

	CORPORATE STANDARD	AA7161001 Rev. No. 04 PAGE 1 of 3																		
WASHERS, MACHINED, STEEL																				
1 DESIGNATION A machined washer of size 8.4 mm made of steel shall be designated as: 1.1 On drawings i) Material specification column: AA7161001 ii) Description column: WASHER MCD 8.4-ST 1.2 On indents Washer Machined 8.4 – Steel: AA7161001 1.3 For issuing enquiries and on purchase orders While issuing enquiries and purchase orders, delete BHEL standard number from the above description and add the information given under clause 2. 2 COMPLIANCE WITH STANDARDS 2.1 Dimensions, Tolerances and General requirements As per IS: 2016-1967, Table-1 2.2 Material Steel as stated in IS: 2016 2.3 Finish Plated as specified in BHEL order. 3 NOTE 3.1 For machined washers of brass, refer to BHEL standard AA7161002 3.2 For machined washers of copper, refer to BHEL standard AA7161004 3.3 Washers to this standard would be unplated, divisions wishing to have plated washers would have 3.4 For general requirements of washers, refer BHEL standard AA0230408 3.5 Weights given in this standard are for general reference only and are not meant for commercial transactions. 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.																				
<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)

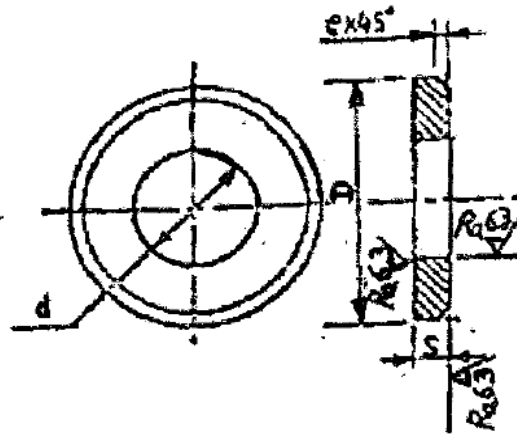
- 1) IS: 6821
- 2) AA0230408
- 3) AA7161002
- 4) AA7161004

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.





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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