

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

SMOOTH FINISH FREE FROM TOOL MARKS.

15° CHAMFER BOTH SIDES OF HEXAGON.

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

ENLARGED VIEW OF UNDERCUT.

ENLARGED VIEW OF UNDERCUT.

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

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

NOTES:- SCREW THREADS TO B.S. SPEC. N° 84 - 1940;

MEDIUM FIT, TRUNCATED THREADS TO AMENDMENT N° 3 - 1945.

ISSUED BY THE ROYAL AIRCRAFT ESTABLISHMENT.

TITLE:- METAL COUPLINGS. REDUCING UNION BODY (STEEL).

DRAWN K Wilson.

TRACED F.M.E. 4-10-45.

ISSUE No.	8	57	8	10	10
ALTER ^N No.	MOD No. AGS/609	A.S. No. AGS/663	AS/AGS 988	SM 856	

CHECKED c.T. Reynolds.

APPROVED *Jorm* 2/11/45

MARK	Z	Y	X	W	V	U	T	S	R	Q	P	N	M	L	K	J	H	G	F	E	D
	B.S.P. THREAD 1" 1/8	B.S.P. THREAD 1" 1/4	±.015" ±.01"	±.01" ±.005"	±.01" ±.005"	±.005" ±.005"	±.005"	DIA. DRILL 3" 1/16	DIA. DRILL 9" 3/32	±.02"	MAX. MIN.	RAD.	±.01" ±.0	RAD.	±.01" ±.0	±.01"	DIA. DRILL 1" 1/16	±.005" ±.01"	±.0 ±.0	±.0 ±.0	±.0 ±.0
A	1" 1/8	1" 1/4	1.12"	.45"	.45"	.295"	.41"	3" 1/16	9" 3/32	.47"	.710"	.01"	.10"	.01"	.14"	.67"	1" 1/16	.330"	.39"	.440"	.52"
B	1" 1/4	3" 8	1.17"	.45"	.50"	.41"	.55"	9" 3/32	13" 3/32	.51"	.820"	.01"	.14"	.01"	.14"	.79"	1" 1/16	.440"	.52"	.580"	.66"
BB	1" 1/4	60% 19 T.P.I.	1.19"	.45"	.52"	.41"	.48"	9" 3/32	23" 64	.54"	.820"	.01"	.14"	.01"	.14"	.79"	1" 1/16	.440"	.52"	.525"	.60"
C	3" 8	1" 1/2	1.35"	.50"	.60"	.55"	.69"	13" 3/32	17" 3/32	.63"	1.010"	.01"	.14"	.015"	.18"	.96"	1" 1/16	.580"	.66"	.720"	.83"
CC	3" 8	75% 14 T.P.I.	1.30"	.50"	.55"	.55"	.60"	13" 3/32	15" 3/32	.58"	.920"	.01"	.14"	.015"	.18"	.92"	1" 1/16	.580"	.66"	.650"	.75"
D	1" 1/2	5" 8	1.58"	.60"	.70"	.69"	.76"	17" 3/32	5" 8	.76"	1.100"	.015"	.18"	.015"	.18"	1.06"	1" 1/16	.720"	.83"	.800"	.91"
E	5" 8	3" 4	1.76"	.70"	.75"	.76"	.90"	5" 8	3" 4	.83"	1.200"	.015"	.16"	.015"	.18"	1.17"	1" 1/16	.800"	.91"	.940"	1.05"
F	3" 4	7" 8	1.90"	.75"	.80"	.90"	1.04"	3" 4	7" 8	.90"	1.390"	.015"	.18"	.015"	.18"	1.37"	.076" (No. 48)	.940"	1.05"	1.085"	1.19"
G	7" 8	1"	1.95"	.80"	.80"	1.04"	1.13"	7" 8	31" 32	.90"	1.480"	.015"	.16"	.02"	.23"	1.47"	.076" (No. 48)	1.085"	1.19"	1.180"	1.31"
H	1"	1" 1/4	1.95"	.80"	.80"	1.13"	1.45"	31" 32	1" 1/4	.84"	1.860"	.02"	.23"	.02"	.23"	1.90"	.076" (No. 48)	1.180"	1.31"	1.520"	1.66"
J	1" 1/4	1" 1/2	2.10"	.80"	.85"	1.45"	1.68"	1" 1/4	15" 32	.97"	2.220"	.02"	.23"	.02"	.23"	2.14"	.076" (No. 48)	1.520"	1.66"	1.750"	1.89"

