

Approval body for construction products
and types of construction

Bautechnisches Prüfamt

An institution established by the Federal and
Laender Governments



European Technical Assessment

ETA-20/0011
of 5 May 2023

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

Chemofast Injection system EP 1000

Product family
to which the construction product belongs

Post-installed reinforcing bar (rebar) connection with
improved bond-splitting behaviour under static loading

Manufacturer

CHEMOFAST Anchoring GmbH
Hanns-Martin-Schleyer-Straße 23
47877 Willich
DEUTSCHLAND

Manufacturing plant

Chemofast Anchoring GmbH

This European Technical Assessment
contains

19 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 332402-00-0601-v01 Edition 10/2020

European Technical Assessment

ETA-20/0011

English translation prepared by DIBt

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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 *Chemofast Injection system EP 1000* in accordance with the regulations for reinforced concrete construction.

Reinforcing bars with a diameter ϕ from 8 to 40 mm according to Annex A and the Chemofast injection mortar EP 1000 are used for the post-installed rebar connection. The rebar is placed into a drilled hole filled with injection mortar and is anchored via the bond between embedded reinforcing bar, 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 rebar connection 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 connections of at least 50 and/or 100 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 to tension load (static and quasi-static loading) | |
| Resistance to combined pull-out and concrete failure in uncracked concrete | See Annex C 2 to C 3 |
| Resistance to concrete cone failure | See Annex C 1 |
| Robustness | See Annex C 2 to C 3 |
| Resistance to bond-splitting failure | See Annex C 2 to C 3 |
| Influence of cracked concrete on resistance to combined pull-out and concrete failure | See Annex C 2 to 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. 332402-00-0601-v01, the applicable European legal act is: [96/582/EC].

The system to be applied is: 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 5 May 2023 by Deutsches Institut für Bautechnik

Dipl.-Ing. Beatrix Wittstock
Head of Section

beglaubigt:
Stiller

Installation condition and application example

Figure A1: Column / wall to foundation / slab

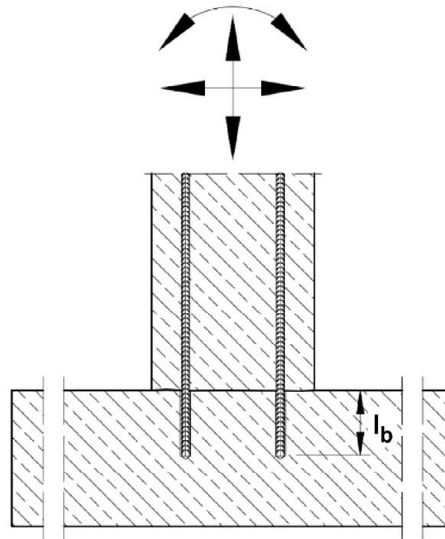
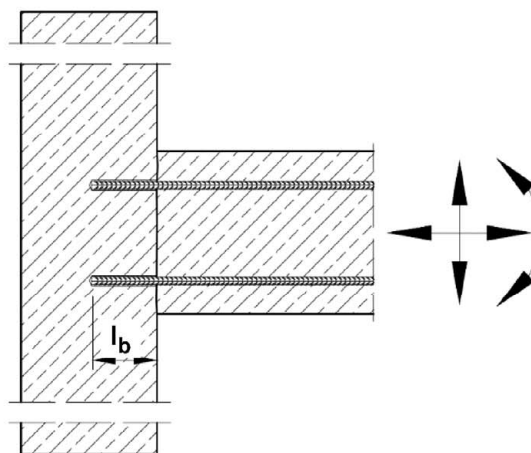


Figure A2: Slab / beam to wall or beam to column



l_b = Embedment length

The transfer of shear forces between new concrete and existing structure shall be designed additionally according to EN 1992-1-1:2004+AC:2010.

Chemofast Injection system EP 1000 for rebar connection

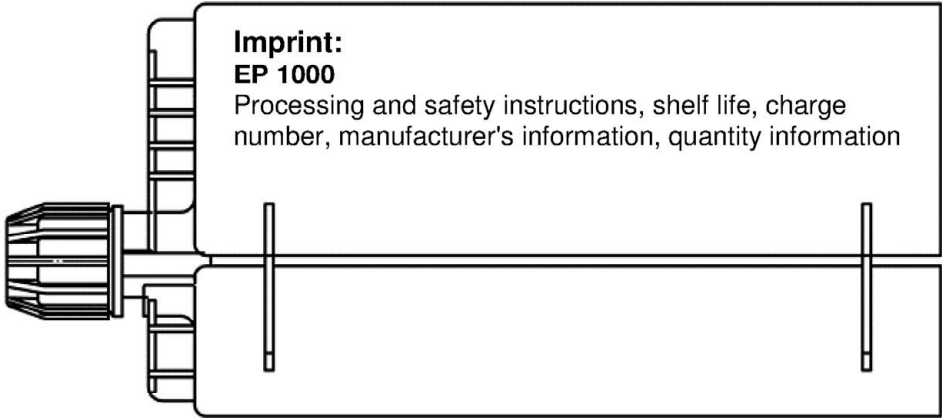
Product description

Installed condition and examples of use for rebars

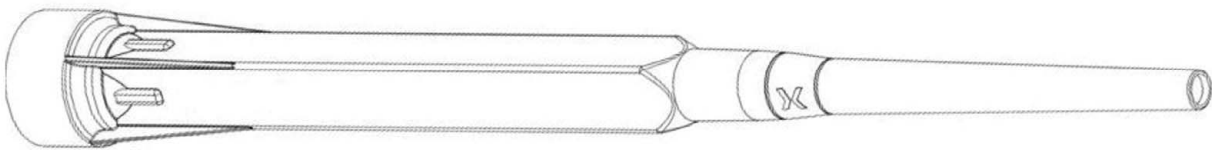
Annex A 1

Cartridge system

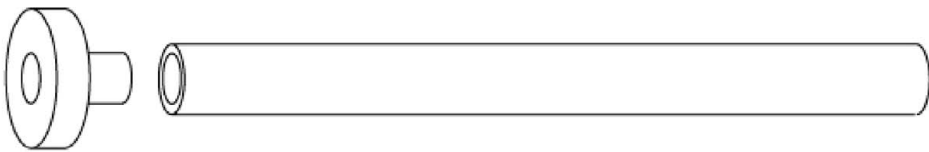
Side-by-Side Cartridge:
440 ml, 585 ml and 1400 ml



