



CORPORATE STANDARD

AA7124102

Rev. No. 07

PAGE 1 of 3

SCREWS, SLOTTED, CHEESE HEAD, PRODUCT GRADE 'A' COARSE PITCH, STEEL, PROPERTY CLASS 4.8 (M1.6 - M10)

1 DESIGNATION

A slotted, cheese head, product Gr.A steel screw of size M10, length 40 mm, coarse pitch and of property class 4.8 shall be designated as

1.1 On drawings

- i) Material specification column : AA7124102
- ii) Description column : SCRU SLT CHS A M10X40-4.8

1.2 On indents

Screws Slotted Cheese Head, A M10X40-4.8; AA7124102

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.

2 COMPLIANCE WITH STANDARDS

2.1 Dimensions, Tolerances & General Requirements

As per IS 1366-2002, Table-1

2.2 Mechanical properties

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

Permissible hardness 124-250 HB

2.3 Threads

Pitch - Coarse to IS 4218, Part 2

Tolerance quality - Medium

Tolerance class - 6g

2.4 Finish

As specified in BHEL order

Revisions:
As per clause 34.2.A) of MOM of MRC-F

APPROVED:
INTERPLANT MATERIAL RATIONALISATION
COMMITTEE – MRC (F)

Rev. No. 07	Amd. No.	Reaffirmed	Prepared HEP, Bhopal	Issued Corp. R&D	Dt. of 1 st Issue 01-01-1977
Dt: 25-10-2016	Dt:	Year:			

3 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** Sizes to the left side of the dotted lines are threaded upto the head.
- 3.3** For screw threads, general (Metric) refer to BHEL standard AA0231800
- 3.4** For tolerance grade, position and class refer to BHEL standard AA0230201
- 3.5** For slotted, cheese head, brass screw refer to BHEL standard AA7124105
- 3.6** Screws to this standard would be un-plated, 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 for commercial transactions.
- 3.8** When fasteners are to be tested with in BHEL, sampling and acceptance plan shall be as per IS 1367, Part 17

4 REFERRED STANDARDS (Latest publications including amendment)

- 1) IS 1367, Part-3 & 17
- 2) IS 4218, Part-2
- 3) AA0231800
- 4) AA0230201
- 5) AA7124105
- 6) AA0231850
- 7) AA0231852

EXPLANATORY NOTE

The following changes have been made in this revision

- Clause 2.2 & 2.3 year of reference is removed.
- Table 1 updated as per IS 1366-2002.

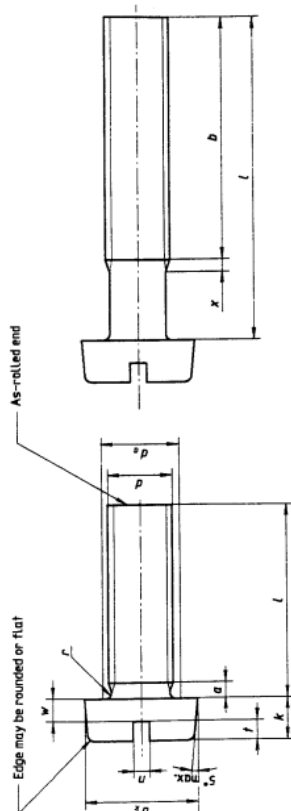


Figure 1

- NOTE**
1. Corporate Sub-Code Numbers are shown below.
 2. Weights have been shown in kg. per 1000 Nos.
 3. For ends refer AA0231852, when chamfered.
 4. For 'a' and 'x' refer AA0231850
 5. Screws with nominal lengths above the dotted lines are thread upto the head.

All dimensions are in mm

TABLE-1

Size d	Head		Slot		Threaded length		NOM. LENGTH (L)																				
	Dia Ø d _k	T _k k	Width n	Depth t			2	2.5	3	4	5	6	8	10	12	16	20	25	30	35	40	45	50	55	60	70	80
Max	Min.	Max.	Min.	Max.	Min.	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	
M 1.6	3	1.10	0.6	0.45	25.7	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	
	2.85	0.96	0.46			Weight																					
M 2	3.8	1.40	0.7	0.60	25.8	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	
	3.62	1.26	0.56			Weight																					
M 2.5	4.5	1.80	0.8	0.70	25.9	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	25	Sub-Code	
	4.32	1.66	0.66			Weight																					
M 3	5.5	2	1	0.85	26	Sub-Code	26	Sub-Code	26	Sub-Code	26	Sub-Code	26	Sub-Code	26	Sub-Code	26	Sub-Code	26	Sub-Code	26	Sub-Code	26	Sub-Code	26	Sub-Code	
	5.32	1.86	0.86			Weight																					
M 4	7	2.6	1.51	1.1	39.4	Sub-Code	39.4	Sub-Code	39.4	Sub-Code	39.4	Sub-Code	39.4	Sub-Code	39.4	Sub-Code	39.4	Sub-Code	39.4	Sub-Code	39.4	Sub-Code	39.4	Sub-Code	39.4	Sub-Code	
	6.78	2.46	1.26			Weight																					
M 5	8.5	3.3	1.51	1.3	39.5	Sub-Code	39.5	Sub-Code	39.5	Sub-Code	39.5	Sub-Code	39.5	Sub-Code	39.5	Sub-Code	39.5	Sub-Code	39.5	Sub-Code	39.5	Sub-Code	39.5	Sub-Code	39.5	Sub-Code	
	8.28	3.12	1.26			Weight																					
M 6	10	3.9	1.91	1.6	40	Sub-Code	40	Sub-Code	40	Sub-Code	40	Sub-Code	40	Sub-Code	40	Sub-Code	40	Sub-Code	40	Sub-Code	40	Sub-Code	40	Sub-Code	40	Sub-Code	
	9.78	3.6	1.66			Weight																					
M 8	13	5	2.31	2	40.5	Sub-Code	40.5	Sub-Code	40.5	Sub-Code	40.5	Sub-Code	40.5	Sub-Code	40.5	Sub-Code	40.5	Sub-Code	40.5	Sub-Code	40.5	Sub-Code	40.5	Sub-Code	40.5	Sub-Code	
	12.73	4.7	2.05			Weight																					
M 10	16	6	2.81	2.4	41	Sub-Code	41	Sub-Code	41	Sub-Code	41	Sub-Code	41	Sub-Code	41	Sub-Code	41	Sub-Code	41	Sub-Code	41	Sub-Code	41	Sub-Code	41	Sub-Code	
	15.73	5.7	2.56			Weight																					