



PLANT STANDARD

HPBP TIRUCHIRAPALLI

BPS: 41601

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Based on IS: 7519-1974

HAMMER DRIVE SCREWS

1.0 SCOPE

Covers the requirements for hammer drive screws in the nominal size range 1.5mm to 6mm (Screw No. 00 to 14).

2.0 SPECIFICATION AND REFERENCE STANDARDS

Dimensions and preferred sizes	Table 1 of this standard	
Preferred length-size combination	Table 1 of this standard	
Thread	As specified in IS: 7519	
Material	Suitable steel	
Manufacture and mechanical properties	Screws to be suitably hardened so that when driven in to steel plates of hardness 128/171 HV or cast iron plates, shall produce mating threads without shearing of the threads on the screws or breaking the screws	
Sampling and Acceptability	Indian Standard	IS: 2614
General requirements	Hammer drive screws shall comply with IS: 7519 in respect of requirements not covered in this standard	

2.1 Referred Standards (Only the current versions are applicable)

IS: 2614 Methods for sampling of fasteners

IS: 7519 Specification for hammer drive screws

3.0 DESIGNATION

3. Hammer drive screw to this standard of nominal size 3mm (screw No. 4) and nominal length 6.4mm shall be designated as

REVISIONS

DATE

APPROVED

STANDARDS SECTION
ENGINEERING AND DEVELOPMENT CENTRE
HPBP TIRUCHIRAPALLI

PREPARED
HPBP TIRUCHY

ISSUED
STANDARDS
ENGG

DATE
DEC 1986

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3.1 On drawings:

- i) Material specification column: IS: 7519
- ii) Description column : SCRU HAMMER NS 3x6.4
- iii) Drawing Number column: 4160103006
- iv) Material code column : 4160104006

3.2 Ordering Description

For placing indents, issuing enquiries and on purchase orders, the Ordering Description given below shall be followed.

Screw No. 4x6.4 - IS: 7519

4.0 ADDITIONAL INFORMATION

- 4.1 While preparing ordering description, the exact screw No. & length shall be taken from Table for the appropriate BPS code and material code.
- 4.2 These hammer drive screws are used for permanent fastening of name plates, rating plates and similar parts to iron, brass, aluminium castings and phenol formoldehde plastics. These screws may be used only in material that is thick enough (should normally be more than screw dia) to permit a sufficient engagement of the threads for satisfactory fastening.
- 4.3 The recommended mating hole sizes for hammer drive screws are tabulated below based on IS: 7519.

SCREW NO.	MATING HOLE DIA IN MM (TOL H11)	
	THIN SHEET METAL, NON FERROUS CASTINGS, PHENOL	CAST IRON, THICK SHEET METAL
00	1.30	1.40
0	1.65	1.75
2	2.20	2.30
4	2.55	2.70
6	3.10	3.30
8	3.70	3.90
10	4.10	4.30
12	4.80	5.00
14	5.50	5.80

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