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**European Technical Assessment Body
for construction products**



European Technical Assessment

**ETA-15/0883
of 21 May 2026**

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

Injection system Hilti HIT-RE 100

Product family
to which the construction product belongs

System for post installed rebar connection with mortar

Manufacturer

Hilti Aktiengesellschaft
Feldkircherstrasse 100
9494 SCHAAN
FÜRSTENTUM LIECHTENSTEIN

Manufacturing plant

Hilti Werke

This European Technical Assessment
contains

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

This European Technical Assessment is
issued in accordance with Article 95(4) of
Regulation (EU) 2024/3110, on the basis of

EAD 330087-01-0601

This version replaces

ETA-15/0883 issued on 6 December 2017

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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 injection mortar Hilti HIT- RE 100 in accordance with the regulations for reinforced concrete construction.

Reinforcing bars made of steel with a diameter ϕ from 8 to 40 mm and Hilti HIT-RE 100 injection mortar are used for the rebar connection. The steel element is placed into a drilled hole filled with injection mortar and is anchored via the bond between embedded element, 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 under static and quasi-static loading	See Annex C1 and C2
Characteristic resistance under seismic loading	See Annex B3, C3

3.2 Safety in case of fire (BWR 2)

Essential characteristic	Performance
Reaction to fire	Class A1
Resistance to fire	See Annex C4

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. 330087-01-0601, 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.

The following standards are referred to in this European Technical Assessment:

- EN 1992-1-1:2004 + AC:2010 Eurocode 2: Design of concrete structures - Part 1-1: General rules and rules for buildings
- EN 1992-1-2:2004 + AC:2008 Eurocode 2: Design of concrete structures - Part 1-2: General rules - Structural fire design
- EN 1998-1:2004 + AC:2009 Eurocode 8: Design of structures for earthquake resistance - Part 1: General rules, seismic actions and rules for buildings
- EN 206:2013 + A1:2016 Concrete - Specification, performance, production and conformity

Issued in Berlin on 21 May 2026 by Deutsches Institut für Bautechnik

Dipl.-Ing. Beatrix Wittstock
Head of Section

beglaubigt:
Baderschneider

Installed condition

Figure A1:
Overlap joint with existing reinforcement for rebar connections of slabs and beams

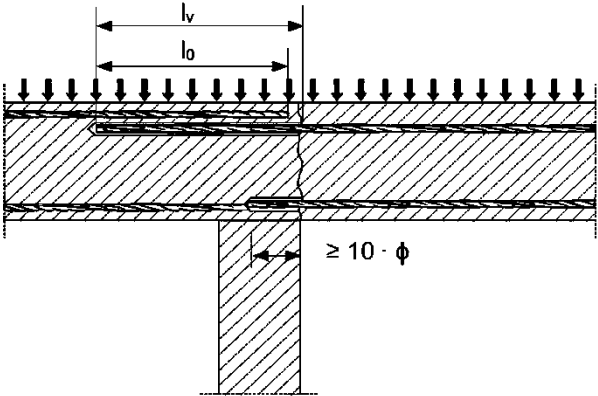


Figure A2:
Overlap joint with existing reinforcement at a foundation of a column or wall where the rebars are stressed in tension

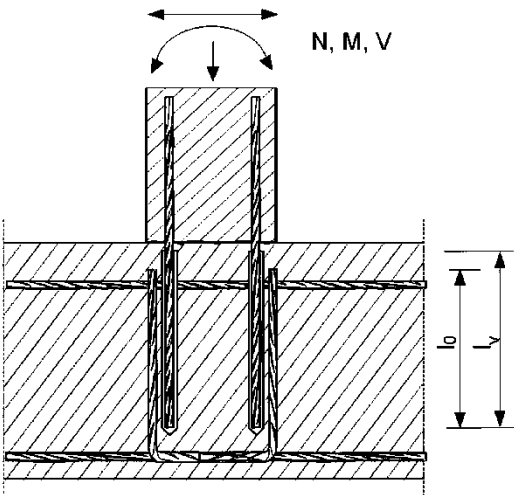
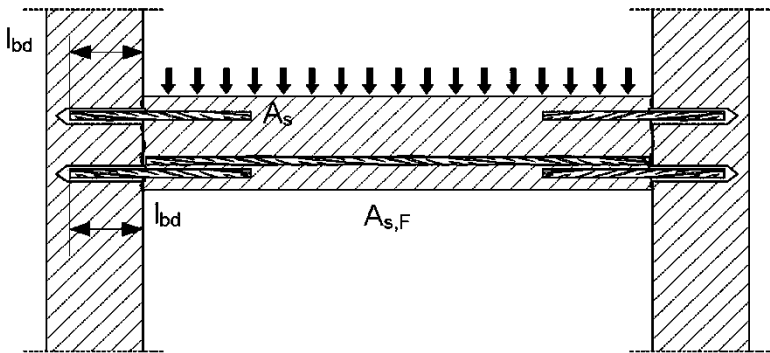


Figure A3:
End anchoring of slabs or beams



Injection system Hilti HIT-RE 100 for rebar connection

Product description
Installed condition: application examples of post-installed rebars

Annex A1

Figure A4:

Rebar connection for components stressed primarily in compression

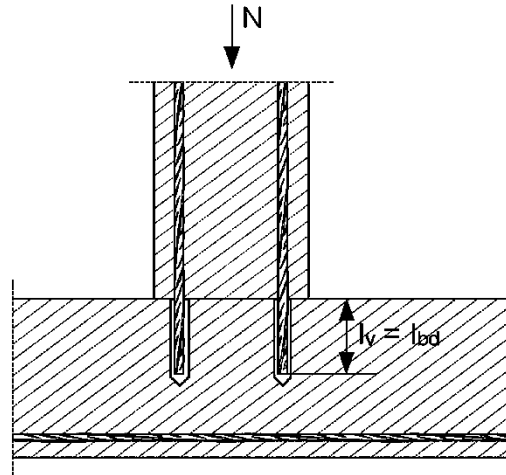
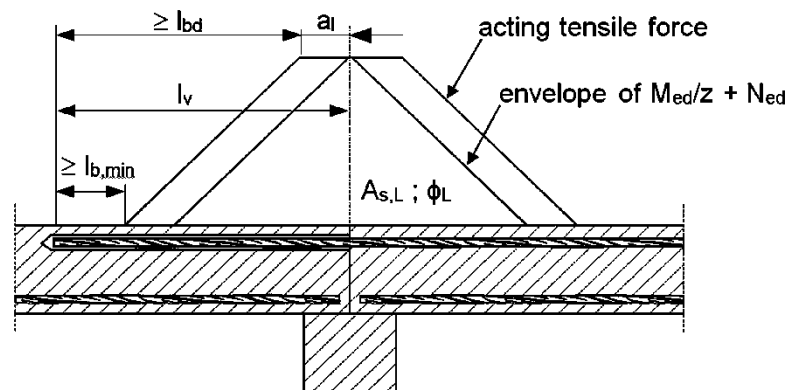


