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European Technical Assessment ETA-20/0793 dated 26/11/2020

English translation prepared by CSTB - Original version in French language

General Part

Nom commercial: *Trade name:*	**Injection system Hilti HIT-RE 500 V4 for rebar connection**
Famille de produit: *Product family:*	Scellement d'armatures rapportées, diamètres 10 à 40mm, avec Système d'injection Hilti HIT-RE 500 V4. **Post installed rebar connections diameter 10 to 40 mm made with Hilti HIT-RE 500 V4 injection mortar.**
Titulaire: *Manufacturer:*	Hilti Corporation Feldkircherstrasse 100 FL-9494 Schaan Principality of Liechtenstein
Usine de fabrication: *Manufacturing plants:*	Hilti plants
Cette evaluation contient: *This Assessment contains:*	24 pages incluant 27 pages d'annexes qui font partie intégrante de cette évaluation 24 *pages including 27 pages of annexes which form an integral part of this assessment*
Base de l'ETE *Basis of ETA:*	DEE 330087-01-0601 *EAD 330087-01-0601*
Cette évaluation remplace: *This Assessment replaces:*	-

Specific Part

1 Technical description of the product

The Hilti HIT-RE 500 V4 is used for the connection, by anchoring or overlap joint, of reinforcing bars (rebars) in existing structures made of ordinary non-carbonated concrete C16/20 to C50/60. The design of the post-installed rebar connections is done in accordance with EN 1992-1-1 and EN 1992-1-2 under static loading and EN 1998-1 under seismic loading.

Covered are rebar anchoring systems consisting of Hilti HIT-RE 500 V4 bonding material and an embedded straight deformed reinforcing bar diameter, d, from 10 to 40 mm with properties according to Annex C of EN 1992-1-1:2004 and EN 10080:2005. The classes B and C of the rebar are recommended. The illustration and the description of the product are given in Annexes A.

2 Specification of the intended use

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

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

3 Performance of the product

3.1 Mechanical resistance and stability (BWR 1)

Essential characteristic	Performance
Characteristic resistance under seismic loading	See Annex C1 and C2

3.2 Safety in case of fire (BWR 2)

Essential characteristic	Performance
Reaction to fire	Anchorages satisfy requirements for Class A1

3.3 Hygiene, health and the environment (BWR 3)

Regarding dangerous substances contained in this European technical approval, there may be requirements applicable to the products falling within its scope (e.g. transposed European legislation and national laws, regulations and administrative provisions).

3.4 Safety in use (BWR 4)

For Basic requirement Safety in use the same criteria are valid as for Basic Requirement Mechanical resistance and stability.

3.5 Protection against noise (BWR 5)

Not relevant.

3.6 Energy economy and heat retention (BWR 6)

Not relevant.

3.7 Sustainable use of natural resources (BWR 7)

For the sustainable use of natural resources, no performance was determined for this product.

3.8 General aspects relating to fitness for use

Durability and Serviceability are only ensured if the specifications of intended use according to Annex B1 are kept.

4 Assessment and verification of constancy of performance (AVCP)

According to the Decision 1996/582/EC of the European Commission[1], as amended, the system of assessment and verification of constancy of performance (see Annex V to Regulation (EU) No 305/2011) given in the following table apply.

Product	Intended use	Level or class	System
Metal anchors for use in concrete	For fixing and/or supporting to concrete, structural elements (which contributes to the stability of the works) or heavy units	—	1

5 Technical details necessary for the implementation of the AVCP system

Technical details necessary for the implementation of the Assessment and verification of constancy of performance (AVCP) system are laid down in the control plan deposited at Centre Scientifique et Technique du Bâtiment.

The manufacturer shall, on the basis of a contract, involve a notified body approved in the field of anchors for issuing the certificate of conformity CE based on the control plan.

