

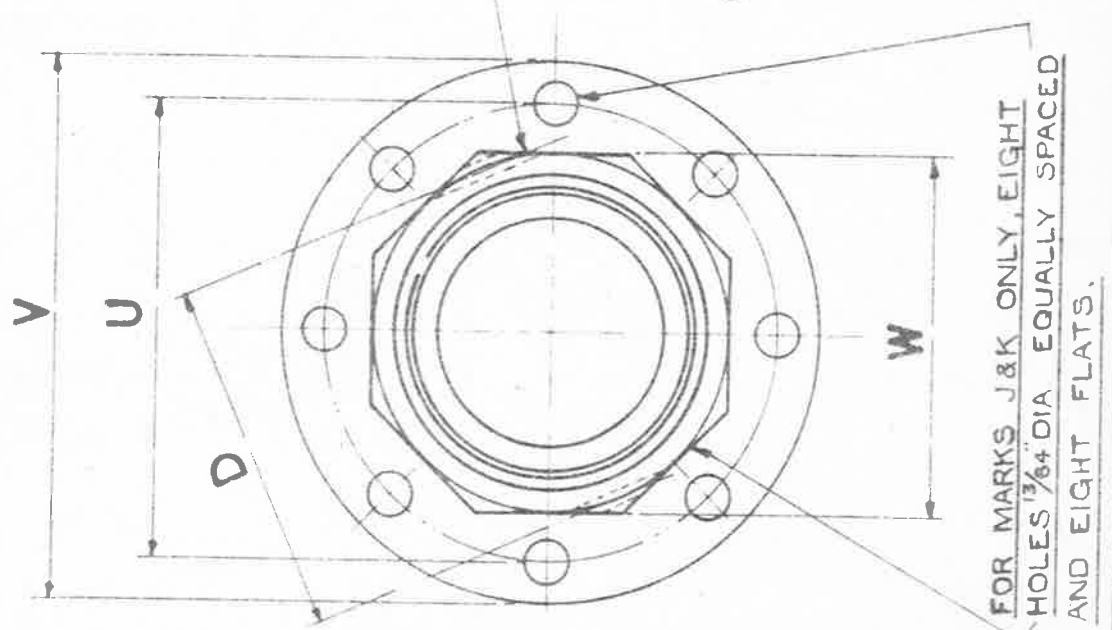
THE MATERIAL TO BE LIGHT ALLOY TO SPEC: D.T.D. 423, (LATEST ISSUE)

FINISH :- TO BE ANODISED TO SPEC: D.T.D. 910, (LATEST ISSUE)

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

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

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



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

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

ENLARGED VIEW OF UNDERCUT.

SMOOTH FINISH FREE FROM TOOL MARKS.

CHAMFER .25" X .04"

30° CHAMFER.

45° CHAMFER TO ROOT OF THREAD

$60^{\circ} \pm 2^{\circ}$

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT

TITLE:- MALE FLANGES. (BOLTED), WITH SPIGOT.-(LIGHT ALLOY).

DRAWN CT.Reynolds.