Figure A5:

Anchoring of reinforcement to cover the enveloped line of acting tensile force in the bending member



Note to Figure A1 to Figure A5:

- In the Figures no transverse reinforcement is plotted, the transverse reinforcement as required by EN 1992-1-1 or EN 1998-1 shall be present.
- The shear transfer between existing and new concrete shall be designed according to EN 1992-1-1 or EN 1998-1.
- Preparing of joints according to Annex B2.

Injection system Hilti HIT-RE 100 for rebar connection

Product description

Installed condition: application examples of post-installed rebars

Annex A2

Product description: Injection mortar and steel elements

Injection mortar Hilti HIT-RE 100: Epoxy resin system with aggregate
330 ml and 500 ml

Marking:
HILTI HIT
Production number and
production line
Expiry date mm/yyyy

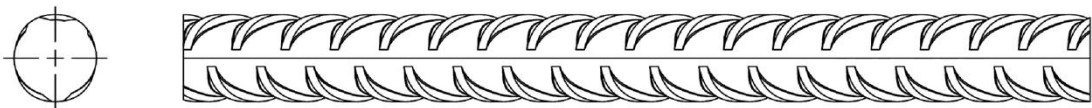


Product name: "Hilti HIT-RE 100"

Static mixer Hilti HIT-RE-M



Steel elements



Reinforcing bar (rebar): ϕ 8 to ϕ 40

- Materials and mechanical properties according to Table A1.
- Minimum value of related rib area f_R according to EN 1992-1-1.
- Rib height of the bar h_{rib} shall be in the range:
 $0,05 \cdot \phi \leq h_{rib} \leq 0,07 \cdot \phi$
- The maximum outer rebar diameter over the ribs shall be:
 $\phi + 2 \cdot 0,07 \cdot \phi = 1,14 \cdot \phi$
(ϕ : Nominal diameter of the bar; h_{rib} : Rib height of the bar)

Table A1: Materials

Designation	Material
Reinforcing bars (rebars)	
Rebar EN 1992-1-1	Bars and de-coiled rods class B or C with f_{yk} and k according to NDP or NCL of EN 1992-1-1 $f_{uk} = f_{tk} = k \cdot f_{yk}$

Injection system Hilti HIT-RE 100 for rebar connection

Product description
Injection mortar / Static mixer / Steel elements
Materials

Annex A3

Specifications of intended use

Anchorage subject to:

- Static and quasi static loading.
- Seismic loading.
- Fire exposure.

Base material:

- compacted reinforced or unreinforced normal weight concrete without fibers in accordance with EN 206.
- Strength classes in accordance with EN 206:
C12/15 to C50/60 for static and quasi-static loading and fire exposure
C16/20 to C50/60 for seismic loading.
- Maximum chloride content of 0,40 % (CL 0.40) related to the cement content according to EN 206.
- 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 at least to the minimum concrete cover in accordance with EN 1992-1-1. The foregoing may be neglected if building components are new and not carbonated and if building components are in dry conditions.

Temperature in the base material:

- **at installation**
+5 °C to +40 °C
- **in-service**
-40 °C to +80 °C (max. long term temperature +50 °C and max. short term temperature +80 °C)

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 of rebar under static or quasi-static loading in accordance with EN 1992-1-1 and Annex B3 and under seismic action in accordance with EN 1998-1.
- Design under fire exposure in accordance with EN 1992-1-2.
- 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:

- Use category: dry or wet concrete (not in flooded holes).
- Hole drilling by hammer drill (HD), hollow drill bit (HDB), compressed air drill mode (CA), diamond coring dry (PCC) or diamond coring wet (DD).
- Overhead installation is admissible.
- 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 for the overlap joint).

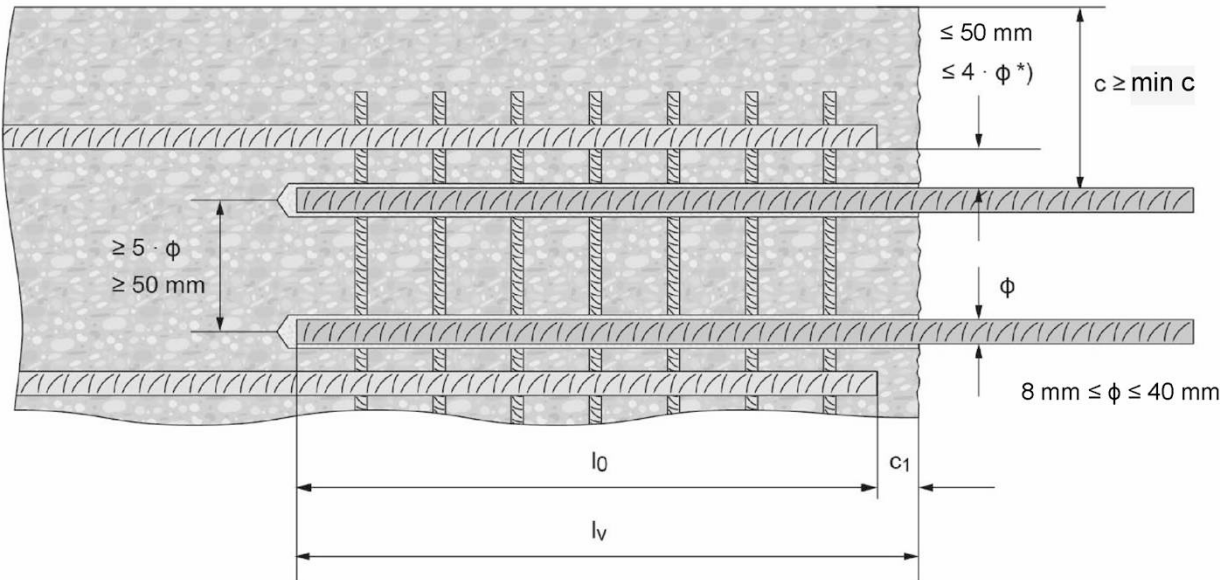
Injection system Hilti HIT-RE 100 for rebar connection

Intended Use
Specifications

Annex B1

Figure B1: General construction rules for post-installed rebars

- Post-installed rebar may be designed for tension forces only.
- The transfer of shear forces between new concrete and existing structure shall be designed additionally according to EN 1992-1-1.
- The joints for concreting must be roughened to at least such an extent that aggregate protrudes.



