



CORPORATE STANDARD

AA 712 31 23

Rev. No. 07

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SCREWS, CAP, HEXAGON SOCKET HEAD, PRODUCT GR. A, COARSE PITCH, STEEL, PROPERTY CLASS 12.9 (M3 - M36)

1.0 DESIGNATION:

A hexagon socket head, cap screw of nominal size M10, length 30mm, coarse pitch, product grade A and of property class 12.9 shall be designated as :

1.1 On drawings:

- i) Material specification column: AA 712 31 23
- ii) Description column: SCRU CAP SOCK A M10 X 30 – 12.9

1.2 On indents:

Screw Hex socket head, cap A M10 X 30 – 12.9: AA 712 31 23.

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 COMPLIANCE WITH STANDARDS:

2.1 Dimensions, Tolerances & General Requirements: As per IS: 2269 - 2006.

2.2 Mechanical properties:

To conform to property Cl. 12.9, 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: 5g - 6g.

2.4 Identification Marking:

As stated in clause 9 of IS: 1367, Part 3 (except for sizes up to M10)

2.5 Surface Discontinuity: As per IS: 1367, Part 9

2.6 Finish: Plated as specified in BHEL order.

3.0 NOTE:

3.1 Length and diameter combination (refer Table 1 on page 3 of 4) between the bold lines should only be used.

3.2 Sizes to the left side of the dotted lines are threaded to the head within 3P.

Revisions : As per Clause. 29.1.2 of 29th MOM of WG-F

APPROVED:

INTERPLANT
STANDARDIZATION COMMITTEE (WG-F)

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3.3 For screw threads, general (Metric) refer to BHEL standard AA 023 18 00

3.4 For tolerance grade, position and class refer to BHEL standard AA 023 02 01

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 transaction.

3.7 The screws to this standard can also be supplied with diamond / straight knurling on the external side of head.

3.8 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: 1367, Pt.3, 9 & 17 2) IS: 2269 3) IS: 4218, Pt 2 4) AA 023 02 01
5) AA 023 18 00 6) AA 023 18 50

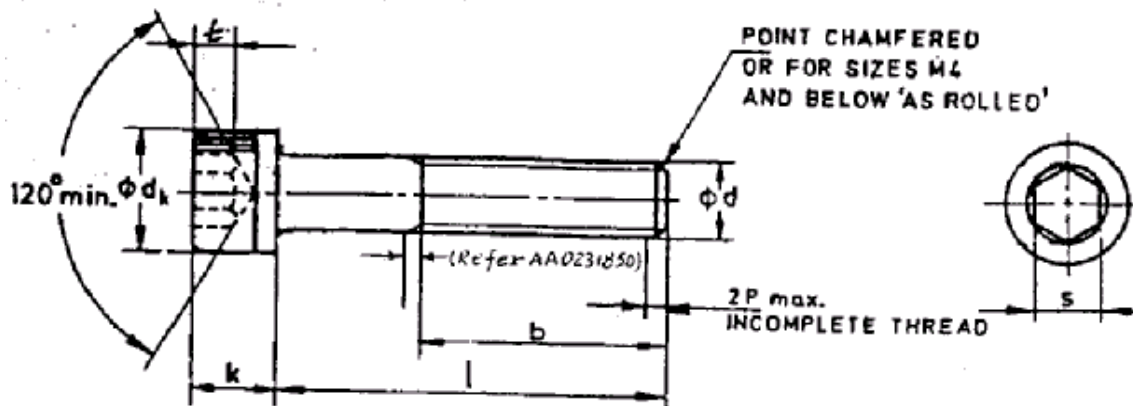


FIG. 1

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EXPLANATORY NOTE :

The following changes have been made in this revision:
Cl 2.1, 2.2, 2.3 & 2.5 - modified.