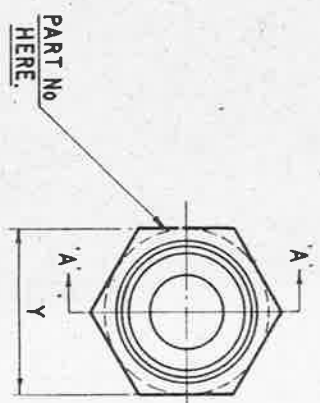
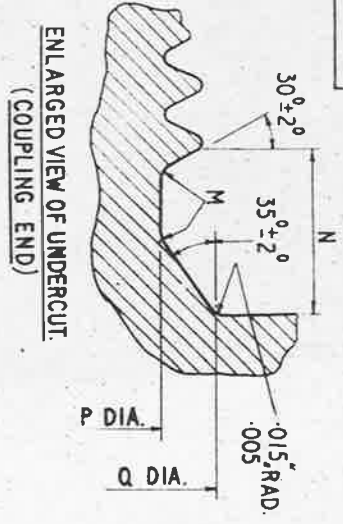


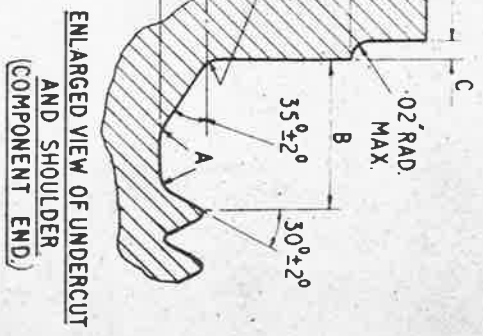
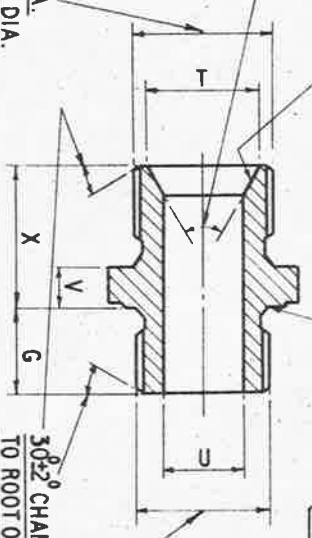
AGS. 3013 SHEET 1

UNIT PART No.	C/N
2	



SMOOTH FINISH.
FREE FROM VISIBLE
TOOL MARKS.

60 ± 10
K MAJOR DIA.
J EFFECTIVE DIA.
H MINOR DIA.
L THREADS PER INCH.



XX MAJOR DIA.
VV EFFECTIVE DIA.
UU MINOR DIA.
YY THREADS PER
INCH.

MACHINE ALL OVER.
SEE AGS. 100 FOR GENERAL INFORMATION.
BSPE THREADS TO BE IN ACCORDANCE WITH BS. SPEC. No 2779
MEDIUM FIT.
UN. THREADS TO BE IN ACCORDANCE WITH BS. SPEC. No 1580 CLASS 2A. FIT

REF.	DRAWING OR PART No.	DESCRIPTION
		STAINLESS STEEL

PIPE COUPLINGS (STEEL) UNION ADAPTOR / UNIFIED ATTACHMENT END, 3/16" TO 1/2" FOR USE WITH PARALLEL GASKETS. (E.G. BONDED SEALS)

USED ON	HT
DESIGNED	PT
DRAWN	RS 116
FAC.	NO PAINT
FAC.	SCALE
FAC.	CHECKED
FAC.	APPROVED FOR
	DATE
	LIMITS NOT SHOWN
	+0.0°

ISSUED BY THE SOCIETY OF BRITISH AIRCRAFT CONSTRUCTORS LTD.,
29, KING STREET, ST. JAMES'S, LONDON S.W.1.

AGS 3013 SHEET 1

REV	DATE	BY	DESCRIPTION
1	7-11		
2	8-26		
3	8-11-8		
4	8-11-8		
5	8-11-8		

SM 2024



ENLARGED VIEW OF UNDERCUT
(COUPLING END)



PART NO. HERE.

APPROVED WORKING PRESSURE
AGE OLD WORKING PRESSURE
UP TO 1/2 20000 L.B./SQ. IN.

NOTED AT THE QUANTITY OF BOTTLE ASSEMBLY CONSUMERS USE.
IN THIS STREET, COLUMBIAN STREET, S.W.

HT	PT	DIS. 116	NO PART

REV	DATE	BY	DESCRIPTION



SECTION A-A
COUPLING END



ENLARGED VIEW OF UNDERCUT
AND SHOULDER
(COMPONENT END)



SECTION A-A
COMPONENT END

MACHINE ALL OVER.
SEE AGS 1100 FOR GENERAL INFORMATION.
BS PF THREADS TO BE IN ACCORDANCE WITH BS SPEC. No. 2779
MEDIUM FIT, TRUNCATED.
UN THREADS TO BE IN ACCORDANCE WITH BS SPEC. No. 1580 CLASS 2A FIT

REV	DATE	BY	DESCRIPTION

AGS.3013-SHEET 2

COUPLING END - B.S.P.F.

MARK OF PIPE	O/D	H MINOR DIAMETER		J EFFECTIVE DIAMETER		K MAJOR DIAMETER		L THREADS PER INCH	M THREAD SIZE	N	P	Q	T	U DRILL	V	X	Y				
		MAX.	TOL.	MIN.	MAX.	TOL.	MIN.											MAX.	TOL.		
A	3/16"	.3372	.0080	.3292	.3601	.0042	.3559	.3777	.0048	.3729	28	1/8 B.S.P.F.	.020"	.110"	.330"	.390"	.300"	.5/32"	.210"	.660"	.6250"
B	1/4"	.4506	.0095	.4411	.4845	.0049	.4794	.5102	.0057	.5045	19	1/4 B.S.P.F.	.030"	.150"	.440"	.520"	.415"	.7/32"	.210"	.660"	.6875"
BB	5/16"	.5326	.0093	.5233	.5663	.0048	.5615	.5922	.0057	.5865	19	5/16 B.S.P.F. (ASSM)	.030"	.150"	.525"	.610"	.485"	9/32"	.210"	.730"	.7500"
C	3/8"	.5886	.0096	.5790	.6223	.0050	.6173	.6482	.0057	.6425	19	3/8 B.S.P.F.	.030"	.150"	.580"	.660"	.555"	21/64"	.230"	.750"	.8125"
CC	7/16"	.6586	.0118	.6468	.7043	.0060	.6983	.7394	.0067	.7327	14	7/16 B.S.P.F. (ASSM)	.040"	.190"	.650"	.750"	.605"	25/64"	.230"	.780"	.8750"
D	1/2"	.7336	.0109	.7227	.7793	.0056	.7737	.8144	.0067	.8077	14	1/2 B.S.P.F.	.040"	.190"	.723"	.830"	.695"	1/2"	.230"	.880"	.9200"