Static mixer PM-19E



Piston plug VS and mixer extension VL

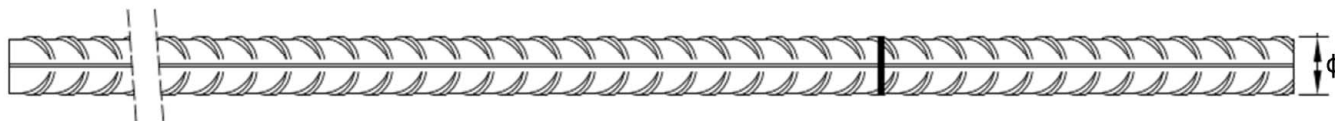


Chemofast Injection system EP 1000 for rebar connection

Product description
Injection system

Annex A 2

Reinforcing bar (rebar): $\phi 8$ up to $\phi 40$



- 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 $0,05\phi \leq h_{rib} \leq 0,07\phi$
(ϕ : Nominal diameter of the bar; h_{rib} : Rib height of the bar)

Table A1: Materials Rebar

| 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 NCI of EN 1992-1-1/NA $f_{uk} = f_{tk} = k \cdot f_{yk}$ |

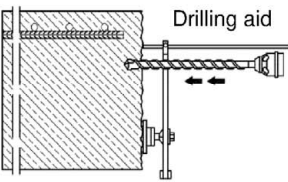
Chemofast Injection system EP 1000 for rebar connection

Product description
Specifications Rebar

Annex A 3





| Specification of the intended use | | | |
|--|---|-----------------------|------------------------|
| Anchorages subject to: | | Working life 50 years | Working life 100 years |
| HD: Hammer drilling HDB: Hammer drilling with hollow drill bit CD: Compressed air drilling DD: Diamond drilling | static and quasi-static loads | Ø8 to Ø40 | Ø8 to Ø40 |
| Temperature Range: | I: - 40°C to +40°C (max long-term temperature +24 °C and max short-term temperature +40 °C) II: - 40°C to +72°C (max long-term temperature +50 °C and max short-term temperature +72 °C) | | |
| Base materials: <ul style="list-style-type: none">- Compacted reinforced or unreinforced normal weight concrete without fibres according to EN 206:2013 + A1:2016.- Strength classes C20/25 to C50/60 according to EN 206:2013 + A1:2016.- Maximum chloride content of 0,40% (CL 0.40) related to the cement content according to EN 206:2013 + A1:2016.- Non-carbonated concrete. <p>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.</p> <p>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.</p> Design: <ul style="list-style-type: none">- 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 EOTA Technical Report TR 069.- 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: <ul style="list-style-type: none">- Dry or wet concrete; for all drilling methods and all diameter.- Water-filled drill holes; for rebar Ø8 to Ø32 only.- Overhead installation allowed.- Hole drilling by hammer drill (HD), hollow drill (HDB), diamond drill (DD) or compressed air drill mode (CD).- Rebar installation carried out by appropriately qualified personnel and under the supervision of the person responsible for technical matters of the site.- 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). | | | |
| Chemofast Injection system EP 1000 for rebar connection | | | Annex B 1 |
| Intended use Specifications | | | |

Table B1: Minimum concrete cover c_{\min} of post-installed rebar depending of drilling method

| Drilling method | Rebar diameter | Without drilling aid | With drilling aid |  |
|---|----------------------|--|--|---|
| HD: Hammer drilling HDB: Hammer drilling with hollow drill bit | < 25 mm | $30 \text{ mm} + 0,06 \cdot l_b \geq 2 \phi$ | $30 \text{ mm} + 0,02 \cdot l_b \geq 2 \phi$ | |
| | $\geq 25 \text{ mm}$ | $40 \text{ mm} + 0,06 \cdot l_b \geq 2 \phi$ | $40 \text{ mm} + 0,02 \cdot l_b \geq 2 \phi$ | |
| DD: Diamond drilling | < 25 mm | Drill rig used as drilling aid | $30 \text{ mm} + 0,02 \cdot l_b \geq 2 \phi$ | |
| | $\geq 25 \text{ mm}$ | | $40 \text{ mm} + 0,02 \cdot l_b \geq 2 \phi$ | |
| CD: Compressed air drilling | < 25 mm | $50 \text{ mm} + 0,08 \cdot l_b$ | $50 \text{ mm} + 0,02 \cdot l_b$ | |
| | $\geq 25 \text{ mm}$ | $60 \text{ mm} + 0,08 \cdot l_b \geq 2 \phi$ | $60 \text{ mm} + 0,02 \cdot l_b \geq 2 \phi$ | |

Comments: The minimum concrete cover acc. EN 1992-1-1:2004+AC:2010 must be observed.
The minimum clear spacing is $a = \max(40 \text{ mm}; 4 \phi)$

Table B2: Dispensing tools

| Cartridge type/size | Hand tool | | Pneumatic tool |
|--|--|---|--|
| Side-by-side cartridges 440, 585 ml |  e.g. SA 296C585 |  e.g. Type H 244 C |  e.g. Type TS 444 KX |
| Side-by-side cartridges 1400 ml | - | - |  e.g. Type TS 471 |

All cartridges could also be extruded by a battery tool.

