

Approval body for construction products
and types of construction

Bautechnisches Prüfamt

An institution established by the Federal and
Laender Governments



European Technical Assessment

ETA-19/0209
of 14 May 2019

English translation prepared by DIBt - Original version in German language

General Part

Technical Assessment Body issuing the
European Technical Assessment:

Deutsches Institut für Bautechnik

Trade name of the construction product

TILCA® TIM U-H Injection system for rebar connection

Product family
to which the construction product belongs

Systems for post-installed rebar
connections with mortar

Manufacturer

EFCO Befestigungstechnik AG
Grabenstraße 1
8606 NÄNIKON
SCHWEIZ

Manufacturing plant

EFCO AG, Plant 2

This European Technical Assessment
contains

21 pages including 3 annexes which form an integral part
of this assessment

This European Technical Assessment is
issued in accordance with Regulation (EU)
No 305/2011, on the basis of

EAD 330087-00-0601

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Specific Part

1 Technical description of the product

The subject of this European Technical Assessment is the post-installed connection, by anchoring or overlap connection joint, of reinforcing bars (rebars) in existing structures made of normal weight concrete, using the "TILCA® TIM U-H Injection System for rebar connection" in accordance with the regulations for reinforced concrete construction.

Reinforcing bars made of steel with a diameter ϕ from 8 to 32 mm or the tension anchor ZA from sizes M12 to M24 according to Annex A and injection mortar TILCA® TIM U-H are used for rebar connections. The rebar is placed into a drilled hole filled with injection mortar and is anchored via the bond between rebar, injection mortar and concrete.

The product description is given in Annex A.

2 Specification of the intended use in accordance with the applicable European assessment Document

The performances given in Section 3 are only valid if the anchor is used in compliance with the specifications and conditions given in Annex B.

The verifications and assessment methods on which this European Technical Assessment is based lead to the assumption of a working life of the rebar connection of at least 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.

3 Performance of the product and references to the methods used for its assessment

3.1 Mechanical resistance and stability (BWR 1)

| Essential characteristic | Performance |
|---|---------------|
| Characteristic resistance under static and quasi-static loading | See Annex C 1 |

3.2 Safety in case of fire (BWR 2)

| Essential characteristic | Performance |
|--------------------------|-----------------------|
| Reaction to fire | Class A1 |
| Resistance to fire | See Annex C 2 and C 3 |

4 Assessment and verification of constancy of performance (AVCP) system applied, with reference to its legal base

In accordance with European Assessment Document EAD No. 330087-00-0601, the applicable European legal act is: [96/582/EC].

The system(s) to be applied is (are): 1

5 Technical details necessary for the implementation of the AVCP system, as provided for in the applicable European Assessment Document

Technical details necessary for the implementation of the AVCP system are laid down in the control plan deposited with Deutsches Institut für Bautechnik.

Issued in Berlin on 14 May 2019 by Deutsches Institut für Bautechnik

BD Dipl.-Ing. Andreas Kummerow
Head of Department

beglaubigt:
Baderschneider

Installation post installed rebar

Figure A1: Overlapping joint for rebar connections of slabs and beams

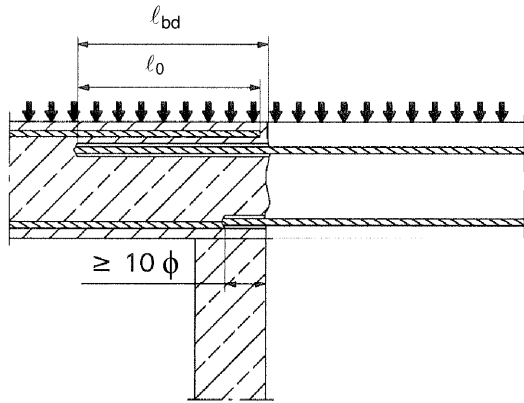


Figure A2: Overlapping joint at a foundation of a wall or column where the rebars are stressed in tension

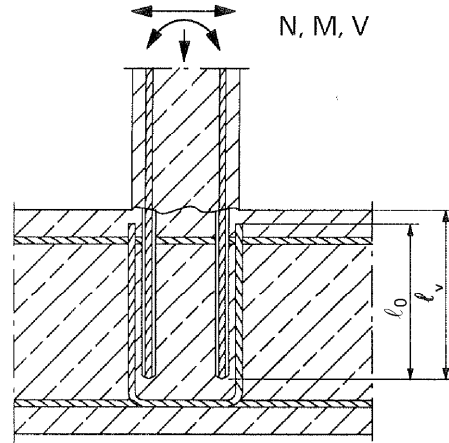


Figure A3: End anchoring of slabs or beams

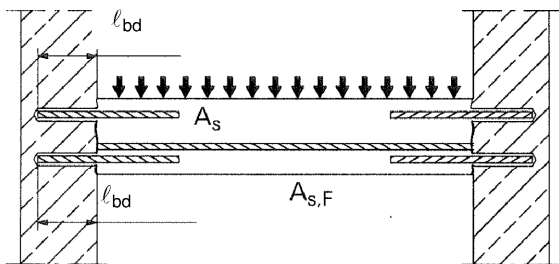


Figure A4: Rebar connection for components stressed primarily in compression. The rebars are stressed in compression

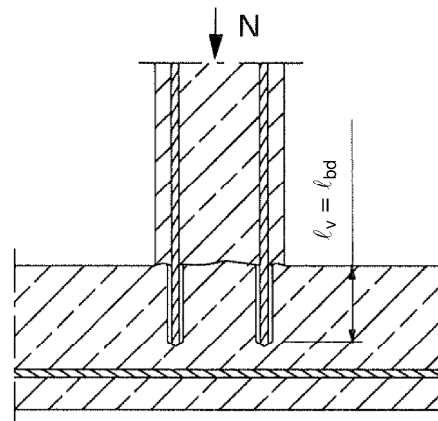
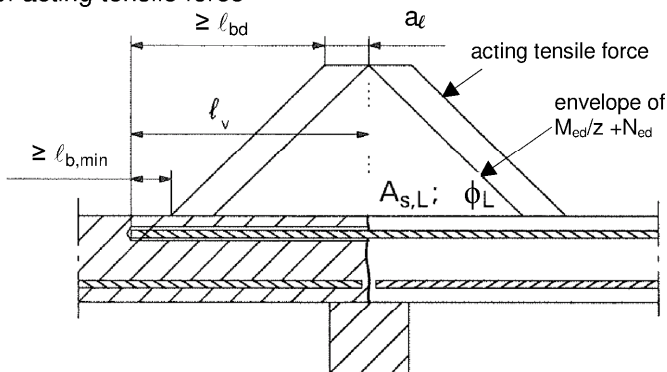


Figure A5: Anchoring of reinforcement to cover the line of acting tensile force



Note to Figure A1 to A5:

In the Figures no transverse reinforcement is plotted, the transverse reinforcement shall comply with EN 1992-1-1:2004+AC:2010.

