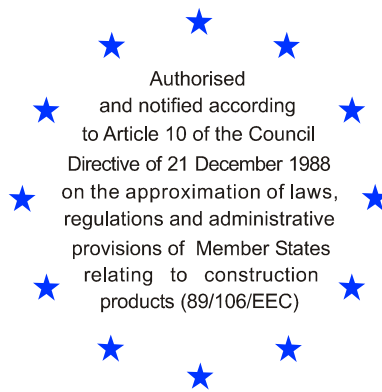


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DIBt

Mitglied der EOTA
Member of EOTA

European Technical Approval ETA-07/0247

English translation prepared by DIBt - Original version in German language

Handelsbezeichnung
Trade name

Halfen Bolzenanker HB-B A4
Halfen Wedge Anchor HB-B A4

Zulassungsinhaber
Holder of approval

Halfen GmbH
Liebigstraße 14
40764 Langenfeld
DEUTSCHLAND

Zulassungsgegenstand
und Verwendungszweck

Kraftkontrolliert spreizender Dübel aus nichtrostendem Stahl in den Größen M6, M8, M10, M12, M16 und M20 zur Verankerung im ungerissenen Beton

*Generic type and use
of construction product*

Torque controlled expansion anchor made of stainless steel of sizes M6, M8, M10, M12, M16 and M 20 for use in non-cracked concrete

Geltungsdauer: vom
Validity: from
bis
to

15 February 2010
28 January 2015

Herstellwerk
Manufacturing plant

Halfen Herstellwerk HB1

Diese Zulassung umfasst
This Approval contains

12 Seiten einschließlich 5 Anhänge
12 pages including 5 annexes

Diese Zulassung ersetzt
This Approval replaces

ETA-07/0247 mit Geltungsdauer vom 23.07.2008 bis 28.01.2010
ETA-07/0247 with validity from 23.07.2008 to 28.01.2010



Europäische Organisation für Technische Zulassungen
European Organisation for Technical Approvals

I LEGAL BASES AND GENERAL CONDITIONS

- 1 This European technical approval is issued by Deutsches Institut für Bautechnik in accordance with:
 - Council Directive 89/106/EEC of 21 December 1988 on the approximation of laws, regulations and administrative provisions of Member States relating to construction products¹, modified by Council Directive 93/68/EEC² and Regulation (EC) N° 1882/2003 of the European Parliament and of the Council³;
 - Gesetz über das In-Verkehr-Bringen von und den freien Warenverkehr mit Bauprodukten zur Umsetzung der Richtlinie 89/106/EWG des Rates vom 21. Dezember 1988 zur Angleichung der Rechts- und Verwaltungsvorschriften der Mitgliedstaaten über Bauprodukte und anderer Rechtsakte der Europäischen Gemeinschaften (Bauprodukten-gesetz - BauPG) vom 28. April 1998⁴, as amended by law of 31 October 2006⁵;
 - Common Procedural Rules for Requesting, Preparing and the Granting of European technical approvals set out in the Annex to Commission Decision 94/23/EC⁶;
 - Guideline for European technical approval of "Metal anchors for use in concrete - Part 2: Torque controlled expansion anchors ", ETAG 001-02.
- 2 Deutsches Institut für Bautechnik is authorized to check whether the provisions of this European technical approval are met. Checking may take place in the manufacturing plant. Nevertheless, the responsibility for the conformity of the products to the European technical approval and for their fitness for the intended use remains with the holder of the European technical approval.
- 3 This European technical approval is not to be transferred to manufacturers or agents of manufacturers other than those indicated on page 1, or manufacturing plants other than those indicated on page 1 of this European technical approval.
- 4 This European technical approval may be withdrawn by Deutsches Institut für Bautechnik, in particular pursuant to information by the Commission according to Article 5(1) of Council Directive 89/106/EEC.
- 5 Reproduction of this European technical approval including transmission by electronic means shall be in full. However, partial reproduction can be made with the written consent of Deutsches Institut für Bautechnik. In this case partial reproduction has to be designated as such. Texts and drawings of advertising brochures shall not contradict or misuse the European technical approval.
- 6 The European technical approval is issued by the approval body in its official language. This version corresponds fully to the version circulated within EOTA. Translations into other languages have to be designated as such.