Chemofast Injection system EP 1000 for rebar connection

Intended use
Minimum concrete cover
Dispensing tools

Annex B 2

Table B3: Brushes, piston plugs, max anchorage depth and mixer extension, hammer (HD), diamond (DD) and compressed air (CD) drilling

| Bar size φ | Drill bit - Ø | | | d _b Brush - Ø | d _{b,min} min. Brush - Ø | Piston plug | Cartridge: 440 ml or 585 ml | | | | Cartridge: 1400 ml | | | |
|-------------------|---------------|------|------|-----------------------------|--------------------------------------|-------------|-----------------------------|--------------------------|--------------------------|--------------------------|--------------------------|-----------------|-----------------------------|------|
| | HD | DD | CD | | | | Hand or battery tool | | Pneumatic tool | | Pneumatic tool | | | |
| | | | | | | | l _{b,max} | Mixer extension | l _{b,max} | Mixer extension | l _{b,max} | Mixer extension | | |
| [mm] | | [mm] | | | [mm] | [mm] | | [mm] | | [mm] | | [mm] | | |
| 8 | 10 | | - | RB10 | 11,5 | 10,5 | - | 250 | VL10/0,75 or VL16/1,8 | 250 | VL10/0,75 or VL16/1,8 | 250 | VL10/0,75 or VL16/1,8 | |
| 10 | 12 | | - | RB12 | 13,5 | 12,5 | - | 700 | | 800 | | 800 | | |
| | 14 | | - | RB14 | 15,5 | 14,5 | VS14 | 250 | | 250 | | 250 | | |
| | 12 | 16 | | | | | | RB16 | | 17,5 | | 16,5 | | VS16 |
| 18 | | RB18 | 20,0 | 18,5 | VS18 | 500 | 1300 | VL10/0,75 or VL16/1,8 | | 1200 | | VL16/1,8 | | |
| 14 | 20 | | RB20 | 22,0 | 20,5 | | | | | VS20 | | | 1400 | |
| 16 | 25 | | - | RB25 | 27,0 | | | | | 25,5 | | | VS25 | 1600 |
| 20 | - | | 26 | RB26 | 28,0 | 26,5 | VS25 | 1000 | | VL10/0,75 or VL16/1,8 | | | 2000 | |
| | 28 | | RB28 | 30,0 | 28,5 | VS28 | | | | | | | | |
| 24/25 | 30 | | RB30 | 32,0 | 30,5 | VS30 | - | | | | | | | - |
| | 32 | | RB32 | 34,0 | 32,5 | VS32 | | | | | | | | |
| 28 | 35 | | RB35 | 37,0 | 35,5 | VS35 | | | | | | | | |
| 32/34 | 40 | | RB40 | 43,5 | 40,5 | VS40 | | | | | | | | |
| 36 | 45 | | RB45 | 47,0 | 45,5 | VS45 | | | | | | | | |
| 40 | - | 52 | - | RB52 | 54,0 | 52,5 | VS52 | | | | | | | |
| | 55 | - | 55 | RB55 | 58,0 | 55,5 | VS55 | | | | | | | |

Table B4: Brushes, piston plugs, max anchorage depth and mixer extension, hammer drilling with hollow drill bit system (HDB)

| Bar size φ | Drill bit - Ø | d _b Brush - Ø | d _{b,min} min. Brush - Ø | Piston plug | Cartridge: 440 ml or 585 ml | | | | Cartridge: 1400 ml | |
|-------------------|---------------|-----------------------------|--------------------------------------|-------------|-----------------------------|-----------------|-----------------------|-----------------------|-----------------------|-----------------|
| | HDB | | | | Hand or battery tool | | Pneumatic tool | | Pneumatic tool | |
| | | | | | l _{b,max} | Mixer extension | l _{b,max} | Mixer extension | l _{b,max} | Mixer extension |
| [mm] | [mm] | No cleaning Required | | | [mm] | | [mm] | | [mm] | |
| 8 | 10 | | - | 250 | VL10/0,75 or VL16/1,8 | 250 | VL10/0,75 or VL16/1,8 | 250 | VL10/0,75 or VL16/1,8 | |
| | 12 | | - | 700 | | 800 | | 800 | | |
| 10 | | | 250 | 250 | | 250 | | 250 | | |
| | 14 | | VS14 | 700 | | 1000 | | 1000 | | |
| 16 | | | 250 | 250 | | 250 | | | | |
| 12 | 16 | | VS16 | 700 | | 1000 | | VL10/0,75 or VL16/1,8 | | 1000 |
| | 18 | | VS18 | | | | | | | |
| 20 | VS20 | | | | | | | | | |
| 20 | 25 | | VS25 | 500 | | | | | | |
| 22 | 28 | | VS28 | | | | | | | |
| 24/25 | 30 | | VS30 | | | | | | | |
| | 32 | | VS32 | | | | | | | |
| 28 | 35 | | VS35 | | | | | | | |
| 32/34 | 40 | | VS40 | | | | | | | |

Chemofast Injection system EP 1000 for rebar connection

Intended use

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

Annex B 3

Cleaning and installation tools

HDB – Hollow drill bit system



The hollow drill system consists of Heller Duster Expert hollow drill bit and a class M Hoover with a minimum negative pressure of 253 hPa and a flow rate of minimum 150 m³/h (42 l/s).

