



CORPORATE STANDARD

AA 712 51 04

Rev. No. 07

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SCREWS, GRUB, SLOTTED, TYPE-C (CONICAL ENDS), PRODUCT Gr:A, COARSE PITCH, STEEL, PROPERTY CLASS 4.8 (M12 - M24)

1.0 DESIGNATION:

A product Gr:A, slotted, steel, grub screw conical end (Type-C), thread M12, length 30mm, coarse pitch and conforming to property class 4.8 shall be designated as:

1.1 On drawings:

- i) Material specification column : AA 712 51 04.
- ii) Description column : SCRUB SLT C A M12X30 - 4.8

1.2 On indents:

Screw grub C A M12X30 - 4.8: AA 712 51 04

1.3 For issuing enquiries and on purchase orders:

While issuing enquiries and purchase orders, enclose a copy of this BHEL standard.

2.0 COMPLIANCE WITH STANDARDS:

2.1 Dimensions, Tolerances and General Requirements:

As per BHEL standard AA 712 51 04

2.2 Mechanical properties:

Material shall conform to properties given against class 4.8, as specified in Table-3 of IS:1367, Part 3

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 : As per Cl. 29.4 of 29th MOM
of WG-F

APPROVED :

INTERPLANT
STANDARDIZATION COMMITTEE (WG-F)

Rev. No. 07

Amd.No.

Prepared

Issued

Dt. of 1st Issue

Dt: 15.04.2011

Dt :

Year :

HARDWAR

Corp. R&D

December, 1976

**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** For sizes less than M12, refer to BHEL standard AA 7125103
- 3.5** Screws to this standard would be unplated, divisions wishing to have plated screws would have to get them plated.
- 3.6** Weights given in this standard are for general reference only and are not meant for commercial transactions.
- 3.7** When fasteners are to be tested with in BHEL, sampling and acceptance plan as per IS:1367, Part 17

4.0 REFERRED STANDARDS (Latest publications including amendment):

- | | | |
|-------------------------|------------------|-----------------|
| 1) IS:1367, Pt 3& Pt 17 | 2) IS:4218, Pt 2 | 3) AA 023 02 01 |
| 4) AA 023 18 00 | 5) AA 0231852 | 6) AA 7125103 |

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**EXPLANATORY NOTE:**

This standard was first issued in January 1977 and was based on IS:2388-71 and reaffirmed in 1991 for dimensions, tolerances and general requirements. Subsequently many changes have been agreed upon at International and IPSC level and were reflected in revised version of IS:1367 “Technical supply condition of threaded fasteners”.

Since the IS:2388 has been withdrawn, therefore the following changes have been made in the corporate standard AA712 51 04 :

- Reference of the IS:2388 has been deleted from clause 2.1 of the standard.
- Clause 1.3, 2.1 and 2.4 have been modified accordingly.
- Clause 4.0 has been modified.