1 Official Journal of the European Communities L 40, 11 February 1989, p. 12

2 Official Journal of the European Communities L 220, 30 August 1993, p. 1

3 Official Journal of the European Union L 284, 31 October 2003, p. 25

4 *Bundesgesetzblatt Teil I 1998*, p. 812

5 *Bundesgesetzblatt Teil I 2006*, p.2407, 2416

6 Official Journal of the European Communities L 17, 20 January 1994, p. 34

II SPECIFIC CONDITIONS OF THE EUROPEAN TECHNICAL APPROVAL

1 Definition of the construction product and intended use

1.1 Definition of the product

The Halfen Wedge anchor HB-B A4 in the range of M6, M8, M10, M12, M16 and M20 is an anchor made of stainless steel which is placed into a drilled hole and anchored by torque-controlled expansion.

An illustration of the product and intended use is given in Annex 1.

1.2 Intended use

The anchor is intended to be used for anchorages for which requirements for mechanical resistance and stability and safety in use in the sense of the Essential Requirements 1 and 4 of Council Directive 89/106 EEC shall be fulfilled and failure of anchorages made with these products would cause risk to human life and/or lead to considerable economic consequences.

The anchor is to be used only for anchorages subject to static or quasi-static loading in reinforced or unreinforced normal weight concrete of strength classes C20/25 at minimum and C50/60 at most according to EN 206:2000-12.

The anchor may be used in non-cracked concrete only.

The anchor may be used in structures subject to dry internal conditions and also in structures subject to external atmospheric exposure (including industrial and marine environment), or exposure in permanently damp internal conditions, if no particular aggressive conditions exist. Such particular aggressive conditions are e. g. permanent, alternating immersion in seawater or the splash zone of seawater, chloride atmosphere of indoor swimming pools or atmosphere with extreme chemical pollution (e. g. in desulphurization plants or road tunnels where de-icing materials are used).

The provisions made in this European technical approval are based on an assumed working life of the anchor of 50 years. The indications given on the working life cannot be interpreted as a guarantee given by the producer, but are to be regarded only as a means for choosing the right products in relation to the expected economically reasonable working life of the works.

2 Characteristics of the product and methods of verification

2.1 Characteristics of the product

The anchor corresponds to the drawings and provisions given in Annexes 2 and 3. The characteristic material values, dimensions and tolerances of the anchor not given in Annexes 2 and 3 shall correspond to the respective values laid down in the technical documentation⁷ of this European technical approval.

The characteristic values for the design of anchorages are given in Annexes 4 and 5.

Each anchor is marked with the identifying mark of the manufacturing plant, the anchor identity, the anchor size, the maximum thickness of fixture for h_{ef} and $h_{ef,red}$ and the letters "A4" for stainless steel according to Annex 2.

The anchor shall only be supplied as a complete unit.

⁷ The technical documentation of this European technical approval is deposited at the Deutsches Institut für Bautechnik and, as far as relevant for the tasks of the approved bodies involved in the attestation of conformity procedure, is handed over to the approved bodies.

2.2 Methods of verification

The assessment of fitness of the anchor for the intended use in relation to the requirements for mechanical resistance and stability and safety in use in the sense of the Essential Requirements 1 and 4 has been made in accordance with the "Guideline for European technical approval of Metal Anchors for Use in Concrete", Part 1 "Anchors in general" and Part 2 "Torque-controlled expansion anchors", on the basis of Option 7.

In addition to the specific clauses relating to dangerous substances contained in this European technical approval, there may be other requirements applicable to the products falling within its scope (e.g. transposed European legislation and national laws, regulations and administrative provisions). In order to meet the provisions of the Construction Products Directive, these requirements need also to be complied with, when and where they apply.

3 Evaluation and attestation of conformity and CE marking

3.1 System of attestation of conformity

According to the Decision 96/582/EG of the European Commission⁸ the system 2(i) (referred to as system 1) of attestation of conformity applies.

This system of attestation of conformity is defined as follows:

System 1: Certification of the conformity of the product by an approved certification body on the basis of:

(a) Tasks for the manufacturer:

- (1) factory production control;
- (2) further testing of samples taken at the factory by the manufacturer in accordance with a prescribed control plan;

(b) Tasks for the approved body:

- (3) initial type-testing of the product;
- (4) initial inspection of factory and of factory production control;
- (5) continuous surveillance, assessment and approval of factory production control.