Hand pump

(Volume 750 ml, $h_0 \geq 10 d_s$, $d_0 \leq 20\text{mm}$)



Compressed air tool

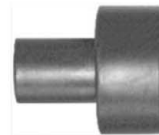
(min 6 bar)



Brush RB



Pistole Plug VS



Brush extension RBL



Table B5: Working time and curing time

| Temperature in base material | | | Maximum working time | Initial curing time ¹⁾ | Minimum curing time ²⁾ |
|------------------------------|-------|---------|----------------------|-----------------------------------|-----------------------------------|
| T | | | t_{work} | $t_{\text{cure,ini}}$ | t_{cure} |
| 0 °C | up to | + 4 °C | 80 min | 30 h | 144 h |
| + 5 °C | up to | + 9 °C | 80 min | 20 h | 48 h |
| + 10 °C | up to | + 14 °C | 60 min | 15 h | 28 h |
| + 15 °C | up to | + 19 °C | 40 min | 9 h | 18 h |
| + 20 °C | up to | + 24 °C | 30 min | 6 h | 12 h |
| + 25 °C | up to | + 34 °C | 12 min | 4 h | 9 h |
| + 35 °C | up to | + 39 °C | 8 min | 3 h | 6 h |
| +40 °C | | | 8 min | 1,5 h | 4 h |

Cartridge temperature

+5 °C up to +40 °C

- 1) After Initial curing time has elapsed, the installation of the connecting reinforcement and the construction of the formwork can be continued
- 2) The minimum curing time is only valid for dry base material.
In wet base material the curing time must be doubled.

Chemofast Injection system EP 1000 for rebar connection

Intended use

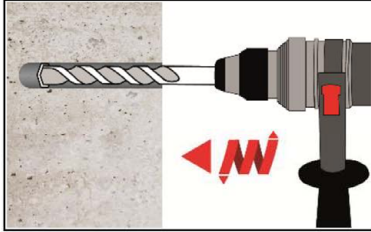
Cleaning and installation tools
Working time and curing time

Annex B 4

Installation instructions

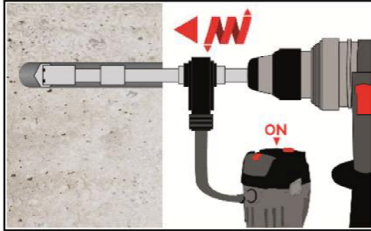
Attention: Before drilling, remove carbonated concrete and clean contact areas (see Annex B1)
In case of aborted drill hole: the drill hole shall be filled with mortar.

Drilling of the bore hole



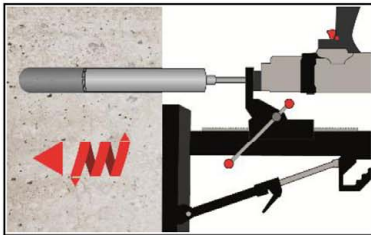
1a. Hammer drilling (HD) / Compressed air drilling (CD)

Drill a hole to the required embedment length.
Drill bit diameter according to Table B3.
Proceed with Step 2 (MAC or CAC).



1b. Hollow drill bit system (HDB) (see Annex B 4)

Drill a hole to the required embedment length.
Drill bit diameter according to Table B4.
The hollow drilling system removes the dust and cleans the bore hole.
Proceed with Step 3.



1c. Diamond drilling (DD)

Drill a hole to the required embedment length required
Drill bit diameter according to Table B3.
Proceed with Step 2 (SPCAC).

Chemofast Injection system EP 1000 for rebar connection

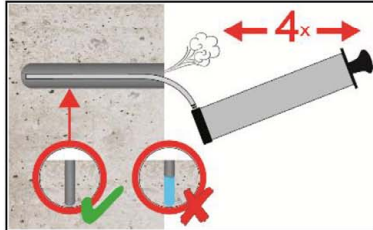
Intended use
Installation instruction

Annex B 5

Installation instructions (continuation)

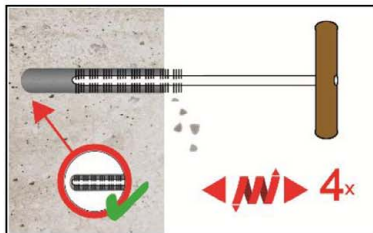
Manual Air Cleaning (MAC)

for drill hole diameter $d_0 \leq 20\text{mm}$ and drill hole depth $h_0 \leq 10\phi$ with drilling method HD/CD

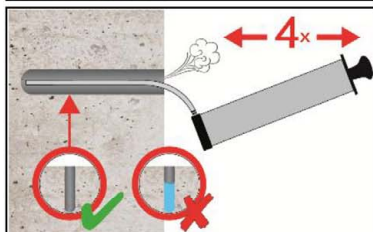


Attention! Standing water in the bore hole must be removed before cleaning.

2a. Blow the bore hole clean minimum 4x from the bottom or back by hand pump (Annex B 4).



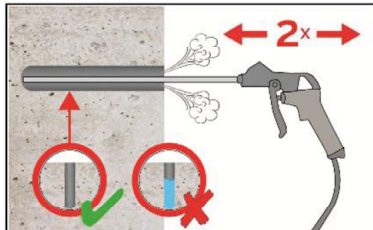
2b. Brush the bore hole minimum 4x with brush RB according to Table B3 over the entire embedment depth in a twisting motion (if necessary, use a brush extension RBL).



2c. Finally blow the bore hole clean minimum 4x from the bottom or back by hand pump (Annex B 4).