Preparing of joints according to Annex B 2

TILCA® TIM U-H Injection System for rebar connection

Product description

Installed condition and examples of use for rebars

Annex A 1

Installation tension anchor ZA

Figure A6: Overlapping joint of a column stressed in bending to a foundation

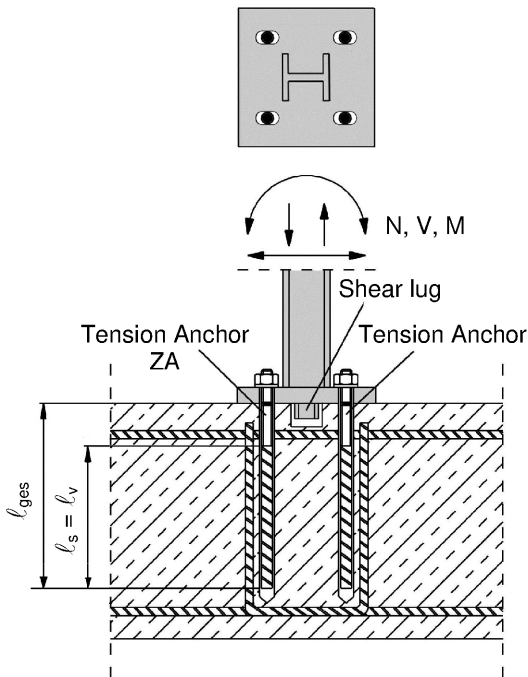


Figure A7: Overlap joint for the anchorage of barrier posts

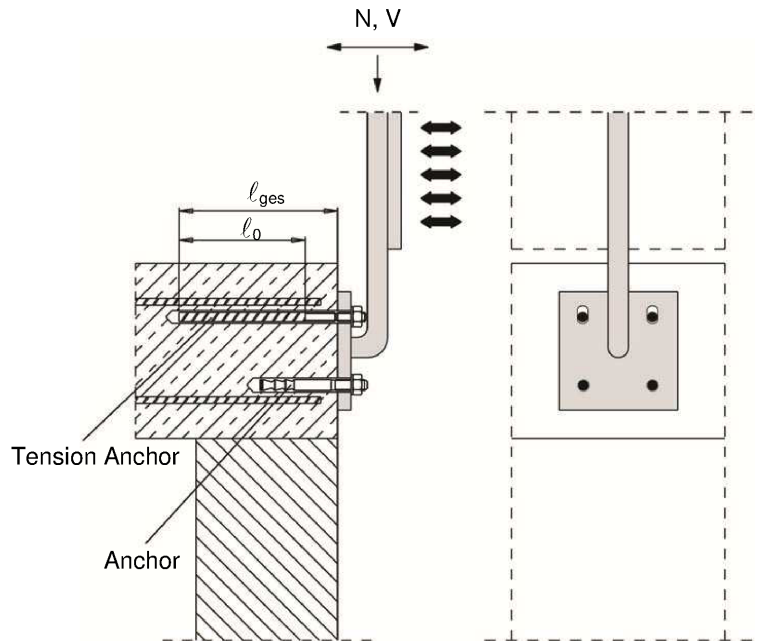
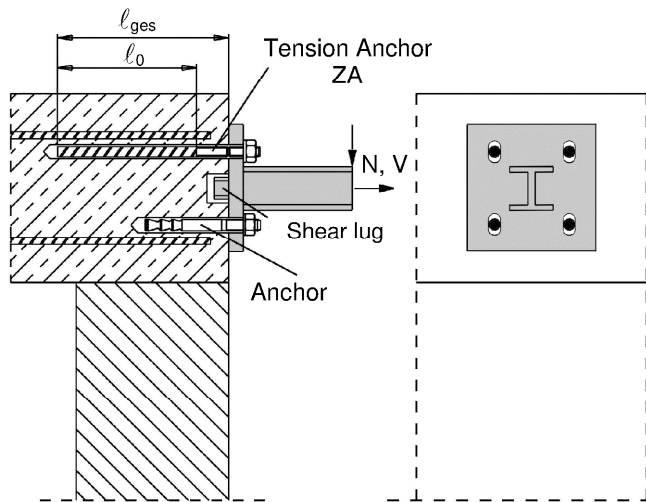


Figure A8: Overlap joint for the anchorage to cantilever members



Note to Figure A6 to A8:

In the Figures no transverse reinforcement is plotted, the transverse reinforcement shall comply with EN 1992-1-1:2002+AC:2010

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TILCA® TIM U-H Injection System for rebar connection

Product description

Installed condition and examples of use for tension anchors ZA

Annex A 2

TILCA® TIM U-H Injection System:

Injection mortar: TILCA TIM U-H

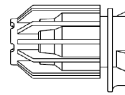
Typ "coaxial": 150 ml, 280 ml,
300 ml up to 333 ml and
380 ml up to 420 ml cartridge

Type "side-by-side":

235 ml, 345 ml and 825 ml
cartridge

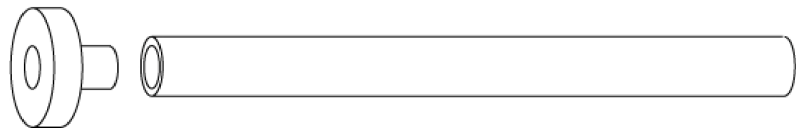
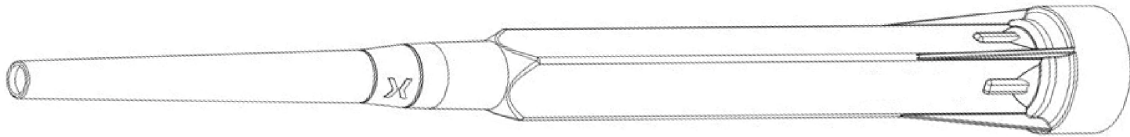


Imprint: TILCA TIM U-H, processing notes,
charge-code, shelf life, hazard-code, curing-
and processing time (depending on the
temperature), optional with travel scale



Imprint: TILCA TIM U-H, processing notes,
charge-code, shelf life, hazard-code, curing-
and processing time (depending on the
temperature), optional with travel scale

Static Mixer

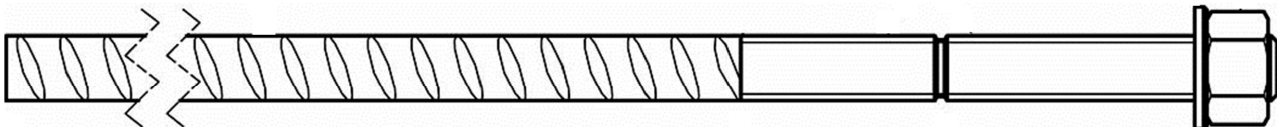


**Piston plug and
mixer extension**

Reinforcing bar (rebar): ø8 to ø32



Tension Anchor ZA: M12 to M24



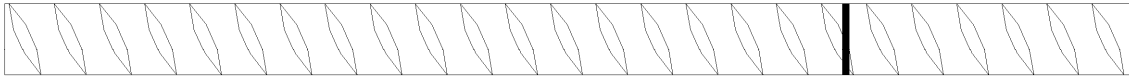
TILCA® TIM U-H Injection System for rebar connection

Product description

Injection mortar / Static mixer / Rebar / Tension Anchor ZA

Annex A 3

Reinforcing bar (rebar): $\varnothing 8, \varnothing 10, \varnothing 12, \varnothing 14, \varnothing 16, \varnothing 20, \varnothing 22, \varnothing 24, \varnothing 25, \varnothing 28, \varnothing 32$



