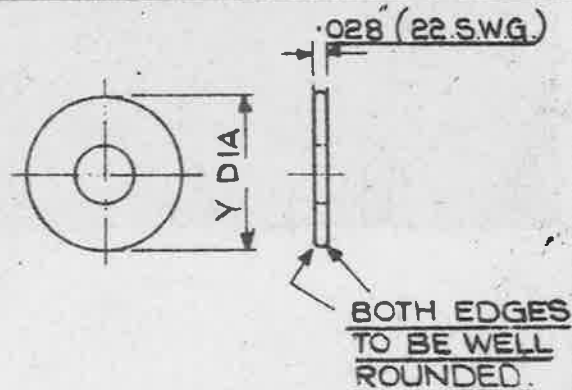
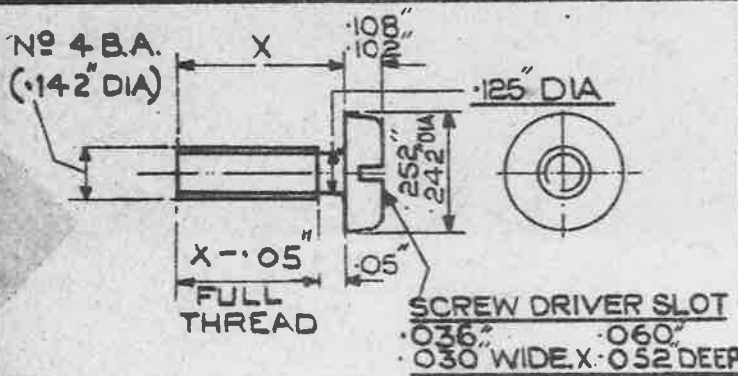
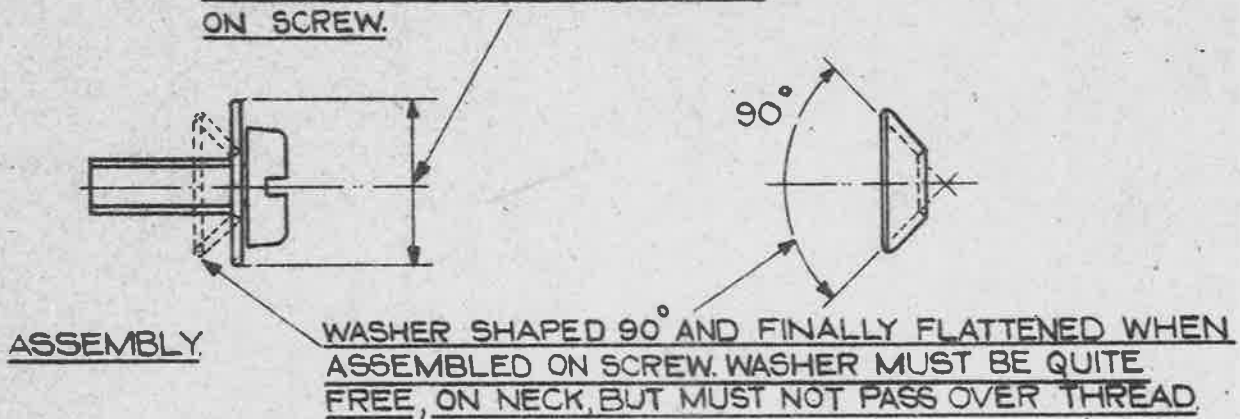
* PART NUMBERS 4 AND 5 **OBSOLESCE**
AVAILABLE AS REPLACEMENTS FOR EXISTING DESIGNS ONLY
SEE S.D.M. 230

FOR MATERIAL, FINISH, DETAILS OF WASHER AND OTHER PARTICULARS, SEE SHEET 1.