Note: Approved bodies are also referred to as "notified bodies".

3.2 Responsibilities

3.2.1 Tasks for the manufacturer

3.2.1.1 Factory production control

The manufacturer shall exercise permanent internal control of production. All the elements, requirements and provisions adopted by the manufacturer shall be documented in a systematic manner in the form of written policies and procedures, including records of results performed. This production control system shall insure that the product is in conformity with this European technical approval.

The manufacturer may only use initial/raw/constituent materials stated in the technical documentation of this European technical approval.

The factory production control shall be in accordance with the control plan which is part of this technical documentation of this European technical approval. The control plan is laid down in the context of the factory production control system operated by the manufacturer and deposited with Deutsches Institut für Bautechnik.⁹

⁸ Official Journal of the European Communities L 254 of 8.10.1996.

⁹ The control plan is a confidential part of the European technical approval and only handed over to the approved body involved in the procedure of attestation of conformity. See section 3.2.2.

The results of factory production control shall be recorded and evaluated in accordance with the provisions of the control plan.

3.2.1.2 Other tasks for the manufacturer

The manufacturer shall, on the basis of a contract, involve a body which is approved for the tasks referred to in section 3.1 in the field of anchors in order to undertake the actions laid down in section 3.2.2 For this purpose, the control plan referred to in sections 3.2.1.1 and 3.2.2 shall be handed over by the manufacturer to the approved body involved.

The manufacturer shall make a declaration of conformity, stating that the construction product is in conformity with the provisions of this European technical approval.

3.2.2 Tasks for the approved bodies

The approved body shall perform the

- initial type-testing of the product,
 - initial inspection of factory and of factory production control,
 - continuous surveillance, assessment and approval of factory production control,
- in accordance with the provisions laid down in the control plan.

The approved body shall retain the essential points of its actions referred to above and state the results obtained and conclusions drawn in a written report.

The approved certification body involved by the manufacturer shall issue an EC certificate of conformity of the product stating the conformity with the provisions of this European technical approval.

In cases where the provisions of the European technical approval and its control plan are no longer fulfilled the certification body shall withdraw the certificate of conformity and inform Deutsches Institut für Bautechnik without delay.

3.3 CE marking

The CE marking shall be affixed on each packaging of the anchor. The letters "CE" shall be followed by the identification number of the approved certification body, where relevant, and be accompanied by the following additional information:

- the name and address of the holder of the approval (legal entity responsible for the manufacture),
- the last two digits of the year in which the CE marking was affixed,
- the number of the EC certificate of conformity for the product,
- the number of the European technical approval,
- the number of the guideline for European technical approval,
- use category (ETAG 001-1 Option 7),
- size.

4 Assumptions under which the fitness of the product for the intended use was favourably assessed

4.1 Manufacturing

The European technical approval is issued for the product on the basis of agreed data/information, deposited with Deutsches Institut für Bautechnik, which identifies the product that has been assessed and judged. Changes to the product or production process, which could result in this deposited data/information being incorrect, should be notified to Deutsches Institut für Bautechnik before the changes are introduced. Deutsches Institut für Bautechnik will decide whether or not such changes affect the approval and consequently the validity of the CE marking on the basis of the approval and if so whether further assessment or alterations to the approval shall be necessary.

4.2 Design of anchorages

The fitness of the anchor for the intended use is given under the following conditions:

The anchorages are designed in accordance with the "Guideline for European technical approval of Metal Anchors for Use in Concrete", Annex C, Method A, under the responsibility of an engineer experienced in anchorages and concrete work.

Verifiable calculation notes and drawings are taking account of the loads to be anchored.

The position of the anchor is indicated on the design drawings (e.g. position of the anchor relative to reinforcement or to supports).