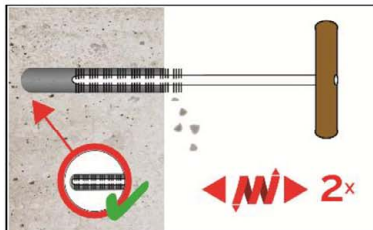
Compressed Air Cleaning (CAC):

All diameter with drilling method HD/CD

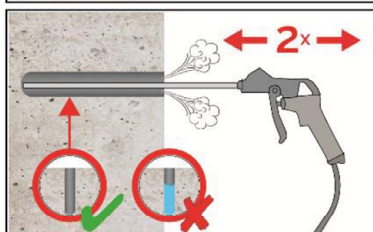


Attention! Standing water in the bore hole must be removed before cleaning.

2a. Blow the bore hole clean minimum 2x with compressed air (min. 6 bar) (Annex B 4) over the entire embedment depth until return air stream is free of noticeable dust. (If necessary, an extension shall be used.)



2b. Brush the bore hole minimum 2x with brush RB according to Table B3 over the entire embedment depth in a twisting motion. (If necessary, a brush extension RBL shall be used.)



2c. Finally blow the bore hole clean minimum 2x with compressed air (min. 6 bar) (Annex B 4) over the entire embedment depth until return air stream is free of noticeable dust. (If necessary, an extension shall be used.)

Protect cleaned bore hole against re-contamination in an appropriate way. If necessary, repeat cleaning process directly before dispensing the mortar. In-flowing water must not contaminate the bore hole again.

Chemofast Injection system EP 1000 for rebar connection

Intended use

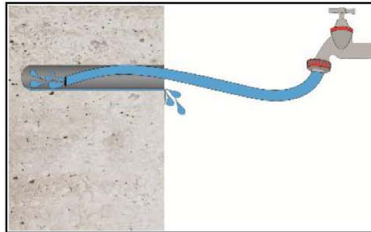
Installation instructions (continuation)

Annex B 6

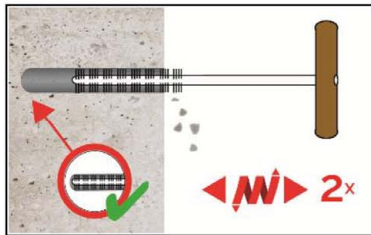
Installation instructions (continuation)

Flush & Compressed Air Cleaning (SPCAC):

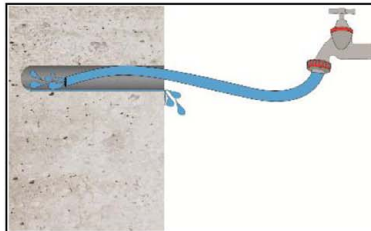
All diameter with drilling method DD



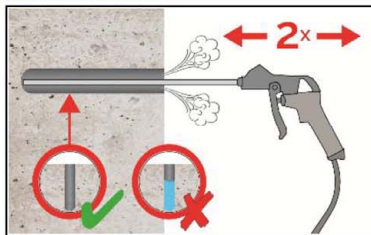
2a. Flushing with water until clear water comes out.



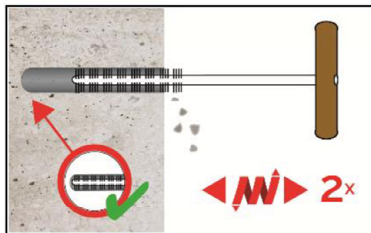
2b. Brush the bore hole minimum 2x with brush RB according to Table B3 over the entire embedment depth in a twisting motion. (If necessary, a brush extension RBL shall be used.)



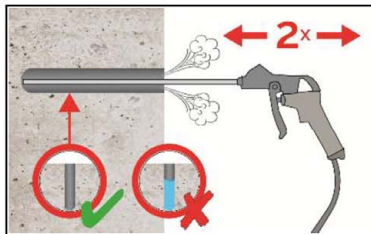
2c. Flushing again with water until clear water comes out.



2d. Blow the bore hole clean minimum 2x with compressed air (min. 6 bar) (Annex B 4) over the entire embedment depth until return air stream is free of noticeable dust. (If necessary, an extension shall be used.)



2e. Brush the bore hole minimum 2x with brush RB according to Table B3 over the entire embedment depth in a twisting motion. (If necessary, a brush extension RBL shall be used.)



2f. Finally blow the bore hole clean minimum 2x with compressed air (min. 6 bar) (Annex B 4) over the entire embedment depth until return air stream is free of noticeable dust. (If necessary, an extension shall be used.)

Protect cleaned bore hole against re-contamination in an appropriate way. If necessary, repeat cleaning process directly before dispensing the mortar. In-flowing water must not contaminate the bore hole again.

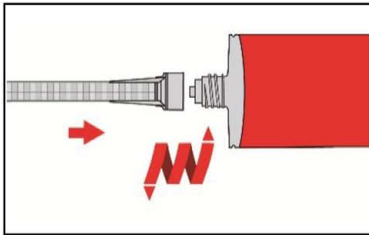
Chemofast Injection system EP 1000 for rebar connection

Intended use

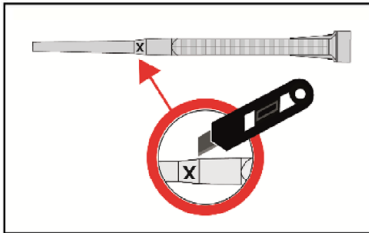
Installation instructions (continuation)

Annex B 7

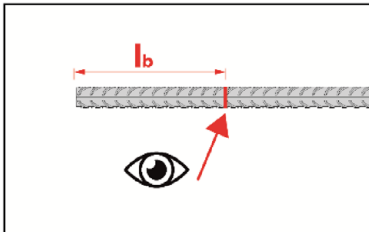
Installation instructions (continuation)



3. Screw on static-mixing nozzle PM-19E, and load the cartridge into an appropriate dispensing tool.
For every working interruption longer than the maximum working time t_{work} (Annex B 4) as well as for new cartridges, a new static-mixer shall be used.