NOTE: DIAMETER OF HOLE IN WASHER TO BE SUCH THAT IT IS HELD CAPTIVE BUT FREE TO TURN AFTER ROLLING OF THREADS.

| | | | | | | |
|---|--------------------|---------------|----------------------|---------|--|--|
| TITLE COMBINED SCREW & WASHER, 4 B.A. | ISSUE | 1 | | | | |
| | ALTN. NO. | AS/AGS 941 | | | | |
| MINISTRY OF SUPPLY APPLICATIONS FOR A.G.S. SHEETS TO:- ATP 4, CHESSINGTON, SURREY GENERAL ENQUIRIES TO:- AD/SAE, ST. GILES COURT, 1-13, ST. GILES HIGH STREET, LONDON W.C. 2 | R.A.E. APPROVAL | | A.D. S.A.E. APPROVAL | | | |
| | SIGNATURE | DATE | SIGNATURE | DATE | | |
| | <i>[Signature]</i> | 28.10.52 | <i>[Signature]</i> | 12.2.53 | | |
| | SHEET NO | 2 | A.G.S. No 1753 | | | |
| NO OF SHEETS | 2 | SHEET 2 | | | | |

NOTE:- WASHER ϕ D DIMENSIONS Y TO BE FINISHED SIZE AFTER ASSEMBLY ON SCREW.



| PART N° | X | E&I 3395 PART N° | |
|---------|-------|-----------------------------------|-----------|
| 1 | .25" | 6 ^S | |
| 2 | .31" | 4 ^S AND 7 ^S | |
| 3 | .40" | 3 ^S AND 5 ^S | |
| 4 | .50" | 2 ^S | OBSOLESCE |
| 5 | .625" | 1 ^S | OBSOLESCE |

| PART N° | Y | E&I 3395 PART N° | |
|---------|------|------------------|-----------|
| A | .25" | 4 ^W | OBSOLESCE |
| B | .28" | 5 ^W | OBSOLESCE |
| C | .33" | 3 ^W | |
| D | .47" | 2 ^W | OBSOLESCE |
| E | .53" | 1 ^W | OBSOLESCE |

NOTES THESE COMBINED SCREWS & WASHERS WERE FORMERLY SHOWN ON DRG E&I 3395 TO DENOTE PART N°:- SCREW N°2 & WASHER 'C' FOR EXAMPLE, WILL BE DESIGNATED AGS.1753/2/C

MANUFACTURING PROCESS:- COLD HEADING WITH ROLLED THREAD. IF HEADS ARE MACHINED THEY ARE TO BE MADE TO DIMENSIONS GIVEN IN BS.SPEC.57.

MAT^L:- MILD STEEL.

FINISH:- CADMIUM PLATED TO SPEC: D.T.D. 904. (LATEST ISSUE). AFTER ASSEMBLY.

| | | | | | | | |
|---|--|------|-------|--------|-----------------------|--------------------------|-----------|
| ISSUED BY THE ROYAL AIRCRAFT ESTABLISHMENT. | TITLE:- COMBINED SCREW & WASHER, 4 B.A. SM 593 | | | | DRAWN J.H. BRASHER | TRACED F.M.E. 23-9-44 | |
| | ISSUE N° | X | 2 HS | 3 | 4 | CHECKED C.T. Reynolds | APPROVED. |
| | ALTER N° | MODN | AS N° | AS AGS | MODN | AS | 9-10-44 |

***OBSOLESCE** PART NUMBERS-AVAILABLE

MINISTRY OF SUPPLY

A.G.S.N^o 1753.

