



**ROTATIONAL—CAPACITY TEST**  
 Long Bolt Procedure 1-5-95  
 (For bolts long enough to be tested in a Skidmore.)

Test Number \_\_\_\_\_  
 Date \_\_\_\_\_  
 Inspector \_\_\_\_\_

County \_\_\_\_\_ Project # \_\_\_\_\_ Design # \_\_\_\_\_

Skidmore Correction	
Calb. Ave _____ kip	Gauge _____ kip
Calb. Ave – Gauge = _____ kip	

Calculations	
Bolt diameter *D* = _____ inches	
4D = _____ in.	8D = _____ in.
Min. Adj. Tension = Min. Tension x 1.15	

Fastener Type **BLACK** **GALVANIZED**  
 Field Relubricated for this test Yes \_\_\_\_\_ No \_\_\_\_\_

Misc. Information

R – C PROCEDURE (I.M. 391)	
Bolt Length = _____ inches	Read _____ kips
Corrected Skidmore Tension (P) = _____ kips	
(Must be = to, or > than TABLE 2 Tension.) OK? _____	
Measured Torque = _____ ft-lbs	
Max. Permitted Torque = _____ ft-lbs	T=0.25x _____ " x _____ lbs
T < 0.25 x dia/12 x P Measured < Max OK? _____ 12"	
*** Complete R – C Test Rotation. ***	
(Should bring total rotation to 2x the rotation required by Turn-of-Nut.)	
Read _____ kips	
Corrected Skidmore Tension = _____ kips	
(Must be > than TABLE 3 Tension) OK? _____	
Condition of Fastener: Nut OK?	Bolt OK? PASS?

**TABLE 1**

Bolt Dia.	Initial Tension Range
3/4"	3 to 5 kips
7/8"	4 to 6 kips
1"	5 to 7 kips
1-1/8"	6 to 8 kips

**TABLE 2**

Bolt Dia.	Specification Min. Tension
3/4"	28.4 kip
7/8"	39.3 kip
1"	51.5 kip
1-1/8"	56.5 kip

**TABLE 3**

Bolt Dia.	Min. Adj. Tension
3/4"	32.7 kip
7/8"	45.2 kip
1"	59.2 kip
1-1/8"	65.0 kip

**TABLE 4**

Bolt Length	R – C Test Total Rotation
L ≤ 4D	2/3
4D < L ≤ 8D	1
8D < L ≤ 12D	1-1/3

Production Lot# \_\_\_\_\_  
 Bolts \_\_\_\_\_  
 Nuts \_\_\_\_\_  
 Washers \_\_\_\_\_  
 R – C Lot # \_\_\_\_\_

**NOTES:**

R – C Procedure from I.M. 391	
1. Place fastener in Skidmore, use washer under "turned" element. Need a minimum 3 to 5 exposed threads behind the nut. (NOTE: May use a maximum of 3 washers &/or or shim plates.)	
2. Initially tension fastener to values in TABLE 1.	
3. Match mark bolt tip, nut corner, washer/shims, and the Skidmore's base plate. (Mark shall be a straight-line.)	
4. Tighten fastener to at least MINIMUM specified tension in TABLE 2. (Include any Skidmore correction factors.) This tension is required for a calculation in step 6 and is called "P" in the formula below. Check total rotation for step 4. Should be about the same as rotation for Turn-of-Nut.	
5. Record torque required to develop tension in step 4. (Torque is read with nut in motion.)	
6. Torque in step 5 must be less than "Maximum" torque. "Maximum" torque is calculated by T = 0.25 x bolt dia/12 x P. If step 5's torque is less than Maximum, bolt and nut pass. If not, lot fails and entire lot may be relubricated and retested or else replaced.	
7. Complete nut rotation as required by R – C Rotation listed in TABLE 4.	
8. Record tension at the end of step 7's added rotation. (Accounting for any Skidmore correction factors.) Step 8's tension must be greater than MINIMUM shown in TABLE 3. If it is greater, fastener passes. If not, fastener lot fails. If lot fails due to tension being less than minimum shown in TABLE 3, the entire bolt lot may be relubricated and tested again. If bolt breaks during step 7, entire bolt lot fails and shall be replaced.	
9. Loosen nut, remove bolt, and inspect bolt and nut for visible signs of damage. Damage could be thread stripping, nut does not run freely to location of test shims, nut is cracked, bolt is cracked in the threads, etc. If there is evidence of damage, the bolt lot is rejected & shall be replaced.	
10. Conduct test on two randomly selected fasteners. Both tested fasteners must pass the R-C test to accept that lot.	

Bolt Diameters Fraction	Decimal
3/4"	0.750"
7/8"	0.875
1-1/8"	1.125"

ASTM GRADES FOR	
Blk & Galv	Bolt A 325
Black	Nut A 194
Galvanized	Nut A 563
Blk & Galv	Washer F 436