



CORPORATE STANDARD

AA 715 91 01

Rev. No. 06

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NUTS, HEXAGON (WITH NON-METALLIC INSERT) STYLE 1, PREVAILING TORQUE, PRODUCT Gr:A, COARSE PITCH, STEEL, PROPERTY CLASS 8 (M3 - M16)

1.0 DESIGNATION:

A prevailing torque type, hexagon nut with non-metallic insert, style 1 thread M10 Product Gr:A, coarse pitch and conforming to property class 8 shall be designated as:

1.1 On drawings:

- i) Material specification column : AA 715 91 01.
- ii) Description column : NUT HEX PVLNG TORQ A M10-8

1.2 On indents:

Nut Hex prevailing torque A M10-8, AA 715 91 01.

1.3 For issuing enquiries and on purchase orders:

While issuing enquiries and purchase orders, delete Corporate standard number from the above description and add the information given under clause 2.

2.0 COMPLIANCE WITH STANDARDS:

2.1 Dimensions, tolerances and general requirements:

As per IS:7002-1991, Table-1.

2.2 Mechanical properties:

2.2.1 For nuts:

To confirm to property class 8, as specified in Table-5 of IS:1367, part 8 -1992

2.2.2 Insert for nut:

Nut insert to be made from polyamide or equivalent material as stated in IS:1367, part 8.

2.3 Identification Marking:

As stated in clause 7 of IS:1367, Part 8.

2.4 Threads:

Pitch-Coarse to IS:4218, Part 2.

Tolerance quality - Medium.

Tolerance class - 6H.

2.5 Finish: Zinc plated and chromated as per IS:1367, part 11.

Revisions :

Cl. 25.7.30 of MOM of WG-F

APPROVED :

INTERPLANT
STANDARDIZATION COMMITTEE (WG-F)

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HARDWAR

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**3.0 NOTE:**

- 3.1** The nut and insert form a single factory pre-assembled unit.
- 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** Weights given in this standard are for general reference only and are not for commercial transactions.
- 3.5** For nuts, hexagon with non-metallic insert style 1, prevailing torque, product Gr:B, coarse pitch, steel, property class 8 (M20-M36), refer BHEL standard AA 715 91 02.
- 3.5** When fasteners are to be tested with in BHEL, the following sampling plan shall be followed 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

4.0 REFERRED STANDARDS (Latest publications including amendment):

- | | | |
|-----------------------|-------------------|-----------------|
| 1) IS:1367, Pt 8 & 11 | 2) IS: 4218, Pt 2 | 3) IS: 7002 |
| 4) AA 02302 01 | 5) AA 023 18 00 | 6) AA 715 91 02 |

EXPLANATORY NOTE:

The following changes have been made in this revision:

- In clause 2.2.1, year of IS:1367, part 8 is 1992.

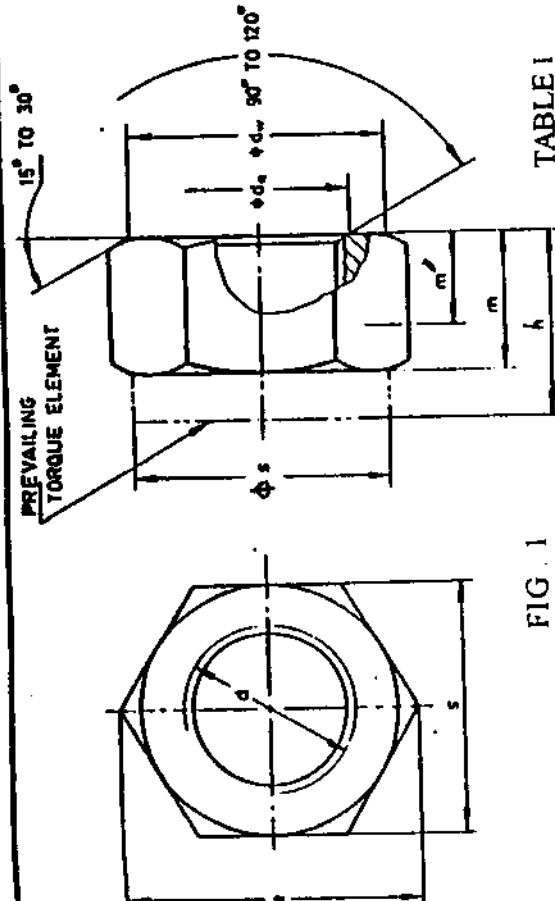


FIG. 1

TABLE I

All dimensions are in mm

THREAD SIZE	FLAT	CORNER	THICKNESS	Wrench Height				SUB-CODE
d	s	e	m	m'	h	d _w	d _a	WEIGHT
NOM.	MIN. MAX.	MIN.	MIN.	MIN. MAX.	MAX.	MIN.	MIN. MAX.	
M3	5.32 5.5	6.01	2.15	1.65 4.5	4.5	4.6	3 3.45	090 / 0.98
M4	6.78 7	7.66	2.90	2.20 6	6	5.9	4 4.60	014 / 1.29
M5	7.78 8	8.79	4.40	2.75 6.8	6.8	6.9	5 5.75	022 / 1.92
M6	9.78 10	11.05	4.90	3.3 8	8	8.9	6 6.75	030 / 3.30
M8	12.73 13	14.38	6.44	4.4 9.5	9.5	11.6	8 8.75	049 / 7.24
M10	15.73 16	17.77	8.04	5.5 11.9	11.9	14.6	10 10.80	057 / 16.2
M12	17.73 18	20.03	10.37	6.6 14.9	14.9	16.6	12 13	065 / 22.5
M16	23.67 24	26.75	14.10	8.8 19.1	19.1	22.5	16 17.3	073 / 44.5

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