COMPONENT END - UNIFIED

MARK OF PIPE	O/D	A	B	C	D	E	F	G	THREAD SIZE	U U		V V		X X		Y Y			
										MINOR DIAMETER	EFFECTIVE DIAMETER	MIN.	MAX.	MIN.	MAX.		MIN.	MAX.	
A	3/16"	.025"	.110"	.030"	.620"	.315"	.375"	.360"	5/8 U.N.F.	.3228	.0068	.5160	.3468	.0038	.3430	.3739	.0072	.3667	24
B	1/4"	.030"	.135"	.030"	.680"	.365"	.445"	.410"	7/16 U.N.F.	.3749	.0078	.3671	.4037	.0042	.3995	.4362	.0081	.4281	20
BB	5/16"	.030"	.135"	.030"	.740"	.430"	.510"	.410"	1/2 U.N.F.	.4374	.0079	.4295	.4662	.0043	.4619	.4987	.0081	.4906	20
C	3/8"	.025"	.150"	.020"	.800"	.485"	.565"	.460"	9/16 U.N.F.	.4929	.0085	.4844	.5250	.0045	.5205	.5611	.0087	.5524	18
CC	7/16"	.035"	.150"	.030"	.870"	.545"	.625"	.460"	5/8 U.N.F.	.5554	.0087	.5467	.5875	.0047	.5828	.6236	.0087	.6149	18
D	1/2"	.035"	.170"	.030"	.990"	.660"	.770"	.510"	3/4 U.N.F.	.6718	.0095	.6623	.7079	.0050	.7029	.7485	.0094	.7391	16

ISSUED BY THE SOCIETY OF BRITISH AIRCRAFT CONSTRUCTORS LTD.
 18 KING STREET ST JAMES'S LONDON S W 1

HT PT SCALE ENITS SHOWN

AGS.3013-SHEET 2

COUPLING END - B.S.P.F.

MARK OF PIPE	H MINOR DIAMETER		J EFFECTIVE DIAMETER		K MAJOR DIAMETER		L THROAT PER INCH	M THREAD SIZE	N	P	Q	T	U DRILL		X	Y	
	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.							U	V			
A 3/16"	.3372	.0080	.3292	.3601	.0042	.3550	.3777	.0048	.3720	1/8 B.S.P.F.	.020"	.110"	.330"	.390"	.300"	.660"	.6250
B 1/4"	.4506	.0095	.4411	.4843	.0049	.4794	.5102	.0057	.5045	1/4 B.S.P.F.	.030"	.150"	.440"	.520"	.415"	.660"	.6875
BB 5/16"	.5326	.0093	.5233	.5663	.0048	.5615	.5922	.0057	.5865	5/16 B.S.P.F. (60 Old Whit)	.030"	.150"	.525"	.610"	.485"	.750"	.7500
C 3/8"	.5886	.0096	.5790	.6223	.0050	.6173	.6482	.0057	.6425	3/8 B.S.P.F.	.030"	.150"	.580"	.660"	.555"	.750"	.8125
D 1/2"	.7336	.0109	.7227	.7793	.0056	.7737	.8144	.0067	.8077	1/2 B.S.P.F.	.040"	.190"	.723"	.830"	.695"	.880"	.9200

COMPONENT END - UNIFIED

MARK OF PIPE	A		B		C		D		E		F		G		H THREAD SIZE	I U U		J V V		K X X		L Y Y		
	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.		U	V	MAX.	MIN.	MAX.	MIN.			
A 3/16"	.023"	.110"	.030"	.020"	.030"	.020"	.030"	.020"	.030"	.020"	.030"	.020"	.030"	.020"	3/8 U.N.F.	.3228	.0068	.3160	.3468	.0038	.3739	.0072	.3667	24
B 1/4"	.030"	.135"	.030"	.125"	.030"	.020"	.030"	.020"	.030"	.020"	.030"	.020"	.030"	.020"	7/16 U.N.F.	.3749	.0078	.3671	.4037	.0042	.3995	.0081	.4281	20
BB 5/16"	.030"	.135"	.030"	.125"	.030"	.020"	.030"	.020"	.030"	.020"	.030"	.020"	.030"	.020"	1/2 U.N.F.	.4374	.0079	.4295	.4662	.0043	.4619	.0081	.4906	20
C 3/8"	.035"	.150"	.030"	.140"	.030"	.020"	.030"	.020"	.030"	.020"	.030"	.020"	.030"	.020"	9/16 U.N.F.	.4929	.0085	.4844	.5250	.0045	.5205	.0087	.5524	18
D 1/2"	.035"	.170"	.030"	.160"	.030"	.020"	.030"	.020"	.030"	.020"	.030"	.020"	.030"	.020"	3/4 U.N.F.	.0718	.0095	.6625	.7079	.0050	.7029	.0094	.7391	16

DESIGNED BY THE SOCIETY OF BRITISH MANUFACTURING ENGINEERS LTD., 76, BOND STREET, ST. JAMES'S, LONDON, S.W. 1.

