



CORPORATE STANDARD

AA 712 21 01

Rev. No. 05

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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.

Prepared

Issued

Dt. of 1st Issue

Dt:01.10.2004

Dt :

Year :

BHOPAL

Corp. R&D

January, 1977

**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.