4.3 Installation of anchors

The fitness for use of the anchor can only be assumed if the anchor is installed as follows:

- Anchor installation carried out by appropriately qualified personnel and under the supervision of the person responsible for technical matters of the site,
- Use of the anchor only as supplied by the manufacturer without exchanging the components of an anchor,
- Anchor installation in accordance with the manufacturer's specifications and drawings and using the appropriate tools,
- Checks before placing the anchor to ensure that the strength class of the concrete in which the anchor is to be placed is in the range given and is not lower than that of the concrete to which the characteristic loads apply,
- Check of concrete being well compacted, e.g. without significant voids,
- Edge distances and spacings not less than the specified values without minus tolerances,
- Positioning of the drill holes without damaging the reinforcement,
- In case of aborted hole: new drilling at a minimum distance away of twice the depth of the aborted hole or smaller distance if the aborted drill hole is filled with high strength mortar and if under shear or oblique tension load it is not in the direction of load application,
- Cleaning of the hole of drilling dust,
- Anchor installation such that the effective anchorage depth is complied with. This compliance is ensured, if the existing thickness of fixture is not greater than the maximum thickness of fixture marked on the anchor in accordance with Annex 2,
- Application of the torque moment given in Annex 3 using a calibrated torque wrench.

5 Responsibility of the manufacturer

The manufacturer is responsible to ensure that the information on the specific conditions according to 1 and 2 including Annexes referred to as well as sections 4.2 and 4.3 is given to those who are concerned. This information may be made by reproduction of the respective parts of the European technical approval. In addition all installation data shall be shown clearly on the package and/or on an enclosed instruction sheet, preferably using illustration(s).

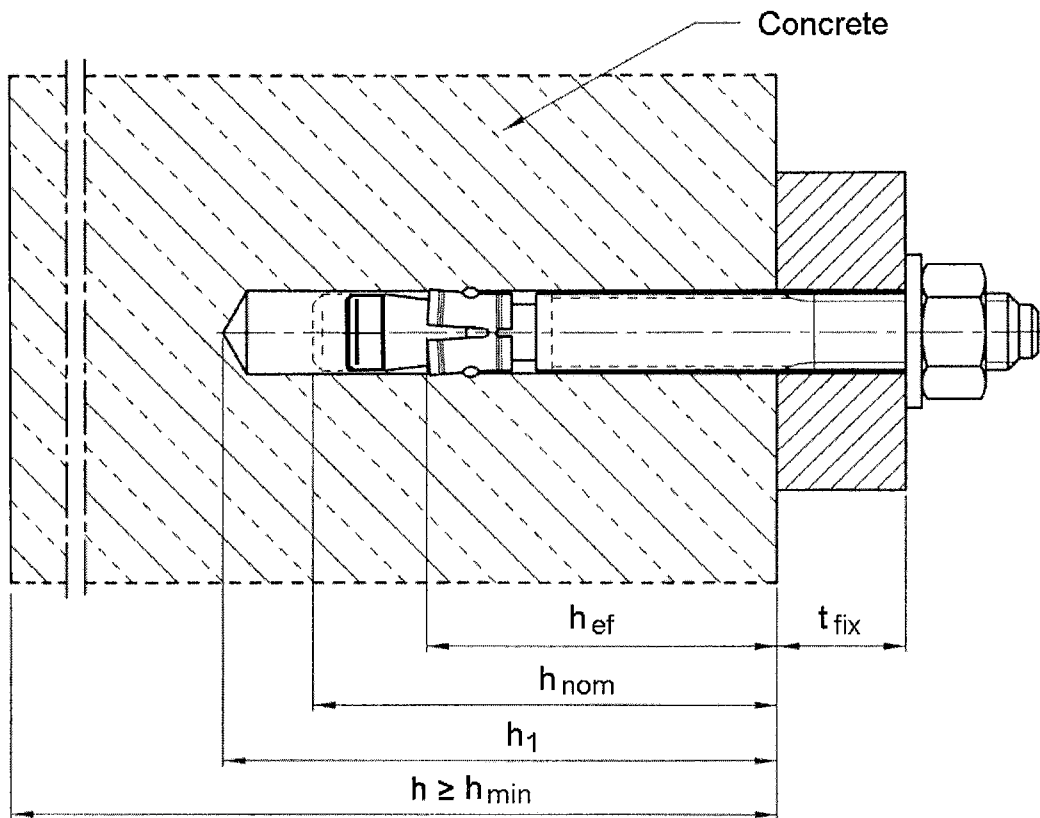
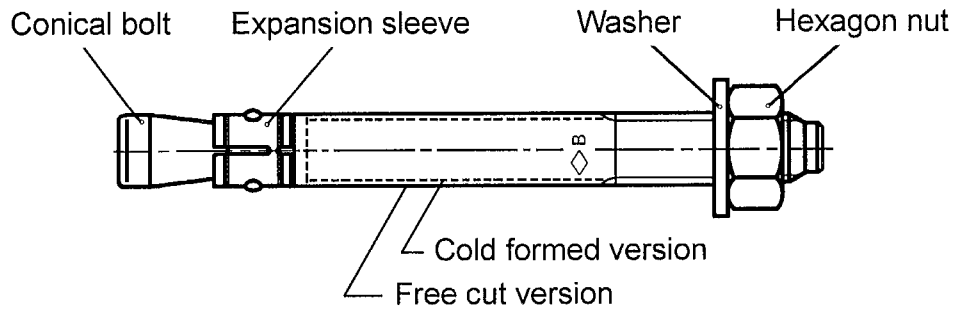
The minimum data required are:

