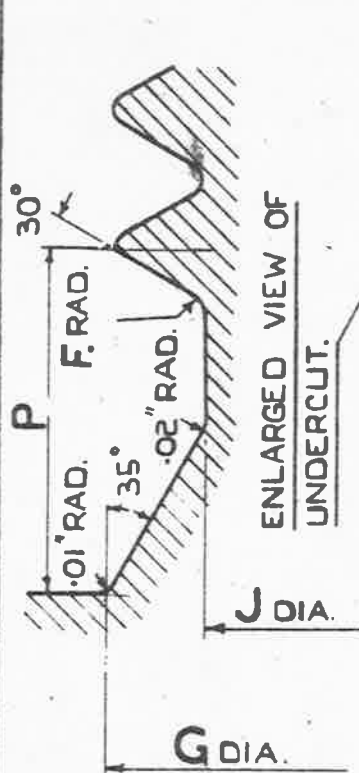


SEE A.G.S.100 FOR
GENERAL INFORMATION.

BASED ON BLACKBURN-AIRCRAFT DRG. No P.24.

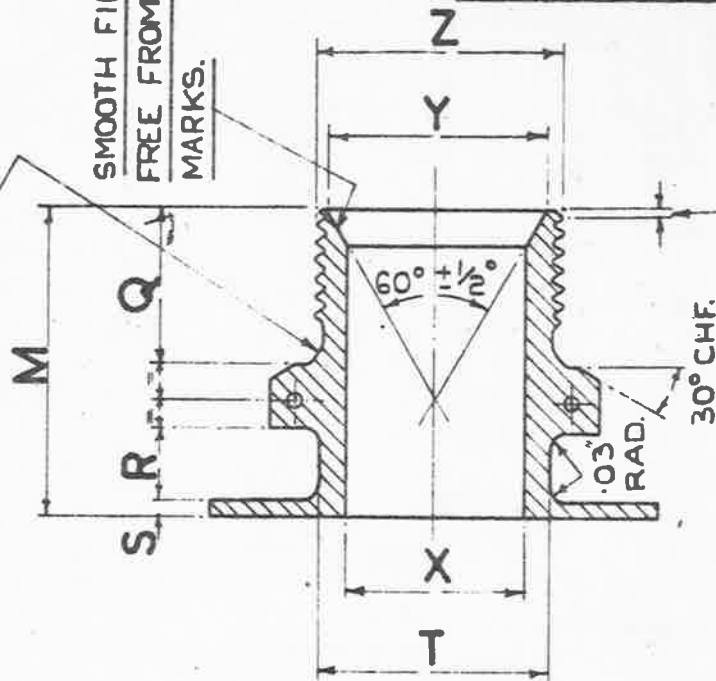
FOR MARKS J & K, ONLY,
EIGHT HOLES, $\frac{13}{64}$ " DIA, EQUALLY
SPACED AND EIGHT FLATS.

SIX HOLES, $\frac{13}{64}$ " DIA,
EQUALLY SPACED.

