



CORPORATE STANDARD

AA 711 11 19

Rev. No. 06

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BOLTS, HEXAGON HEAD, PRODUCT Gr: 'A' COARSE PITCH, STEEL PROPERTY CLASS 4.8 (M20 - M24)

1.0 DESIGNATION:

A product Gr. A hexagon head, steel bolt to M20, length 80mm, coarse pitch and conforming to property class 4.8 shall be designated as:

1.1 On drawings:

- i) Material specification column : AA 711 11 19
- ii) Description column : BOLT HEX A M20 X 80 - 4.8.

1.2 On indents:

Bolt Hex A M20 X 80 - 4.8: AA 711 11 19.

1.3 For issuing enquiries and on purchase orders:

While issuing enquiries and purchase orders, delete BHEL standard number from above description and add the information given under clause 2.0:

2.0 COMPLIANCE WITH STANDARDS:

2.1 Dimensions, Tolerances & General Requirements:

As per IS:1364, Part 1-2002.

2.2 Mechanical properties:

To conform to property class 4.8, as specified in Table-3 of IS:1367, Part 3-2002.

2.3 Threads:

Pitch-coarse to IS:4218, Part 2.

Tolerance quality - Medium.

Tolerance class - 6g.

2.4 Identification Marking:

As stated in clause 9 of IS:1367, Part 3.

2.5 Finish: Plated as specified in BHEL order.

Revisions :

Cl. 25.2.9 of MOM of WG-F

APPROVED :

INTERPLANT
STANDARDIZATION COMMITTEE (WG-F)

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**3.0 NOTE:**

- 3.1** Length and diameter combination (refer Table -1 in page 3 of 3) between the bold lines should only be used.
- 3.2** For screw threads, general (Metric) refer to BHEL standard AA 023 18 00.
- 3.3** For tolerance grade, position and class refer to BHEL standard AA 023 02 01.
- 3.4** Bolts to this standard would be unplated, divisions wishing to have plated bolts would have to get them plated.
- 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 sampling and acceptance plan shall be as per IS:1367, part 17.

4.0 REFERRED STANDARDS (Latest publications including amendment):

- 1) IS: 1364, Pt 1 2) IS: 1367, Pt 3 & 17 3) IS: 4218, Pt.2 4) AA 023 18 00
5) AA 023 02 01 6) AA 023 18 50

EXPLANATORY NOTE:

This revision issued with the following changes:

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-- In Cl.1, In clause 2.2, year of IS:1367-Part3 is modified.