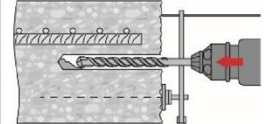
*) If the clear distance between lapped bars exceeds $4 \cdot \phi$ or 50 mm, then the lap length shall be increased by the difference between the clear bar distance and $4 \cdot \phi$ or 50 mm.

- c concrete cover of post-installed rebar
- c₁ concrete cover at end-face of existing rebar
- c_{min} minimum concrete cover according to Table B1 and to EN 1992-1-1
- ϕ diameter of reinforcement bar
- l₀ lap length
according to EN 1992-1-1 for static loading and
according to EN 1998-1, section 5.6.3 for seismic action
- l_v effective embedment depth $\geq l_0 + c_1$
- d₀ nominal drill bit diameter, see Annex B4 and B5

Injection system Hilti HIT-RE 100 for rebar connection	Annex B2
Intended Use General construction rules for post-installed rebars	

Table B1: Minimum concrete cover min c^1 of the post-installed rebar depending on drilling method and drilling tolerance

Drilling method	Bar diameter [mm]	Minimum concrete cover min c^1 [mm]	
		Without drilling aid	With drilling aid
Hammer drilling (HD) and (HDB) ²⁾	$\phi < 25$	$30 + 0,06 \cdot l_v \geq 2 \cdot \phi$	$30 + 0,02 \cdot l_v \geq 2 \cdot \phi$
	$\phi \geq 25$	$40 + 0,06 \cdot l_v \geq 2 \cdot \phi$	$40 + 0,02 \cdot l_v \geq 2 \cdot \phi$
Compressed air drilling (CA)	$\phi < 25$	$50 + 0,08 \cdot l_v$	$50 + 0,02 \cdot l_v$
	$\phi \geq 25$	$60 + 0,08 \cdot l_v \geq 2 \cdot \phi$	$60 + 0,02 \cdot l_v \geq 2 \cdot \phi$
Diamont coring dry (PCC) or wet (DD)	$\phi < 25$	Drill stand is used as drilling aid	$30 + 0,02 \cdot l_v \geq 2 \cdot \phi$
	$\phi \geq 25$		$40 + 0,02 \cdot l_v \geq 2 \cdot \phi$



¹⁾ See Annex B2, Figure B1.

²⁾ HDB = hollow drill bit Hilti TE-CD and TE-YD

Comments: The minimum concrete cover acc. EN 1992-1-1 must be observed.

The same minimum concrete covers apply for rebar elements in the case of seismic loading, i.e. $c_{min,seis} = 2 \cdot \phi$.

Table B2: Maximum embedment depth $l_{v,max}$ depending on bar diameter and dispenser

Bar diameter ϕ [mm]	Dispensers	
	HDM 330, HDM 500, HIT-MD 2000, HIT-MD 2500	HDE 500, HIT-P 3000 F, HIT-P 3500 F, HIT-ED 3500
ϕ [mm]	$l_{v,max}$ [mm]	$l_{v,max}$ [mm]
8	1000	1000
10		
12		
13		1200
14		
16	700	1500
18		
19		1300
20		
22		
24	500	1000
25		
26		
28		
29		700
30	-	
32		
34		
36		
40		500

Injection system Hilti HIT-RE 100 for rebar connection

Intended Use

Minimum concrete cover / Maximum embedment depth

Annex B3

Table B3: Maximum working time, initial curing time and minimum curing time¹⁾

Temperature in the base material T	Maximum working time $t_{work}^{2)}$	Initial curing time $t_{assembly}^{3)}$	Minimum curing time $t_{cure}^{2)}$
+5°C to 9°C	2 hours	18 hours	72 hours
+10°C to 14°C	1,5 hours	12 hours	48 hours
+15°C to 19°C	30 min	8 hours	24 hours
+20°C to 24°C	25 min	6 hours	12 hours
+25°C to 29°C	20 min	5 hours	10 hours
+30°C to 39°C	12 min	4 hours	8 hours
+40°C	12 min	2 hours	4 hours

¹⁾ The curing time data are valid for dry base material only.

In wet base material the curing times must be doubled

²⁾ The temperature of the foil pack must be between +5 °C and +40 °C during use.

³⁾ After $t_{assembly}$ has elapsed preparation work may continue

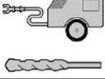
Injection system Hilti HIT-RE 100 for rebar connection

