



CORPORATE STANDARD

AA 716 40 02

REV. No. 05

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WASHERS, SPRING LOCK, SINGLE COIL, RECTANGULAR, SECTION, TYPE - B (WITH FLAT ENDS), STEEL

1.0 DESIGNATION:

A single coil, rectangular section, spring lock washer, Type -B (with flat ends) for right hand threads, of nominal size 5 mm, and made of steel shall be designated as:

1.1 On Drawings:

- i) Material specification column-AA 716 40 02.
- ii) Description column- WASHER SPRING LOCK SC B 5-ST.

1.2 On Indents:

Washer Spring Lock B 5- AA 716 40 02

1.3 For issuing enquiries and on purchase orders:

While issuing enquiries and purchase orders, delete the Corporate Standard No. from the above description and add the information given under clause 2.

2.0 COMPLIANCE WITH STANDARDS:

- | | | |
|---|---|---|
| 2.1 Dimensions, Tolerances & General Requirements | : | To IS: 3063/Reaffirmed 2004, Type - B (Table-IA). |
| 2.2 Material | : | Spring steel Gr.3 to Gr.6, as specified in IS 4072. |

Revisions: Cl. 27.1.2 of MOM of WG (F)

Approved: **INTERPLANT
STANDARDIZATION COMMITTEE - WG (F)**

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**2.3 Heat Treatment and Hardness:**

Spring washer after coiling shall be suitably heat treated, so as to result in the finished washer having a hardness in the range of 430 - 530 HV.

2.4 Finish:

Unplated.

3.0 NOTE:

3.1 For washers spring lock, Type - A refer Corporate Standard AA 716 40 01.

3.2 Lock washers to this standard would be unplated, divisions wishing to have plated washers would have to get them plated.

3.3 Weights given in this standard are for general reference only and are not meant for commercial transactions.

3.4 When the fasteners are to be tested within BHEL, the following sampling plan based on IS:6821 (Table-1) shall be followed as detailed below for physical properties.

LOT SIZE	SAMPLE SIZE	ACCEPTANCE No.
Upto 1000	5	0
1001 - 3000	8	0
3001 - 10000	13	0
10001 - 35000	20	0
Over 35000	32	1

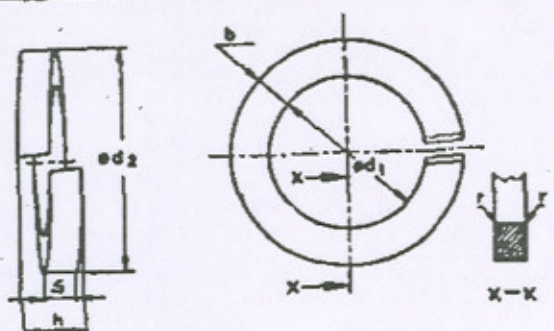


FIG. 1

Note:

1. Corporate sub-code Numbers only are shown in Table 1.
2. Weights have been shown in kg per 1000 No.

TABLE 1
All dimensions are in 'mm'

Nom size	Internal Dia. d_1		Out-side dia. d_2	Width b		Thickness s		Radius r Nom	For Bolt Nut or Screw size	Sub-code	Weight
	Basic	Tol+		Basic	Tol+	Basic	Tol+				
2	2.1	0.3	4.4	0.9	0.1	0.5	0.1	0.1	M2		0.033
2.2	2.3	0.3	4.8	1.0	0.1	0.6	0.1	0.1	M2.2		0.050
2.5	2.6	0.3	5.1	1.0	0.1	0.6	0.1	0.1	M2.5		0.053
3.0	3.1	0.3	6.2	1.3	0.1	0.8	0.1	0.2	M3	010	0.112
4.0	4.1	0.3	7.6	1.5	0.1	0.9	0.1	0.2	M4	029	0.18
5.0	5.1	0.3	9.2	1.8	0.1	1.2	0.1	0.2	M5	037	0.36
6.0	6.1	0.4	11.8	2.5	0.15	1.6	0.1	0.3	M6	045	0.83
8.0	8.1	0.4	14.8	3.0	0.15	2.0	0.1	0.5	M8	053	1.60
10.0	10.2	0.5	18.1	3.5	0.2	2.2	0.15	0.5	M10	061	2.53
12.0	12.2	0.5	21.1	4.0	0.2	2.5	0.15	1.0	M12	070	3.82
16.0	16.2	0.8	27.4	5.0	0.2	3.5	0.2	1.0	M16	088	8.91
20.0	20.2	1.0	33.6	6.0	0.2	4.0	0.2	1.0	M20	096	15.2
24.0	24.5	1.0	40.0	7.0	0.25	5.0	0.2	1.6	M24	100	26.2
30.0	30.5	1.2	48.2	8.0	0.25	6.0	0.2	1.6	M30	118	44.3
36.0	36.5	1.2	58.2	10.0	0.25	6.0	0.2	1.6	M36	126	67.3
42.0	42.5	1.2	68.2	12.0	0.25	7.0	0.25	2.0	M42		111
48.0	49.0	1.5	75.0	12.0	0.25	7.0	0.25	2.0	M48		123
52.0	53.0	1.5	83.0	14.0	0.25	8.0	0.25	2.0	M52		182
56.0	57.0	1.5	87.0	14.0	0.25	8.0	0.25	2.0	M56		193
60.0	61.0	1.5	91.0	14.0	0.25	8.0	0.25	2.0	M60		203
64.0	65.0	1.5	95.0	14.0	0.25	8.0	0.25	2.0	M64		218

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4.0 REFERRED STANDARDS : (Latest Publications Including Amendments)

IS 2507 AA 716 40 01

IS 6821