

ISO 18954:2026-05 (E)

Steel structures - Structural bolting - Test method to determine parameters of bolt tightening procedures

Contents		Page
Foreword		iv
Introduction		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Symbols	2
5	General	3
6	Mechanical properties of bolting components	6
7	Fitness for purpose test	6
7.1	General	6
7.2	Test apparatus	6
7.3	Test assemblies	7
7.4	Test set-up	7
7.5	Test procedure	8
7.6	Evaluation of the test results	9
7.7	Requirements for suitability	10
7.7.1	General	10
7.7.2	Maximum individual value of the bolt force during the tightening test ($F_{b,max}$)	10
7.7.3	Angle of additional nut rotation	10
7.7.4	Individual values of the k-factor	11
7.8	Test report	11
8	Determination of tightening parameters	12
8.1	General	12
8.2	Criteria for the determination of the tightening parameters	12
Bibliography		14