DESIGNED: DRAWN: CHECKED: DATE: 1954

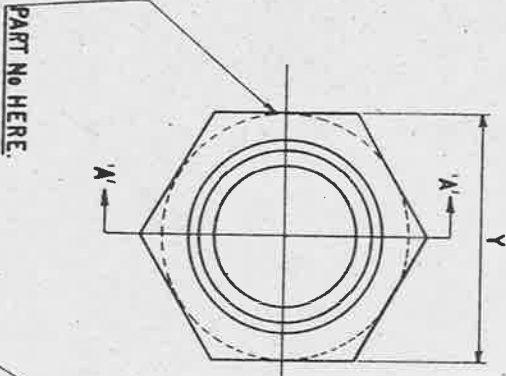
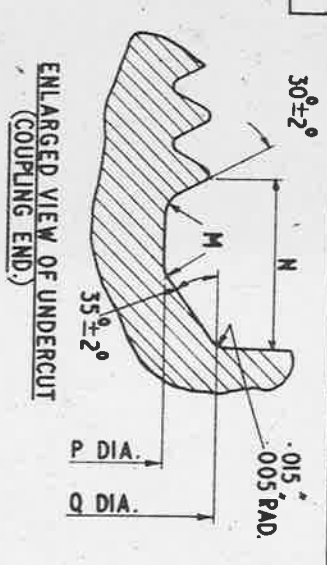
HT PT

SCALE: LIMITS NOT SHOWN

AGS.3013-SHEET 2

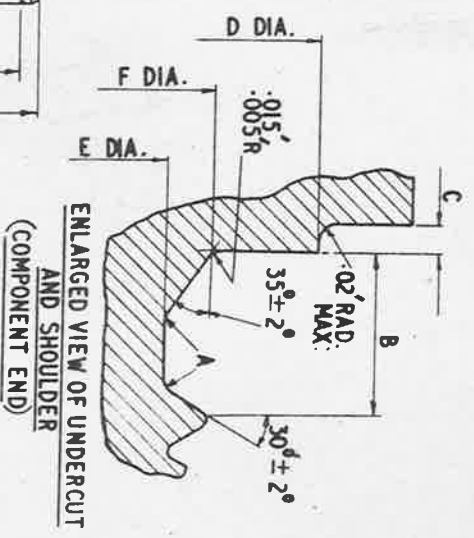
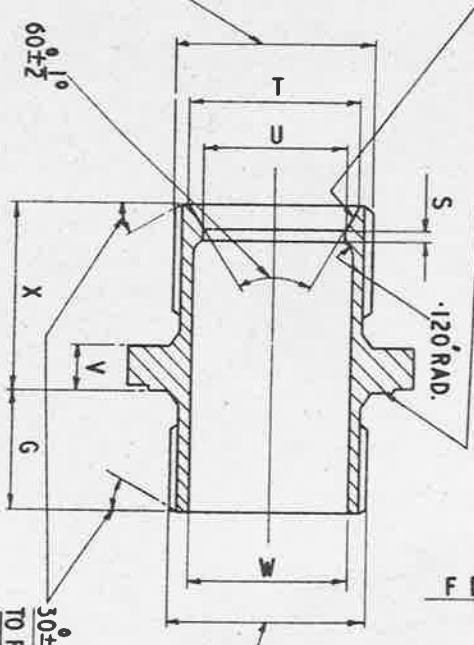
A.G.S. 3013. SHEET 3.

2. F.2.	C/N
---------	-----



K MAJOR DIA.
J EFFECTIVE DIA.
H MINOR DIA.
L THREADS PER INCH.

SMOOTH FINISH FREE FROM VISIBLE TOOL MARKS.



XX MAJOR DIA.
VV EFFECTIVE DIA.
UU MINOR DIA.
YY THREADS PER INCH.

COMPONENT END

MACHINE ALL OVER
SEE AGS. 100 FOR GENERAL INFORMATION
B.S.P.F. THREADS TO BE IN ACCORDANCE WITH B.S. SPEC. No. 2779. MEDIUM FIT.
U.N. THREADS TO BE IN ACCORDANCE WITH B.S. SPEC. No. 1580. CLASS 2 A. FIT.

DESIGNED	DRAWN	TRACED	CHECKED	APPROVED FOR	DATE	PIPE COUPLINGS (STEEL UNION ADAPTER) (UNITED KINGDOM) (FOR USE WITH PARALLEL) (AGS. 3013. SHEET 3)
F.A.C.	F.A.C.	F.A.C.	F.A.C.	F.A.C.	15.5.58	
DESIGNED		DRAWN		TRACED		CHECKED
F.A.C.		F.A.C.		F.A.C.		F.A.C.
APPROVED FOR		DATE		PIPE COUPLINGS (STEEL UNION ADAPTER) (UNITED KINGDOM) (FOR USE WITH PARALLEL) (AGS. 3013. SHEET 3)		GASKETS (3) BONDED SEALS.
HT		PT		RS 116		NO PAINT
DRAWING OR PART No.		SCALE		DESCRIPTION		LIMITS SHOWN
STAINLESS STEEL				D.T.D. S.S.		MATERIAL SEPARATE
THIRD ANGLE PROJECTION						

ISSUED BY THE SOCIETY OF BRITISH AIRCRAFT CONSTRUCTORS LTD.
29, KING STREET, ST. JAMES'S, LONDON S.W.1.

A.G.S. 3013, SHEET 3.

REV	DESCRIPTION
1	AS SHOWN
2	1-1
3	F 25
4	F 10
5	F 10



ENLARGED VIEW OF UNDERCUT (COUPLING END)

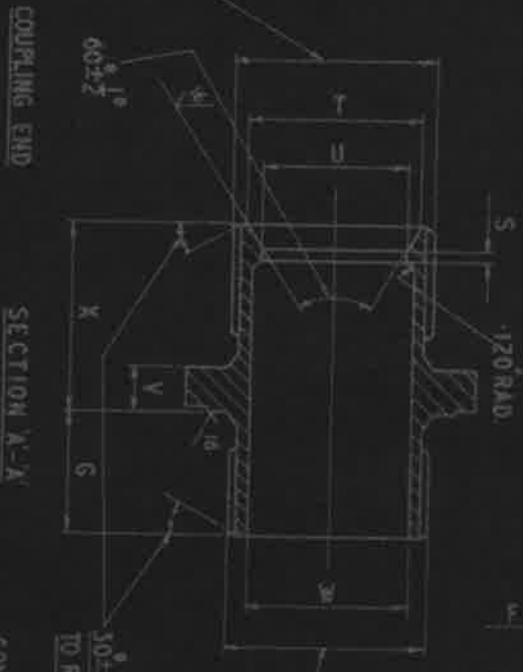


ENLARGED VIEW OF UNDERCUT AND SHOULDER (COMPONENT END)



PART No HERE

K MAJOR DIA.
J EFFECTIVE DIA.
H MINOR DIA.
L THREADS PER INCH.



SECTION A-A

XX MAJOR DIA.
VV EFFECTIVE DIA.
UU MINOR DIA.
YY THREADS PER INCH

30°±2° CHAMFER TO ROOT OF THREAD.