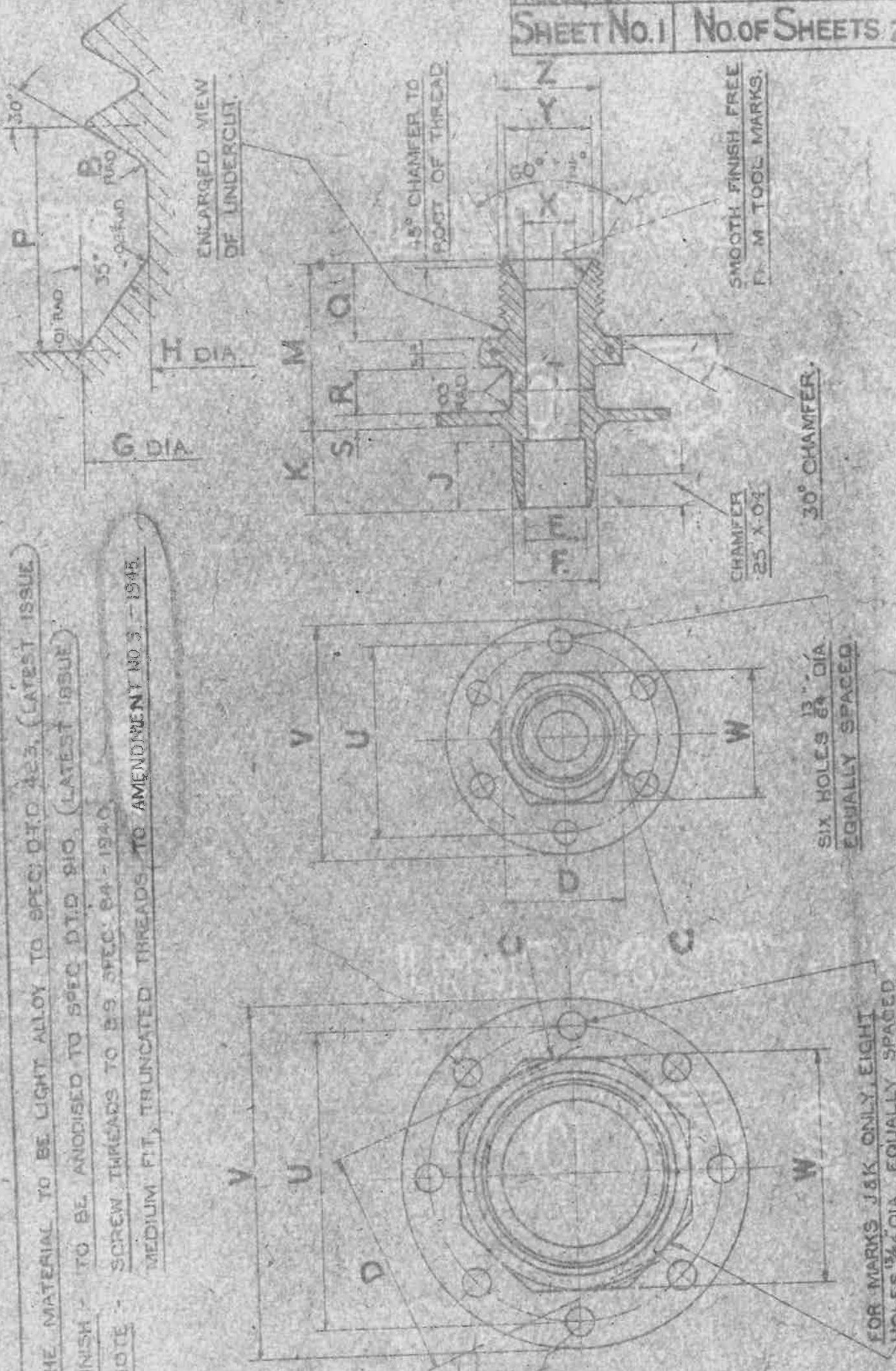
TRACED P. flint 20/10/45

ISSUE No	3	REV	4	5	5
ALTER. No	MOD. No	A.S. No	AS/ACS	SM	
	AGS/609	AGS/663	988	856	

CHECKED J. Moore

APPROVED J. Moore 5/11/45

28 1.46
RES. AGS. 145



THE MATERIAL TO BE LIGHT ALLOY TO SPEC. DTD 423. (LATEST ISSUE)

FINISH - TO BE ANODISED TO SPEC. DTD 810. (LATEST ISSUE)

NOTE - SCREW THREADS TO B.S. SPEC. 64-1940 MEDIUM FIT, TRUNCATED THREADS TO AMENDMENT NO. 3 - 1945.

ISSUED BY ROYAL AIRCRAFT ESTABLISHMENT	TITLE - MALE FLANGES, (BOLTED) WITH SPRIGOT - (LIGHT ALLOY).		DRAWN C.T. Reynolds.	TRACE P. flin 20/12
	ISSUE NO. 4	AGS. NO. 4	CHECKED J. Moran	APPROVED J. Moran
	ALTER. NO.	AGS. NO. 465		

M A R K	Z	Y	X	W		V	U	T	S	R	Q	P	M	K	J	H	G	F	E	D	C	B
				MIN	MAX																	
A	1/8 BSP THREAD	295 +0.005	1/8 DIA DRILL	520	525	1.42	1.025	370	08	35	45	10	103	50	40	330	39	34	187	48	1/8	0.01
B	1/8	410	3/8	705	710	1.50	1.100	437	08	35	45	14	106	50	40	440	52	40	260	67	1/8	0.01
BB	1/8 19TPI 60%	480	1/8	760	765	1.60	1.200	500	08	35	52	14	116	50	40	525	60	47	312	75	1/8	0.01
C	1/8 14TPI	550	1/8	815	820	1.70	1.300	562	08	35	56	14	120	52	42	580	66	53	375	79	1/8	0.01
CC	1/8 75%	600	1/8	915	920	1.80	1.400	625	08	35	55	18	122	58	46	650	76	59	437	92	1/8	0.01
D	1/8	690	1/8	1002	1010	1.90	1.500	687	08	35	60	18	128	65	53	720	83	66	500	96	1/8	0.01
E	1/8	760	1/8	1092	1100	2.00	1.600	812	08	35	70	18	141	79	67	800	91	78	625	106	1/8	0.01
F	1/8	900	1/8	1192	1200	2.10	1.700	937	08	35	75	18	149	95	80	940	105	90	750	117	1/8	0.01
G	1/8	1040	1/8	1382	1390	2.25	1.850	1062	08	35	80	18	156	107	92	1085	119	103	875	137	0.076 1/8 (N°48)	0.015
H	1/8	1130	1/8	1468	1480	2.35	1.950	1187	08	35	80	23	158	120	105	1150	131	116	1000	147	0.076 1/8 (N°48)	0.020
J	1/8	1450	1/8	1845	1860	2.75	2.350	1468	08	35	80	23	161	145	130	1200	166	141	1250	185	0.076 1/8 (N°48)	0.020
K	1/8	1480	1/8	2200	2220	3.15	2.700	1625	08	35	85	23	168	160	155	1750	189	166	1500	214	0.076 1/8 (N°48)	0.020

ISSUED BY
ROYAL
AIRCRAFT
ESTABLISHMENT

TITLE: MALE FLANGES (BOLTED)
WITH SPK GOT - (LIGHT ALLOY)

ISSUE No
ALTERATION

1				
2				

ISSUED BY	
DATE	
SCALE	