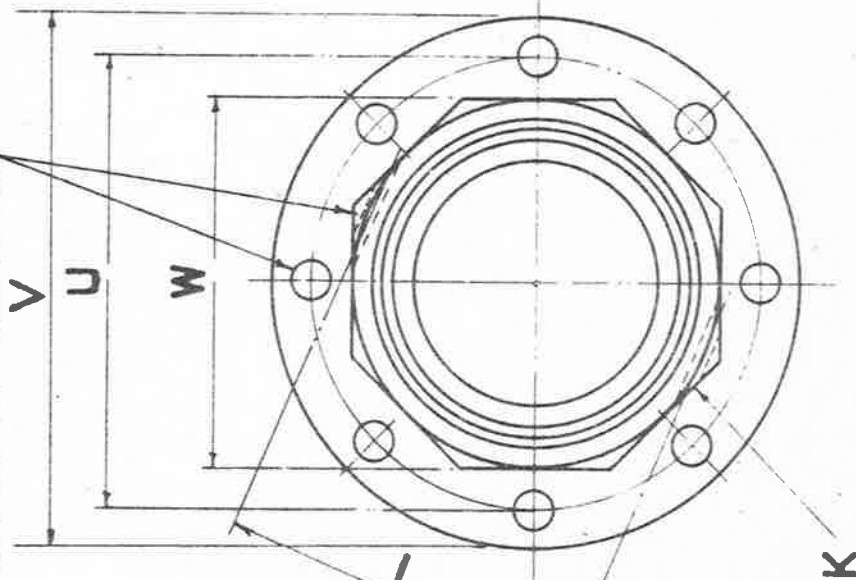
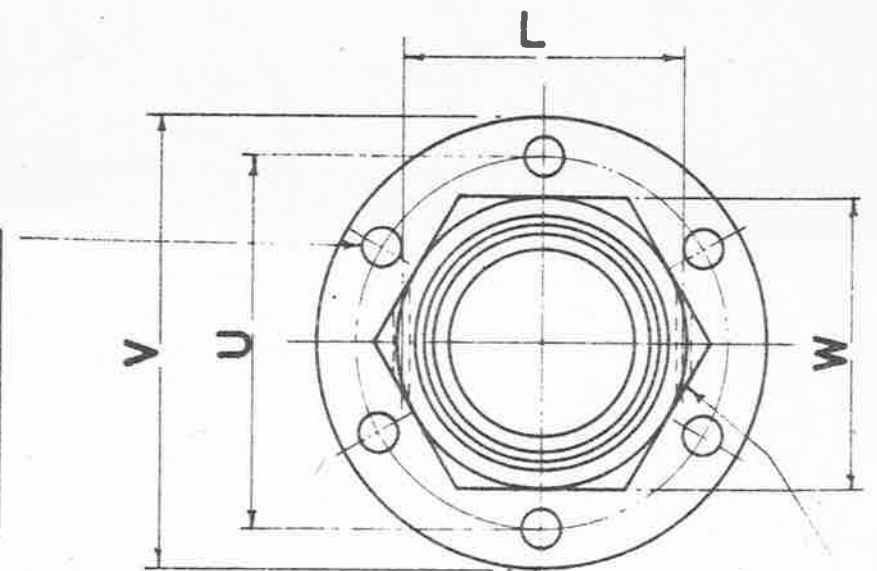


ENLARGED VIEW OF
UNDERCUT.

SMOOTH FINISH
FREE FROM TOOL
MARKS.



45° CHAMFER TO
ROOT OF THREAD.



THE MATERIAL TO BE STEEL TO BS. SPEC. S.L (LATEST ISSUE.)

FINISH :- TO BE CADMIUM PLATED TO SPEC: No D.T.D.904, (LATEST ISSUE)

NOTE:- SCREW THREADS TO BS. SPEC. No 84-1940,

MEDIUM FIT, TRUNCATED THREADS TO AMENDMENT No 3 - 1945.

ISSUED BY THE
ROYAL AIRCRAFT
ESTABLISHMENT.

TITLE:- MALE FLANGES, (BOLTED),
(STEEL).

DRAWN
K.Wilson.

