

# DIN EN 14399-8:2019-06 (E)

## High-strength structural bolting assemblies for preloading - Part 8: System HV - Hexagon fit bolt and nut assemblies

---

<b>Contents</b>		<b>Page</b>
European foreword .....		3
Introduction .....		4
<b>1</b>	<b>Scope .....</b>	<b>6</b>
<b>2</b>	<b>Normative references .....</b>	<b>6</b>
<b>3</b>	<b>Fit bolts .....</b>	<b>7</b>
<b>3.1</b>	<b>Dimensions of fit bolts .....</b>	<b>7</b>
<b>3.2</b>	<b>Specifications for fit bolts and reference standards .....</b>	<b>10</b>
<b>3.3</b>	<b>Marking of fit bolts .....</b>	<b>11</b>
<b>4</b>	<b>Nuts .....</b>	<b>11</b>
<b>4.1</b>	<b>Dimensions of nuts .....</b>	<b>11</b>
<b>4.2</b>	<b>Specification for nuts and reference standards .....</b>	<b>13</b>
<b>4.3</b>	<b>Decarburization of the nut thread .....</b>	<b>13</b>
<b>4.4</b>	<b>Marking of nuts .....</b>	<b>13</b>
<b>5</b>	<b>Designation of the bolt/nut assemblies .....</b>	<b>14</b>
<b>6</b>	<b>Associated washers .....</b>	<b>14</b>
<b>7</b>	<b>Functional characteristics of the bolt/nut/washers assembly .....</b>	<b>14</b>
<b>7.1</b>	<b>General .....</b>	<b>14</b>
<b>7.2</b>	<b>Maximum individual value of the bolt force during fitness for purpose test (Fbi max) .....</b>	<b>15</b>
<b>7.3</b>	<b>Values of angle 1 .....</b>	<b>15</b>
<b>7.4</b>	<b>Values of angle 2 .....</b>	<b>15</b>
<b>7.5</b>	<b>Individual values of the k-factor (ki), mean value of the k-factor (km) and coefficient of variation of the k-factor (Vk) .....</b>	<b>15</b>
<b>7.5.1</b>	<b>Individual values of the k-factor (ki) for k-class K1 .....</b>	<b>15</b>
<b>7.5.2</b>	<b>Mean value of the k-factor (km) and coefficient of variation of the k-factor (Vk) for k-class K2 .....</b>	<b>16</b>
<b>Annex A (normative) Clamp lengths and grip lengths .....</b>		<b>17</b>
<b>Bibliography .....</b>		<b>20</b>