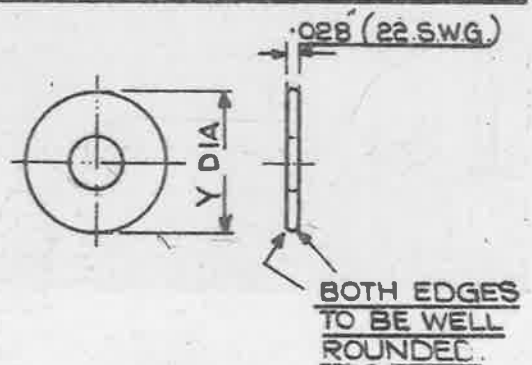
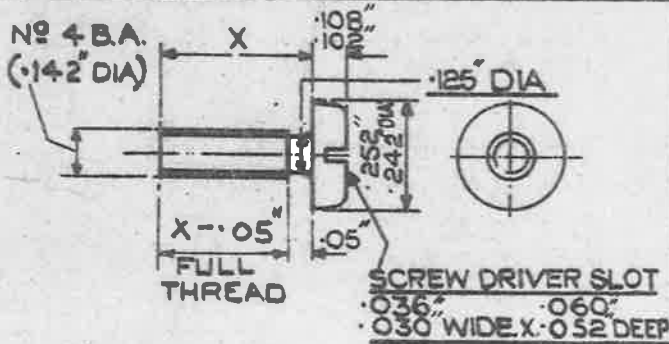
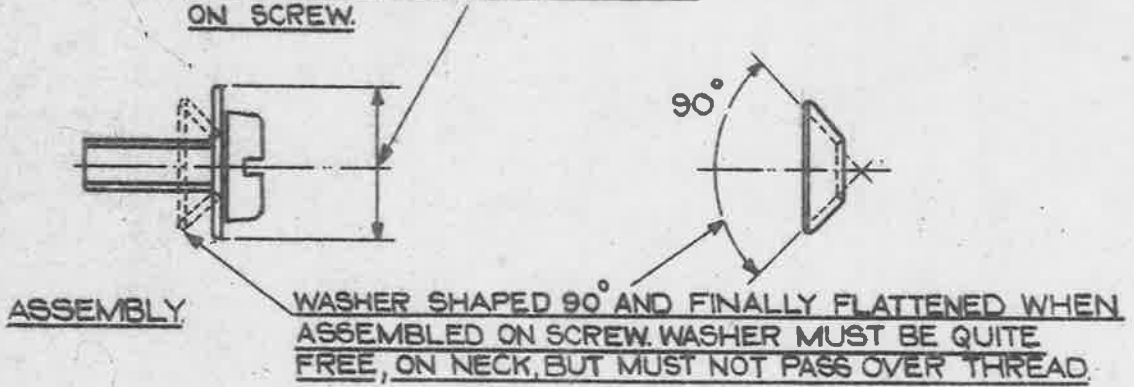
AS REPLACEMENTS FOR EXISTING DESIGNS ONLY.
SEE S.D.M. 230.

1

2

FOR ALTERNATIVE METHOD OF MANUFACTURE WHEN
THREADS ARE ROLLED AFTER ASSEMBLY OF WASHER, SEE SHEET 2.

NOTE:- WASHER ϕ D DIMENSIONS Y TO BE
FINISHED SIZE AFTER ASSEMBLY
ON SCREW.



| PART N ^o | X | E&I 3395 PART N ^o |
|---------------------|-------|-----------------------------------|
| 1 | .25" | 6 ^s |
| 2 | .31" | 4 ^s AND 7 ^s |
| 3 | .40" | 3 ^s AND 5 ^s |
| * 4 | .50" | 2 ^s |
| * 5 | .625" | 1 ^s |

| PART N ^o | Y | E&I 3395 PART N ^o |
|---------------------|------|------------------------------|
| * A | .25" | 4 ^w |
| * B | .28" | 5 ^w |
| C _x | .33" | 3 ^w |
| * D | .47" | 2 ^w |
| * E | .53" | 1 ^w |

NOTES THESE COMBINED SCREWS & WASHERS WERE
FORMERLY SHOWN ON DRG E8I 3395
TO DENOTE PART N^o: SCREW N^o2 & WASHER 'C'
FOR EXAMPLE, WILL BE DESIGNATED AGS.1753/2/C

MANUFACTURING PROCESS:- COLD HEADING WITH ROLLED THREAD.
IF HEADS ARE MACHINED THEY ARE TO BE MADE TO
DIMENSIONS GIVEN IN BS.SPEC.57.

MAT^l:- MILD STEEL.

FINISH:- CADMIUM PLATED TO SPEC: D.T.D. 904. (LATEST ISSUE).
AFTER ASSEMBLY.

ISSUED BY THE
ROYAL
AIRCRAFT
ESTABLISHMENT.

3226

COMBINED SCREW &
WASHER, 4 B.A.

J.H.BRASHER F.M.E.23-9-44

SM 533 SM 672
X 2 HS 3 # 5
MOD NR AS NO AS AGS MOD/AGS AS/AGS C.T.Reynolds
AGS/BSB AGS/77 8/1 909 941
30/1/45 30-10-45 9-10-44