- Diameter of drill bit,
- Thread diameter,
- Maximum thickness of the fixture,
- Minimum effective anchorage depth,
- Minimum hole depth,
- Torque moment,
- Information on the installation procedure, including cleaning of the hole, preferably by means of an illustration,
- Reference to any special installation equipment needed,
- Identification of the manufacturing batch.

All data shall be presented in a clear and explicit form.

Dipl.-Ing. Georg Feistel
Head of Division Construction Engineering
of Deutsches Institut für Bautechnik
Berlin, 15 February 2010

beglaubigt
Tempel



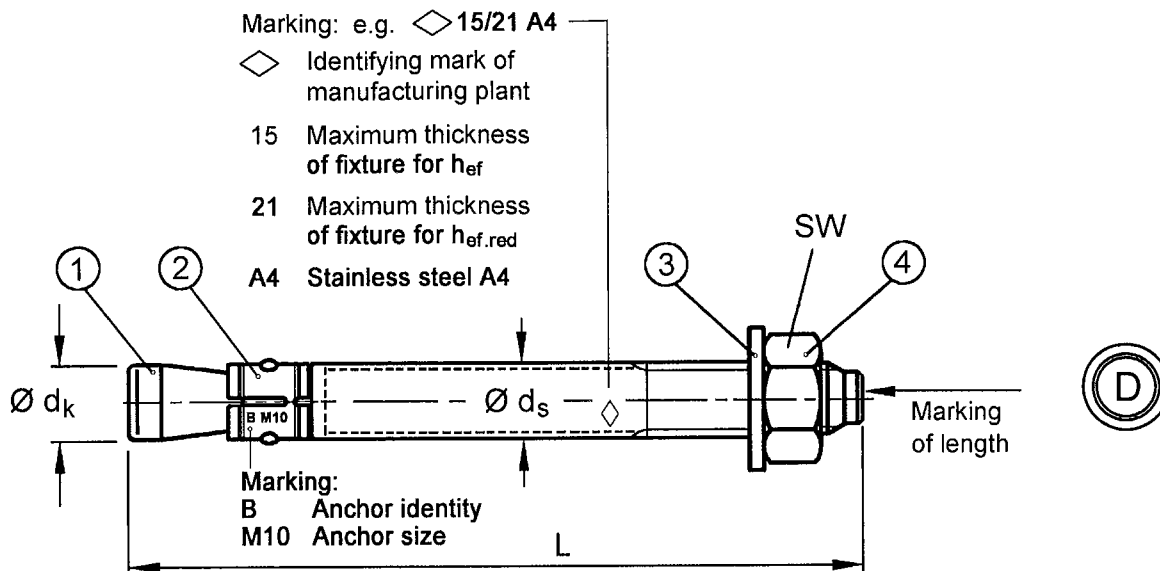
Halfen Wedge Anchor HB-B A4

Product and intended use

Annex 1

of European
technical approval

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Marking of length	A	B	C	D	E	F	G	H	I	J	K	L	M
Length of anchor min \geq	38.1	50.8	63.5	76.2	88.9	101.6	114.3	127.0	139.7	152.4	165.1	177.8	190.5
Length of anchor max $<$	50.8	63.5	76.2	88.9	101.6	114.3	127.0	139.7	152.4	165.1	177.8	190.5	203.2