The original French version is signed by

Anca Cronopol
Head of the division,

[1] Official Journal of the European Communities L 254 of 08.10.1996

Installed condition

Figure A1:

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

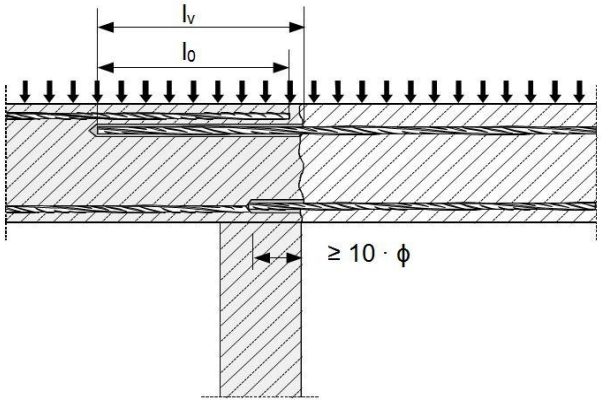


Figure A2:

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

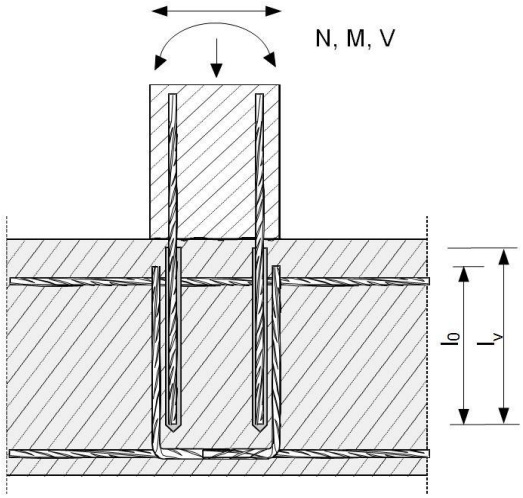
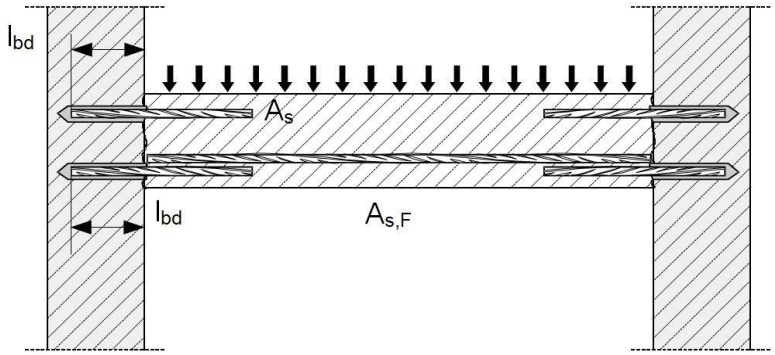


Figure A3:

End anchoring of slabs or beams



Injection system Hilti HIT-RE 500 V4	
Product description Installed condition: application examples of post-installed rebars	**Annex A1**

Figure A4:

Rebar connection for components stressed primarily in compression

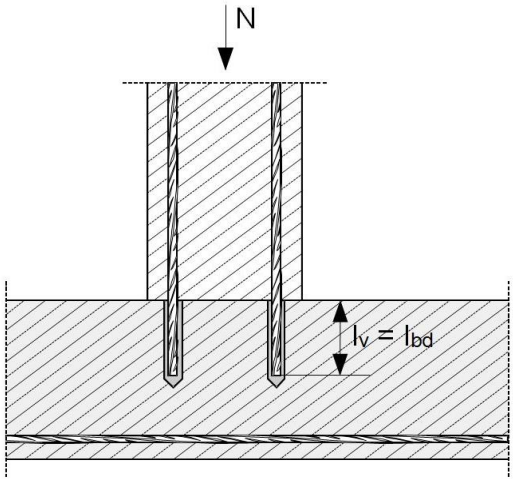
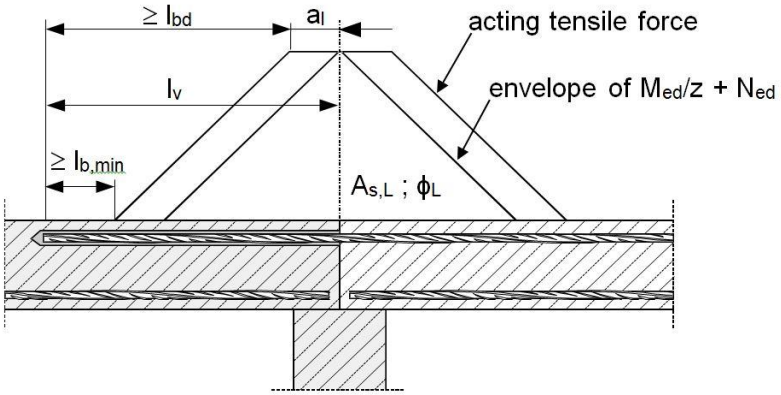