TRACED
J.O.F.
26.10.45

ISSUE No

3

4

5

5

ALTER^N No

MOD No
AGS/609

A.S. No
AGS/663

AS/AGS
988

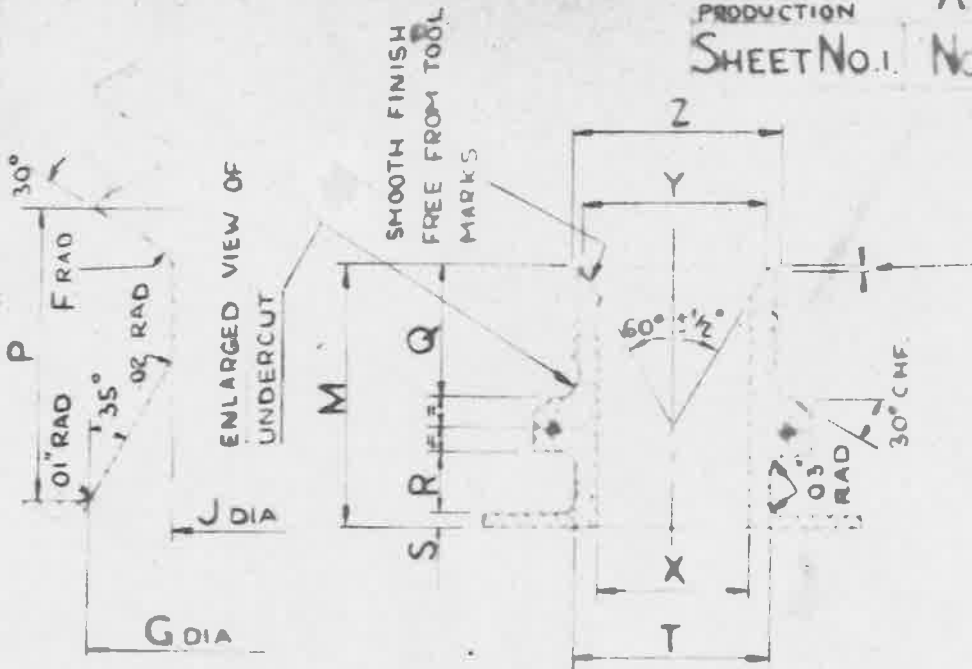
SM
856

CHECKED

C.T. Reynolds

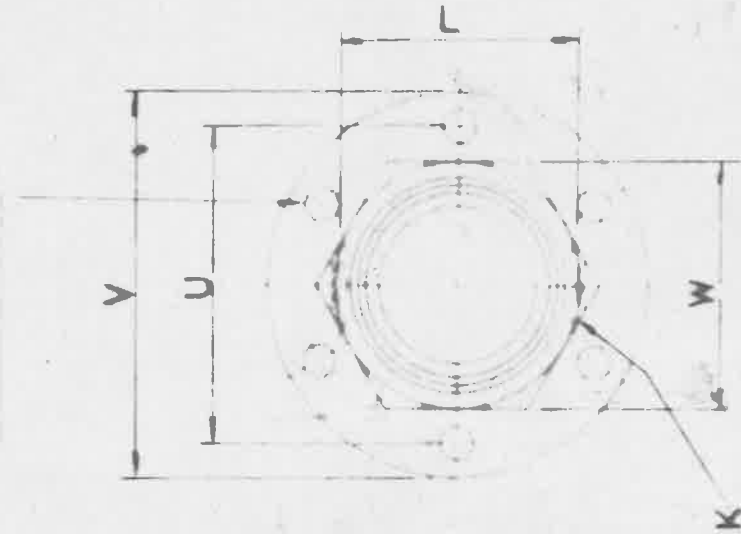
APPROVED

1/11/45

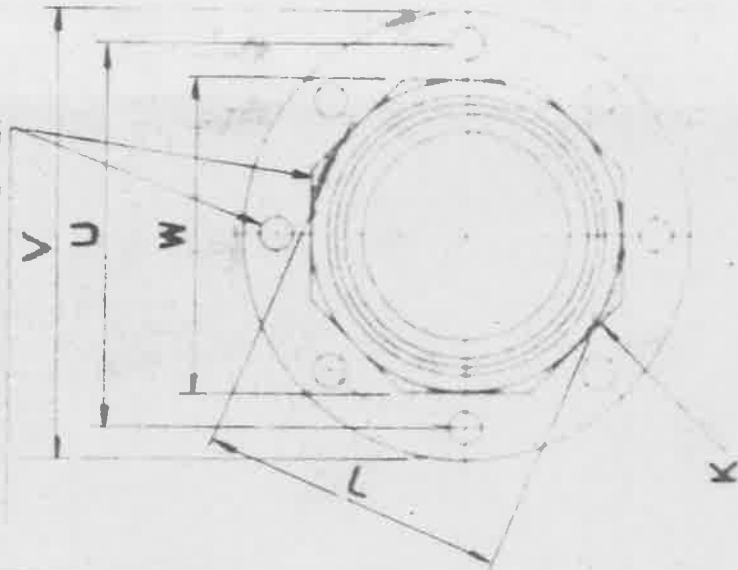


45° CHAMFER TO
ROOT OF THREAD

SIX HOLES, $\frac{13}{64}$ DIA,
EQUALLY SPACED.



FOR MARKS J & K ONLY.
EIGHT HOLES, $\frac{13}{64}$ DIA, EQUALLY
SPACED AND EIGHT FLATS.



