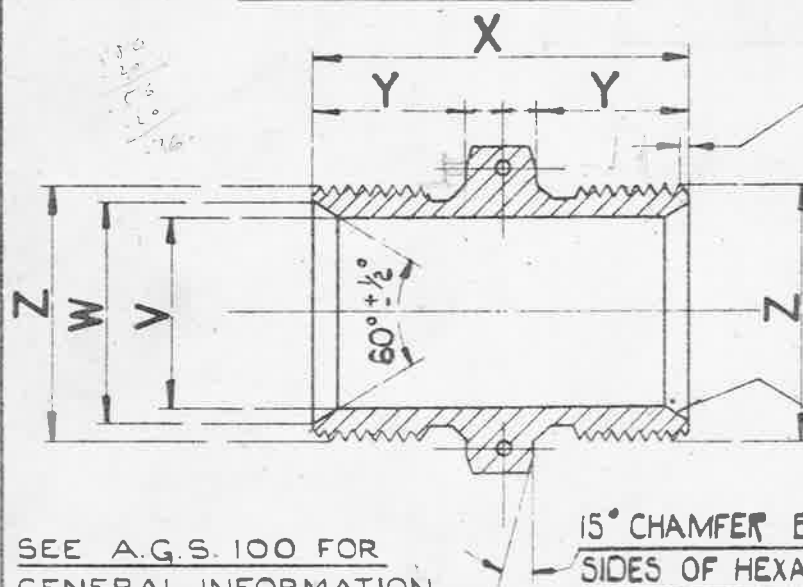


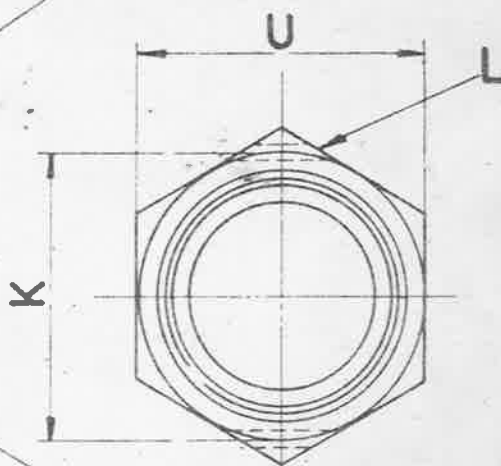
ENLARGED VIEW OF UNDERCUT  
BOTH SIDES OF HEXAGON

45° CHAMFER TO ROOT  
OF THREAD. NOTE  
APPLIES TO BOTH END.



SEE A.G.S. 100 FOR  
GENERAL INFORMATION.

15° CHAMFER BOTH  
SIDES OF HEXAGON



SMOOTH FINISH, FREE FROM  
TOOL MARKS. NOTE APPLIES  
TO BOTH ENDS.

M A R K	Z	Y	X	W	V	U		T	S	R	M	L	K
	B. S. PIPE	±.010"	±.015"	±.005"	DIA DRILL	MAX.	MIN.	+0 -.01"	+0 -.005"	RAD.	+01" -0	DRILL	±.01"
A	1/8"	.45"	1.12"	.295"	3/16"	.525"	.520"	.39"	.330"	.01"	.10"	1/16"	.48"
B	1/4"	.45"	1.12"	.41"	9/32"	.710"	.705"	.52"	.440"	.01"	.14"	1/16"	.67"
BB	19 T.P.I. .60% %	.52"	1.26"	.48"	23/64"	.820"	.815"	.60"	.525"	.01"	.14"	1/16"	.79"
C	3/8"	.52"	1.26"	.55"	13/32"	.820"	.815"	.66"	.580"	.01"	.14"	1/16"	.79"
CC	14 T.P.I. .75% %	.55"	1.34"	.60"	15/32"	.920"	.915"	.75"	.650"	.015"	.18"	1/16"	.92"
D	1/2"	.60"	1.45"	.69"	17/32"	1.010"	1.002"	.83"	.720"	.015"	.18"	1/16"	.96"
E	5/8"	.70"	1.68"	.76"	5/8"	1.100"	1.092"	.91"	.800"	.015"	.18"	1/16"	1.06"
F	3/4"	.75"	1.81"	.90"	3/4"	1.200"	1.192"	1.05"	.940"	.015"	.18"	1/16"	1.17"
G	7/8"	.80"	1.95"	1.04"	7/8"	1.390"	1.382"	1.19"	1.085"	.015"	.18"	.076" N° 48	1.37"
H	1"	.80"	1.95"	1.13"	31/32"	1.480"	1.468"	1.31"	1.180"	.02"	.23"	.076" N° 48	1.47"
J	1 1/4"	.80"	1.95"	1.45"	1 1/4"	1.860"	1.845"	1.66"	1.520"	.02"	.23"	.076" N° 48	1.90"
K	1 1/2"	.85"	2.15"	1.68"	1 5/32"	2.220"	2.200"	1.89"	1.750"	.02"	.23"	.076" N° 48	2.14"
L	1 3/4"	.95"	2.35"	1.92"	1 1/16"	2.410"	2.390"	2.12"	1.990"	.02"	.23"	.076" N° 48	2.36"
M	2"	1.00"	2.50"	2.15"	1 7/8"	2.760"	2.735"	2.35"	2.220"	.02"	.23"	.076" N° 48	2.77"

THE MATERIAL TO BE STEEL TO B.S SPEC: S.1 (LATEST ISSUE)

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

NOTE: SCREW THREADS TO B.S. SPEC: N° 84-1940,

MEDIUM FIT, TRUNCATED THREADS (AMENDMENT N° 3 - 1945)

ISSUED BY THE ROYAL AIRCRAFT ESTABLISHMENT.	TITLE:- DOUBLE ENDED UNION BODY. (STEEL.)				DRAWN C.T. Reynolds.	TRACED B.E.H. 12-8-45
	ISSUE N°	10	11	11	CHECKED [Signature]	APPROVED [Signature]
ALTER N°	MOD AGS/631	AS/AGS 988	SM 856			

ISSUE	ALT. No.
12	F.2
13	F.96
14	F.125



ENLARGED VIEW OF UNDERCUT, BOTH SIDES OF HEXAGON.