- Minimum value of related rip area $f_{R,min}$ according to EN 1992-1-1:2004+AC:2010
- Rib height of the bar shall be in the range $0,05\phi \leq h \leq 0,07\phi$
(ϕ : Nominal diameter of the bar; h: Rip height of the bar)

Table A1: Materials


| Designation | Material |
|---|--|
| Rebar EN 1992-1-1:2004+AC:2010, Annex C | Bars and de-coiled rods class B or C f_{yk} and k according to NDP or NCL of EN 1992-1-1/NA $f_{uk} = f_{tk} = k \cdot f_{yk}$ |


TILCA® TIM U-H Injection System for rebar connection

Product description
Specifications Rebar

Annex A 4

Tension Anchor ZA: M12, M16, M20, M24

Marking: e.g.  ZA 12 A4

-  Mark of the producer
- ZA Trade name
- 12 Rod diameter/thread
- A4 for stainless steel A4
- HCR for high corrosion resistance steel

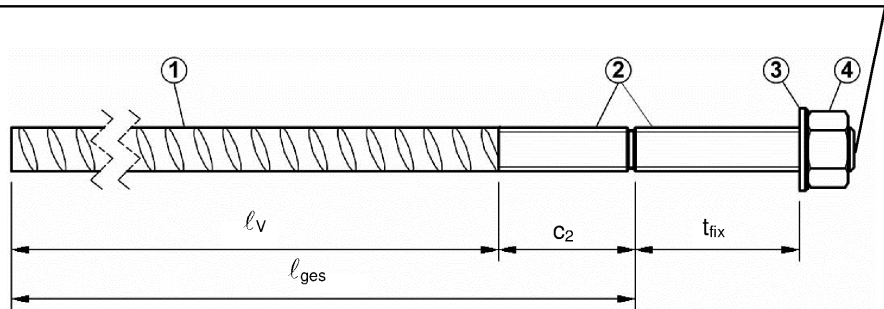


Table A2: Materials

| Part | Designation | Material | | | | | | | | | | | |
|------|-------------------|---|-----|-----|-----|--|-----|-----|-----|---|-----|-----|-----|
| | | ZA vz | | | | ZA A4 | | | | ZA HCR | | | |
| | | M12 | M16 | M20 | M24 | M12 | M16 | M20 | M24 | M12 | M16 | M20 | M24 |
| 1 | Reinforcement bar | Class B according to NDP or NCL of EN 1992-1-1/NA $f_{yk} = f_{tk} = k \cdot f_{yk}$ | | | | | | | | | | | |
| 2 | Threaded rod | Steel, zinc plated according to EN 10087:1998 or EN 10263:2001 | | | | Stainless steel, 1.4362, 1.4401, 1.4404, 1.4571, EN 10088-1:2014 | | | | High corrosion resistant steel, 1.4529, 1.4565, EN 10088-1:2014 | | | |
| | | f_{yk} [N/mm ²] 640 | | | | 640 | | | | 560 | | | |
| 3 | Washer | Steel, zinc plated according to EN 10087:1998 or EN 10263:2001 | | | | Stainless steel, 1.4362, 1.4401, 1.4404, 1.4571, EN 10088-1:2014 | | | | High corrosion resistant steel, 1.4529, 1.4565, EN 10088-1:2014 | | | |
| 4 | Nut | EN 10263:2001 | | | | EN 10088-1:2014 | | | | EN 10088-1:2014 | | | |

Table A3: Dimensions and installation parameter

| Size | | | ZA-M12 | ZA-M16 | ZA-M20 | ZA-M24 |
|---------------------------------------|------------------|---------------------|---------------------------------|--------|--------|--------|
| Diameter of threaded rod | | [mm] | 12 | 16 | 20 | 24 |
| Diameter of reinforcement bar | | [mm] | 12 | 16 | 20 | 25 |
| Drill hole diameter | | [mm] | 16 | 20 | 25 | 32 |
| Diameter of clearance hole in fixture | | [mm] | 14 | 18 | 22 | 26 |
| With across nut flats | SW | [mm] | 19 | 24 | 30 | 36 |
| Stress area | A _s | [mm ²] | 84 | 157 | 245 | 353 |
| Effective embedment depth | l _v | [mm] | according to static calculation | | | |
| Length of bonded thread | plated | c ₂ [mm] | ≥ 20 | ≥ 20 | ≥ 20 | ≥ 20 |
| | A4/HCR | | ≥ 100 | ≥ 100 | ≥ 100 | ≥ 100 |
| Minimum thickness of fixture | t _{fix} | [mm] | 5 | 5 | 5 | 5 |
| Maximum thickness of fixture | t _{fix} | [mm] | 3000 | 3000 | 3000 | 3000 |
| Maximum installation torque | T _{max} | [Nm] | 50 | 100 | 150 | 150 |

TILCA® TIM U-H Injection System for rebar connection

Product description
Specifications Tension Anchor ZA

Annex A 5

Specifications of intended use

Anchorage subject to:

- Static and quasi-static loads.
- Fire exposure

Base materials:

- Reinforced or unreinforced normal weight concrete according to EN 206-1:2000.
- Strength classes C12/15 to C50/60 according to EN 206-1:2000.
- Maximum chloride concrete of 0,40% (CL 0.40) related to the cement content according to EN 206-1:2000.
- Non-carbonated concrete.

Note: In case of a carbonated surface of the existing concrete structure the carbonated layer shall be removed in the area of the post-installed rebar connection with a diameter of $\phi + 60$ mm prior to the installation of the new rebar.

The depth of concrete to be removed shall correspond to at least the minimum concrete cover in accordance with EN 1992-1-1:2004+AC:2010.

The foregoing may be neglected if building components are new and not carbonated and if building components are in dry conditions.

Temperature Range:

- - 40°C to +80°C (max. short term temperature +80°C and max long term temperature +50°C).

Use conditions (Environmental conditions):

- Structures subject to dry internal conditions or subject to external atmospheric exposure (including industrial and marine environment) and to permanently damp internal condition, if no particular aggressive conditions exist (stainless steel or high corrosion resistant steel).
- Structures subject to external atmospheric exposure and to permanently damp internal condition, if other particular aggressive conditions exist (high corrosion resistant steel).

Note: 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).

Design:

- Anchorages are designed under the responsibility of an engineer experienced in anchorages and concrete work.
- Verifiable calculation notes and drawings are prepared taking account of the forces to be transmitted.
- Design according to EN 1992-1-1:2004+AC:2010, EN 1992-1-2:2004+AC:2008 and Annex B 2 and B 3.
- The actual position of the reinforcement in the existing structure shall be determined on the basis of the construction documentation and taken into account when designing.

Installation:

- Dry or wet concrete.
- It must not be installed in flooded holes.
- Overhead installation allowed.
- Hole drilling by hammer drill (HD) hollow drill (HDB) or compressed air drill mode (CD).
- The installation of post-installed rebar resp. tension anchors shall be done only by suitable trained installer and under supervision on site; the conditions under which an installer may be considered as suitable trained and the conditions for supervision on site are up to the Member States in which the installation is done.
- Check the position of the existing rebars (if the position of existing rebars is not known, it shall be determined using a rebar detector suitable for this purpose as well as on the basis of the construction documentation and then marked on the building component for the overlap joint).