ISSUED BY
ROYAL
AIRCRAFT
ESTABLISHMENT

TITLE: METAL COUPLINGS.
REDUCING UNION BODY. (STEEL).

DRAWN
K. Wilson.

TRACED
S. TONES
2-10-45

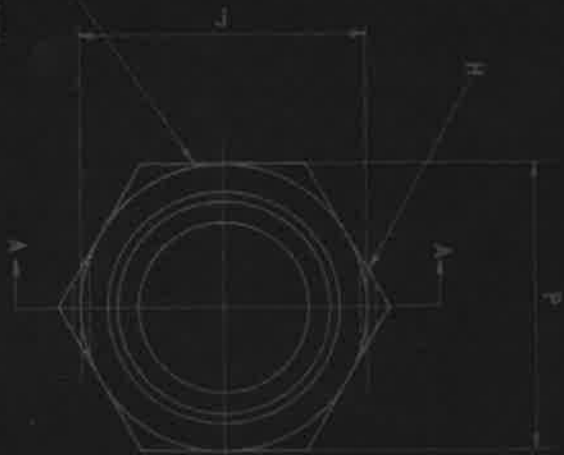
ISSUE No 1 2
ALTER No
MOD No AS/AGS
AGS/609 829
28.2.46 SM370
CTR

CHECKED
C.T. Reynolds.

APPROVED
10/11/45

REV.	DATE	BY	CHKD.
1			
2	196		
3			
4			

SM2024



PART NO. HERE

APPROVED WORKING PRESSURE
 CLASS WORKING PRESSURE
 A TO D 2000 LB./SQ. IN.
 D TO G 500 LB./SQ. IN.
 H & J 100 LB./SQ. IN.



ENLARGED VIEW OF UNDERCUT



SECTION A-A



ENLARGED VIEW OF UNDERCUT

45° CHAMFER TO
 ROOT OF THREAD
 APPLIES BOTH ENDS.

R.S.P.F. THREADS TO B.S. SPEC. 2779 MEDIUM FIT TRUNCATED.
 SEE A.G.S. 100 FOR GENERAL INFORMATION.

MADE BY THE BRITISH STEEL CORPORATION, SHEFFIELD, U.K.
 70, KING STREET, ST. LEONARDS-ON-SEA, S.W.1

DESIGN	GROUP	GRADE	TEMP.	TEST

HT	TEMP.	TIME

PT	TEMP.	TIME

STEEL	STEEL	STEEL

AGS. 950 SHEET 2

3 (E. 2.)