45° CHAMFER TO ROOT OF THREAD APPLIES BOTH ENDS.

SECTION 'A-A'

15° CHAMFER BOTH SIDES OF HEXAGON.



SEE AGS. 100 FOR GENERAL INFORMATION.  
B.S.P.F. THREADS TO B.S. SPEC. 3779 MEDIUM FIT TRUNCATED.

USED

ON

DESIGNED

DRAWN

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

F.A.C.

F.A.C.

F.A.C.

TRACED

F.A.C.

F.A.C.

CHECKED

F.A.C.

F.A.C.

APPROVED FOR

*[Signature]*

*[Signature]*

DATE

12.2.58

12.2.58

REF. DRAWING OR PART No.

HT

PT

R.S. 111b NO. PAINT

DESCRIPTION

STEEL

SCALE

LIMITS NOT SHOWN

AS DRAWN UNIT QTY

+

010

THIRD ANGLE PROJECTION

MATERIAL - REMARKS

B.S. SPEC. S.1

DOUBLE ENDED UNION BODY (STEEL)

AGS. 949. SHEET 1

A.G.S. 949 SHEET 2

SM  
2027

MARK	K	L DRILL DIA.	M	R		S	T	U	V DRILL DIA.	W	X	Y	Z
				RAO.	RAD.								
A	.490° .470°	1/6	.110° .100°	.010°	.010°	.330° .325°	.390° .380°	.525° .520°	3/16	.300° .290°	1.135° 1.105°	.460° .440°	1/8 B.S.P.F. THREAD
B	.680° .660°	1/6	.150° .140°	.010°	.010°	.440° .435°	.520° .510°	.710° .705°	9/32	.415° .405°	1.135° 1.105°	.460° .440°	1/4
B-B	.800° .780°	1/6	.150° .140°	.010°	.010°	.525° .520°	.600° .590°	.820° .815°	23/64	.485° .475°	1.275° 1.245°	.530° .510°	19 T.P.I. 60° O/D WHITE S&A
C	.800° .780°	1/6	.150° .140°	.010°	.010°	.580° .575°	.660° .650°	.820° .815°	13/32	.555° .545°	1.275° 1.245°	.530° .510°	3/8
C C	.950° .910°	1/6	.190° .180°	.015°	.015°	.650° .645°	.750° .740°	.920° .915°	15/32	.605° .595°	1.355° 1.325°	.560° .540°	14 T.P.I. 75° O/D WHITE S&A
D	.970° .950°	1/6	.190° .180°	.015°	.015°	.720° .715°	.830° .820°	1.010° 1.002°	17/32	.695° .685°	1.465° 1.435°	.610° .590°	1/2
E	1.070° 1.050°	1/6	.190° .180°	.015°	.015°	.800° .795°	.910° .900°	1.100° 1.092°	5/8	.765° .755°	1.695° 1.665°	.710° .690°	5/8
F	1.180° 1.160°	1/6	.190° .180°	.015°	.015°	.940° .935°	1.050° 1.040°	1.200° 1.192°	3/4	.905° .895°	1.825° 1.795°	.760° .740°	3/4
G	1.380° 1.360°	No. 48. (.076" DIA.)	.190° .180°	.015°	.015°	1.085° 1.080°	1.190° 1.180°	1.390° 1.382°	7/8	1.045° 1.035°	1.965° 1.935°	.810° .790°	7/8
H	1.480° 1.460°	No. 48. (.076" DIA.)	.240° .230°	.020°	.020°	1.180° 1.175°	1.310° 1.300°	1.480° 1.468°	31/32	1.135° 1.125°	1.965° 1.935°	.810° .790°	1"
J	1.910° 1.890°	No. 48. (.076" DIA.)	.240° .230°	.020°	.020°	1.520° 1.515°	1.660° 1.650°	1.860° 1.845°	1 1/4	1.435° 1.445°	1.965° 1.935°	.810° .790°	1 1/4
K	2.150° 2.130°	No. 48. (.076" DIA.)	.240° .230°	.020°	.020°	1.750° 1.745°	1.890° 1.880°	2.220° 2.200°	1 1/2	1.685° 1.675°	2.165° 2.135°	.860° .840°	1 1/2
L	2.370° 2.350°	No. 48. (.076" DIA.)	.240° .230°	.020°	.020°	1.990° 1.985°	2.120° 2.110°	2.410° 2.390°	1 1/2	1.925° 1.915°	2.365° 2.335°	.960° .940°	3"
M	2.780° 2.760°	No. 48. (.076" DIA.)	.240° .230°	.020°	.020°	2.220° 2.215°	2.350° 2.340°	2.760° 2.735°	1 7/8	2.155° 2.145°	2.515° 2.485°	1.010° .990°	2"

DESIGNED BY THE SOCIETY OF METALLURGICAL ENGINEERS LTD.  
15, KING STREET, ST. JAMES'S, LONDON, E.W.1.

CHECKED DATE F.A.C. CHECKED DATE F.A.C. CHECKED DATE F.A.C. CHECKED DATE F.A.C.

DOUBLE ENDED UNION BODY (STEEL)

AGS. 949 SHEET 2

NO.	DRAWING OR PART No.	DESCRIPTION	UNITS (IF NOT SHOWN)	MATERIAL	REMARKS