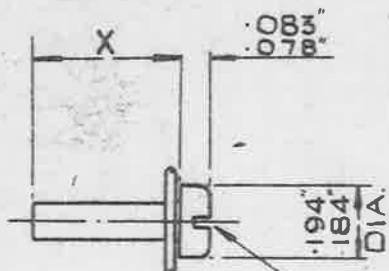
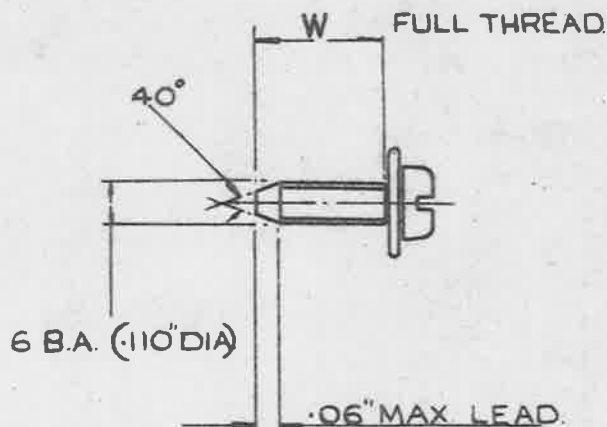


ALTERNATIVE METHOD OF MANUFACTURE WHEN THREADS ARE ROLLED AFTER ASSEMBLY OF WASHER.



SCREW DRIVER SLOT
 .028" .044"
 .024" WIDE X .038" DEEP



ASSEMBLY OF SCREW & WASHER BEFORE ROLLING THREADS

ASSEMBLY OF SCREW & WASHER AFTER ROLLING THREADS

PART N ^o	X	W	E & I 3396 PART N ^o
1	.19"	.15"	4 ^s
2	.25"	.21"	3 ^s
3	.38"	.34"	2 ^s
4	.50"	.46"	1 ^o

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.

SMGTR

TITLE COMBINED SCREW & WASHER 6 B.A.

ISSUE	1				
ALT. N ^o	As/AGS 941				
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 N ^o	2	A.G.S. No 1754 SHEET 2			
NO OF SHEETS	2				

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.

OBSOLESCE

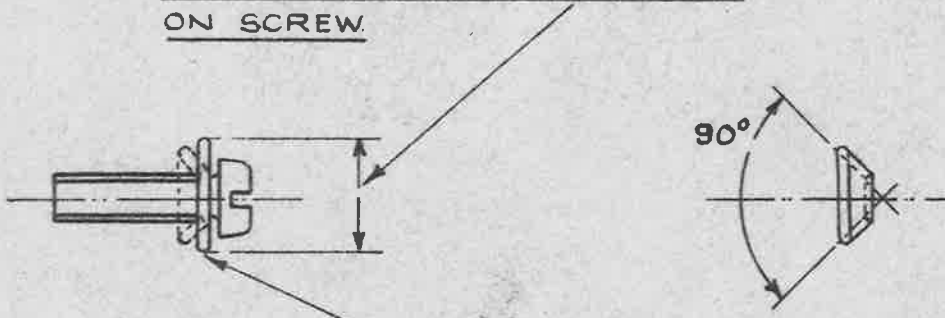
NOT TO BE USED FOR NEW DESIGNS
SEE S.D.M. 230

MINISTRY OF
SUPPLY

AGS. N^o 1754

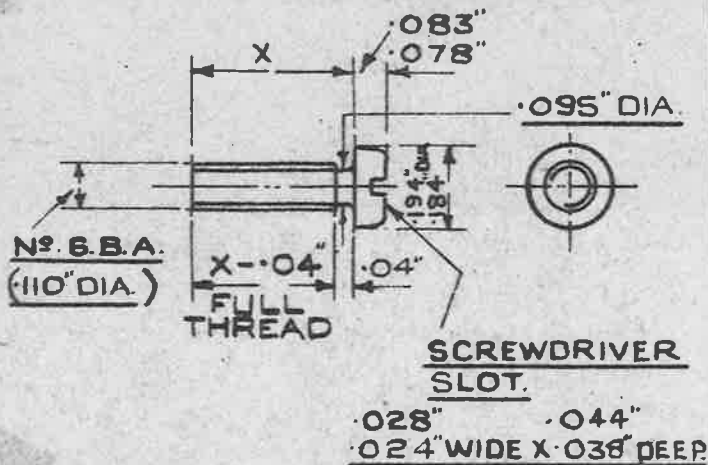
SHEET N^o 1 | N^o OF SHEETS 1

NOTE:- WASHER ^oD DIMENSIONS 'Y' TO BE
FINISHED SIZE AFTER ASSEMBLY
ON SCREW.



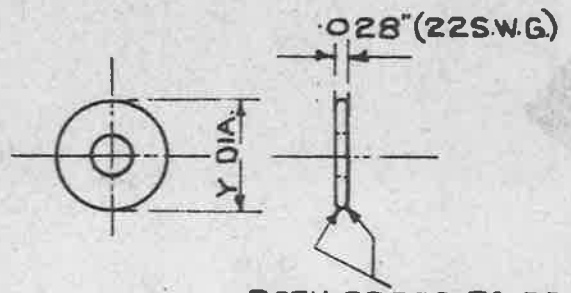
ASSEMBLY.