COMPONENT END

APPROVED WORKING PRESSURE
500 LBS/SQ IN.

MACHINE ALL OVER
PER A.S. 100 FOR GENERAL INFORMATION
B.S.P. THREADS TO BE IN ACCORDANCE WITH B.S. SPEC. NO. 2779 MEDIUM FIT TRUNCATED
U.N. THREADS TO BE IN ACCORDANCE WITH B.S. SPEC. NO. 1580 CLASS 2 A FIT.

DESIGNED BY	DRWING OR	SCALE	DATE	REVISED	BY	DATE	REVISED	BY	DATE	REVISED	BY	DATE
AGS	SPRINKLER STEEL	1:1										
APPROVED	DESCRIPTION	UNIT	QTY	REVISED	BY	DATE	REVISED	BY	DATE	REVISED	BY	DATE

AGS 3013, SHEET 3.

M

C/N
2 F2

COUPLING END - B.S.P.F.

MARK OF PIPE	H MINOR DIAMETER		J EFFECTIVE DIAMETER		K MAJOR DIAMETER		L THD. PER INCH	M THD. SIZE	N	P	Q	S	T	U DRILL		V	W	X	Y		
	MAX.	TOL.	MIN.	MAX.	TOL.	MIN.								MAX.	MIN.					MAX.	
E 5/8"	.8106"	.0109"	.7997"	.8563"	.0056"	.8507"	.8914"	.0067"	.8847"	14	5/8 B.S.P.F.	.040"	.190"	.800"	.910"	.070"	.765"	.250"	.660"	.950"	.1250"
F 3/4"	.9496"	.0113"	.9383"	.9953"	.0060"	.9893"	.0304"	.0067"	.0237"	14	3/4 B.S.P.F.	.040"	.190"	.935"	.1050"	.070"	.905"	.250"	.830"	1000"	.3125"
G 7/8"	1.0976"	.0114"	1.0862"	1.1433"	.0061"	1.1372"	1.1784"	.0067"	1.1717"	14	7/8 B.S.P.F.	.040"	.190"	1.085"	1.190"	.090"	1.045"	.270"	.910"	1.070"	.4375"
H 1"	1.1926"	.0125"	1.1801"	1.2508"	.0065"	1.2443"	1.2956"	.0078"	1.2878"	11	1" B.S.P.F.	.050"	.240"	1.180"	1.310"	.090"	1.135"	.270"	1.030"	1.070"	.6250"

COMPONENT END - UNIFIED

MARK OF PIPE	A	B	C	D	E	F	G	THREAD SIZE	U-U MINOR DIAMETER		V-V EFFECTIVE DIAMETER		X-X MAJOR DIAMETER		Y-Y THDS PER INCH			
									MAX.	TOL.	MIN.	MAX.	MIN.	MAX.				
E 5/8"	.040"	.190"	.040"	1.110"	.775"	.885"	.560"	7/8 U.N.F.	.7858"	.0105"	.7753"	.8270"	.0054"	.8216"	.8734"	.0103"	.8631"	14
F 3/4"	.045"	.220"	.040"	1.300"	.945"	1.075"	.660"	1 1/16 U.N.S.	.9586"	.0117"	.9469"	1.0067"	.0057"	1.0010"	1.0608"	.0114"	1.0494"	12
G 7/8"	.045"	.220"	.040"	1.420"	1.070"	1.200"	.660"	1 1/8 U.N.S.	1.0836"	.0117"	1.0719"	1.1317"	.0057"	1.1260"	1.1858"	.0114"	1.1744"	12
H 1"	.045"	.220"	.040"	1.610"	1.195"	1.325"	.660"	1 1/2 U.N.S.	1.2085"	.0119"	1.1966"	1.2566"	.0059"	1.2507"	1.3107"	.0114"	1.2993"	12

ISSUED BY THE SOCIETY OF BRITISH AIRCRAFT CONSTRUCTORS LTD.,
28, KING STREET, ST. JAMES'S, LONDON S.W. 1.

DESIGNED BY: DRAWN BY: CHECKED BY: DATE: 1/5/58

SCALE: 3/4" = 1"

LIMITS NOT SHOWN UNLESS OTHERWISE SPECIFIED

PIPE COUPLINGS (STEEL) UNION ADAPTOR (UNIFIED ATTACHMENT END, 5/8 TO 1" FOR USE WITH PARALLEL GASKETS (e.g. BRONDEE SEALS))

A.G.S. 3013-SHEET 4

SHEET C-18-230

SM2027

COUPLING END - B.S.P.F.

MARK OF PIPE	H MINOR DIAMETER TOL.		J EFFECTIVE DIAMETER TOL.		K MAJOR DIAMETER TOL.		L THDS PER INCH	M THD SIZE	N	P	Q	S	T	U DRILL	V	W	X	Y
	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.												
E 5/8	.8106	-.0109	-.7997	-.8563	-.0056	-.8507	14	5/8	.190	-.800	-.910	-.070	-.765	5/8	-.250	-.660	-.950	1250
F 3/4	.9496	-.0113	-.9383	-.9953	-.0060	-.9893	14	3/4	.180	-.795	-.900	-.050	-.755	3/4	-.230	-.640	-.930	1150
H 1"	1.1926	-.0125	1.1801	1.2508	-.0065	1.2443	11	1"	.240	1.180	1.310	-.090	1.135	1 1/16	-.270	1.030	1.070	1620

COMPONENT END - UNIFIED

MARK OF PIPE	A		B		C		D		E		F		G		H THRD. PER INCH	I THD. SIZE	U-U MINOR DIAMETER TOL.		V-V EFFECTIVE DIAMETER TOL.		X-X MAJOR DIAMETER TOL.		Y-Y THDS PER INCH
	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.			MAX.	MIN.	MAX.	MIN.			
E 5/8	.040	-.190	.040	1.110	.775	.895	.560	7/8	.7858	.0105	.7753	.8270	-.0034	.8216	-.8734	.0103	.8631	14					
F 3/4	.045	-.220	.040	1.300	.945	1.075	.660	1 1/16	.9586	.0117	.9469	1.0067	-.0057	1.0010	1.0608	.0114	1.0494	12					
H 1"	.045	-.220	.040	1.610	1.195	1.325	.660	5/8	1.2085	.0119	1.1966	1.2566	-.0059	1.2507	1.3107	.0114	1.2993	12					