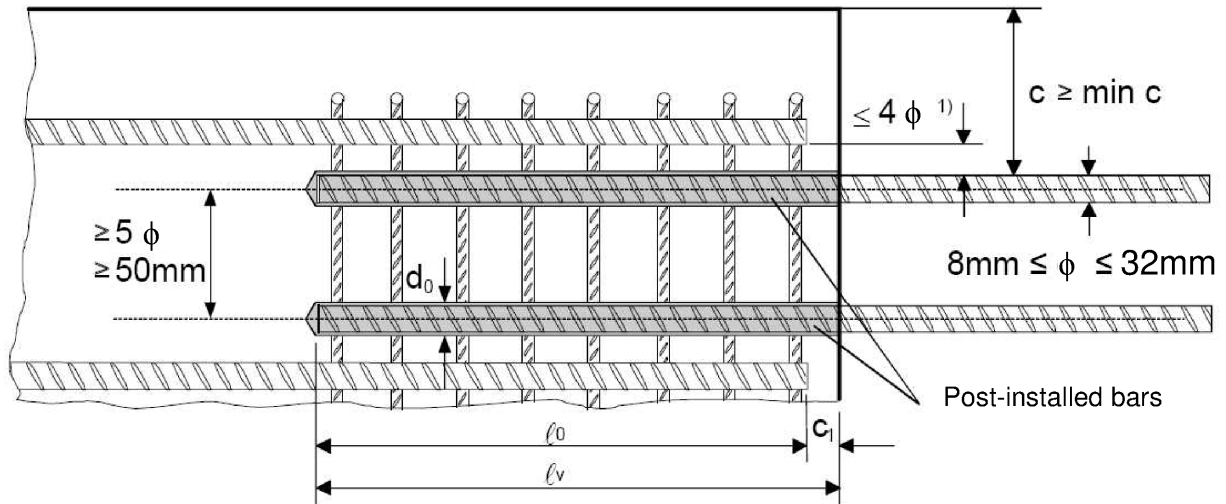
TILCA® TIM U-H Injection System for rebar connection

Intended use
Specifications

Annex B 1

Figure B1: General construction rules for post-installed rebars

- Only tension forces in the axis of the rebar may be transmitted
- The transfer of shear forces between new concrete and existing structure shall be designed additionally according to EN 1992-1-1:2004+AC:2010.
- The joints for concreting must be roughened to at least such an extent that aggregate protrude.



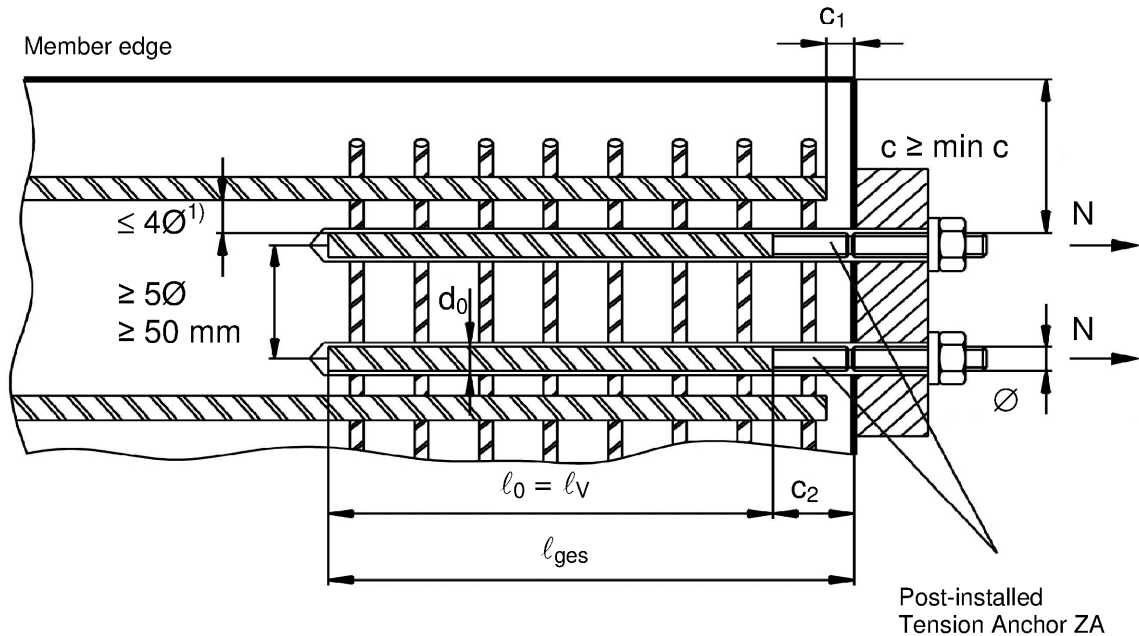
- 1) If the clear distance between lapped bars exceeds 4ϕ , then the lap length shall be increased by the difference between the clear bar distance and 4ϕ .

The following applies to Figure B1:

- c concrete cover of post-installed rebar
- c_1 concrete cover at end-face of existing rebar
- $\min c$ minimum concrete cover according to Table B1 and to EN 1992-1-1:2004+AC:2010, Section 4.4.1.2
- ϕ diameter of post-installed rebar
- l_0 lap length, according to EN 1992-1-1:2004+AC:2010, Section 8.7.3
- l_v effective embedment depth, $\geq l_0 + c_1$
- d_0 nominal drill bit diameter, see Annex B 6

Figure B2: General construction rules for tension anchors ZA

- The length of the bonded-in thread may be not be accounted as anchorage
- Only tension forces in the direction of the bar axis may be transmitted by the tension anchor ZA
- The tension force must be transferred via an overlap joint to the reinforcement in the building part.
- The transfer of shear forces shall be ensured by appropriate additional measures, e.g shear lugs or by anchors with an European technical assessment.
- In the anchor plate, the holes for the tension anchors shall be executed as elongated holes with axis in the direction of the shear force.



- 1) If the clear distance between lapped bars exceeds 4ϕ , then the lap length shall be increased by the difference between the clear bar distance and 4ϕ .

