



CORPORATE STANDARD

AA 715 11 12

Rev. No. 04

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NUTS HEXAGON, PRODUCT Gr: B, COARSE PITCH, STEEL, PROPERTY CLASS 6 (M20 - M36)

1.0 DESIGNATION:

A Product Gr: B hexagon, steel nut, thread M24, coarse pitch, and conforming to property class 6 shall be designated as:

1.1 On drawings:

- i) Material specification column : AA 715 11 12
- ii) Description column : NUT HEX B M24 - 6.

1.2 On indents:

Nut Hex B M24 -6: AA 715 11 12.

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 COMPLY WITH STANDARDS:

2.1 Dimensions, Tolerances & General Requirements:

As per IS: 1364, Part 3 - 2002.

2.2 Mechanical properties:

To conform to property Class 6, as specified in table 5&6 of IS: 1367, Part.6-1994.

2.3 Threads:

Pitch-coarse to IS:4218, Part 2-1976.

Tolerance quality - Medium.

Tolerance class – 6H.

2.4 Identification Marking

As stated in clause 9 of IS: 1367, Part 6.

2.5 Finish: Plated as specified in BHEL order.

Revisions :

CI 24.8.37 of MOM of WG-F

APPROVED :

INTERPLANT
STANDARDIZATION COMMITTEE (WG-F)

Rev. No. 04

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**3.0 NOTE:**

- 3.1** For nut, hexagon, brass product Gr:A, coarse pitch, (M1.6-M16) refer BHEL standard AA 715 11 13.
- 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** Nuts to this standard would be unplated, divisions wishing to have plated Screws 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 2) IS: 1367 Pt.6,17 3) IS: 4218, Pt 2 4) AA 023 18 00
5) AA 023 02 01 6) AA 715 11 13

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

- In Cl.1., nominal diameter 24 mm size modified as thread M 24.
- Cl.2. Material (Rev02) is deleted is due to duplication and all other clauses are renumbered.
- In Cl 2.1, IS is revised in 2002.
- In Cl 2.3, Tolerance modified as 6H.
- In Identification marking clause, existing Cl 3 of IS:1367, Pt 18 is modified as Cl.9 of IS:1367 Pt.6.
- Cl.3.6 sampling and acceptance plan shall be as per IS:1367 Pt.17 instead of IS: 2614 which was withdrawn.
- Cl.4.0 Referred standard is added.
- Four pages made into three pages



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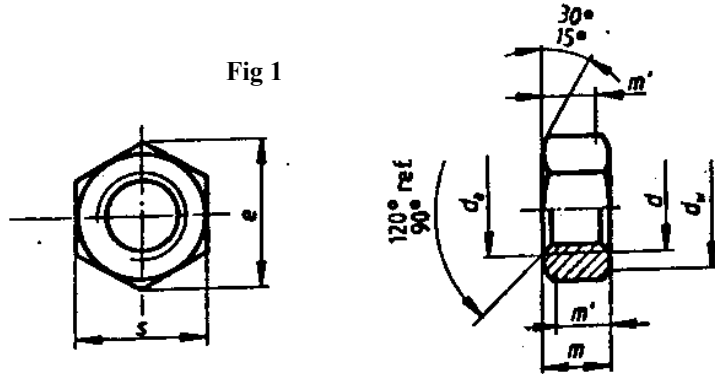


Table 1

All dimensions are in mm.

SIZE	FLATS		CORNERS	THICKNESS		WRENCH. DIA	DIA	DIA		SUBCODE/ WEIGHT	
d	s		e	m		m'	dw	da			
Nom.	max.	min.	min.	max.	min	min.	min.	min	max		
M20	30	29.16	32.95	18.0	16.9	13.5	27.7	20	21.6	017/	64.59
M24	36	35	39.55	21.5	20.2	16.2	33.3	24	25.9	025/	110.40
M30	46	45	50.85	25.6	24.3	19.4	42.8	30	32.4	033/	237.40
M36	55	53.8	60.79	31.0	29.4	23.5	51.1	36	38.9	041/	396.80

NOTE: 1) Corporate sub code numbers are shown above