Figure A5:

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 1992-1-1:2004+AC:2010 shall be present.
- The shear transfer between existing and new concrete shall be designed according to EN 1992-1-1:2004+AC:2010 or EN 1998-1:2004+AC:2009.
- Preparing of joints according to Annex B2.

The reference to EN 1992-1-1:2004+AC:2010 is cited in the following as EN 1992-1-1 only.
The reference to EN 1998-1:2004+AC:2009 is cited in the following as EN 1998-1 only.

Product description: Injection mortar and steel elements

Injection mortar Hilti HIT-RE 500 V4: epoxy system with aggregate

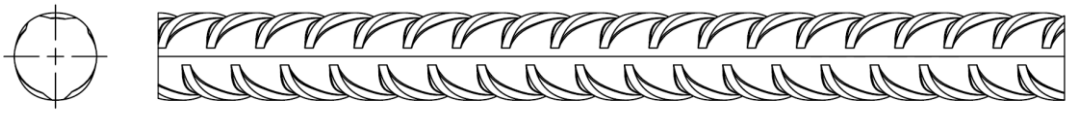
330 ml, 500 ml and 1400 ml

Marking:
HILTI HIT
Product name
Production time and line
Expiry date mm/yyyy

Product name: “Hilti HIT-RE 500 V4”

Static mixer Hilti HIT-RE-M

Steel elements



Reinforcing bar (rebar): ϕ 10 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:
  $0{,}05 \cdot \phi \le h_{rib} \le 0{,}07 \cdot \phi$
- 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 and AC:2010, Annex C	Bars and de-coiled rods class B or C with f_{yk} and k according to NDP or NCL of EN 1992-1-1/NA:2013 $f_{uk} = f_{tk} = k \cdot f_{yk}$

Specifications of intended use

Anchorages subject to:

- Seismic loading: rebar ϕ 10 to ϕ 40
  Note: Static and quasi static loading according ETA-20/0540.

Base material:

- Compacted reinforced or unreinforced normal weight concrete without fibres according to EN 206:2013+A1:2016.
- Strength classes C16/20 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.
  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 ϕ + 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. 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:

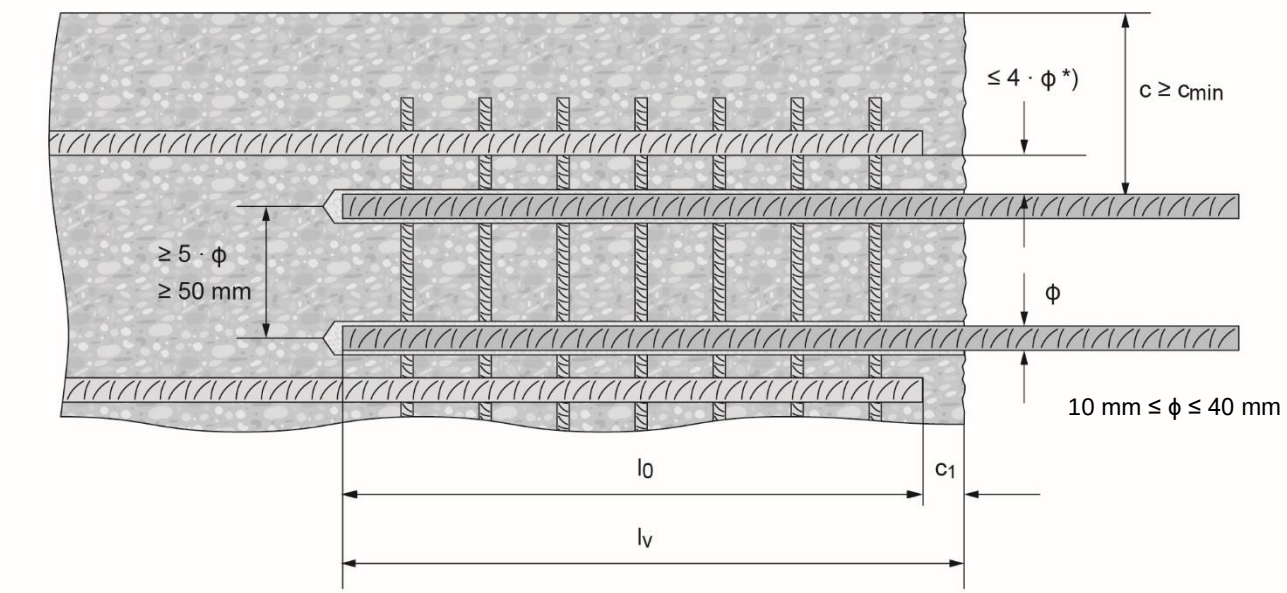
- Anchorages are designed under the responsibility of an engineer experienced in anchorages and concrete work.
- Verifiable calculation notes and drawings are prepared taking account of the forces to be transmitted.
- Design in accordance with EN 1992-1-1 and EN 1998-1. The actual position of the reinforcement in the existing structure shall be determined on the basis of the construction documentation and considered when designing.

