



AG.S. 3012-* TO BE LEGIBLY AND DURABLY MARKED IN POSITION SHOWN. (* MARK)

ALL SHARP EDGES AND BURRS TO BE REMOVED MACHINE ALL OVER.

MATERIAL:- NON-CORR. STEEL TO SPEC. D.T.D. 525 (LATEST ISSUE)

NOTES:- 1. B.S.P. THREADS TO BE IN ACCORDANCE WITH B.S. SPEC. NO 84 (LATEST ISSUE) MEDIUM FIT, TRUNCATED.
 U.N. THREADS TO BE IN ACCORDANCE WITH B.S. SPEC. NO 1580 (LATEST ISSUE) CLASS 2A FIT.
 2. THE ECCENTRICITY BETWEEN CONE AND BORE IS NOT TO EXCEED .006" FULL INDICATOR MOVEMENT.

TITLE:- PIPE COUPLINGS (STEEL) CONE UNION ADAPTOR / UNIFIED ATTACHMENT END 3/16" TO 1/2" - FOR USE WITH PARALLEL GASKETS (eg. BONDED SEALS)

MINISTRY OF SUPPLY

APPLICATIONS FOR A.G.S. SHEETS TO:- AT. P4 BLOCK 'E', CHESSINGTON SURREY

GENERAL ENQUIRIES TO:- A.D./S.A.E. ST GILES COURT, 1-13 ST. GILES HIGH STREET, LONDON. W.C.2.

ISSUE	1				
ALT. NO.	1013				
R.A.E. APPROVAL		A.D. S.A.E. APPROVAL			
SIGNATURE	DATE	SIGNATURE	DATE		
<i>[Signature]</i>	30.5.56	<i>[Signature]</i>	21/6/56		
SHEET NO	1	A.G.S. No		3012	
NO OF SHEETS	2			SHEET I.	

COUPLING END - B.S.P.

M A R K	OUT DIA OF PIPE	Y		X	W	V	U	T	S	O	P	N	M	L		K		J		H			
		MAX.	MIN.	+01 -0	+01 -0	+0 -01	+0 -01	+0 -01	+0 -01	THD SIZE	THD SIZE	MAJOR DIAMETER	MAJOR DIAMETER	MAJOR DIAMETER	MAJOR DIAMETER	MAJOR DIAMETER	MAJOR DIAMETER	MAJOR DIAMETER	MAJOR DIAMETER	MAJOR DIAMETER	MAJOR DIAMETER	MAJOR DIAMETER	MAJOR DIAMETER
A	3/16	.6250	.6170	.85	.63	.20	1/8	.160	.03	.39	.330	.10	.015	28	.3777	.0048	.3729	.3601	.0042	.3559	.3372	.0080	.3292
B	1/4	.6875	.6795	.94	.66	.20	3/16	.224	.04	.52	.440	.14	.025	19	.5102	.0057	.5045	.4843	.0049	.4794	.4506	.0095	.4411
BB	5/16	.7500	.7420	1.00	.68	.20	15/64	.267	.04	.61	.525	.14	.025	19	.5922	.0057	.5865	.5663	.0048	.5615	.5326	.0093	.5233
C	3/8	.8125	.8045	1.07	.75	.22	19/64	.333	.04	.66	.580	.14	.025	19	.6482	.0057	.6425	.6223	.0050	.6173	.5886	.0096	.5790
CC	7/16	.8750	.8670	1.11	.79	.22	23/64	.392	.04	.75	.650	.18	.035	14	.7394	.0067	.7327	.7043	.0060	.6983	.6586	.0118	.6468
D	1/2	1.0000	.9920	1.14	.82	.22	27/64	.453	.06	.83	.723	.18	.035	14	.8144	.0067	.8077	.7793	.0056	.7737	.7336	.0109	.7227

COMPONENT END - UNIFIED

M A R K	OUT DIA OF PIPE	G	F	E	D	C	B	A	Y	XX	VV		UU	
											MAJOR DIAMETER	EFFECTIVE DIAMETER	MINOR DIAMETER	MINOR DIAMETER
A	3/16	.35	.375	.315	.610	.02	.100	.020	24	3/8	.3667	.3468	.3430	.3160
B	1/4	.40	.445	.365	.670	.02	.125	.025	20	7/16	.4281	.4037	.3995	.3671
BB	5/16	.40	.510	.430	.730	.02	.125	.025	20	1/2	.4906	.4662	.4619	.4295
C	3/8	.45	.565	.485	.790	.02	.140	.030	18	9/16	.5524	.5250	.5205	.4844
CC	7/16	.45	.625	.545	.860	.02	.140	.030	18	5/8	.6149	.5875	.5828	.5467
D	1/2	.50	.770	.660	.980	.02	.160	.030	16	3/4	.7391	.7079	.7029	.6623

TITLE: - PIPE COUPLINGS (STEEL) CONE UNION ADAPTOR / UNIFIED ATTACHMENT END, 3/16" TO 1/2" - FOR USE WITH PARALLEL GASKETS (e.g. BONDED SEALS)

MINISTRY OF SUPPLY
APPLICATIONS FOR A.G.S. SHEETS TO:-
A.T.P. 4, BLOCK 'E', CHESSINGTON, SURREY.
GENERAL ENQUIRIES TO:-
A.D./S.A.E. ST GILES COURT, 1-13
ST GILES HIGH STREET, LONDON W.C.2.