Marking of length	N	O	P	Q	R	S	T	U	V	W	X	Y	Z
Length of anchor min \geq	203.2	215.9	228.6	241.3	254.0	279.4	304.8	330.2	355.6	381.0	406.4	431.8	457.2
Length of anchor max $<$	215.9	228.6	241.3	254.0	279.4	304.8	330.2	355.6	381.0	406.4	431.8	457.2	483.0

Dimensions in mm

Table 1: Dimensions

Anchor size	$\varnothing d_k$	$\varnothing d_s$	Anchor length L		SW
			Standard anchorage depth	Reduced anchorage depth	
M6	6	6 / 5.3 ¹⁾	$t_{fix} + 57.4$	$t_{fix, hef, red} + 47.4$	10
M8	8	8 / 7.1 ¹⁾	$t_{fix} + 66.4$	$t_{fix, hef, red} + 57.4$	13
M10	10	10 / 8.9 ¹⁾	$t_{fix} + 74.0$	$t_{fix, hef, red} + 68.0$	17
M12	12	12 / 10.7 ¹⁾	$t_{fix} + 96.5$	$t_{fix, hef, red} + 81.5$	19
M16	16	16 / 14.5 ¹⁾	$t_{fix} + 117.8$	$t_{fix, hef, red} + 101.8$	24
M20	19.7	19.7 / 18.2 ¹⁾	$t_{fix} + 142.7$	$t_{fix, hef, red} + 120.7$	30

¹⁾ cold formed version

Table 2: Designations and Materials

Part	Designation	Materials
1	Conical bolt	Stainless steel 1.4401, 1.4404, 1.4571, 1.4578, 1.4362, EN 10088, coated
2	Expansion sleeve	Stainless steel 1.4401, 1.4571, 1.4362, EN 10088
3	Washer acc. to EN ISO 7089, or EN ISO 7093, or EN ISO 7094	Stainless steel 1.4401, 1.4571, 1.4362, EN 10088
4	Hexagon nut DIN 934	ISO 3506, A4-70, stainless steel 1.4401, 1.4571, 1.4362, EN 10088, coated