Installation:

- Use category: dry or wet concrete (not in flooded holes).
- Drilling technique:
  - hammer drilling (HD),
  - hammer drilling with Hilti hollow drill bit TE-CD, TE-YD (HDB),
  - compressed air drilling (CA)
  - diamond coring (wet) (DD),
  - diamond coring (dry) (PCC),
  - diamond coring with roughening with Hilti Roughening tool TE-YRT (RT).
- 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).

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·ϕ, then the lap length shall be increased by the difference between the clear bar distance and 4·ϕ.

c concrete cover of post-installed rebar
c_1 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
l_0 lap length, according to EN 1992-1-1 for static loading and according to EN 1998-1, chapter 5.6.3 for seismic loading
l_v effective embedment depth ≥ $l_0 + c_1$
d_0 nominal drill bit diameter

Table B1: Minimum concrete cover c_{min}[1)] of the post-installed rebar depending on drilling method and drilling tolerance

Drilling method	**Rebar diameter [mm]**	**Minimum concrete cover c_{min}[1)] [mm]**	
		Without drilling aid	With drilling aid
Hammer drilling (HD) and hammer drilling with Hilti hollow drill bit TE-CD, TE-YD (HDB)	$\phi < 25$	$30 + 0{,}06 \cdot l_v \geq 2 \cdot \phi$	$30 + 0{,}02 \cdot l_v \geq 2 \cdot \phi$
	$\phi \geq 25$	$40 + 0{,}06 \cdot l_v \geq 2 \cdot \phi$	$40 + 0{,}02 \cdot l_v \geq 2 \cdot \phi$
Compressed air drilling (CA)	$\phi < 25$	$50 + 0{,}08 \cdot l_v$	$50 + 0{,}02 \cdot l_v$
	$\phi \geq 25$	$60 + 0{,}08 \cdot l_v \geq 2 \cdot \phi$	$60 + 0{,}02 \cdot l_v \geq 2 \cdot \phi$
Diamond coring (wet/dry) (DD)/(PCC)	$\phi < 25$	Drill stand works like a drilling aid	$30 + 0{,}02 \cdot l_v \geq 2 \cdot \phi$
	$\phi \geq 25$		$40 + 0{,}02 \cdot l_v \geq 2 \cdot \phi$
Diamond coring with roughening with Hilti Roughening tool TE-YRT (RT)	$\phi < 25$	$30 + 0{,}06 \cdot l_v \geq 2 \cdot \phi$	$30 + 0{,}02 \cdot l_v \geq 2 \cdot \phi$
	$\phi \geq 25$	$40 + 0{,}06 \cdot l_v \geq 2 \cdot \phi$	$40 + 0{,}02 \cdot l_v \geq 2 \cdot \phi$