The following applies to Figure B2:

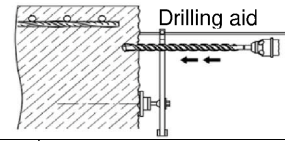
| | |
|------------------|---|
| c | concrete cover of tension anchor ZA |
| c ₁ | concrete cover at end-face of existing rebar |
| c ₂ | Length of bonded thread |
| min c | minimum concrete cover according to Table B1 and to EN 1992-1-1:2004+AC:2010, Section 4.4.1.2 |
| φ | diameter of tension anchor |
| l ₀ | lap length, according to EN 1992-1-1:2004+AC:2010, Section 8.7.3 |
| l _v | effective embedment depth, $\geq l_0 + c_1$ |
| l _{ges} | overall embedment depth, $\geq l_0 + c_2$ |
| d ₀ | nominal drill bit diameter, see Annex B 6 |

TILCA® TIM U-H Injection System for rebar connection

Intended use
General construction rules for tension anchors

Annex B 3

Table B1: Minimum concrete cover $\min c$ ¹⁾ of post-installed rebar and tension anchor ZA depending of drilling method



| Drilling method | Rebar diameter | Without drilling aid | With drilling aid |
|---|----------------------|--|--|
| Hammer drilling (HD) Hollow drill bit system (HDB) | < 25 mm | $30 \text{ mm} + 0,06 \cdot l_v \geq 2 \phi$ | $30 \text{ mm} + 0,02 \cdot l_v \geq 2 \phi$ |
| | $\geq 25 \text{ mm}$ | $40 \text{ mm} + 0,06 \cdot l_v \geq 2 \phi$ | $40 \text{ mm} + 0,02 \cdot l_v \geq 2 \phi$ |
| Compressed air drilling (CD) | < 25 mm | $50 \text{ mm} + 0,08 \cdot l_v$ | $50 \text{ mm} + 0,02 \cdot l_v$ |
| | $\geq 25 \text{ mm}$ | $60 \text{ mm} + 0,08 \cdot l_v$ | $60 \text{ mm} + 0,02 \cdot l_v$ |

¹⁾ see Annex B2, Figures B1 and Annex B3, Figure B2
Comments: The minimum concrete cover acc. EN 1992-1-1:2004+AC:2010 must be observed

Table B2: maximum embedment depth $l_{v,max}$

| Rebar | Tension anchor | $l_{v,max}$ [mm] |
|--------|----------------|--------------------|
| ϕ | ϕ | |
| 8 mm | | 1000 |
| 10 mm | | 1000 |
| 12 mm | ZA-M12 | $1000^{1)} / 1200$ |
| 14 mm | | $1000^{1)} / 1400$ |
| 16 mm | ZA-M16 | $1000^{1)} / 1600$ |
| 20 mm | ZA-M20 | $1000^{1)} / 2000$ |
| 22 mm | | $1000^{1)} / 2000$ |
| 24 mm | | $1000^{1)} / 2000$ |
| 25 mm | ZA-M24 | $1000^{1)} / 2000$ |
| 28 mm | | $1000^{1)} / 2000$ |
| 32 mm | | $1000^{1)} / 2000$ |

¹⁾ maximum embedment depth for use with hollow drill bit system (HDB)

Table B3: Base material temperature, gelling time and curing time

| Concrete temperature | Gelling working time ¹⁾ | Minimum curing time in dry concrete | Minimum curing time in wet concrete |
|-----------------------|------------------------------------|-------------------------------------|-------------------------------------|
| - 5 °C to - 1 °C | 50 min | 5 h | 10 h |
| 0 °C to + 4 °C | 25 min | 3,5 h | 7 h |
| + 5 °C to + 9 °C | 15 min | 2 h | 4 h |
| + 10 °C to + 14 °C | 10 min | 1 h | 2 h |
| + 15 °C to + 19 °C | 6 min | 40 min | 60 min |
| + 20 °C to + 29 °C | 3 min | 30 min | 60 min |
| + 30 °C to + 40 °C | 2 min | 30 min | 60 min |
| Cartridge temperature | +5°C to +40°C | | |

¹⁾ t_{gel} : maximum time from starting of mortar injection to completing of rebar setting.










TILCA® TIM U-H Injection System for rebar connection

Intended use

Minimum concrete cover, maximum embedment depth, working time and curing times

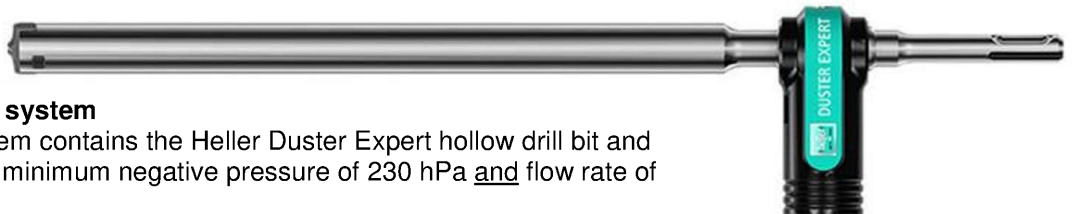
Annex B 4

Table B4: Dispensing tools

| Cartridge type/size | Hand tool | | Pneumatic tool |
|---|---|--|--|
| Coaxial cartridges 150, 280, 300 up to 333 ml |  e.g. Type H 297 or H244C | |  e.g. Type TS 492 X |
| Coaxial cartridges 380 up to 420 ml |  e.g. Type CCM 380/10 |  e.g. Type H 285 or H244C |  e.g. Type TS 485 LX |
| Side-by-side cartridges 235, 345 ml |  e.g. Type CBM 330A |  e.g. Type H 260 |  e.g. Type TS 477 LX |
| Side-by-side cartridge 825 ml | - | - |  e.g. Type TS 498X |

All cartridges could also be extruded by a battery tool.

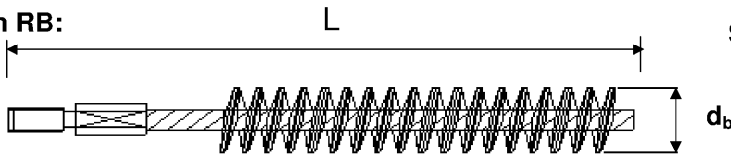
Cleaning and installation tools



HDB – Hollow drill bit system

The hollow drill bit system contains the Heller Duster Expert hollow drill bit and a class M vacuum with minimum negative pressure of 230 hPa and flow rate of minimum 61l/s.

Brush RB:



SDS Plus Adapter:



Brush extension:



Hand pump (volume 750 ml)



Rec. compressed air tool
hand slide valve (min 6 bar)

TILCA® TIM U-H Injection System for rebar connection

Intended Use

Dispensing, cleaning and installation tools

Annex B 5

Table B5: Brushes, piston plugs, max anchorage depth and mixer extension, hammer (HD) and compressed air (CD) drilling