DESIGNED BY: H.T. DRAWN BY: F.A.C. CHECKED BY: F.A.C. DATE: 5.5.57

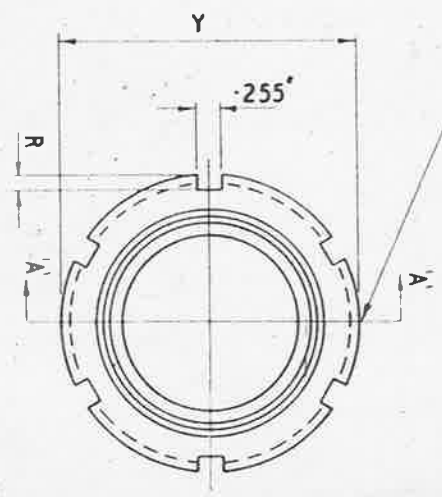
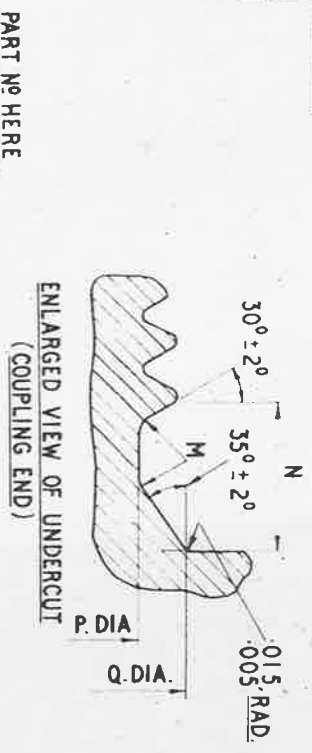
SCALE: H.T. PT. SCALE: 1:1

PIPE COUPLINGS (STEEL) UNION ADAPTOR (UNIFIED ATTACHMENT END, 5/8 TO 1 FOR USE WITH PARALLEL GASKETS (e.g. GRONDED SEALS).)

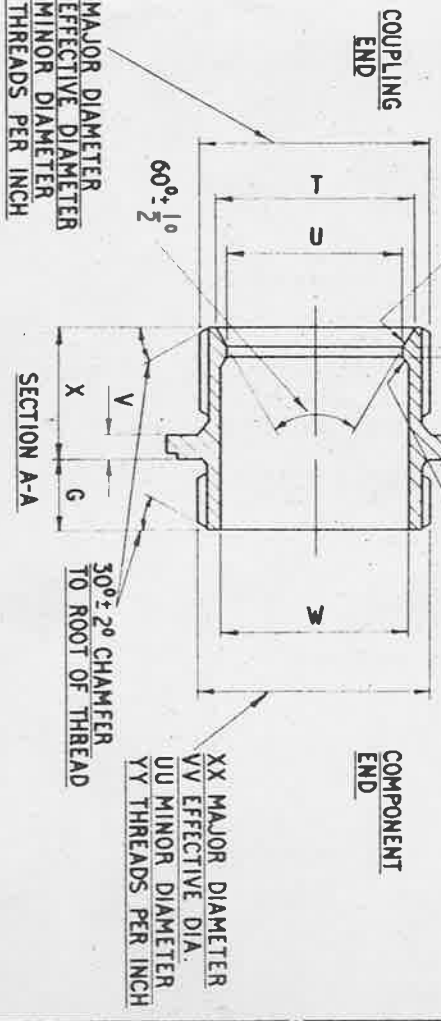
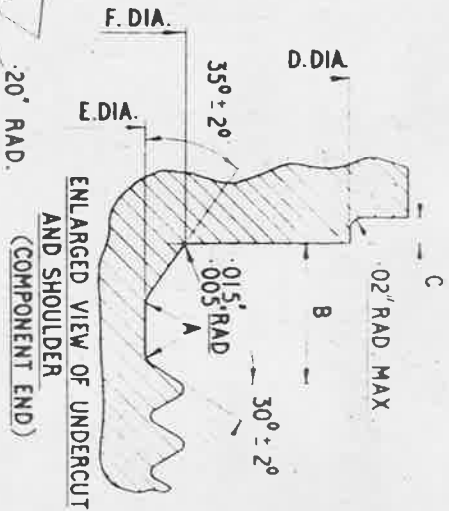
A.G.S. 3013-SHEET 4

A.G.S. 3013-SHEET 5

REVISED	DATE	BY
2		



SMOOTH FINISH
FREE FROM VISIBLE
TOOL MARKS



K MAJOR DIAMETER
J EFFECTIVE DIAMETER
H MINOR DIAMETER
L THREADS PER INCH

XX MAJOR DIAMETER
VV EFFECTIVE DIA.
UU MINOR DIAMETER
YY THREADS PER INCH

MACHINE ALL OVER
SEE A.G.S. 100 FOR GENERAL INFORMATION.
BS.PE. THREADS TO BE IN ACCORDANCE WITH B.S. SPEC. 2779,
MEDIUM FIT.
UN. THREADS TO BE IN ACCORDANCE WITH B.S. SPEC. 1580,
CLASS 2. A. FIT.

REF.	DRAWING OR PART NO.	DESCRIPTION	STAINLESS STEEL

REF.	DRAWING OR PART NO.	DESCRIPTION	STAINLESS STEEL

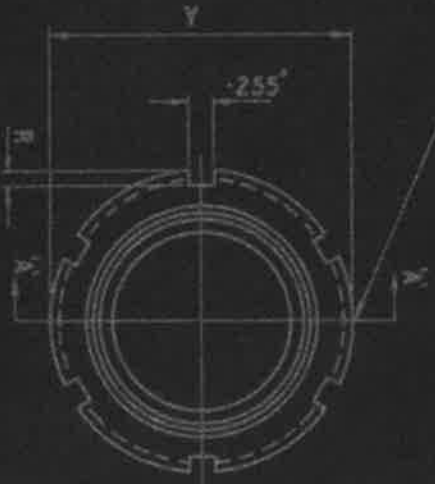
DESIGNED	SCALE	LIMITS
F.A.C.	1:1	± 0.10"
DRAWN	CHECKED	DATE
F.A.C.	F.A.C.	1/5 58
ISSUED BY THE SOCIETY OF BRITISH AIRCRAFT CONSTRUCTORS LTD.		
29 KING STREET, ST. JAMES'S, LONDON, S.W. 1		

A.G.S. 3013. SHEET 5.