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

Elements	**Dispensers**		
Rebar	HDM 330, HDM 500	HDE 500	HIT-P8000D
Size	$l_{v,max}$ [mm]	$l_{v,max}$ [mm]	$l_{v,max}$ [mm]
ϕ 10	1000	1000	-
ϕ 12		1200	1200
ϕ 13		1300	1300
ϕ 14		1400	1400
ϕ 16		1600	1600
ϕ 18	700	1800	1800
ϕ 20	600	2000	2000
ϕ 22	500	1800	2200
ϕ 24	300	1300	2400
ϕ 25	300	1500	2500
ϕ 26	300	1000	2600
ϕ 28	300	1000	2800
ϕ 30	-	1000	3000
ϕ 32		700	3200
ϕ 34		600	
ϕ 36		600	
ϕ 40		400	

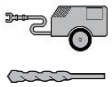
Table B3: Working time and curing time[1) 2)]

Temperature in the base material T	Maximum working time t_{work}	Initial curing time $t_{cure,ini}$	Minimum curing time t_{cure}
-5 °C to -1 °C	2 hours	48 hours	168 hours
0 °C to 4 °C	2 hours	24 hours	48 hours
5 °C to 9 °C	2 hours	16 hours	24 hours
10 °C to 14 °C	1,5 hours	12 hours	16 hours
15 °C to 19 °C	1 hour	8 hours	16 hours
20 °C to 24 °C	30 min	4 hours	7 hours
25 °C to 29 °C	20 min	3,5 hours	6 hours
30 °C to 34 °C	15 min	3 hours	5 hours
35 °C to 39 °C	12 min	2 hours	4,5 hours
40 °C	10 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 minimum temperature of the foil pack is +5° C.

Table B4: Parameters of drilling, cleaning and setting tools hammer drilling and compressed air drilling

Elements	**Drill and clean**					**Installation**		
Rebar	Hammer drilling (HD)	Compressed air drilling (CA)	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 10	12	-	12	12	HIT-DL 10/0,8 or HIT-DL V10/1	12	HIT-VL 9/1,0	1000
	14	-	14	14		14	HIT-VL 11/1,0	1000
ϕ 12	14	-	14	14		14		1000
	16	-	16	16		16		1200
	-	17	18	16		16		
ϕ 13	16	-	16	16		16		1300
	-	17	18	16		16		
ϕ 14	18	-	18	18		18		1400
	-	17	18	16		16		
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	HIT-VL 16/0,7 and/or HIT-VL 16	1600
ϕ 18	22	22	22	22		22		1800
ϕ 20	25	-	25	25		25		2000
	-	26	28	25		25		
ϕ 22	28	28	28	28		28		2200
ϕ 24	30	30	30	30		30		1000
	32	32	32	32		32		2400
ϕ 25	30	30	30	30		30		1000
	32	32	32	32		32		2500
ϕ 26	35	35	35	32		35		2600
ϕ 28	35	35	35	32		35		2800
ϕ 30	-	35	35	32		35		3000
	37	37	37	32		37		
ϕ 32	40	40	40	32		40		3200
ϕ 34	-	42	42	32		42		3200
	45	-	45	32		45		
ϕ 36	45	45	45	32		45		3200
ϕ 40	52	-	55	32		55		3200
	-	57	55	32		55		

[1] Assemble extension HIT-VL 16/0,7 with coupler HIT-VL K for deeper drilled holes.

Table B5: Parameters of drilling, cleaning and setting tools hammer drilling with hollow drill bit and diamond coring (dry)