| Bar size ϕ | Tension anchor ϕ | Drill bit - ϕ | | d_b Brush - ϕ | $d_{b,min}$ min. Brush - ϕ | Piston plug | Cartridge: All sizes | | | | Cartridge: side-by-side (825 ml) | | | |
|--------------------|--------------------------|--------------------|----|-------------------------|--|-------------|-------------------------|-----------------|----------------|-----------------|--|-----------------|-----------|------|
| | | HD | CD | | | | Hand or battery tool | | Pneumatic tool | | Pneumatic tool | | | |
| | | | | | | | $l_{v,max}$ | Mixer extension | $l_{v,max}$ | Mixer extension | $l_{v,max}$ | Mixer extension | | |
| [mm] | [mm] | [mm] | | [mm] | [mm] | | [mm] | | [mm] | | [mm] | | | |
| 8 | | 12 | - | RB12 | 13,5 | 12,5 | - | 700 | VL10/0,75 | 800 | VL10/0,75 | 800 | VL10/0,75 | |
| 10 | | 14 | - | RB14 | 15,5 | 14,5 | IA14 | | | 1000 | | 1000 | | 1000 |
| 12 | ZA-M12 | 16 | | RB16 | 17,5 | 16,5 | IA16 | | | | | 1200 | | 1200 |
| 14 | | 18 | | RB18 | 20,0 | 18,5 | IA18 | | | | | 1400 | | 1400 |
| 16 | ZA-M16 | 20 | | RB20 | 22,0 | 20,5 | IA20 | | | | | 1600 | | 1600 |
| 20 | ZA-M20 | 25 | - | RB25 | 27,0 | 25,5 | IA25 | 500 | VL10/0,75 | 700 | VL10/0,75 | 2000 | VL16/1,8 | |
| | | - | 26 | RB26 | 28,0 | 26,5 | IA25 | | | | | | | |
| 22 | | 28 | | RB28 | 30,0 | 28,5 | IA28 | | | | | | | |
| 24 | | 32 | | RB32 | 34,0 | 32,5 | IA32 | | | | | | | |
| 25 | ZA-M24 | 32 | | RB32 | 34,0 | 32,5 | IA32 | | | | | | | |
| 28 | | 35 | | RB35 | 37,0 | 35,5 | IA35 | 500 | VL10/0,75 | 700 | VL10/0,75 | 2000 | VL16/1,8 | |
| 32 | | 40 | | RB40 | 43,5 | 40,5 | IA40 | | | | | | | |

Table B6: Brushes, piston plugs, max anchorage depth and mixer extension, hammer drilling with hollow drill bit system (HDB)

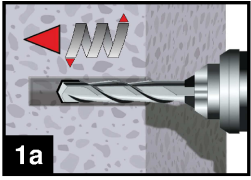
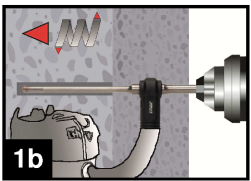

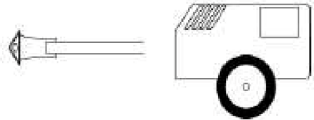
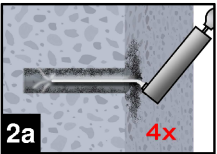
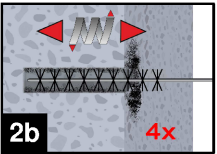
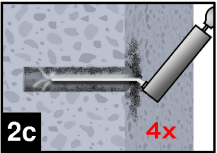
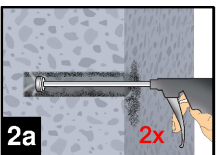
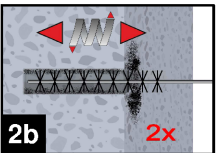
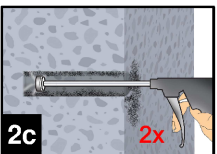
| Bar size ϕ | Tension anchor ϕ | Drill bit - ϕ | d_b Brush - ϕ | $d_{b,min}$ min. Brush - ϕ | Piston plug | Cartridge: All sizes | | | | Cartridge: side-by-side (825 ml) | | | | | | |
|--------------------|--------------------------|--------------------|-------------------------|--|-------------|-------------------------|-----------------|----------------|-----------------|--|-----------------|----------|-----------|------|------|------|
| | | HDB | | | | Hand or battery tool | | Pneumatic tool | | Pneumatic tool | | | | | | |
| | | | | | | $l_{v,max}$ | Mixer extension | $l_{v,max}$ | Mixer extension | $l_{v,max}$ | Mixer extension | | | | | |
| [mm] | [mm] | [mm] | | | | | [mm] | | [mm] | | [mm] | | | | | |
| 8 | | 12 | No cleaning required | | | 700 | VL10/0,75 | 800 | VL10/0,75 | 800 | VL10/0,75 | 800 | VL10/0,75 | | | |
| 10 | | 14 | | | | | | | | | | | | IA14 | 1000 | 1000 |
| 12 | ZA-M12 | 16 | | | | | | | | | | | | IA16 | 1000 | 1000 |
| 14 | | 18 | | | | | | | | | | | | IA18 | | |
| 16 | ZA-M16 | 20 | | | | | | | | | | | | IA20 | | |
| 20 | ZA-M20 | 25 | | | | IA25 | 500 | VL10/0,75 | 700 | VL10/0,75 | 1000 | VL16/1,8 | | | | |
| 22 | | 28 | | | | IA28 | | | | | | | | | | |
| 24 | | 32 | | | | IA32 | | | | | | | | | | |
| 25 | ZA-M24 | 32 | | | | IA32 | | | | | | | | | | |
| 28 | | 35 | | | | IA35 | | | | | | | | | | |
| 32 | | 40 | | | | IA40 | 500 | VL10/0,75 | 500 | VL10/0,75 | 1000 | VL16/1,8 | | | | |
| | | | | | | | | | | | | | | | | |

TILCA® TIM U-H Injection System for rebar connection

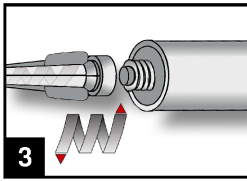
Intended Use

Parameter brushes, piston plugs, max anchorage depth and mixer extension

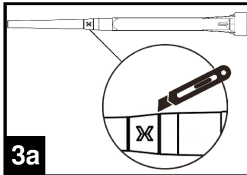
Annex B 6

| | |
|--|---|
| A) Bore hole drilling | |
| <p>Note: Before drilling, remove carbonated concrete and clean contact areas (see Annex B1) In case of aborted drill hole: the drill hole shall be filled with mortar.</p> | |
|  <p>1a</p> | <p>1a. Hammer (HD) or compressed air drilling (CD) Drill a hole into the base material to the size and embedment depth required by the selected reinforcing bar with carbide hammer drill (HD) or a compressed air drill (CD). Proceed with Step 2.</p> |
|  <p>1b</p> | <p>1b. Hollow drill bit system (HDB) (see Annex B 5) Drill a hole into the base material to the size and embedment depth required by the selected reinforcing bar. This drilling system removes the dust and cleans the bore hole during drilling. Proceed with Step 3.</p> |
| |  <p>Hammer drill (HD + HDB)</p>  <p>Compressed air drill (CD)</p> |
| B) Bore hole cleaning | |
| MAC: Cleaning for bore hole diameter $d_0 \leq 20\text{mm}$ and bore hole depth $h_0 \leq 10d_s$ | |
|  <p>2a 4x</p> | <p>2a. Starting from the bottom or back of the bore hole, blow the hole clean with a hand pump (Annex B 7) a minimum of four times.</p> |
|  <p>2b 4x</p> | <p>2b. Check brush diameter (Table B5). Brush the hole with an appropriate sized wire brush $> d_{b,min}$ (Table B5) a minimum of four times in a twisting motion. If the bore hole ground is not reached with the brush, a brush extension shall be used.</p> |
|  <p>2c 4x</p> | <p>2c. Finally blow the hole clean again with a hand pump (Annex B 7) a minimum of four times.</p> |
| CAC: Cleaning for all bore hole diameter and bore hole depth | |
|  <p>2a 2x</p> | <p>2a. Starting from the bottom or back of the bore hole, blow the hole clean with compressed air (min. 6 bar) (Annex B 7) a minimum of two times until return air stream is free of noticeable dust. If the bore hole ground is not reached an extension shall be used.</p> |
|  <p>2b 2x</p> | <p>2b. Check brush diameter (Table B5). Brush the hole with an appropriate sized wire brush $> d_{b,min}$ (Table B5) a minimum of two times. If the bore hole ground is not reached with the brush, a brush extension shall be used (Table B5).</p> |
|  <p>2c 2x</p> | <p>2c. Finally blow the hole clean again with compressed air (min. 6 bar) (Annex B 7) a minimum of two times until return air stream is free of noticeable dust. If the bore hole ground is not reached an extension shall be used.</p> |
| TILCA® TIM U-H Injection System for rebar connection | |
| Intended Use Installation instruction | Annex B 7 |