SM.2027

MARK	D	E	F	G	H	J	K	L		M	N		P	Q	R	S	T	U	V	W	X	Y	Z	
								DRILL DIA.	RAD.		DRILL DIA.	RAD.												
A	.520	.440	.390	.330	1"	.680	.150	.010	.110	.010	.710	.490	.415	.300	.460	.460	.135	.460	.460	.135	1"	1"	1"	1"
	.510	.435	.380	.325	1"	.660	.140	.010	.100	.010	.705	.450	.405	.290	.440	.440	.105	.440	.440	.105	1"	1"	1"	1"
B	.660	.580	.520	.440	1"	.800	.150	.010	.150	.010	.820	.530	.555	.415	.510	.510	.185	.490	.490	.185	1"	1"	1"	1"
	.650	.575	.510	.435	1"	.780	.140	.010	.140	.010	.815	.490	.545	.405	.440	.440	.155	.440	.440	.155	1"	1"	1"	1"
BB	.600	.525	.520	.440	1"	.800	.150	.010	.150	.010	.820	.560	.485	.415	.530	.530	.205	.490	.490	.205	1"	1"	1"	1"
	.590	.520	.510	.435	1"	.780	.140	.010	.140	.010	.815	.520	.475	.405	.510	.510	.175	.440	.440	.175	1"	1"	1"	1"
C	.830	.720	.660	.580	1"	.970	.190	.015	.150	.015	1.010	.650	.695	.555	.610	.610	.365	.590	.590	.365	1"	1"	1"	1"
	.820	.715	.650	.575	1"	.950	.180	.015	.140	.015	1.002	.610	.685	.545	.590	.590	.335	.590	.590	.335	1"	1"	1"	1"
CC	.750	.650	.660	.580	1"	.930	.190	.015	.150	.015	.920	.600	.605	.555	.560	.560	.315	.560	.560	.315	1"	1"	1"	1"
	.740	.645	.650	.575	1"	.910	.180	.015	.140	.015	.915	.560	.595	.545	.540	.540	.285	.540	.540	.285	1"	1"	1"	1"
D	.910	.800	.830	.720	1"	1.070	.190	.015	.190	.015	1.100	.780	.765	.695	.710	.710	.595	.690	.690	.595	1"	1"	1"	1"
	.900	.795	.820	.715	1"	1.050	.180	.015	.180	.015	1.092	.740	.755	.685	.690	.690	.565	.690	.690	.565	1"	1"	1"	1"
E	1.050	.940	.910	.800	1"	1.180	.190	.015	.190	.015	1.200	.850	.905	.765	.760	.760	.775	.760	.760	.775	1"	1"	1"	1"
	1.040	.935	.900	.795	1"	1.160	.180	.015	.180	.015	1.192	.810	.895	.755	.740	.740	.745	.740	.740	.745	1"	1"	1"	1"
F	1.190	1.085	1.050	.940	No. 48	1.380	.190	.015	.190	.015	1.390	.920	1.045	.905	.905	.915	.915	.905	.905	.915	1"	1"	1"	1"
	1.180	1.080	1.040	.935	Core DIA	1.360	.180	.015	.180	.015	1.382	.880	1.035	.895	.790	.790	.985	.790	.790	.985	1"	1"	1"	1"
G	1.310	1.180	1.190	1.085	No. 48	1.480	.240	.020	.190	.020	1.480	.920	1.135	.905	.905	.905	.905	.905	.905	.905	1"	1"	1"	1"
	1.300	1.175	1.180	1.080	Core DIA	1.460	.230	.020	.180	.020	1.468	.880	1.125	.905	.810	.810	.965	.810	.810	.965	1"	1"	1"	1"
H	1.660	1.520	1.310	1.180	No. 48	1.910	.240	.020	.240	.020	1.860	.860	1.455	.910	.910	.965	.910	.910	.965	.910	1"	1"	1"	1"
	1.650	1.515	1.300	1.175	Core DIA	1.890	.230	.020	.230	.020	1.845	.820	1.445	.905	.810	.810	.955	.810	.810	.955	1"	1"	1"	1"
J	1.890	1.750	1.660	1.520	No. 48	2.150	.240	.020	.240	.020	2.220	.990	1.685	.955	.955	.955	.955	.955	.955	.955	1"	1"	1"	1"
	1.880	1.745	1.650	1.515	Core DIA	2.130	.230	.020	.230	.020	2.200	.950	1.675	.945	.840	.840	.985	.840	.840	.985	1"	1"	1"	1"

ON MARKS 'BB' AND 'CC' THREADS TO BE
B.S. 84 WHITWORTH FORM.

DESIGNED	DRAWN	TRACED	CHECKED	DATE	HT	PT	SCALES	DESCRIPTION	MATERIAL-REMARKS
ISSUED BY THE SOCIETY OF AUTOMOBILE ENGINEERS LTD., 25, EBEL STREET, ST. JAMES'S, LONDON, S.W.1.					METAL COUPLINGS REDUCING UNION BODY (STEEL)				
AGS. 950 SHEET 2									