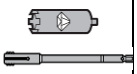
Elements	**Drill and clean**					**Installation**		
Rebar	Hammer-drilling with Hollow drill bit (HDB)[3]	Diamond coring (dry) (PCC)	Brush HIT-RB	Air nozzle HIT-DL	Extension for air nozzle	Piston plug HIT-SZ	Extension for piston plug	Maximum embedment depth
							 [1]	-
Size	d_0 [mm]	d_0 [mm]	Size	Size	[-]	Size	[-]	$l_{v,max}$ [mm]
ϕ 10	12	-	No cleaning required.			12	HIT-VL 9/1,0	1000
	14	-				14	HIT-VL 11/1,0	1000
ϕ 12	14	-				14		1000
	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 20	25	-				25		1000
ϕ 22	28	-				28		1000
ϕ 24	32	-				32		1000
	-	35				35		2400
ϕ 25	32	-				32		1000
	-	35				35		2500
ϕ 26	35	35				32		1000 [2] / 2600
ϕ 28	35	35				32		1000 [2] / 2800
ϕ 30	-	35				32		3000
ϕ 32	-	47				32		3200
ϕ 34	-	47				32		3200
ϕ 36	-	47				32		3200
ϕ 40	-	52				32		3200

[1] Assemble extension HIT-VL 16/0,7 with coupler HIT-VL K for deeper drilled holes.

[2] Maximum embedment depth for use with Hilti Hollow drill bit TE-CD / TE-YD.

[3] To be used in combination with Hilti vacuum cleaner with suction volume >= 57 l/s.

Table B6: Parameters of drilling, cleaning and setting tools diamond coring (wet) and diamond coring with roughening

Elements	**Drill and clean**					**Installation**		
Rebar	Diamond coring (wet) (DD)	Diamond coring with roughening (RT)	Brush HIT-RB	Air nozzle HIT-DL	Extension for air nozzle	Piston plug HIT-SZ	Extension for piston plug	Maximum embedment depth
							 [1]	-
Size	d_0 [mm]	d_0 [mm]	Size	Size	[-]	Size	[-]	$l_{v,max}$ [mm]
ϕ 12	14	-	14	14	HIT-DL 10/0,8 or HIT-DL V10/1	14	HIT-VL 11/1,0	1000
	16	-	16	16		16		1200
ϕ 14	18	18	18	18		18		1400 / 900 [2]
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	HIT-VL 16/0,7 and/or HIT-VL 16	1600 / 1000 [2]
ϕ 18	22	22	22	22		22		1800 / 1200 [2]
ϕ 20	25	25	25	25		25		2000 / 1300 [2]
ϕ 22	28	28	28	28		28		2200 / 1400 [2]
ϕ 24	30	30	30	30		30		1000
	32	32	32	32		32		2400 / 1600 [2]
ϕ 25	30	30	30	30		30		1000
	32	32	32	32		32		2500 / 1600 [2]
ϕ 26	35	35	35	32		35		2600 / 1800 [2]
ϕ 28	35	35	35	32		35		2800 / 1800 [2]
ϕ 30	37	-	37	32		37		3000
ϕ 32	40	-	40	32		40		3200
ϕ 34	42	-	42	32		42		3200
	45	-	45	32		45		
ϕ 36	47	-	47	32		47		3200
ϕ 40	52	-	52	32		52		3200

[1] Assemble extension HIT-VL 16/0,7 with coupler HIT-VL K for deeper drilled holes.

[2] Maximum embedment depth for use with Hilti Roughening tool TE-YRT.

Table B7: Cleaning alternatives

Automatic Cleaning (AC): Cleaning is performed during drilling with Hilti hollow drill bit TE-CD, TE-YD including vacuum cleaner.	
Compressed Air Cleaning (CAC): air nozzle with an orifice opening of minimum 3,5 mm in diameter. + brush HIT-RB	
Manual Cleaning (MC): Hilti hand pump + brush HIT-RB for cleaning of drill holes with diameters $d_0 \leq 20$ mm and drill hole depths $h_0 \leq 10 \cdot d$.	
Compressed Air without brushing (C): air nozzle with an orifice opening of minimum 3,5 mm in diameter. for cleaning of drill holes with diameters $d_0 \leq 32$ mm.	

