



CORPORATE STANDARD

AA 712 21 01

Rev. No. 05

PAGE 1 OF 3

SCREWS, SLOTTED, COUNTERSUNK HEAD, COARSE PITCH, STEEL PRODUCT Gr: A, PROPERTY CLASS 4.8 (M1.6 - M20)

1.0 DESIGNATION:

A Product Gr: A slotted, countersunk head, steel screw of thread M8, length 20mm, coarse pitch, and conforming to property class 4.8 shall be designated as:

1.1 On drawings:

- i) Material specification column : AA 712 21 01
- ii) Description column : SCRU SLT CSK A M8x20-4.8.

1.2 On indents:

Screw Slotted Countersunk Head A , M8 X 20 - 4.8: AA 712 21 01.

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:1365 - 1978.

2.2 Mechanical properties:

To conform to property Cl. 4.8, as specified in table 3 of IS: 1367, Part.3-2002.
Permissible hardness 124-250 HB for sizes M 1.6 to M 10.

2.3 Threads:

Pitch-coarse to IS:4218, Part 2.
Tolerance quality - Medium.
Tolerance class - 6g.

2.4 Identification and Marking:

As per 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)

Rev. No. 05

Amd.No. 00

Prepared
BHOPAL

Issued
Corp. R&D

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Dt :

Year :

**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 In table-1 sizes to the left side of broken stepped line are threaded upto the head.
- 3.3 For screw threads, general (Metric) refer to BHEL standard AA 023 18 00.
- 3.4 For tolerance grade, position and class refer to BHEL standard AA 023 02 01.
- 3.5 For slotted, counter sunk head, brass screws refer to BHEL standard AA 712 21 03.
- 3.6 Screws to this standard would be unplated, divisions wishing to have plated Screws would have to get them plated.
- 3.7 Weights given in this standard are for general reference only and are not meant for commercial transaction.
- 3.8 When the fasteners are to be tested, within BHEL, the sampling and acceptance shall be as per IS:1367, Part.17.

4.0 REFERRED STANDARDS (Latest publications including amendment):

- | | | | |
|-----------------|-----------------------|-------------------|-----------------|
| 1) IS:1365 | 2) IS: 1367 (Pt.3&17) | 3) IS: 4218, Pt.2 | 4) AA 023 02 01 |
| 5) AA 023 18 00 | 6) AA 023 18 50 | 7) AA 023 18 52 | 8) AA 712 21 03 |

EXPLANATORY NOTE:

The following changes have been made in this revision:

- In clause 2.2 , year of IS:1367-part 3 is modified.



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PAGE 3 OF 3

NOTE

- 1 Corporate Sub-Code Numbers are shown below
- 2 Weights have been shown in kg. per 100 Nos.
- 3 For Threaded Run out Refer AA 023 18 50.
- 4 For ends refer AA 023 18 52, when chamfered.

T A B L E 1
All dimensions are in mm

Size	HEAD		SLOT		The added length	NOM. LENGTH (L)																																
	Dia	Depth	Width	Depth		2.5	3	4	5	6	8	10	12	14	16	20	25	30	35	40	45	50	55	60	70	80	90	100	110	120	130	140	150					
Nom.	d2	k	n	t	b	Sub-code	Weight	Sub-code	Weight	Sub-code	Weight	Sub-code	Weight	Sub-code	Weight	Sub-code	Weight	Sub-code	Weight	Sub-code	Weight	Sub-code	Weight	Sub-code	Weight	Sub-code	Weight	Sub-code	Weight	Sub-code	Weight	Sub-code	Weight	Sub-code	Weight			
M 1.6	3.00	0.36	0.6	0.32	15																																	
M 2	3.80	1.2	0.7	0.4	16																																	
M 2.5	4.70	1.5	0.8	0.5	18					339	347	355																										
M 3	5.60	1.65	1	0.5	19					363	0.10	0.29	0.71																									
M 4	7.50	2.2	1.2	0.8	22					0.35	0.44	0.56	0.72																									
M 5	9.20	3.5	1.51	1	25					320	0.37	0.65																										
M 6	11.00	3	1.91	1.2	8																																	
M 8	14.50	4	2.31	1.6	34																																	
M 10	18.00	5	2.61	2	40																																	
M 12	22.00	6	3.31	2.4	46																																	
M 16	29.00	8	4.37	3.2	58																																	
M 20	36.00	10	5.37	4	70																																	