A.G.S. 3013-SHEET 5

REV.	DATE	BY	CHKD.
1	7-11		
2	7-26		
3	8-18		
4	8-18		
5	7-23		

SM 2024



X MAJOR DIAMETER
Y EFFECTIVE DIAMETER
Z MINOR DIAMETER
L THREADS PER INCH

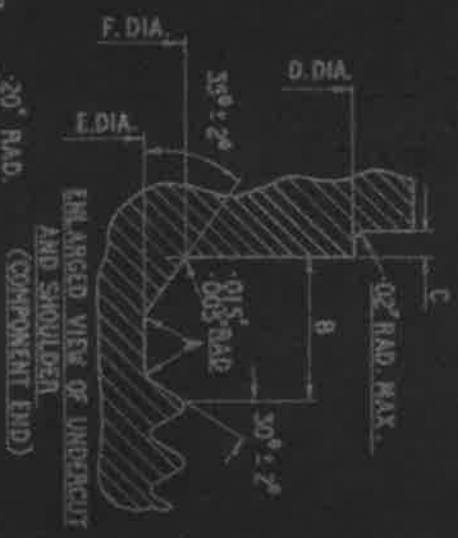
COUPLING END



SECTION A-A

30° ± 2° CHAMFER TO FOOT OF THREAD

COMPONENT END



XX MAJOR DIAMETER
YY EFFECTIVE DIA.
UU MINOR DIAMETER
VY THREADS PER INCH

APPROVED WORKING PRESSURE
PIPE O.D. WORKING PRESSURE
1 1/4 TO 2" 300 LB./SQ. IN.

MACHINE ALL OVER.
SEE A.G.S. 100 FOR GENERAL INFORMATION.
B.S.P.F. THREADS TO BE IN ACCORDANCE WITH B.S. SPEC. 2779.
MEDIUM FIT, TRUNCATED.
U.N. THREADS TO BE IN ACCORDANCE WITH B.S. SPEC. 1580.
CLASS 2, A. FIT.

STAINLESS STEEL	0170 / 525
WORKING PRESSURE	
THIRD ANGLE PROJECTION	

HT	PT	SCALE	LIMITS	FINISH	TEMP.	STRESS	TEST	REMARKS
	R.S. 119		± 0.10"					
	NO. OF TAPS							
	DRIVEN							
	TAPPED							
	DRIVEN							
	DRIVEN							
	DRIVEN							
	DRIVEN							

DESIGNED BY THE SOCIETY OF METALLURGICAL ENGINEERS LTD.,
18, BEECH STREET, ST. LEONARD'S, LONDON, E.W.1.

C/N
2 FZ

COUPLING END - B.S.P.F.

MARK OF PIPE	H MINOR DIAMETER		J EFFECTIVE DIAMETER		K MAJOR DIAMETER		L THDS PER INCH	M THREAD SIZE	N	P	Q	R	S	T	U DRILL	V	W	X	Y	
	MAX.	TOL.	MIN.	MAX.	MIN.	MAX.														MIN.
J	1.5336	.0129	1.5207	1.5918	0.0069	1.5849	1.6366	0.0078	1.6288	1.4	1.520	1.660	1.45	0.90	1.455	3/16	.270	1.310	1.120	2.160
K	1.7656	.0132	1.7524	1.8238	0.0072	1.8166	1.8686	0.0078	1.8608	1 1/2	1.750	1.890	1.45	1.10	1.685	7/16	.270	1.570	1.160	2.370
L	1.9996	.0133	1.9863	2.0578	0.0073	2.0506	2.1026	0.0078	2.0948	3/4	1.985	2.120	1.70	1.10	1.925	5/8	.270	1.810	1.260	2.850
M	2.2306	.0134	2.2172	2.2888	0.0073	2.2815	2.3336	0.0078	2.3258	2	2.240	2.380	1.50	1.10	2.195	7/8	.270	2.030	1.310	3.160

COMPONENT END-UNIFIED

MARK OF PIPE	A	B	C	D	E	F	G	H THREAD SIZE	U U		V V		X X		Y Y THREADS PER INCH		
									MINOR DIAMETER	EFFECTIVE DIAMETER	MINOR DIAMETER	EFFECTIVE DIAMETER	MINOR DIAMETER	EFFECTIVE DIAMETER			
J	1.045	.035	2.20	.050	2.010	1.505	1.635	5/8	1.5210	.0119	1.5091	1.5691	0.0059	1.5632	0.014	1.6118	12
K	1.045	.035	2.20	.050	2.210	1.755	1.885	1 7/8	1.7710	.0119	1.7591	1.8191	0.0059	1.8132	0.014	1.8618	12
L	1.045	.035	2.20	.050	2.710	2.130	2.250	2 1/4	2.1459	.0122	2.1337	2.1940	0.0062	2.1878	0.014	2.2367	12
M	1.045	.035	2.20	.050	3.010	2.380	2.500	2 1/2	2.3959	.0122	2.3837	2.4440	0.0062	2.4378	0.014	2.4867	12

ISSUED ON _____ H.T. _____ P.T. _____ SCALE _____ LIMITS _____

DESIGNED _____ DRAWN _____ FACED _____ TRACED _____ CHECKED _____

DATE _____

PIPE COUPLINGS (STEEL) UNION ADAPTOR UNIFIED ATTACHMENT ENDS, 1/4" TO 2". FOR USE WITH PARALLEL CASSETS (SEE BONDED SEALS)

AGS. 3013 - SHEET 6

REV	DATE	BY
2	F.72	

COUPLING END - B.S.P.F.