Intended use

Maximum working time, initial curing time and minimum curing time

Annex B4

Table B4: Parameters of drilling, cleaning and setting tools

Elements		Drill and clean					Installation		
Rebar	Hammer drilling (HD)	Compressed air drilling (CA)	Diamond core wet (DD)	Brush HIT-RB	Air nozzle HIT-DL	Extension for air nozzle	Piston plug HIT-SZ	Extension for piston plug	Maximum embedment depth
									-
size	d ₀ [mm]	d ₀ [mm]	d ₀ [mm]	size	size	[-]	size	[-]	l _{v,max} [mm]
φ 8	10	-	10	10	10	HIT-DL 10/0,8 or HIT-DL V10/1	-	HIT-VL 9/1,0	250
	12	-	12	12	12		12		1000
φ 10	12	-	12	12	12		12		250
	14	-	14	14	14		14	HIT-VL 11/1,0	1000
φ 12	14	-	14	14	14		14		250
	16	-	16	16	16		16		1200
	-	17	-	18	16		18		1200
φ 13	16	16	16	16	16		16		1200
φ 14	18	17	18	18	18		18 / 16 ¹⁾		1200
φ 16	20	-	20	20	20	HIT-DL 16/0,8 or HIT-DL B and/or HIT-VL 16/0,7 and/or HIT-VL 16	20 / 18 ¹⁾	HIT-VL 16/0,7 and/or HIT-VL 16	1500
	-	20	-	22	20		22		1300
φ 18	22	22	22	22	22		22		1300
φ 19	25	25	25	25	25		25		1300
φ 20	25 / 24 ¹⁾	-	25	25 / 24 ¹⁾	25 / 24 ¹⁾		25 / 24 ¹⁾		1300 / 400 ¹⁾
	-	26	-	28	25		28		1000
φ 22	28	28	28	28	28		28		1000
φ 24	32	32	32	32	32		32		1000 / 500 ¹⁾
φ 25	32 / 30 ¹⁾	32 / 30 ¹⁾	32	32 / 30 ¹⁾	32		32 / 30 ¹⁾		700
φ 26	35	35	35	35	35		35		700
φ 28	35	35	35	35	35		35		700
φ 29	37	37	37	37	37		37		700
φ 30	-	35	35	35	35		35		500
	37	-	-	37	37		37		
φ 32	40	40	40	40	40		40		
φ 34	-	42	42	42	42		42		
	45	-	-	45	45		45		
φ 36	45	45	-	45	45		45		
	-	-	47	47	47		47		
φ 40	-	-	52	52	52		52		
	55	57	-	55	55		55		

¹⁾ Each of the two given values can be used.

²⁾ Assemble extension HIT-VL 16/0,7 with coupler HIT-DL K for deeper anchor holes.

Injection system Hilti HIT-RE 100 for rebar connection

Intended Use
Parameters of cleaning and setting tools

Annex B5

Table B5: Parameters of drilling and setting tools with hollow drill bit or dry diamond coring

Elements	Drill					Installation		
Rebar	Hammer drilling, hollow drill bit (HDB) ¹⁾	Diamond core dry (PCC)	Brush HIT-RB	Air nozzle HIT-DL	Extension for air nozzle	Piston plug HIT-SZ	Extension for piston plug	Maximum embedment depth
								-
size	d ₀ [mm]	d ₀ [mm]	size	size	[-]	size	[-]	l _{v,max} [mm]
φ 8	12	-	No cleaning required			10	HIT-VL 9/1,0	
	12	-				12		200
φ 10	12	-				12		200
	14	-				14	HIT-VL 11/1,0	240
φ 12	14	-				14		240
	16	-				16		1000
φ 13	16	-				16		1000
φ 14	18	-				18		1000
φ 16	20	-				20	HIT-VL 16/0,7 and/or HIT-VL 16	1000
φ 18	22	-				22		1000
φ 19	25	-				25		1000
φ 20	25	-				25		1000
φ 22	28	-				28		1000
φ 24	32	-				32		1000
	-	35				35		1000
φ 25	32	-				32		1000
	-	35				35		1000
φ 26	-	35				35		700
φ 28	-	35				35		700
φ 29	-	35				35		700
φ 30	-	35				35		700
φ 32	-	47				45		700
φ 34	-	47				45		
φ 36	-	47				45		
φ 40	-	52				52		

¹⁾ With vacuum cleaner Hilti VC 4X/10/20/40/60 (automatic filter cleaning activated, eco mode off) or a vacuum cleaner providing equivalent cleaning performance in combination with the specified Hilti hollow drill bit TE-CD or TE-YD.

²⁾ Assemble extension HIT-VL 16/0.7 with coupler HIT-DL K for deeper anchor holes.

Injection system Hilti HIT-RE 100 for rebar connection

Intended Use
Dry diamond coring: Parameters of cleaning and setting tools

Annex B6

Cleaning alternatives

Manual Cleaning (MC):

Hilti hand pump for blowing out drill holes with diameters $d_0 \leq 20$ mm and drill hole depths $h_0 \leq 10 \cdot d$.
+ brush HIT-RB



Compressed Air Cleaning (CAC):

air nozzle with an orifice opening of minimum 3,5 mm in diameter.
+ brush HIT-RB



Automatic Cleaning (AC):

Cleaning is performed during drilling with Hilti TE-CD and TE-YD drilling system including vacuum cleaner.



Installation instruction

Safety Regulations:

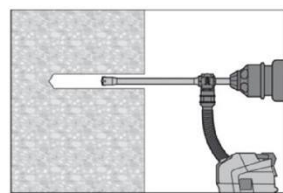


Review the Material Safety Data Sheet (MSDS) before use for proper and safe handling!
Wear well-fitting protective goggles and protective gloves when working with Hilti HIT-RE 100.
Important: Observe the installation instruction provided with each foil pack.

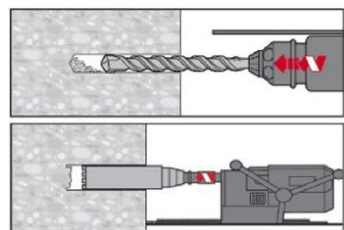
Hole drilling

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

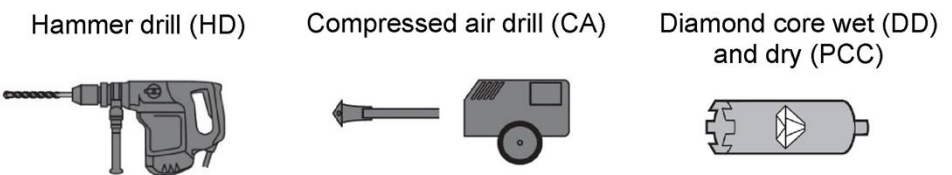
Drilling



Drill hole to the required embedment depth with an appropriately sized Hilti TE-CD or TE-YD hollow drill bit (HDB) with Hilti vacuum attachment. This drilling system removes the dust and cleans the bore hole during drilling when used in accordance with the user's manual.
After drilling is complete, proceed to the "injection preparation" step in the instructions for use.
Drill bit size see Table B5



Drill hole to the required embedment depth with a hammer drill set in rotation-hammer mode, a compressed air drill using an appropriately sized carbide drill bit or a diamond coring machine.