ISSUE: 1013
S R I V P
MOD/AGS

R.A.E. APPROVAL: SIGNATURE: *[Signature]* DATE: 30.9.56
A.D.S.A.E. APPROVAL: SIGNATURE: *[Signature]* DATE: 21/6/56

SHEET No: 2
No of SHEETS: 2
A.G.S. No: 3012
SHEET 2

ALL DIMENSIONS ARE IN INCHES
A.G.S. 3012 SHEET 2

A.G.S. 3012-SHEET. I.

REV	DATE	BY	CHKD
1	1/13		
2	1/13		
3	1/13		
4	1/13		

SM2024



MACHINE ALL OVER.
SEE A.G.S. NO. FOR GENERAL INFORMATION.
B.S.P.T. THREADS TO BE IN ACCORDANCE WITH B.S. SPEC. NO. 2779.
MEDIUM FIT TRUNCATED. UN. THREADS TO BE IN ACCORDANCE
WITH B.S. SPEC. NO. 1580 CLASS 2A FIT. THE ECCENTRICITY BETWEEN
CONE & BORE IS NOT TO EXCEED .006" FULL INDICATOR MOVEMENT.

APPROVED WORKING PRESSURE
BASE DIA. WORKING PRESSURE
UP TO 1/2" 5000 LB./SQ. IN.

STAINLESS STEEL
FINISH

DT D. 525
HAYBALL-60000

NO.	REV.	DATE	BY	CHKD.
1		1/13		
2		1/13		
3		1/13		
4		1/13		

NO.	REV.	DATE	BY	CHKD.
1		1/13		
2		1/13		
3		1/13		
4		1/13		

NO.	REV.	DATE	BY	CHKD.
1		1/13		
2		1/13		
3		1/13		
4		1/13		

NO.	REV.	DATE	BY	CHKD.
1		1/13		
2		1/13		
3		1/13		
4		1/13		

SM2027

A.G.S. 3012 — SHEET 2

REVISED BY THE SOCIETY OF BOILING ALUMINUM CONSTRUCTION LTD.
30 KING STREET ST. AMBROSE, LONDON, S.W.1

COUPLING END B.S.P.F.

MARK OF PIPE	H MINOR DIAMETER		J EFFECTIVE DIAMETER		K MAJOR DIAMETER		L THREADS PER INCH	M THREAD SIZE	N	P	Q	S	T	U DRILL		V	W	X	Y		
	MAX	TOL	MIN	MAX	MIN	MAX								MIN	MAX					MIN	
A 3/16	.3372	.0080	.3292	.3601	.0042	.3559	.3777	.0048	.3729	.28	.0200	.110	.330	.390	.035	.170	1	.210	.640	.860	.6250
B 1/4	.4506	.0093	.4411	.4843	.0049	.4794	.5102	.0057	.5045	19	.030	.150	.440	.520	.045	.234	3	.210	.670	.950	.6875
B-B 5/16	.5326	.0093	.5233	.5663	.0048	.5615	.5922	.0057	.5865	19	.030	.150	.525	.610	.045	.277	15	.210	.690	.910	.7500
C 3/8	.5886	.0096	.5790	.6223	.0050	.6173	.6482	.0057	.6425	19	.030	.150	.580	.660	.045	.343	19	.230	.760	.980	.8125
D 1/2	.7336	.0100	.7227	.7793	.0056	.7737	.8144	.0067	.8077	14	.040	.190	.723	.830	.065	.463	27	.250	.830	1.150	.9000

COMPONENT END UNIFIED.

MARK OF PIPE	A	B	C	D	E	F	G	THREAD SIZE	U U		V V		X X		Y Y			
									MAX	TOL	MAX	TOL	MAX	TOL		MAX	TOL	
A 3/16	.025	.110	.030	.620	.315	.375	.360	3/8 U.M.F.	.322	.0068	.3160	.3468	.0038	.3430	.3739	.0072	.3667	24
B 1/4	.030	.135	.030	.680	.365	.445	.410	1/2 U.M.F.	.374	.0078	.3671	.4037	.0042	.3995	.4362	.0081	.4281	20
B-B 5/16	.030	.135	.030	.740	.430	.510	.410	1/2 U.M.F.	.4374	.0079	.4295	.4662	.0043	.4619	.4907	.0081	.4906	20
C 3/8	.035	.150	.030	.800	.485	.565	.460	3/8 U.M.F.	.4929	.0085	.4844	.5250	.0045	.5205	.5611	.0087	.5524	18
D 1/2	.055	.170	.030	.990	.660	.770	.510	1/2 U.M.F.	.6718	.0095	.6623	.7079	.0050	.7029	.7485	.0094	.7391	16

DESIGNED BY THE SOCIETY OF BOILING ALUMINUM CONSTRUCTION LTD.
30 KING STREET ST. AMBROSE, LONDON, S.W.1

REVISIONS: DRAWN: F.A.C. CHECKED: F.A.C. DATE: _____

HT PT

PIPE COUPLERS (STEEL) SOME UNION ADAPTOR / END ATTACHMENT END BUSHES / END BUSHES / END BUSHES

A.G.S. 3012 — SHEET 2.