WASHER SHAPED 90° AND FINALLY FLATTENED WHEN
ASSEMBLED ON SCREW. WASHER MUST BE QUITE FREE
ON NECK, BUT MUST NOT PASS OVER THREAD.



SCREWDRIVER
SLOT.

.028" .044"
.024" WIDE X .038" DEEP



BOTH EDGES TO BE
WELL ROUNDED.

PART N ^o	X	E&I 3396 PART N ^o
1	.187"	4 ^s
2	.250"	3 ^s
3	.375"	2 ^s
4	.500"	1 ^s

PART N ^o	Y DIA.	E&I 3396 PART N ^o
A	.20"	2 ^w
B	.23"	3 ^w
C	.28"	1 ^w

NOTES:- THESE COMBINED SCREWS & WASHERS WERE FORMERLY
SHOWN ON DRG. E&I 3396
TO DENOTE PART N^o: SCREW N^o 2 & WASHER 'C' FOR
EXAMPLE, WILL BE DESIGNATED AGS 1754/2/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:- 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 6. B.A. 511593

DRAWN
J.H. BRASHER
TRACED
B. GODDARD
23-9-44

ISSUE N ^o	1	2	3	4
ALTER N ^o	MOD/AGS AGS/658	RS. NO AGS/377	AS/AGS 821	MOD/AGS 909

CHECKED
C.T. Reynolds
APPROVED
0-10-44

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

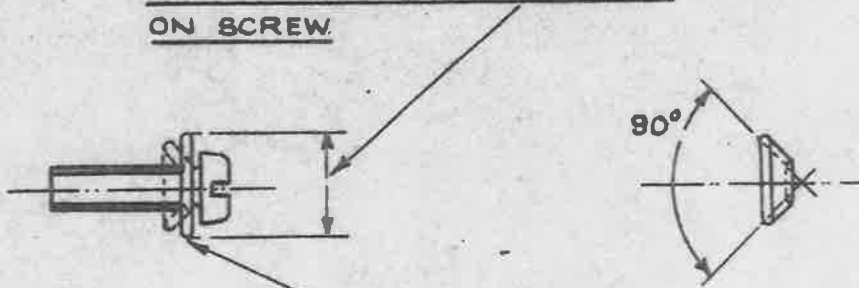
MINISTRY OF
SUPPLY

1754
2

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

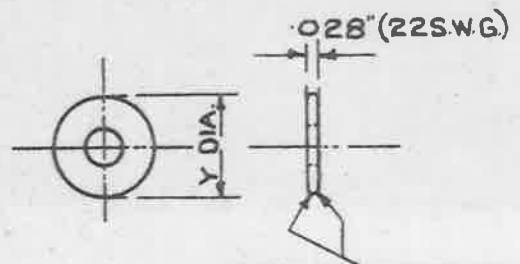
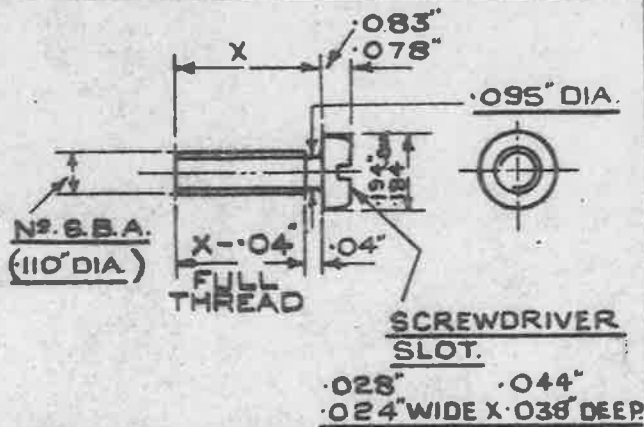
NOTE:- WASHER ϕ D DIMENSIONS 'Y' TO BE

FINISHED SIZE AFTER ASSEMBLY
ON SCREW.



ASSEMBLY.

WASHER SHAPED 90° AND FINALLY FLATTENED WHEN
ASSEMBLED ON SCREW. WASHER MUST BE QUITE FREE
ON NECK, BUT MUST NOT PASS OVER THREAD.



BOTH EDGES TO BE
WELL ROUNDED.

PART N°	X	E&I 3396 PART N°
1	.187"	4 ^s
2	.250"	3 ^s
3	.375"	2 ^s
4	.500"	1 ^s

PART N°	Y DIA.	E&I 3396 PART N°
A	.20"	2 ^w
B	.23"	3 ^w
C	.28"	1 ^w

NOTES:- THESE COMBINED SCREWS & WASHERS WERE FORMERLY
SHOWN ON DRG E&I 3396
TO DENOTE PART N°: SCREW N° 2 & WASHER 'C' FOR
EXAMPLE, WILL BE DESIGNATED AGS 1754/2/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:- MILD STEEL.

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

ISSUED BY THE
ROYAL
AIRCRAFT
ESTABLISHMENT

3226

TITLE - COMBINED SCREW &
WASHER 6. B.A.

DESIGNED BY	J. H. BRASHER	DRAWN BY	S. GODDARD
CHECKED BY	C. T. REYNOLDS	DATE	23-9-44
APPROVED BY			

SM593 SM672

MOON AS. NO. AS/AGS MOD/AGS/AGS
AGS/AGS/AGS/AGS 821 909 941

30-1-45. 30-10-45

9-10-44