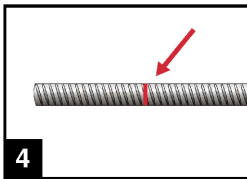
C) Preparation of bar and cartridge



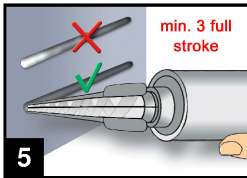
3. Attach the supplied static-mixing nozzle to the cartridge and load the cartridge into the correct dispensing tool.
For every working interruption longer than the recommended working time (Table B3) as well as for every new cartridges, a new static-mixer shall be used.



- 3a. In case of using the mixer extension VL16/1,8, the tip of the mixer nozzle has to be cut off at position „X“.

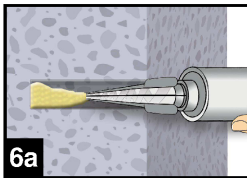


4. Prior to inserting the reinforcing bar into the filled bore hole, the position of the embedment depth shall be marked (e.g. with tape) on the reinforcing bar and insert bar in empty hole to verify hole and depth l_v .
The reinforcing bar should be free of dirt, grease, oil or other foreign material.

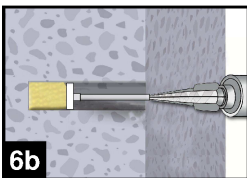


5. Prior to dispensing into the anchor hole, squeeze out separately the mortar until it shows a consistent grey colour, but a minimum of three full strokes, and discard non-uniformly mixed adhesive components.

D) Filling the bore hole

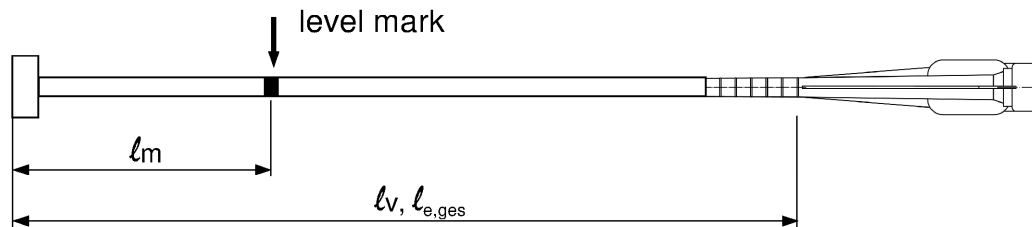


6. Starting from the bottom or back of the cleaned anchor hole fill the hole up to approximately two-thirds with adhesive. Slowly withdraw the static mixing nozzle as the hole fills to avoid creating air pockets. For embedment larger than 190 mm an extension nozzle shall be used.



For overhead and horizontal installation and bore holes deeper than 240 mm a piston plug and the appropriate mixer extension must be used.

Observe the gel-/ working times given in Table B3.



Injection tool must be marked by mortar level mark l_m and anchorage depth l_v resp. $l_{e,ges}$ with tape or marker.
Quick estimation: $l_m = 1/3 \cdot l_v$ Continue injection until the mortar level mark l_m becomes visible.

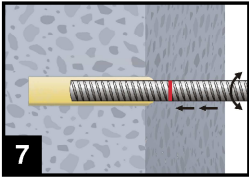
$$\text{Optimum mortar volume: } l_m = l_v \text{ resp. } l_{e,ges} \cdot \left(1,2 \cdot \frac{\phi^2}{d_0^2} - 0,2 \right) \quad [\text{mm}]$$

TILCA® TIM U-H Injection System for rebar connection

Intended Use
Installation instruction

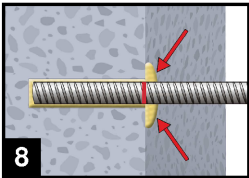
Annex B 8

E) Inserting the rebar

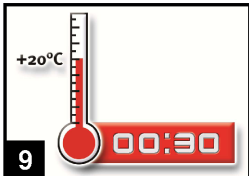


7. Push the reinforcing bar into the anchor hole while turning slightly to ensure positive distribution of the adhesive until the embedment depth is reached.

The bar should be free of dirt, grease, oil or other foreign material.



8. Be sure that the bar is inserted in the bore hole until the embedment mark is at the concrete surface and that excess mortar is visible at the top of the hole. If these requirements are not maintained, the application has to be renewed. For overhead installation fix embedded part (e.g. wedges).



9. Observe gelling time t_{gel} . Attend that the gelling time can vary according to the base material temperature (see Table B3). It is not allowed to move the bar after gelling time t_{gel} has elapsed. Allow the adhesive to cure to the specified time prior to applying any load. Do not move or load the bar until it is fully cured (attend Table B3). After full curing time t_{cure} has elapsed, the add-on part can be installed.

TILCA® TIM U-H Injection System for rebar connection

Intended Use
Installation instruction

Annex B 9

Minimum anchorage length and minimum lap length

The minimum anchorage length $\ell_{b,min}$ and the minimum lap length $\ell_{0,min}$ according to EN 1992-1-1:2004+AC:2010 ($\ell_{b,min}$ acc. to Eq. 8.6 and Eq. 8.7 and $\ell_{0,min}$ acc. to Eq. 8.11) shall be multiply by the amplification factor α_{lb} according to Table C1.

Table C1: Amplification factor α_{lb} related to concrete class and drilling method

| Concrete class | Drilling method | Bar size | Amplification factor α_{lb} |
|------------------|---------------------|-----------------------------------|------------------------------------|
| C12/15 to C50/60 | All drilling method | 8 mm to 32 mm ZA-M12 to ZA-M24 | 1,0 |

Table C2: Reduction factor k_b for all drilling methods

| Rebar - \emptyset | Concrete class | | | | | | | | |
|--|----------------|--------|--------|--------|--------|--------|--------|--------|--------|
| | C12/15 | C16/20 | C20/25 | C25/30 | C30/37 | C35/45 | C40/50 | C45/55 | C50/60 |
| ϕ 8 to 32 mm ZA-M12 to ZA-M24 | 1,0 | | | | | | | | |

Table C3: Design values of the ultimate bond stress $f_{bd,PIR}$ in N/mm² for all drilling methods and for good conditions

$$f_{bd,PIR} = k_b \cdot f_{bd}$$

with

f_{bd} : Design value of the ultimate bond stress in N/mm² considering the concrete classes and the rebar diameter according to EN 1992-1-1:2004+AC:2010.

