



CORPORATE STANDARD

AA7126938

Rev. No. 05

PAGE 1 of 3

SCREWS, HAMMER DRIVE, STEEL

1 DESIGNATION

A Hammer Drive screw of screw No.4, length 8 mm and made of steel shall be designated as

1.1 On drawings

- i) Material specification column : AA7126938
- ii) Description column : SCRU HAMMER No.4X8-ST

1.2 On indents

Screw, Hammer Drive, No. 4 x 8-ST: AA7126938

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 7519-1974, Table-1 & 2

2.2 Material

As specified in IS 7519

2.3 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. 05	Amd. No.	Reaffirmed	Prepared HEP, Bhopal	Issued Corp. R&D	Dt. of 1 st Issue 01-01-1977
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DRC-R5050

**3 NOTE**

- 3.1** Length & Screw No. Combination (refer Table-1 at page 3 of 3) between the bold lines should only be used.
- 3.2** Hammer drive screws shall have fully formed threads, extending from the base of the pilot to the head, except that threads at the starting end and under the head may be complete for a length equal to one-half of the maximum screw diameter due to the natural flow of material in the thread forming operation.
- 3.3** The material shall be thick enough to provide adequate thread engagement and the thickness should not normally be less than the screw diameter.
- 3.4** Screws to this standard would be un-plated, 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, sampling and acceptance plan shall be as per IS 1367, Part 17

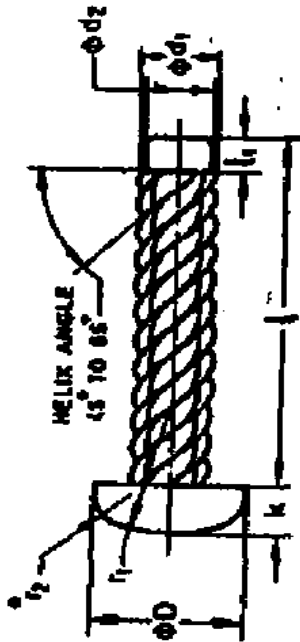
4 REFERRED STANDARDS (Latest publications including amendment)

- 1) IS 1367, Part-17

EXPLANATORY NOTE

The following changes have been made in this revision

- Clause 1.2 modified.
- Clause 2.1, Re-affirmation year of IS: 7519 modified as 2006


FIG. 1

Note:

1. Corporate Sub-code Numbers only are shown in the Table1.
2. Weights have been shown in kg. per 1000 Nos.

Table-1

All dimensions are in mm

Screw No.	Outside diameter d_1 Max.	HEAD		Pilot diameter r d_2 Max.	Number of Thread Starts	Mating hole diameter H11		l_1 Min.	BASIC LENGTH (l)										
		Diameter r D Max.	Height k Max.			Thin sheet metal, nonferrous castings, phenol	Cast Iron, thick sheet metal		Tol. ± 0.4										
									2.4	3.2	4.0	4.8	6.4	8.0	9.5	12.5	16.0	19.0	
00	1.52	2.51	0.86	1.25	6	1.30	1.40	0.50											
0	1.90	3.23	1.24	1.60	6	1.65	1.75	0.90				0.12							
2	2.54	4.12	1.75	2.11	8	2.20	2.30					0.55							
4	2.95	5.36	2.18	2.44	7	2.55	2.70	1.20				0.31		0.20	0.63	101			
6	3.56	6.60	2.62	2.95	7	3.10	3.30					0.49	0.58	0.39	0.71	0.98			
8	4.24	7.85	3.05	3.45	8	3.70	3.90					0.81		0.80					
10	4.62	9.12	3.48	3.84	8	4.10	4.30	1.60				1.30		1.30			0.47		
12	5.38	10.36	3.89	4.50	8	4.80	5.00					2.37							
14	6.15	11.62	4.32	5.13	9	5.50	5.80	2.00									1.10		