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



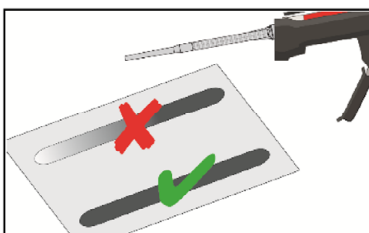
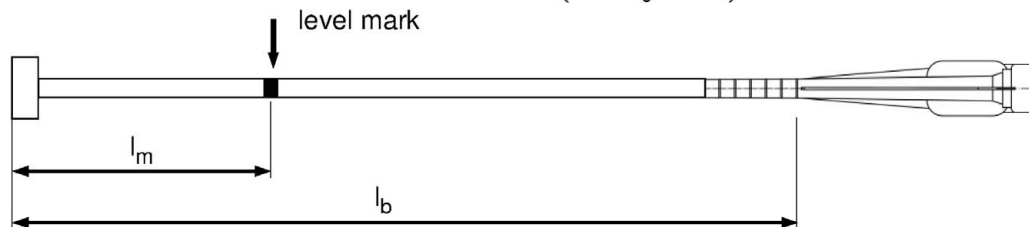
4. Mark embedment length l_b on the reinforcing bar.
The reinforcing bar shall be free of dirt, grease, oil or other foreign material.

5. Mark mixer nozzle and extension with mortar level mark l_m and embedment length l_b

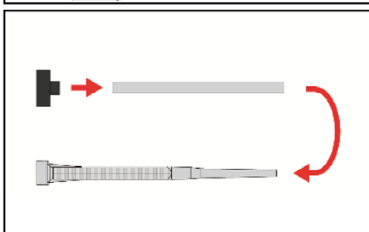
Quick estimation: $l_m = 1/3 \cdot l_b$

Optimum mortar volume:

$$l_m = l_b \cdot \left(1,2 \cdot \frac{\phi^2}{d_0^2} - 0,2 \right)$$



6. Not proper mixed mortar is not sufficient for fastening.
Dispense and discard mortar until an uniform grey or red colour is shown (at least 3 full strokes).



7. Piston plugs VS and mixer nozzle extensions VL shall be used according to Table B3 or B4.
Assemble mixing nozzle, mixer extension and piston plug before injecting mortar.

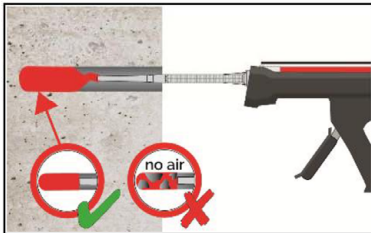
Chemofast Injection system EP 1000 for rebar connection

Intended use

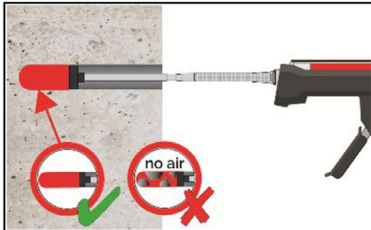
Installation instructions (continuation)

Annex B 8

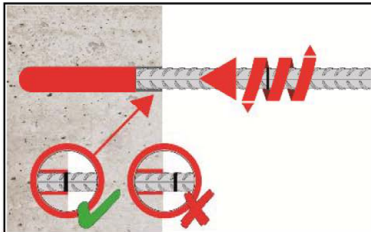
Installation instructions (continuation)



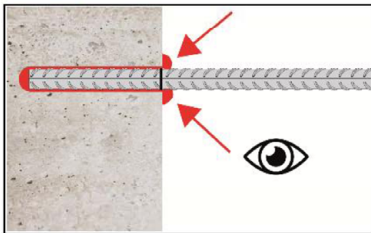
- 8a. Injecting mortar without piston plug VS:**
Starting at bottom of the hole and fill the hole with adhesive until the mortar level mark is visible. (If necessary, a mixer nozzle extension shall be used.) Slowly withdraw of the static mixing nozzle avoid creating air pockets. Observe the temperature related working time t_{work} (Annex B 4).



- 8b. Injecting mortar with piston plug VS:**
Insert piston plug to bottom of the hole and fill the hole with mortar until mortar level mark l_m is visible. (If necessary, a mixer nozzle extension shall be used.) During injection the piston plug is pushed out of the bore hole by the back pressure of the mortar. Observe the temperature related working time t_{work} (Annex B 4).



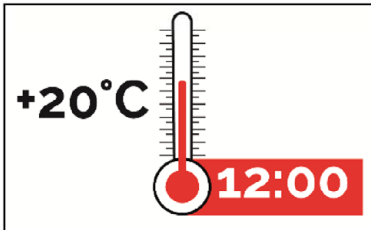
- 9.** Insert the reinforcing bar while turning slightly up to the embedment mark.



- 10.** Annular gap between reinforcing bar and base material must be completely filled with mortar. Otherwise, the installation must be repeated starting from step 8 before the maximum working time t_{work} has expired.



- 11.** For application in vertical upwards direction the reinforcing bar shall be fixed (e.g. wedges).



- 12.** Temperature related curing time t_{cure} (Annex B 4) must be observed. After initial curing time $t_{cure,ini}$ has elapsed, the installation of the connecting reinforcement and the formwork can be continued. The full load to the reinforcing bar may be applied after the full curing time t_{cure} has elapsed.