(for all other bond conditions multiply the values by 0.7)

k_b : Reduction factor according to Table C2

| Rebar - \emptyset | Concrete class | | | | | | | | |
|--|----------------|--------|--------|--------|--------|--------|--------|--------|--------|
| | C12/15 | C16/20 | C20/25 | C25/30 | C30/37 | C35/45 | C40/50 | C45/55 | C50/60 |
| ϕ 8 to 32 mm ZA-M12 to ZA-M24 | 1,6 | 2,0 | 2,3 | 2,7 | 3,0 | 3,4 | 3,7 | 4,0 | 4,3 |

TILCA® TIM U-H Injection System for rebar connection

Performances

Amplification factor α_{lb}

Design values of ultimate bond resistance $f_{bd,PIR}$

Annex C 1

Design value of the ultimate bond stress $f_{bd,fi}$ under fire exposure for concrete classes C12/15 to C50/60, (all drilling methods):

The design value of the bond stress $f_{bd,fi}$ under fire exposure has to be calculated by the following equation:

$$f_{bd,fi} = k_{fi}(\theta) \cdot f_{bd,PIR} \cdot \gamma_c / \gamma_{M,fi}$$

with: $\theta \leq 364^\circ\text{C}$: $k_{fi}(\theta) = 30,34 \cdot e^{(\theta - 0,011)} / (f_{bd,PIR} \cdot 4,3) \leq 1,0$
 $\theta > 364^\circ\text{C}$: $k_{fi}(\theta) = 0$

$f_{bd,fi}$ Design value of the ultimate bond stress in case of fire in N/mm²

θ Temperature in °C in the mortar layer.

$k_{fi}(\theta)$ Reduction factor under fire exposure.

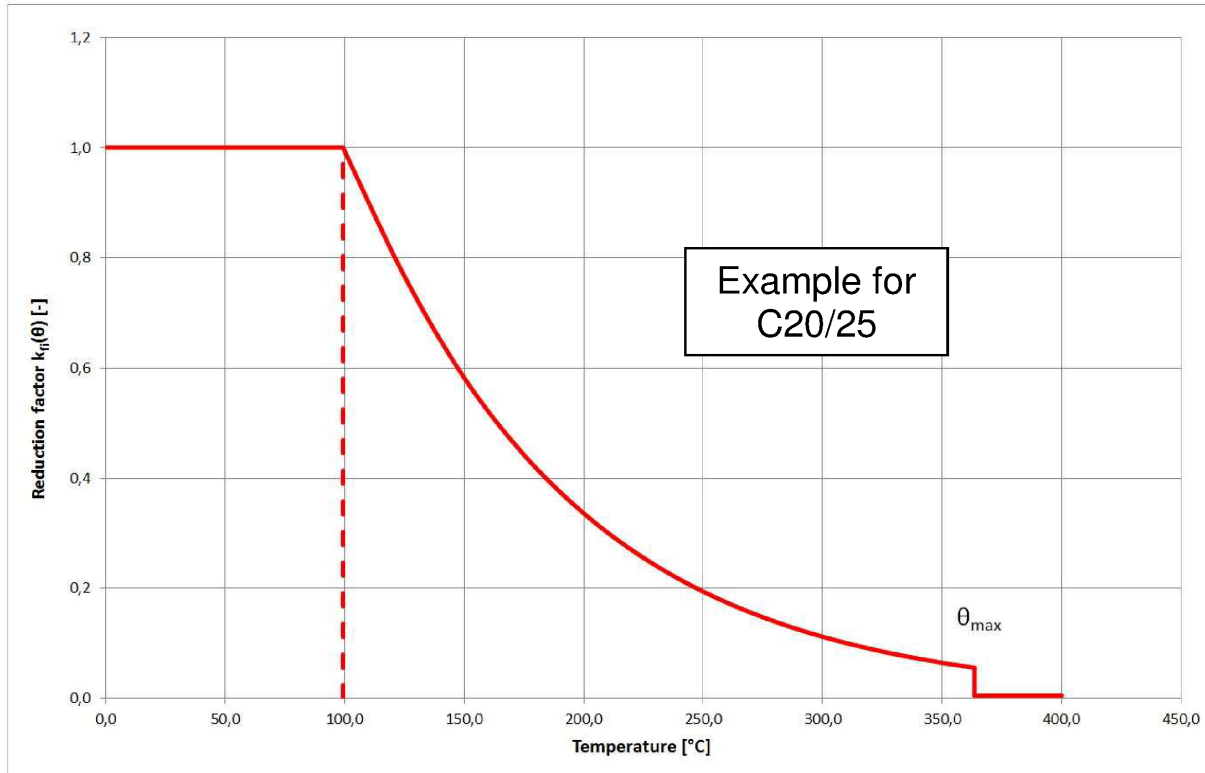
$f_{bd,PIR}$ Design value of the ultimate bond stress in N/mm² in cold condition according to Table C3 considering the concrete classes, the rebar diameter and the bond conditions according to EN 1992-1-1:2004+AC:2010.

γ_c partially safety factor according to EN 1992-1-1:2004+AC:2010

$\gamma_{M,fi}$ partially safety factor according to EN 1992-1-2:2004+AC:2008

For evidence under fire exposure the anchorage length shall be calculated according to EN 1992-1-1:2004+AC:2010 Equation 8.3 using the temperature-dependent ultimate bond stress $f_{bd,fi}$.

Example graph of Reduction factor $k_{fi}(\theta)$ for concrete classes C20/25 for good bond conditions:



TILCA® TIM U-H Injection System for rebar connection

Performances

Design value of bond strength $f_{bd,fi}$ under fire exposure

Annex C 2

| Table C4: Characteristic tension strength for tension anchor ZA under fire exposure, concrete classes C12/15 to C50/60, according to Technical Report TR 020 | | | | | |
|--|------|---|----------------------|------------|------------------|
| Tension Anchor | | M12 | M16 | M20 | M24 |
| Steel, zinc plated (ZA vz) | | | | | |
| Characteristic steel strength | R30 | $\sigma_{Rk,s,fi}$ | [N/mm ²] | 20 | |
| | R60 | | | 15 | |
| | R90 | | | 13 | |
| | R120 | | | 10 | |
| Stainless Steel (ZA A4 or ZA HCR) | | | | | |
| Characteristic steel strength | R30 | $\sigma_{Rk,s,fi}$ | [N/mm ²] | 30 | |
| | R60 | | | 25 | |
| | R90 | | | 20 | |
| | R120 | | | 16 | |
| Design value of the steel strength $\sigma_{Rd,s,fi}$ under fire exposure | | | | | |
| The design value of the steel strength $\sigma_{Rd,s,fi}$ under fire exposure has to be calculated by the following equation: | | | | | |
| $\sigma_{Rd,s,fi} = \sigma_{Rk,s,fi} / \gamma_{M,fi}$ | | | | | |
| with: | | | | | |
| $\sigma_{Rk,s,fi}$ | | characteristic steel strength according to Table C4 | | | |
| $\gamma_{M,fi}$ | | partially safety factor according to EN 1992-1-2:2004+AC:2008 | | | |
| TILCA® TIM U-H Injection System for rebar connection | | | | | Annex C 3 |
| Performances Design value of the steel strength $\sigma_{Rd,s,fi}$ for tension anchor ZA under fire exposure | | | | | |