



Cooper & Turner

**World Class Products for a
Worldwide Market**

**TORQUES
FOR
STRUCTURAL
BOLTING**

Torques for Structural Bolting

Q: What tightening torques should be used for structural bolting?

We can confirm categorically that there are no installation torques for structural bolts / setscrews manufactured in accordance with BS EN 15048. The only reason for torque tightening structural bolts / setscrews would be to preload them, however, structural bolts / setscrews and nuts manufactured in accordance with BS EN 15048 are not designed to be preloaded, if preloading is required then the only suitable assemblies are high-strength structural bolting assemblies for preloading in accordance with BS EN 14399 (the type of assemblies formerly known as HSFG).

For confirmation of the fact that structural bolts / setscrews are not suitable for preloading, reference should be made to BS EN 1090-2 clause 5.6.3 and BS EN 15048-1 and for confirmation of which structural bolting assemblies are suitable for preloading reference should be made to BS EN 1090-2 clause 5.6.4 and BS EN 14399 .

Structural bolts / setscrews should be tightened strictly in accordance with the BCSA and SCI recommendations, contained in the National Structural Steelwork Specification for Building Construction, 5th Edition CE Marking version section 6.1.8 Bolt Tightening which states ' Bolts may be assembled using power tools or shall be fully tightened by hand using spanners in accordance with BS2583'

BS2583 is the specification for podger spanners.

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