MARK OF PIPE	H MINOR DIAMETER		J EFFECTIVE DIAMETER		K MAJOR DIAMETER		L THROTS PER INCH	M THREAD SIZE	N	P	Q	R	S	T	U DRILL		V	W	X	Y	
	MAX.	TOL.	MIN.	MAX.	MIN.	MAX.									MIN.	MAX.					MIN.
J 1 1/4	1.5336	-.0129	1.5207	1.5918	1.5949	1.6366	0.0781	1.6288	1 1/4	0.50	2.40	1.520	1.660	1.45	0.90	1.455	1.16	2.70	1.310	1.120	2.160
K 1 1/2	1.7656	-.0132	1.7524	1.8238	1.8166	1.8685	0.0781	1.8608	1 1/2	0.50	2.40	1.750	1.890	1.45	1.10	1.685	1.16	2.70	1.570	1.160	2.370
L 1 3/4	1.9996	-.0133	1.9863	2.0578	2.0505	2.1026	0.0781	2.0948	1 3/4	0.50	2.40	1.985	2.120	1.70	1.10	1.925	1.18	2.70	1.810	1.260	2.850
M 2	2.2306	-.0134	2.2172	2.2888	2.2815	2.3336	0.0781	2.3258	2	0.50	2.40	2.215	2.350	1.70	1.10	2.155	1.18	2.70	2.030	1.310	3.160

COMPONENT END - UNIFIED

MARK OF PIPE	A	B	C	D	E	F	G	H T	I UNITS NOT SHOWN	J DATE	U U		V V		X X		Y Y	
											MINOR DIAMETER	EFFECTIVE DIAMETER	MINOR DIAMETER	EFFECTIVE DIAMETER	MINOR DIAMETER	EFFECTIVE DIAMETER		
J 1 1/4	0.45	0.20	0.50	2.010	1.505	1.635	0.660	1 7/8	1.5210	0.119	1.5091	1.5091	1.5091	1.5632	1.6232	0.114	1.6118	12
K 1 1/2	0.45	0.20	0.50	2.210	1.755	1.885	0.660	1 7/8	1.7710	0.119	1.7591	1.7591	1.7591	1.8132	1.8732	0.114	1.8618	12
L 1 3/4	0.45	0.20	0.50	2.710	2.130	2.250	0.660	2 1/4	2.1459	0.122	2.1337	2.1337	2.1337	2.1940	2.2481	0.114	2.2367	12
M 2	0.45	0.20	0.50	3.010	2.580	2.500	0.660	2 1/2	2.3959	0.122	2.3837	2.3837	2.3837	2.4440	2.4981	0.114	2.4867	12

DESIGNED	DRAWN	TRACED	CHECKED	APPROVED
PAC	PAC	PAC	PAC	PAC
SCALE	SCALE	SCALE	SCALE	SCALE
1/2"	1/2"	1/2"	1/2"	1/2"
DATE	DATE	DATE	DATE	DATE
1/8-5-57	1/8-5-57	1/8-5-57	1/8-5-57	1/8-5-57

PIPE COUPLINGS (STEEL) UNION ADAPTOR / UNIFIED ATTACHMENT END, 1/4" TO 2" FOR USE WITH PARALLEL GASKETS (EN BONDED SEALS)

AGS 3013 - SHEET 6

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

MINISTRY OF SUPPLY
 R.A.E. APPROVAL
 A.D./S.A.E. APPROVAL
 ISSUE SR 14
 ALING 1013

SIGNATURE DATE 30.5.56
 SIGNATURE DATE 21/6/56
 SHEET NO 2
 NO OF SHEETS 6
 A.G.S. No 3013
 SHEET 2

COUPLING END - B.S.P.

MARK	OUT DIA OF PIPE	Y		X	V	U	T	Q	P	N	M	L	K		J		H				
		MAX.	MIN										MAJOR DIAMETER	EFFECTIVE DIAMETER	MAJOR DIAMETER	EFFECTIVE DIAMETER	MINOR DIAMETER	MINOR DIAMETER	MINOR DIAMETER	MINOR DIAMETER	
A	3/16	.6250	.6170	.65	.20	5/32	.295	.39	.330	.10	.015	28	.3777	.0048	.3729	.3601	.0042	.3559	.3372	.0080	.3292
B	1/4	.6875	.6795	.65	.20	7/32	.410	.52	.440	.14	.025	19	.5102	.0057	.5045	.4843	.0049	.4794	.4506	.0095	.4411
BB	5/16	.7500	.7420	.72	.20	9/32	.480	.61	.525	.14	.025	19	.5922	.0057	.5865	.5663	.0048	.5615	.5326	.0093	.5233
C	3/8	.8125	.8045	.74	.22	21/64	.550	.66	.580	.14	.025	19	.6482	.0057	.6425	.6223	.0050	.6173	.5886	.0096	.5790
CC	7/16	.8750	.8670	.77	.22	25/64	.600	.75	.650	.18	.035	14	.7394	.0067	.7327	.7043	.0060	.6983	.6586	.0118	.6468
D	1/2	1.0000	.9920	.87	.22	1/2	.690	.83	.723	.18	.035	14	.8144	.0067	.8077	.7793	.0056	.7737	.7336	.0109	.7227

COMPONENT END - UNIFIED

MARK	OUT DIA OF PIPE	G		F	E	D	C	B	A	THD	T	XX		VV		UU				
		MAX.	MIN									MAJOR DIAMETER	EFFECTIVE DIAMETER	MAJOR DIAMETER	EFFECTIVE DIAMETER	MINOR DIAMETER	MINOR DIAMETER	MINOR DIAMETER	MINOR DIAMETER	
A	3/16	.35	.375	.315	.610	.02	.100	.020	5/8	UN.F.	24	.3739	.0072	.3667	.3468	.0038	.3430	.3228	.0068	.3160
B	1/4	.40	.445	.365	.670	.02	.125	.025	7/16	UN.F.	20	.4362	.0081	.4281	.4037	.0042	.3995	.3749	.0078	.3671
BB	5/16	.40	.510	.430	.730	.02	.125	.025	1/2	UN.F.	20	.4987	.0081	.4906	.4662	.0043	.4619	.4374	.0079	.4295
C	3/8	.45	.565	.485	.790	.02	.140	.030	9/16	UN.F.	18	.5611	.0087	.5524	.5250	.0045	.5205	.4929	.0085	.4844
CC	7/16	.45	.625	.545	.860	.02	.140	.030	1 1/8	UN.F.	18	.6236	.0087	.6149	.5875	.0047	.5828	.5554	.0087	.5467
D	1/2	.50	.770	.660	.980	.02	.160	.030	1 1/4	UN.F.	16	.7485	.0094	.7391	.7079	.0050	.7029	.6718	.0095	.6623

AGS DIMENSIONS IN INCHES
 AGS 3013 SHEET 2

MINISTRY OF SUPPLY
 APPLICATIONS FOR A.G.S. SHEETS TO:-
 A.T.P. 4 BLOCK 'E', CHESSINGTON, SURREY.
 GENERAL ENQUIRIES TO:-
 AD/SAE, 51 GILES COURT, 1-13
 51 GILES HIGH STREET, LONDON W.C.2.