Halfen Wedge Anchor HB-B A4

Dimensions, Designations and materials of anchor

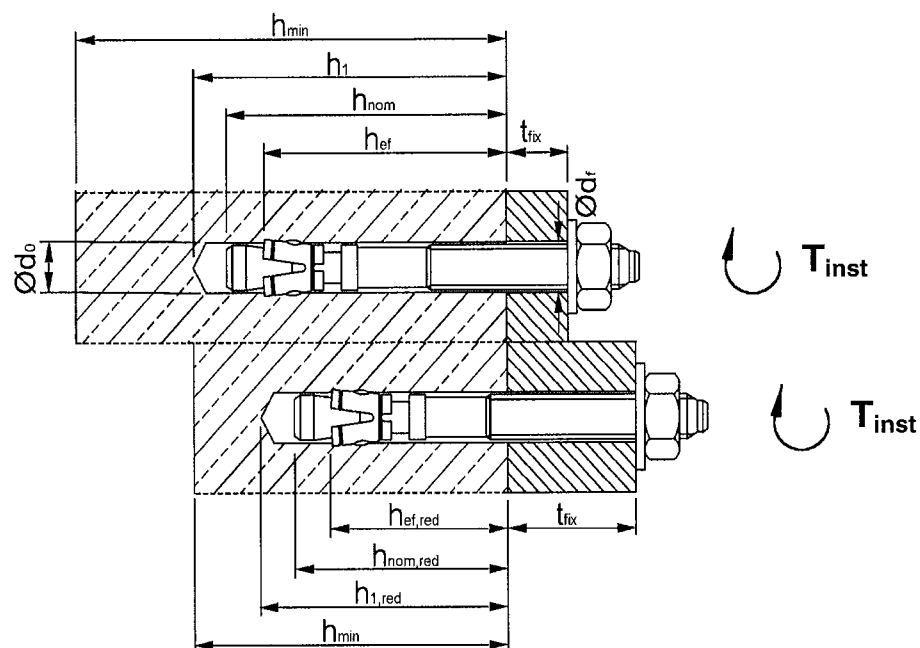
Annex 2

of European technical approval

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Table 3: Installation data

Anchor size			M6	M8	M10	M12	M16	M20
Nominal drill hole diameter	$d_0 =$	[mm]	6	8	10	12	16	20
Cutting diameter of drill bit	$d_{cut} \leq$	[mm]	6.40	8.45	10.45	12.5	16.5	20.55
Torque moment	$T_{inst} =$	[Nm]	6	15	25	50	100	160
Diameter of clearance hole in the fixture	$d_f \leq$	[mm]	7	9	12	14	18	22
Standard anchorage depth								
Depth of drill hole	$h_1 \geq$	[mm]	55	65	70	90	110	130
Embedment depth	$h_{nom} \geq$	[mm]	49	56	62	81	99	121
Effective anchorage depth	$h_{ef} \geq$	[mm]	40	44	48	65	80	100
Reduced anchorage depth								
Depth of drill hole	$h_{1,red} \geq$	[mm]	45	55	65	75	95	110
Embedment depth	$h_{nom,red} \geq$	[mm]	39	47	56	66	83	99
Effective anchorage depth	$h_{ef,red} \geq$	[mm]	30	35	42	50	64	78

**Table 4: Minimum thickness of concrete member, minimum spacing and minimum edge distance**

Anchor size			M6	M8	M10	M12	M16	M20
Standard anchorage depth h_{ef}								
Minimum member thickness	h_{min}	[mm]	100	100	100	130	160	200
Minimum spacing	s_{min}	[mm]	35	35	45	60	80	100
	for $c \geq$	[mm]	40	65	70	100	120	150
Minimum edge distance	c_{min}	[mm]	35	45	55	70	80	100
	for $s \geq$	[mm]	60	110	80	100	140	180
Reduced anchorage depth $h_{ef,red}$								
Minimum member thickness	h_{min}	[mm]	80	80	100	100	130	160
Minimum spacing	s_{min}	[mm]	35	60	55	100	110	140
Minimum edge distance	c_{min}	[mm]	40	60	65	100	110	140

Halfen Wedge Anchor HB-B A4**Annex 3**

**Installation parameters,
Minimum thickness of member, minimum spacing
and edge distance**

of European
technical approval

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Table 5: Design method A, characteristic values for tension loads

Anchor size			M6	M8	M10	M12	M16	M20
Steel failure								
Characteristic resistance	$N_{Rk,s}$	[kN]	10	18	30	44	88	134
Partial safety factor	γ_{Ms} ¹⁾	[-]	1.50					1.68
Pull-out and Splitting for standard anchorage depth h_{ef}								
The higher one of the decisive resistances of Case 1 and Case 2 is applicable.								
Case 1								
Characteristic resistance in non-cracked concrete C20/25	$N_{Rk,p}$ ⁵⁾	[kN]	6	9	12	20	30	40
Respective spacing	$S_{cr,sp}$	[mm]	3 h_{ef}					
Respective edge distance	$C_{cr,sp}$	[mm]	1.5 h_{ef}					
Case 2								
Characteristic resistance in non-cracked concrete C20/25	$N_{Rk,p}$	[kN]	7.5 ⁵⁾	12	16	25	3)	3)
Respective spacing	$S_{cr,sp}$	[mm]	160	220	240	340	410	560
Respective edge distance	$C_{cr,sp}$	[mm]	80	110	120	170	205	280
Pull-out and splitting for reduced anchorage depth $h_{ef,red}$								
Characteristic resistance in non-cracked concrete C20/25	$N_{Rk,p}$	[kN]	6 ⁴⁾	9 ⁴⁾	12	3)	3)	3)
Respective spacing	$S_{cr,sp}$	[mm]	180	210	230	300	320	400
Respective edge distance	$C_{cr,sp}$	[mm]	90	105	115	150	160	200
Increasing factors for $N_{Rk,p}$	ψ_C	C30/37	[-]	1.22				
		C40/50	[-]	1.41				
		C50/60	[-]	1.55				
Concrete cone failure for standard anchorage depth h_{ef}								
Effective anchoring depth	h_{ef}	[mm]	40	44	48	65	80	100
Spacing	$S_{cr,N}$	[mm]	3 h_{ef}					
Edge distance	$C_{cr,N}$	[mm]	1.5 h_{ef}					
Concrete cone failure for reduced anchorage depth $h_{ef,red}$								
Effective anchoring depth	$h_{ef,red}$	[mm]	30 ⁴⁾	35 ⁴⁾	42	50	64	78
Spacing	$S_{cr,N}$	[mm]	3 h_{ef}					
Edge distance	$C_{cr,N}$	[mm]	1.5 h_{ef}					
Partial safety factor	$\gamma_{Mp} = \gamma_{Msp} = \gamma_{Mc}$ ¹⁾	[-]	1.5 ²⁾					

