



CORPORATE STANDARD

AA 712 11 23

Rev. No. 07

PAGE 1 OF 3

SCREWS, HEXAGON HEAD, PRODUCT GRADE 'A' COARSE PITCH, STEEL, PROPERTY CLASS 8.8 (M6 - M24)

1.0 DESIGNATION:

A product Gr. A hexagon head, steel screws of thread M8, length 50mm, coarse pitch and conforming to property class 8.8 shall be designated as:

1.1 On drawings:

- i) Material specification column : AA 712 11 23
- ii) Description column : SCRU HEX A M8X50 - 8.8.

1.2 On indents:

Screws Hex A M8 X 50 - 8.8 ; AA 712 11 23.

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 2.0.

2.0 COMPLIANCE WITH STANDARDS:

2.1 Dimensions, tolerances & general Requirements:

As per IS:1364, Part 2 - 2002.

2.2 Mechanical Properties:

To conform to property class 8.8 as specified in Table - 3 of IS:1367, Part.3-2002.
Permissible hardness 238-350 HB for sizes M6-M10.

2.3 Threads:

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

2.4 Identification Marking:

As stated in Cl.9.2.1 of IS:1367, Part.3.

2.5 Surface Discontinuity: As per IS:1367, Part.9.

2.6 Finish: Plated as specified in BHEL order

Revisions :

Cl. 25.7.11 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 on 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** Screws 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 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.2 2) IS:1367 Pt.3, 9&17 3) IS: 4218, Pt.2 4) AA 023 02 01
5) AA 023 18 00 6) AA 023 18 50

EXPLANATORY NOTE:**The following changes have been made in the revision:**

- New clause 2.5 Surface Discontinuity is added.
- Existing clause 2.5 is renumbered as 2.6.
- In Cl.2.2, year of IS is modified as 2002.
- Clause 9 of IS:1367 is included in Cl 4.0