Chemofast Injection system EP 1000 for rebar connection

Intended use
Installation instructions (continuation)

Annex B 9

**Table C1: Characteristic resistance to tension load (static and quasi-static loading)
for a working life of 50 and 100 years**

| Fastener | | | All sizes |
|------------------------------|-------------|------|-------------------------|
| Concrete cone failure | | | |
| Uncracked concrete | $k_{ucr,N}$ | [-] | 11,0 |
| Cracked concrete | $k_{cr,N}$ | [-] | 7,7 |
| Edge distance | $c_{cr,N}$ | [mm] | 1,5 l_b ¹⁾ |
| Spacing | $s_{cr,N}$ | [mm] | 3,0 l_b ¹⁾ |

¹⁾ see Annex A 1

Chemofast Injection system EP 1000 for rebar connection

Performances

Characteristic values of tension loads under static and quasi-static action
for a working life of 50 and 100 years

Annex C 1

| Table C2: Characteristic resistance to tension load under static and quasi-static loading in hammer drilled holes (HD), compressed air drilled holes (CD) and in hammer drilled holes with hollow drill bit (HDB); working life 50 and 100 years | | | | | | | | | | | | | | | | |
|--|---------------|---|--|--------------|---|------|------|------|------|------|------|------|------|-------------------|------|----|
| Reinforcing bar | | | Ø 8 | Ø 10 | Ø 12 | Ø 14 | Ø 16 | Ø 20 | Ø 24 | Ø 25 | Ø 28 | Ø 32 | Ø 36 | Ø 40 | | |
| Combined pull-out and concrete failure; working life 50 and 100 years | | | | | | | | | | | | | | | | |
| Characteristic resistance in uncracked concrete C20/25 in hammer drilled holes (HD) and compressed air drilled holes (CD) | | | | | | | | | | | | | | | | |
| Temperature range | I: 24°C/40°C | Dry, wet concrete and flooded bore hole | $\tau_{Rk,ucr,50}$ = $\tau_{Rk,ucr,100}$ | [N/mm²] | 16 | 16 | 16 | 16 | 16 | 16 | 15 | 15 | 15 | 15 | 15 | 15 |
| | II: 50°C/72°C | | | | 12 | 12 | 12 | 12 | 12 | 12 | 12 | 12 | 11 | 11 | 11 | 11 |
| Characteristic resistance in uncracked concrete C20/25 in hammer drilled holes with hollow drill bit (HDB) | | | | | | | | | | | | | | | | |
| Temperature range | I: 24°C/40°C | Dry, wet concrete | $\tau_{Rk,ucr,50}$ = $\tau_{Rk,ucr,100}$ | [N/mm²] | 14 | 14 | 13 | 13 | 13 | 13 | 13 | 13 | 13 | 13 | 1) | |
| | II: 50°C/72°C | | | | 12 | 12 | 12 | 11 | 11 | 11 | 11 | 11 | 11 | 11 | | |
| | I: 24°C/40°C | flooded bore hole | | | 13 | 13 | 13 | 13 | 13 | 13 | 13 | 13 | 13 | 13 | | |
| | II: 50°C/72°C | | | | 11 | 11 | 11 | 11 | 11 | 11 | 11 | 11 | 11 | 11 | | |
| Reduction factor $\psi_{sus,50}^0, \psi_{sus,100}^0$ in cracked and uncracked concrete C20/25; (HD, CD and HDB) | | | | | | | | | | | | | | | | |
| Temperature range | I: 24°C/40°C | Dry, wet concrete and flooded bore hole | $\psi_{sus,50}^0$ = $\psi_{sus,100}^0$ | [-] | 0,80 | | | | | | | | | | | |
| | II: 50°C/72°C | | | | 0,68 | | | | | | | | | | | |
| Increasing factors for concrete | | | ψ_c | [-] | $(f_{ck} / 20)^{0,1}$ | | | | | | | | | | | |
| Characteristic bond resistance depending on the concrete strength class | | | $\tau_{Rk,ucr,50}$ = | | $\psi_c \cdot \tau_{Rk,ucr,50,(C20/25)}$ | | | | | | | | | | | |
| | | | $\tau_{Rk,ucr,100}$ = | | $\psi_c \cdot \tau_{Rk,ucr,100,(C20/25)}$ | | | | | | | | | | | |
| Influence of cracked concrete on combined pullout and concrete cone failure; working life of 50 and 100 years; (HD, CD and HDB) | | | | | | | | | | | | | | | | |
| Factor for influence of cracked concrete | HD, CD | Ω_{cr} | [-] | 0,84 | 0,84 | 0,85 | 0,86 | 0,87 | 0,89 | 0,91 | 0,91 | 0,92 | 0,94 | 0,94 | 0,95 | |
| | HDB | | | 0,84 | 0,84 | 0,85 | 0,86 | 0,87 | 0,89 | 0,91 | 0,91 | 0,92 | 0,94 | NDA ¹⁾ | | |
| Bond-splitting failure; working life 50 and 100 years; (HD, CD and HDB) | | | | | | | | | | | | | | | | |
| Product basic factor | | A_k | [-] | 6,0 | | | | | | | | | | | | |
| Exponent for influence of... | | | | | | | | | | | | | | | | |
| - concrete compressive strength | | sp1 | [-] | 0,32 | | | | | | | | | | | | |
| - rebar diameter ϕ | | sp2 | [-] | 0,60 | | | | | | | | | | | | |
| - concrete cover c_d | | sp3 | [-] | 0,30 | | | | | | | | | | | | |
| - side concrete cover (c_{max} / c_d) | | sp4 | [-] | 0,28 | | | | | | | | | | | | |
| - embedment length l_b | | lb1 | [-] | 0,66 | | | | | | | | | | | | |
| Concrete cone failure | | | | | | | | | | | | | | | | |
| Relevant parameter | | | | see Table C1 | | | | | | | | | | | | |
| Installation factor; (HD, CD and HDB) | | | | | | | | | | | | | | | | |
| for dry and wet concrete | | γ_{inst} | [-] | 1,0 | | | | | | | | | | 1,2 | | |
| for flooded bore hole | | | | 1,2 | | | | | | | | | | 1) | | |
| 1) no performance assessed | | | | | | | | | | | | | | | | |
| Chemofast Injection system EP 1000 for rebar connection | | | | | | | | | | | | | | Annex C 2 | | |
| Performances | | | | | | | | | | | | | | | | |
| Characteristic resistance to tension load under static and quasi-static loading; working life of 50 and 100 years; (HD, CD and HDB) | | | | | | | | | | | | | | | | |