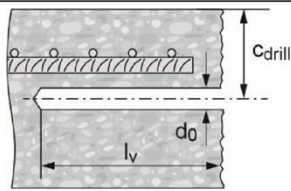


Injection system Hilti HIT-RE 100 for rebar connection

Intended Use
Cleaning alternatives
Installation instructions

Annex B7

Splicing applications



Measure and control concrete cover c .

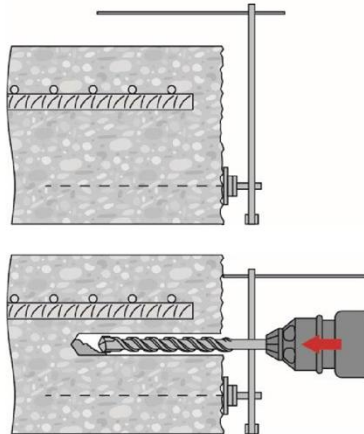
$$C_{\text{drill}} = c + d_0/2.$$

Drill parallel to edge and to existing rebar.

Where applicable use Hilti drilling aid HIT-BH.

Drilling aid

For holes $l_v > 20$ cm use drilling aid.



Ensure that the drill hole is parallel to the existing rebar.

Three different options can be considered:

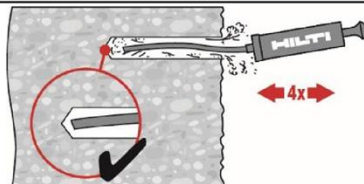
- Hilti drilling aid HIT-BH
- Lath or spirit level
- Visual check

Drill hole cleaning

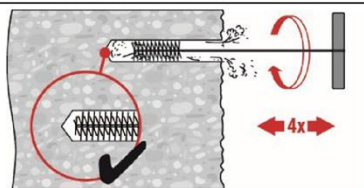
Just before setting the bar the drill hole must be free of dust and debris.
Inadequate hole cleaning = poor load values.

Manual Cleaning (MC)

For drill hole diameters $d_0 \leq 20$ mm and drill hole depths $h_0 \leq 10 \cdot d$.

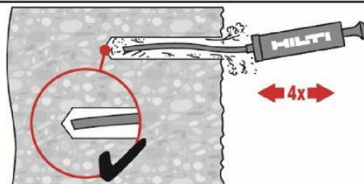


The Hilti hand pump may be used for blowing out drill holes up to diameters $d_0 \leq 20$ mm and embedment depths up to $h_{\text{ef}} \leq 10 \cdot d$.
Blow out at least 4 times from the back of the drill hole until return air stream is free of noticeable dust.



Brush 4 times with the specified brush (see Table B4) by inserting the steel brush Hilti HIT-RB to the back of the hole (if needed with extension) in a twisting motion and removing it.

The brush must produce natural resistance as it enters the drill hole (brush $\varnothing \geq$ drill hole $\varnothing$) - if not the brush is too small and must be replaced with the proper brush diameter.



Blow out again with the Hilti hand pump at least 4 times until return air stream is free of noticeable dust.

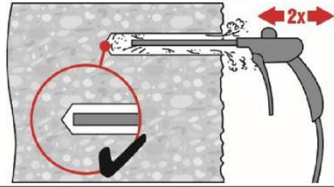
Injection system Hilti HIT-RE 100 for rebar connection

Intended Use
Installation instructions

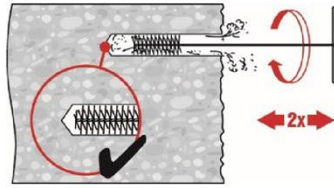
Annex B8

Compressed Air Cleaning (CAC)

For all drill hole diameters d_0 and all drill hole depths $h_0 \leq 20 \cdot d$.

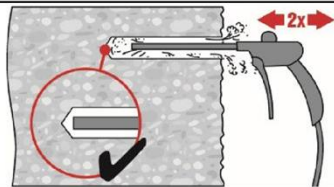


Blow 2 times from the back of the hole (if needed with nozzle extension) over the whole length with oil-free compressed air (min. 6 bar at 6 m³/h) until return air stream is free of noticeable dust.



Brush 2 times with the specified brush (see Table B4) by inserting the steel brush Hilti HIT-RB to the back of the hole (if needed with extension) in a twisting motion and removing it.

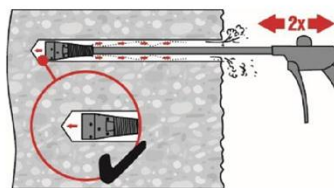
The brush must produce natural resistance as it enters the drill hole (brush $\varnothing \geq$ drill hole $\varnothing$) - if not the brush is too small and must be replaced with the proper brush diameter.



Blow again with compressed air 2 times until return air stream is free of noticeable dust.

Compressed Air Cleaning (CAC)

For drill holes deeper than 250 mm (for $\varnothing$ 8 to $\varnothing$ 12) or deeper than $20 \cdot \varnothing$ (for $\varnothing > 12$ mm)



Use the appropriate air nozzle Hilti HIT-DL (see Table B4).

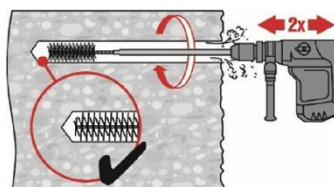
Blow 2 times from the back of the hole over the whole length with oil-free compressed air until return air stream is free of noticeable dust.

For drill hole diameters ≥ 32 mm the compressor has to supply a minimum air flow of 140 m³/h.

Safety tip:

Do not inhale concrete dust.

Use of the dust collector Hilti HIT-DRS is recommended.



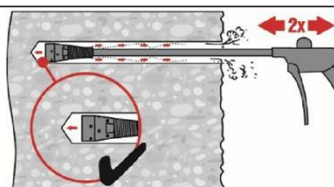
Screw the round steel brush HIT-RB in one end of the brush extension(s) HIT-RBS, so that the overall length of the brush is sufficient to reach the base of the drill hole. Attach the other end of the extension to the TE-C/TE-Y chuck.

Brush 2 times with the specified brush (see Table B4) by inserting the steel brush Hilti HIT-RB to the back of the hole (if needed with extension) and removing it.

Safety tip:

Start machine brushing operation slowly.

Start brushing operation once the brush is inserted in the borehole.



Use the appropriate air nozzle Hilti HIT-DL (see Table B4).