THE MATERIAL TO BE STEEL TO BS. SPEC. S. 1. (LATEST ISSUE)
FINISH - TO BE CADMIUM PLATED TO SPEC: No. D.T.D. 904, (LATEST ISSUE)
NOTE SCREW THREADS TO B.S. SPEC No. 84-1940.
MEDIUM FIT, TRUNCATED THREADS TO AMENDMENT No. 3 - 1945

ISSUED BY THE
ROYAL AIRCRAFT
ESTABLISHMENT

TITLE - MALE FLANGES, (BOLTED),
(STEEL)

DRAWN
K. Wilson

TRACED

ISSUE No

3

4

ALTER No

28.1.46

CHECKED

APPROVED.

BASED ON BLACKBURN AIRCRAFT DRG NO P24

MINISTRY OF
AIRCRAFT
PRODUCTION

AGS No. 978

SHEET No. 2

No. OF SHEETS 2

| MARK | Z | Y | X | W | V | U | T | S | R | Q | P | M | L | K | J | G | F |
|------|--------------|------------------|--------------|----------------|------------------|---------------|---------------|---------------|----------------|---------------|---------------|----------------|--------------|----------------|---------------|------|------|
| | BSR -RCA | + .005 - .005 | DIA DRILL | MIN MAX | + .005 - .005 | + .01 - .0 | + .01 - .0 | + .01 - .0 | + .005 - .0 | + .01 - .0 | + .01 - .0 | + .01 - .01 | DIA DRILL | + .0 - .005 | + .0 - .01 | RAD. | |
| A | 1/8 | .295 | 3/16 | .520 525 | 1.42 | 1.025 | .370 | .08 | .35 | .45 | .10 | .103 | 1/16 | 1/16 | .30 | .01 | |
| B | 1/4 | .41 | 1/4 | .705 710 | 1.50 | 1.10 | .437 | .08 | .35 | .45 | .14 | 1.06 | 1/16 | 1/16 | .440 | .52 | .01 |
| BB | 60% 19TPI | .48 | 5/16 | .760 765 | 1.60 | 1.20 | .500 | .08 | .35 | .52 | .14 | 1.15 | 1/16 | 1/16 | .525 | .60 | .01 |
| C | 3/8 | .55 | 3/8 | .815 820 | 1.70 | 1.30 | .562 | .08 | .35 | .55 | .14 | 1.20 | 1/16 | 1/16 | .580 | .66 | .01 |
| CC | 75% 14TPI | .60 | 7/16 | .915 920 | 1.80 | 1.40 | .625 | .08 | .35 | .55 | .18 | 1.22 | 1/16 | 1/16 | .650 | .75 | .015 |
| D | 1/2 | .69 | 1/2 | 1.002 1.010 | 1.90 | 1.50 | .687 | .08 | .35 | .60 | .18 | 1.28 | 1/16 | 1/16 | .720 | .83 | .015 |
| E | 5/8 | .76 | 9/16 | 1.092 1.100 | 2.00 | 1.60 | .812 | .08 | .35 | .70 | .18 | 1.41 | 1/16 | 1/16 | .800 | .91 | .015 |
| F | 3/4 | .90 | 1/2 | 1.192 1.200 | 2.10 | 1.70 | .937 | .08 | .35 | .75 | .18 | 1.49 | 1/16 | 1/16 | .940 | 1.05 | .015 |
| G | 7/8 | 1.04 | 13/16 | 1.382 1.390 | 2.25 | 1.85 | 1.062 | .08 | .35 | .80 | .18 | 1.56 | 1/16 | 1/16 | 1.085 | 1.19 | .015 |
| H | 1" | 1.13 | 15/16 | 1.468 1.480 | 2.35 | 1.95 | 1.187 | .08 | .35 | .80 | .23 | 1.58 | 1/16 | 1/16 | 1.18 | 1.31 | .02 |
| J | 1 1/4 | 1.45 | 1 1/2 | 1.845 1.860 | 2.75 | 2.35 | 1.468 | .08 | .35 | .80 | .25 | 1.61 | 1/16 | 1/16 | 1.52 | 1.66 | .02 |
| K | 1 1/2 | 1.68 | 1 5/8 | 2.200 2.220 | 3.15 | 2.70 | 1.625 | .08 | .35 | .85 | .23 | 1.68 | 1/16 | 1/16 | 1.75 | 1.89 | .02 |

ISSUED BY
ROKPEL
ESTABL. PERMIT

TITLE - MALE FLANGES (BOLTED)
(STEEL)

K 1111