| Table C3: Characteristic resistance to tension load under static and quasi-static loading in diamond drilled holes (DD); working life 50 and 100 years | | | | | | | | | | | | | | | | |
|--|---------------|---|-----------------------|--------------|---|------|------|------|------|------|------|-----------|------|------|------|------|
| Reinforcing bar | | | | Ø 8 | Ø 10 | Ø 12 | Ø 14 | Ø 16 | Ø 20 | Ø 24 | Ø 25 | Ø 28 | Ø 32 | Ø 36 | Ø 40 | |
| Combined pull-out and concrete failure | | | | | | | | | | | | | | | | |
| Characteristic resistance in uncracked concrete C20/25; working life 50 years | | | | | | | | | | | | | | | | |
| Temperature range | I: 24°C/40°C | Dry, wet concrete and flooded bore hole | $\tau_{Rk,ucr,50}$ | [N/mm²] | 14 | 13 | 13 | 13 | 12 | 12 | 11 | 11 | 11 | 11 | 11 | 10 |
| | II: 50°C/72°C | | | | 11 | 11 | 10 | 10 | 10 | 9,5 | 9,5 | 9,5 | 9,0 | 9,0 | 8,5 | 8,5 |
| Reduction factor $\psi_{sus,50}^0$ in cracked and uncracked concrete C20/25; working life 50 years | | | | | | | | | | | | | | | | |
| Temperature range | I: 24°C/40°C | Dry, wet concrete and flooded bore hole | $\psi_{sus,50}^0$ | [-] | 0,77 | | | | | | | | | | | |
| | II: 50°C/72°C | | | | 0,72 | | | | | | | | | | | |
| Characteristic resistance in uncracked concrete C20/25; working life 100 years | | | | | | | | | | | | | | | | |
| Temperature range | I: 24°C/40°C | Dry, wet concrete and flooded bore hole | $\tau_{Rk,ucr,100}$ | [N/mm²] | 14 | 13 | 13 | 13 | 12 | 12 | 11 | 11 | 11 | 11 | 11 | 10 |
| | II: 50°C/72°C | | | | 11 | 10 | 10 | 10 | 9,5 | 9,0 | 9,0 | 9,0 | 8,5 | 8,5 | 8,0 | 8,0 |
| Reduction factor $\psi_{sus,100}^0$ in cracked and uncracked concrete C20/25; working life 100 years | | | | | | | | | | | | | | | | |
| Temperature range | I: 24°C/40°C | Dry, wet concrete and flooded bore hole | $\psi_{sus,100}^0$ | [-] | 0,73 | | | | | | | | | | | |
| | II: 50°C/72°C | | | | 0,70 | | | | | | | | | | | |
| Increasing factors for concrete | | | ψ_c | [-] | $(f_{ck} / 20)^{0,2}$ | | | | | | | | | | | |
| Characteristic bond resistance depending on the concrete strength class | | | $\tau_{Rk,ucr,50} =$ | | $\psi_c \cdot \tau_{Rk,ucr,50,(C20/25)}$ | | | | | | | | | | | |
| | | | $\tau_{Rk,ucr,100} =$ | | $\psi_c \cdot \tau_{Rk,ucr,100,(C20/25)}$ | | | | | | | | | | | |
| Influence of cracked concrete on combined pullout and concrete cone failure; working life 50 and 100 years | | | | | | | | | | | | | | | | |
| Factor for influence of cracked concrete | | | Ω_{cr} | [-] | 0,87 | 0,88 | 0,89 | 0,90 | 0,91 | 0,94 | 0,94 | 0,94 | 0,93 | 0,93 | 0,93 | 0,93 |
| Bond-splitting failure; working life 50 and 100 years | | | | | | | | | | | | | | | | |
| Product basic factor | | | A_k | [-] | 5,9 | | | | | | | | | | | |
| Exponent for influence of... | | | | | | | | | | | | | | | | |
| - concrete compressive strength | | | sp1 | [-] | 0,28 | | | | | | | | | | | |
| - rebar diameter ϕ | | | sp2 | [-] | 0,53 | | | | | | | | | | | |
| - concrete cover c_d | | | sp3 | [-] | 0,36 | | | | | | | | | | | |
| - side concrete cover (c_{max} / c_d) | | | sp4 | [-] | 0,29 | | | | | | | | | | | |
| - embedment length l_b | | | lb1 | [-] | 0,65 | | | | | | | | | | | |
| Concrete cone failure | | | | | | | | | | | | | | | | |
| Relevant parameter | | | | see Table C1 | | | | | | | | | | | | |
| Installation factor | | | | | | | | | | | | | | | | |
| for dry and wet concrete | | | γ_{inst} | [-] | 1,0 | | | | | | | | | | 1,2 | |
| for flooded bore hole | | | | | 1,2 | | | | | 1,4 | | | | | 1) | |
| 1) no performance assessed | | | | | | | | | | | | | | | | |
| Chemofast Injection system EP 1000 for rebar connection | | | | | | | | | | | | Annex C 3 | | | | |
| Performances Characteristic resistance to tension load under static and quasi-static loading; working life 50 and 100 years (DD) | | | | | | | | | | | | | | | | |