Blow 2 times from the back of the hole over the whole length with oil-free compressed air until return air stream is free of noticeable dust.

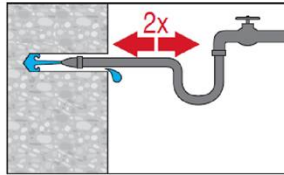
Injection system Hilti HIT-RE 100 for rebar connection

Intended Use
Installation instructions

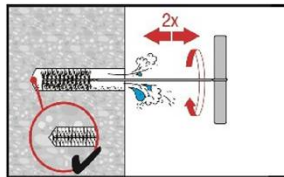
Annex B9

In addition for wet diamond coring (DD):

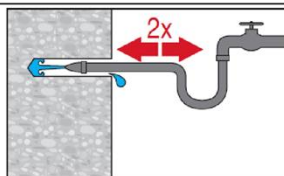
For all drill hole diameters d_0 and all drill hole depths h_0 .



Flush 2 times by inserting a water hose (water-line pressure) to the back of the hole until water runs clear.

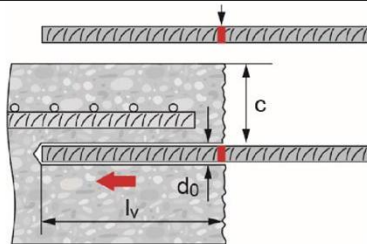


Brush 2 times with the specified brush (see Table B4) by inserting the steel brush Hilti HIT-RB to the back of the hole (if needed with extension) in a twisting motion and removing it.
The brush must produce natural resistance as it enters the drill hole (brush $\varnothing \geq$ drill hole $\varnothing$) - if not the brush is too small and must be replaced with the proper brush diameter.



Flush 2 times by inserting a water hose (water-line pressure) to the back of the hole until water runs clear.

Rebar preparation

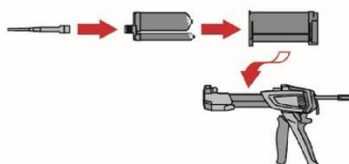


Before use, make sure the rebar is dry and free of oil or other residue.

Mark the embedment depth on the rebar (e.g. with tape) $\rightarrow l_v$.

Insert Rebar in borehole to verify hole and setting depth l_v .

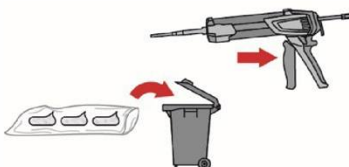
Injection preparation



Tightly attach Hilti mixing nozzle HIT-RE-M to foil pack manifold. Do not modify the mixing nozzle.

Observe the instruction for use of the dispenser.

Check foil pack holder for proper function. Insert foil pack into foil pack holder and put holder into dispenser.



The foil pack opens automatically as dispensing is initiated. Depending on the size of the foil pack an initial amount of adhesive has to be discarded. Discarded quantities are:

- 3 strokes for 330 ml foil pack,
- 4 strokes for 500 ml foil pack,

Injection system Hilti HIT-RE 100 for rebar connection

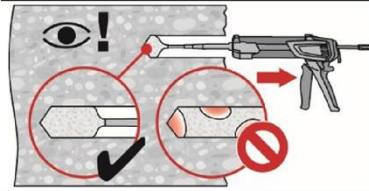
Intended Use
Installation instructions

Annex B10

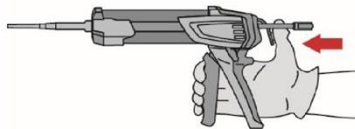
Inject adhesive

Inject adhesive from the back of the drill hole without forming air voids.

Injection method for drill hole depth ≤ 250 mm (without overhead applications)

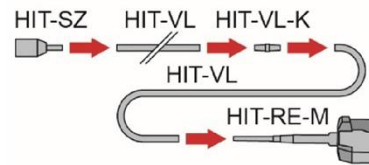


Inject the adhesive starting at the back of the hole, slowly withdrawing the mixer with each trigger pull. Fill approximately 2/3 of the drill hole to ensure that the annular gap between the anchor and the concrete is completely filled with adhesive along the embedment length.



After injection is completed, depressurize the dispenser by pressing the release trigger. This will prevent further adhesive discharge from the mixer.

Injection method for drill hole depth > 250 mm or overhead applications

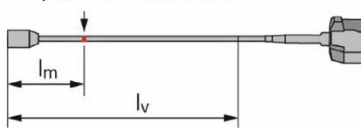


Assemble mixing nozzle HIT-RE-M, extension(s) and piston plug HIT-SZ (see Table B4).

For combinations of several injection extensions use coupler HIT-VL-K. A substitution of the injection extension for a plastic hose or a combination of both is permitted.

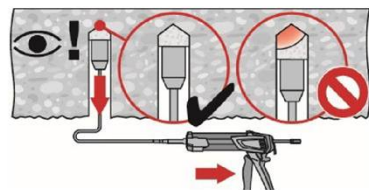
The combination of HIT-SZ piston plug with HIT-VL 16 pipe and then HIT-VL 16 tube supports proper injection.

required mortar level

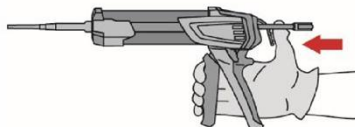


Mark the required mortar level l_m and embedment depth l_v with tape or marker on the injection extension.

- estimation:
 $l_m = 1/3 \cdot l_v$
- precise formula for optimum mortar volume:
 $l_m = l_v \cdot (1,2 \cdot (\phi^2 / d_0^2) - 0,2)$



For overhead installation the injection is only possible with the aid of extensions and piston plugs. Assemble HIT-RE-M mixer, extension(s) and appropriately sized piston plug (see Table B4). Insert piston plug to back of the hole and inject adhesive. During injection the piston plug will be naturally extruded out of the drill hole by the adhesive pressure.