ISSUE 5R 1477
 ALT No 10135
 MOD/AGS
 R.A.E. APPROVAL
 A.D. S.A.E. APPROVAL
 SIGNATURE
 DATE 30.9.56
 SIGNATURE
 DATE 21/6/56
 A.G.S. No 3013
 SHEET No 4
 NO OF SHEETS 6
 SHEET 4
 SHEET 6

COUPLING END - B.S.P.

MARK	OUT DIA OF PIPE	Y		X	W	V	U	T	S	Q	P	N	M	L	K		J		H				
		MAX	MIN												MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	
E	5/8	1.1250	1.1150	.94	.65	.24	5/8	.760	.06	.91	.800	.18	.035	14	.8914	.0067	.8847	.8563	.0056	.8507	.8106	.0109	.7997
F	3/4	1.3125	1.3005	.99	.82	.24	3/4	.900	.06	1.05	.935	.18	.035	14	1.0304	.0067	1.0237	.9953	.0060	.9893	.9496	.0113	.9383
G	7/8	1.4375	1.4225	1.06	.90	.26	7/8	1.040	.08	1.19	1.085	.18	.035	14	1.1784	.0067	1.1717	1.1433	.0061	1.1372	1.0976	.0114	1.0862
H	1	1.6250	1.6100	1.06	1.02	.26	15/16	1.130	.08	1.31	1.180	.23	.045	11	1.2956	.0078	1.2878	1.2508	.0065	1.2443	1.1926	.0125	1.1801

COMPONENT END - UNIFIED

MARK	OUT DIA OF PIPE	G	F	E	D	C	B	A	THD	YY	XX		VV		UU				
											MAJOR DIAMETER	EFFECTIVE DIAMETER	MAJOR DIAMETER	EFFECTIVE DIAMETER	MINOR DIAMETER	MINOR DIAMETER			
E	5/8	.55	.885	.775	1.10	.03	.18	.035	7/8 UNF	14	.8734	.0103	.8631	.8270	.0054	.8216	.7858	.0105	.7753
F	3/4	.65	1.075	.945	1.29	.03	.21	.040	1 1/16 UNS.	12	1.0608	.0114	1.0494	1.0067	.0057	1.0010	.9586	.0117	.9469
G	7/8	.65	1.200	1.070	1.41	.03	.21	.040	1 3/16 UNS.	12	1.1858	.0114	1.1744	1.1317	.0057	1.1260	1.0836	.0117	1.0719
H	1	.65	1.325	1.195	1.60	.03	.21	.040	1 5/16 UNS.	12	1.3107	.0114	1.2993	1.2566	.0059	1.2507	1.2085	.0119	1.1966

ALL DIMENSIONS ARE IN INCHES

A.G.S. 3013 SHEET 4

MINISTRY OF SUPPLY
 APPLICATIONS FOR A.G.S. SHEETS TO:-
 AT P.4 BLOCK E, CHESSINGTON, SURREY.
 GENERAL ENQUIRIES TO:-
 AD/SAE, ST GILES COURT, 1-13
 ST GILES HIGH STREET, LONDON, W.C.2

TITLE:- PIPE COUPLINGS (STEEL UNION ADAPTOR/UNIFIED ATTACHMENT END, 1/4" TO 2" - FOR USE WITH PARALLEL GASKETS (G-BONDED SEALS))
 ISSUE: 1013
 R.A.T. APPROVAL: [Signature]
 DATE: 3.5.56
 SIGNATURE: [Signature]
 DATE: 21/6/56
 AD. SAE APPROVAL: [Signature]
 SHEET NO: 6
 NO. OF SHEETS: 6
 A.G.S. NO: 3013
 SHEET 6

COUPLING END - B.S.P.

MARK	OUT DIA OF PIPE	Y	X	W	V	U	T	S	R	Q	P	N	M	L	K	J	H							
		MAX	MIN	±.01	±.01	DRILL	±.005	±.01	+0 -0	+0 -0	+01 ±.005	±.01	±.01	T P	MAJOR DIA	EFFECTIVE DIA	MINOR DIA							
J	1 1/4	2.16	2.14	1.11	1.30	26 3/16	1.45	.08	1.25	1.66	1.520	.23	.045	1 1/4	11	1.6366	.0078	1.6288	1.5918	.0069	1.5849	1.5336	.0129	1.5207
K	1 1/2	2.37	2.35	1.15	1.56	26 1/2	1.68	.10	1.25	1.89	1.750	.23	.045	1 1/2	11	1.8686	.0078	1.8608	1.8238	.0072	1.8166	1.7656	.0132	1.7524
L	1 3/4	2.85	2.83	1.25	1.80	26 5/8	1.92	.10	1.50	2.12	1.985	.23	.045	1 3/4	11	2.1026	.0078	2.0948	2.0578	.0073	2.0505	1.9994	.0133	1.9863
M	2	3.16	3.14	1.30	2.02	26 7/8	2.15	.10	1.50	2.35	2.215	.23	.045	2	11	2.3336	.0078	2.3258	2.2888	.0073	2.2815	2.2306	.0134	2.2172

COMPONENT END - UNIFIED

MARK	OUT DIA OF PIPE	G	F	E	D	C	B	A	TH'D SIZE	Y	XX	VV	UU						
		±.01	+0 -0.10	+0 -0.05	±.01	+01 -0	+01 -0	±.005	TH'D SIZE	T P	MAJOR DIA	EFFECTIVE DIA	MINOR DIA						
J	1 1/4	.65	1.635	1.505	2.00	.04	.21	.040	1 5/8	12	1.6232	.0114	1.6118	1.5691	.0059	1.5632	1.5210	.0119	1.5091
K	1 1/2	.65	1.885	1.755	2.20	.04	.21	.040	1 3/4	12	1.8732	.0114	1.8618	1.8191	.0059	1.8132	1.7710	.0119	1.7591
L	1 3/4	.65	2.250	2.130	2.70	.04	.21	.040	2 1/4	12	2.2481	.0114	2.2367	2.1940	.0062	2.1878	2.1459	.0122	2.1337
M	2	.65	2.500	2.380	3.00	.04	.21	.040	2 1/2	12	2.4981	.0114	2.4867	2.4440	.0062	2.4378	2.3959	.0122	2.3837