	<h1 style="margin: 0;">CORPORATE STANDARD</h1>	<div style="border-bottom: 1px solid black; padding: 2px;">AA7161001</div> <div style="border-bottom: 1px solid black; padding: 2px;">Rev. No. 04</div> <div style="padding: 2px;">PAGE 1 of 3</div>																		
<h2 style="margin: 0;">WASHERS, MACHINED, STEEL</h2>																				
<p>1 DESIGNATION</p> <p>A machined washer of size 8.4 mm made of steel shall be designated as:</p> <p>1.1 On drawings</p> <p style="margin-left: 20px;">i) Material specification column: AA7161001</p> <p style="margin-left: 20px;">ii) Description column: WASHER MCD 8.4-ST</p> <p>1.2 On indents</p> <p style="margin-left: 20px;">Washer Machined 8.4 – Steel: AA7161001</p> <p>1.3 For issuing enquiries and on purchase orders</p> <p style="margin-left: 20px;">While issuing enquiries and purchase orders, delete BHEL standard number from the above description and add the information given under clause 2.</p> <p>2 COMPLIANCE WITH STANDARDS</p> <p>2.1 Dimensions, Tolerances and General requirements</p> <p style="margin-left: 20px;">As per IS: 2016-1967, Table-1</p> <p>2.2 Material</p> <p style="margin-left: 20px;">Steel as stated in IS: 2016</p> <p>2.3 Finish</p> <p style="margin-left: 20px;">Plated as specified in BHEL order.</p> <p>3 NOTE</p> <p>3.1 For machined washers of brass, refer to BHEL standard AA7161002</p> <p>3.2 For machined washers of copper, refer to BHEL standard AA7161004</p> <p>3.3 Washers to this standard would be unplated, divisions wishing to have plated washers would have</p> <p>3.4 For general requirements of washers, refer BHEL standard AA0230408</p> <p>3.5 Weights given in this standard are for general reference only and are not meant for commercial transactions.</p> <p>3.6 When fasteners are to be tested with in BHEL, the following sampling and acceptance plan based on IS: 6821 (Table-2) shall be followed for physical properties.</p>																				
<table border="1" style="margin: auto; border-collapse: collapse;"> <thead> <tr> <th style="padding: 5px;">LOT SIZE</th> <th style="padding: 5px;">SAMPELE SIZE</th> <th style="padding: 5px;">ACCEPTANCE NOS.</th> </tr> </thead> <tbody> <tr> <td style="padding: 5px;">Up to 1000</td> <td style="padding: 5px;">5</td> <td style="padding: 5px;">0</td> </tr> <tr> <td style="padding: 5px;">1001-3000</td> <td style="padding: 5px;">8</td> <td style="padding: 5px;">0</td> </tr> <tr> <td style="padding: 5px;">3003-10000</td> <td style="padding: 5px;">13</td> <td style="padding: 5px;">0</td> </tr> <tr> <td style="padding: 5px;">10001-35000</td> <td style="padding: 5px;">20</td> <td style="padding: 5px;">0</td> </tr> <tr> <td style="padding: 5px;">Over 35000</td> <td style="padding: 5px;">32</td> <td style="padding: 5px;">1</td> </tr> </tbody> </table>			LOT SIZE	SAMPELE SIZE	ACCEPTANCE NOS.	Up to 1000	5	0	1001-3000	8	0	3003-10000	13	0	10001-35000	20	0	Over 35000	32	1
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Revisions: As per clause 29.4 of MOM of WG-F		APPROVED: INTERPLANT MATERIAL RATIONALISATION COMMITTEE – MRC (F)																		
Rev. No. 04	Amd. No.	Reaffirmed																		
Dt: 15-04-2011	Dt:	Year: 2019																		
Prepared HPEP, Hyderabad		Issued Corp. R&D																		
Dt. of 1 st Issue 01-01-1977																				

4 REFERRED STANDARDS (Latest publications including amendment)

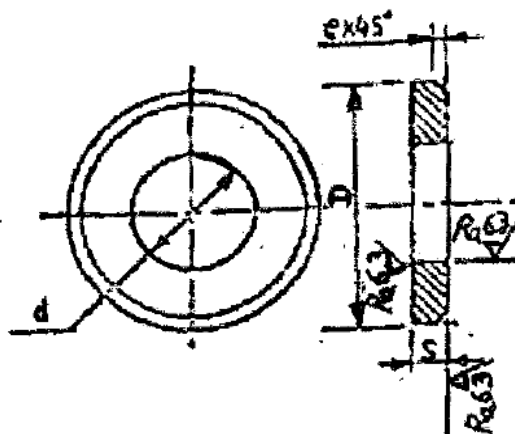
- 1) IS: 6821
- 2) AA0230408
- 3) AA7161002
- 4) AA7161004

EXPLANATORY NOTE

This standard was first issued in January 1977. The standard was based on IS:2016-1967 for dimensions, tolerances and general requirements. Subsequently many changes have been agreed upon at International & IPSC level and were reflected in IS: 2016-1967.

There is no change in IS: 2016-1967. This standard has been reviewed and brought up to date.

- Clause 3.6 “Sampling plan” for washers has been modified in line with IS: 6821
- Clause 4.0 has been modified accordingly.





CORPORATE STANDARD

AA7161001

Rev. No. 04

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Note:

- 1) Corporate sub codes are shown in Table
- 2) Weights have been shown in kg per 1000 Nos.

Table 1

All dimensions in mm.

Size Nom. d h12	Outside diameter D		Thickness S		e nom	for bolt or screw size	Sub-code	Weight
	Basic	Tol.	Basic	Tol.				
1.7	4	+0 -0.3	0.3	±0.1	0.1	M1.6		
2.2	5	+0 -0.3	0.3	±0.1	0.1	M2	170	
2.7	6.5	+0 -0.3	0.5	±0.1	0.2	M2.5	161	
3.2	7	+0 -0.3	0.5	±0.1	0.2	M3	013	0.11
4.3	9	+0 -0.3	0.8	±0.1	0.3	M4	021	0.29
5.3	10	+0 -0.3	1	±0.1	0.4	M5	030	0.42
6.4	12.5	+0 -0.4	1.6	±0.2	0.6	M6	048	1.08
8.4	17	+0 -0.4	1.6	±0.2	0.6	M8	056	2.07
10.5	21	+0 -0.5	2	±0.2	0.6	M10	064	3.98
13	24	+0 -0.5	2.5	±0.3	0.6	M12	072	6.16
17	30	+0 -0.5	3	±0.3	0.6	M16	080	11.17
21	37	+0 -0.8	3	±0.3	1	M20	099	16.7
25	44	+0 -0.8	4	±0.3	1	M24	102	31.78
31	56	+0 -1.0	4	±0.3	1	M30	110	52.95
37	66	+0 -1.0	5	±0.6	1.6	M36	129	89.99
43	78	+0 -1.0	7	±1	1.6	M42	137	180.3
50	92	+0 -1.5	8	±1	1.6	M48	145	291.26
58	105	+0 -1.5	9	±1	1.6	M56	188	421.8
66	115	+0 -1.5	9	±1	2	M64	153	486.45