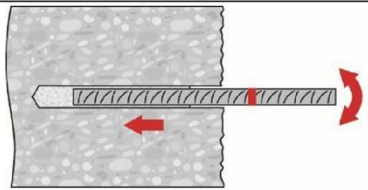
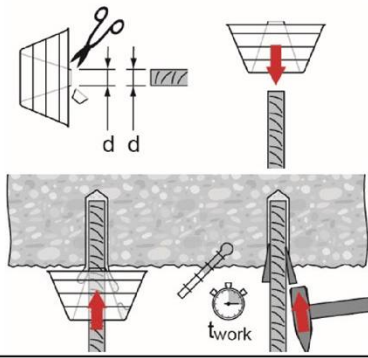
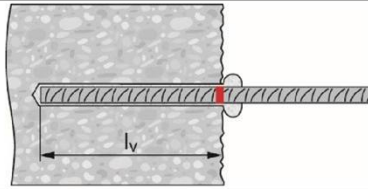
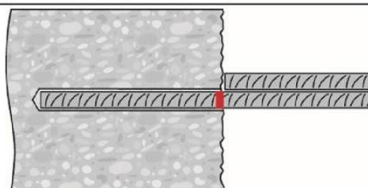
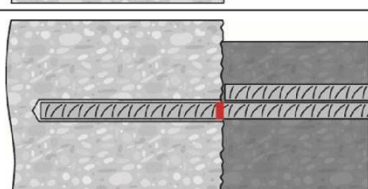


After injection is completed, depressurize the dispenser by pressing the release trigger. This will prevent further adhesive discharge from the mixer.

Injection system Hilti HIT-RE 100 for rebar connection

Intended Use
Installation instructions

Annex B11

Setting the element	Before use, verify that the element is dry and free of oil and other contaminants.
	For easy installation insert the rebar into the drill hole while slowly twisting until the embedment mark is at the concrete surface level.
	For overhead application: During insertion of the rebar mortar might flow out of the drill hole. For collection of the flowing mortar HIT-OHC may be used. Support the rebar and secure it from falling until mortar has started to harden, e.g. using wedges HIT-OHW. For overhead installation use piston plugs and fix embedded parts with e.g. wedges.
	After installing the rebar the annular gap must be completely filled with mortar. Proper installation: - desired anchoring embedment l_v is reached: embedment mark at concrete surface. - excess mortar flows out of the borehole after the rebar has been fully inserted until the embedment mark.
	Observe the working time t_{work} (see Table B3), which varies according to temperature of base material. Minor adjustments to the rebar position may be performed during the working time. After $t_{assembly}$ (see Table B3) preparation work may continue.
	Full load may be applied only after the curing time t_{cure} has elapsed (see Table B3).
Injection system Hilti HIT-RE 100 for rebar connection	
Intended Use Installation instructions	Annex B12

Minimum anchorage length and minimum lap length

The minimum anchorage length $l_{b,min}$ and the minimum lap length $l_{0,min}$ according to EN 1992-1-1 shall be multiplied by the relevant amplification factor α_{lb} given in Table C1 and Table C2.

Table C1: Amplification factor α_{lb} and $\alpha_{lb,100y}$ for hammer drilling (HD) and (HDB), compressed air drilling (CA)

	Amplification factor $\alpha_{lb} = \alpha_{lb,100y}$ [-]								
Size [mm]	Concrete class								
	C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 8 to ϕ 40	1,0								

Table C2: Amplification factor α_{lb} and $\alpha_{lb,100y}$ for diamond coring dry (PCC) and diamond coring wet (DD)

	Amplification factor $\alpha_{lb} = \alpha_{lb,100y}$ [-]								
Size [mm]	Concrete class								
	C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 8 to ϕ 40	1,5								

Table C3: Bond efficiency factor k_b and $k_{b,100y}$ for hammer drilling (HD) and (HDB), compressed air drilling (CA) and diamond coring dry (PCC)

	Bond efficiency factor $k_b = k_{b,100y}$ [-]								
Size [mm]	Concrete class								
	C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 8 to ϕ 40	1,0								

Table C4: Bond efficiency factor k_b and $k_{b,100y}$ for diamond coring wet (DD)

	Bond efficiency factor $k_b = k_{b,100y}$ [-]								
Size [mm]	Concrete class								
	C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 8 to ϕ 32	1,0				0,90	0,79	0,73	0,68	0,63
34	1,0				0,90	0,79	0,73	0,68	0,63
36	1,0				0,90	0,79	0,73	0,68	0,63
40	1,0				0,90	0,79	0,73	0,68	0,63

Injection system Hilti HIT-RE 100 for rebar connection

Performances
Amplification factor and bond efficiency factor

Annex C1

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

$$f_{bd,PIR,100y} = k_{b,100y} \cdot f_{bd}$$

- f_{bd} : Design value of the bond strength in N/mm² considering
- the concrete strength class
 - good bond condition (for all other bond conditions multiply the values by $\eta_1 = 0,7$)
 - recommended partial factor $\gamma_c = 1,5$ according to EN 1992-1-1.
 - rebar diameter for $\phi > 32$ mm ($\eta_2 = (132 - \phi) / 100$)

$k_b, k_{b,100y}$: Bond efficiency factor according to Table C3 and Table C4

Table C5: Design values of the bond strength $f_{bd,PIR}$ and $f_{bd,PIR,100y}$ for hammer drilling (HD) and (HDB), compressed air drilling (CA) and diamond coring dry (PCC)

	Bond strength $f_{bd,PIR} = f_{bd,PIR,100y}$ [N/mm ²]								
Bar diameter	Concrete class								
	C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 8 to ϕ 32	1,6	2,0	2,3	2,7	3,0	3,4	3,7	4,0	4,3
34	1,6	2,0	2,3	2,6	2,9	3,3	3,6	3,9	4,2
36	1,5	1,9	2,2	2,6	2,9	3,3	3,6	3,8	4,1
40	1,5	1,8	2,1	2,5	2,8	3,1	3,4	3,7	4,0

Table C6: Design values of the bond strength $f_{bd,PIR}$ and $f_{bd,PIR,100y}$ for diamond coring wet (DD)

	Bond strength $f_{bd,PIR} = f_{bd,PIR,100y}$ [N/mm ²]								
Bar diameter	Concrete class								
	C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 8 to ϕ 32	1,6	2,0	2,3	2,7					
34	1,6	2,0	2,3	2,6					
36	1,5	1,9	2,2	2,6					
40	1,5	1,8	2,1	2,5					

Injection system Hilti HIT-RE 100 for rebar connection

Performances

Design values of the bond strength $f_{bd,PIR}$ and $f_{bd,PIR,100y}$ for static loading

Annex C2

Minimum anchorage length and minimum lap length under seismic action

The minimum anchorage length $l_{b,min}$ and the minimum lap length $l_{0,min}$ according to EN 1992-1-1 shall be multiplied by the relevant amplification factor α_{lb} given in Table C1.