1) In absence of other national regulations

2) The partial safety factor $\gamma_2 = 1.0$ is included

3) Pull-out failure is not decisive.

4) Use restricted to anchorages of indeterminate structural components

5) For the proof against splitting failure according to ETAG 001 Annex C, $N_{Rk,c}^0$ in equation (5.3) has to be replaced by $N_{Rk,p}$ ($\psi_{ucr,sp} = 1.0$).

Table 6: Displacements under tension loads

Anchor size			M6	M8	M10	M12	M16	M20
Standard anchorage depth								
Tension load	N	[kN]	3.6	5.7	7.6	11.9	17.2	24.0
Displacement	δ_{N0}	[mm]	0.7	0.9	0.5	0.6	0.9	2.1
	$\delta_{N_{sc}}$	[mm]	1.8					
Reduced anchorage depth								
Tension load	N	[kN]	2.9	4.3	5.7	8.5	12.3	16.6
Displacement	δ_{N0}	[mm]	0.4	0.7	0.4	0.4	0.6	1.5
	$\delta_{N_{sc}}$	[mm]	1.3					

Halfen Wedge Anchor HB-B A4

**Design method A,
characteristic values for tension loads,
displacements**

Annex 4

of European
technical approval

ETA-07/0247

Table 7: Design method A, characteristic values for shear loads

Anchor Size			M6	M8	M10	M12	M16	M20
Steel failure without lever arm								
Characteristic resistance	$V_{Rk,s}$	[kN]	7	12	19	27	50	86
Partial safety factor	$\gamma_{Ms}^{1)}$	[-]	1.25					1.4
Steel failure with lever arm								
Characteristic bending moment	$M_{Rk,s}^0$	[Nm]	10	24	49	85	199	454
Partial safety factor	$\gamma_{Ms}^{1)}$	[-]	1.25					1.4
Concrete pryout failure for standard anchorage depth h_{ef}								
Factor in equation (5.6) ETAG 001 Annex C, 5.2.3.3	k	[-]	1.0	1.0	1.0	2.0	2.0	2.0
Concrete pryout failure for reduced anchorage depth $h_{ef,red}$								
Factor in equation (5.6) ETAG 001 Annex C, 5.2.3.3	k	[-]	1.0 ³⁾	1.0 ³⁾	1.0	1.0	2.0	2.0
Partial safety factor	$\gamma_{Mcp}^{1)}$	[-]	1.5 ²⁾					
Concrete edge failure for standard anchorage depth h_{ef}								
Effective length of anchor in shear loading	l_f	[mm]	40	44	48	65	80	100
Concrete edge failure for reduced anchorage depth $h_{ef,red}$								
Effective length of anchor in shear loading	l_f	[mm]	30 ³⁾	35 ³⁾	42	50	64	78
Outside diameter of anchor	d_{nom}	[mm]	6	8	10	12	16	20
Partial safety factor	$\gamma_{Mc}^{1)}$	[-]	1.5 ²⁾					

¹⁾ In absence of other national regulations

²⁾ The partial safety factor $\gamma_2 = 1.0$ is included

³⁾ Use restricted to anchorages of indeterminate structural components

Table 8: Displacements under shear loads

Anchor Size			M6	M8	M10	M12	M16	M20
Shear load	V	[kN]	4.0	6.9	10.9	15.4	28.6	43.7
Displacements	δ_{v0}	[mm]	1.1	2.0	1.2	2.0	2.2	2.1
	$\delta_{v\infty}$	[mm]	1.7	3.0	1.8	3.0	3.3	3.2

Halfen Wedge Anchor HB-B A4

**Design method A,
characteristic values for shear loads,
displacements**

Annex 5

of European
technical approval

ETA-07/0247