The minimum concrete cover according to Table B3 and $c_{min,seis} = 2 \cdot \phi$ applies.

Table C7: Bond efficiency factor $k_{b,seis}$ and $k_{b,seis,100y}$ for hammer drilling (HD) and (HDB), compressed air drilling (CA) and diamond coring dry (PCC)

Size [mm]	Bond efficiency factor $k_{b,seis} = k_{b,seis,100y}$ [-]							
	Concrete class							
	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 8 to ϕ 40	1,0							

$$f_{bd,PIR,seis} = k_{b,seis} \cdot f_{bd}$$

$$f_{bd,PIR,seis,100y} = k_{b,seis,100y} \cdot f_{bd}$$

f_{bd} : Design value of the bond strength in N/mm² considering

- the concrete strength class
- good bond condition (for all other bond conditions multiply the values by $\eta_1 = 0,7$)
- recommended partial factor $\gamma_c = 1,5$ according to EN 1992-1-1.
- rebar diameter for $\phi > 32$ mm ($\eta_2 = (132 - \phi) / 100$)

$k_{b,seis}$, $k_{b,seis,100y}$: Bond efficiency factor according to Table C7

Table C8: Design values of the bond strength $f_{bd,PIR,seis}$ and $f_{bd,PIR,seis,100y}$ for hammer drilling (HD) and (HDB), compressed air drilling (CA) and diamond coring dry (PCC)

Bar diameter	Bond strength $f_{bd,PIR,seis} = f_{bd,PIR,seis,100y}$ [N/mm ²]							
	Concrete class							
	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 8 to ϕ 32	2,0	2,3	2,7	3,0	3,4	3,7	4,0	4,3
34	2,0	2,3	2,6	2,9	3,3	3,6	3,9	4,2
36	1,9	2,2	2,6	2,9	3,3	3,6	3,8	4,1
40	1,8	2,1	2,5	2,8	3,1	3,4	3,7	4,0

Injection system Hilti HIT-RE 100 for rebar connection

Performances
Bond efficiency factor and design values of the bond strengths $f_{bd,PIR,seis}$ and $f_{bd,PIR,seis,100y}$ for seismic action

Annex C3

Bond strengths $f_{bd,fi}$ and $f_{bd,fi,100y}$ at increased temperature for concrete strength classes C12/15 to C50/60, for hammer drilling

The bond strengths $f_{bd,fi}$ for a working life of 50 years and $f_{bd,fi,100y}$ for a working life of 100 years at increased temperature have to be calculated by the following equations:

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

for a working life of 50 years

$$f_{bd,fi,100y} = k_{fi,100y}(\theta) \cdot f_{bd,PIR,100y} \cdot \gamma_c / \gamma_{M,fi}$$

for a working life of 100 years

with:

$$\theta \leq \theta_{max}: k_{fi}(\theta) = 1329,53 \cdot \theta^{-1,326} / (f_{bd,PIR} \cdot 4,3) \leq 1,0 \quad 50 \text{ years}$$
$$k_{fi,100y}(\theta) = 1329,53 \cdot \theta^{-1,326} / (f_{bd,PIR,100y} \cdot 4,3) \leq 1,0 \quad 100 \text{ years}$$

and

$$\theta > \theta_{max}: k_{fi}(\theta) = k_{fi,100y}(\theta) = 0,0$$
$$\theta_{max} = 282 \text{ }^{\circ}\text{C}$$

- $f_{bd,fi}$; $f_{bd,fi,100y}$

Design value of bond strength at increased temperature in N/mm² for a working life of 50 years; 100 years
- θ

Temperature in $^{\circ}\text{C}$ in the mortar
- θ_{max}

Temperature in $^{\circ}\text{C}$ at which the mortar can no longer transfer bond stresses
- $k_{fi}(\theta)$; $k_{fi,100y}(\theta)$

Temperature reduction factor for a working life of 50 years; 100 years
- $f_{bd,PIR}$; $f_{bd,PIR,100y}$

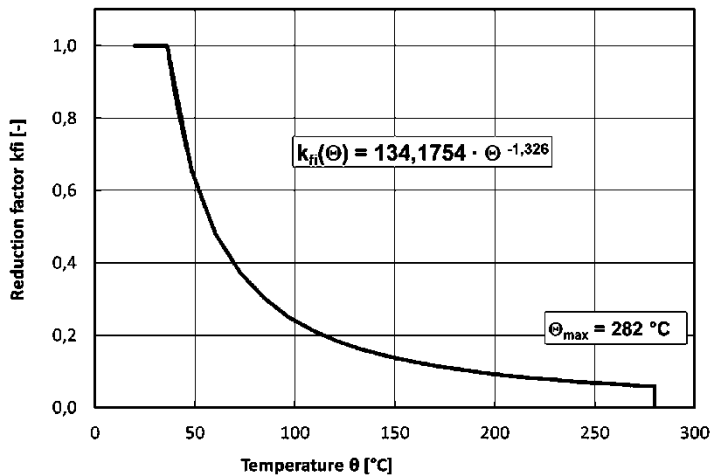
Design value of bond strength in N/mm² in cold condition according to Table C5 and Table C6 considering concrete class, rebar diameter, drilling method and bond condition according to EN 1992-1-1 for a working life of 50 years; 100 years
- γ_c

1,5 Partial factor according to EN 1992-1-1
- $\gamma_{M,fi}$

1,0 Partial factor according to EN 1992-1-2

At increased temperature the anchorage length shall be calculated according to EN 1992-1-1 Equation 8.3 using the temperature-dependent ultimate bond strength $f_{bd,fi}$.

Figure C1 Example graph of reduction factor $k_{fi}(\theta) = k_{fi,100y}(\theta)$ for concrete classes C20/25 for good bond conditions:



Injection system Hilti HIT-RE 100 for rebar connection

Performances
Bond strengths $f_{bd,fi}$ and $f_{bd,fi,100y}$ at increased temperature
Temperature reduction factors $k_{fi}(\theta)$ and $k_{fi,100y}(\theta)$ at increased temperature

Annex C4