Table B8: Parameters for use of the Hilti Roughening tool TE-YRT

Diamond coring		Roughening tool TE-YRT	Wear gauge RTG…
			
d_0			
nominal [mm]	measured [mm]	d_0 [mm]	size
18	17,9 to 18,2	18	18
20	19,9 to 20,2	20	20
22	21,9 to 22,2	22	22
25	24,9 to 25,2	25	25
28	27,9 to 28,2	28	28
30	29,9 to 30,2	30	30
32	31,9 to 32,2	32	32
35	34,9 to 35,2	35	35

Table B9: Installation parameters for use of the Hilti Roughening tool TE-YRT

l_v [mm]	Roughening time $t_{roughen}$ ($t_{roughen}$ [sec] = l_v [mm] / 10)
0 to 100	10
101 to 200	20
201 to 300	30
301 to 400	40
401 to 500	50
501 to 600	60

Table B10: Hilti Roughening tool TE-YRT and wear gauge RTG

TE-YRT	
RTG	

Installation instruction

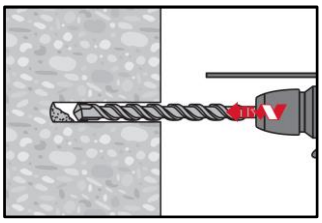
Safety Regulations:

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 500 V4.
Important: Observe the installation instruction provided with each foil pack.

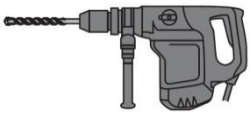
Hole drilling

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.

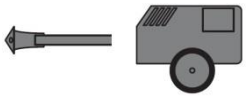
a) Hammer drilling



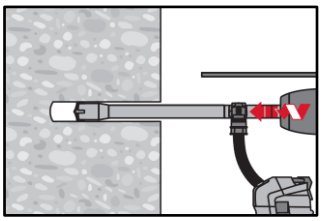
Drill hole to the required embedment depth with a hammer drill set in rotation-hammer mode or a compressed air drill using an appropriately sized carbide drill bit.



Compressed air drill (CA)

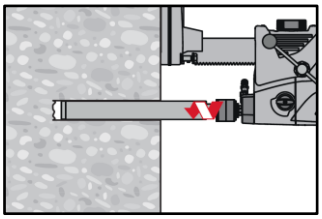


b) Hammer drilling with Hilti hollow drill bit TE-CD, TE-YD



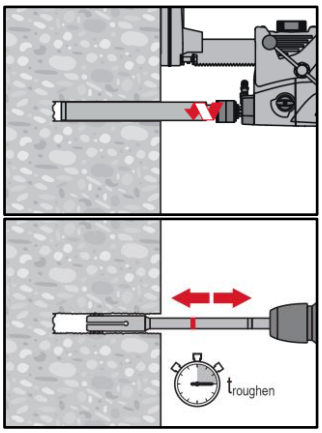
Drill hole to the required embedment depth with an appropriately sized Hilti TE-CD or TE-YD hollow drill bit with Hilti vacuum cleaner VC 20/40 (-Y) (suction volume >= 57 l/s). This drilling system removes the dust and cleans the drill hole during drilling when used in accordance with the user's manual. After drilling is completed, proceed to the "injection preparation" step in the installation instruction.

c) Diamond coring



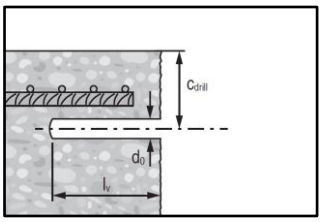
Diamond coring is permissible when suitable diamond core drilling machines and the corresponding core bits are used.

d) Diamond coring with roughening with Hilti Roughening tool TE-YRT



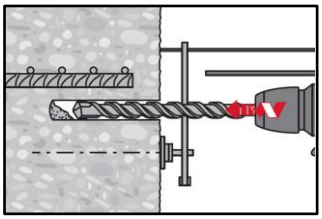
Diamond coring is permissible when suitable diamond core drilling machines and the corresponding core bits are used.
For the use in combination with Hilti Roughening tool TE-YRT see parameters in Table B6.
Before roughening water needs to be removed from the drill hole. Check usability of the roughening tool with the wear gauge RTG.
Roughen the drill hole over the whole length to the required l_v.

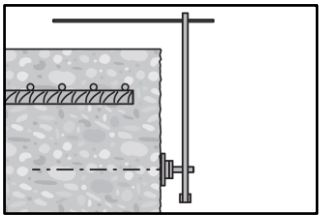
Splicing applications



Measure and control concrete cover c.
$c_{drill} = c + d_0/2$.
Drill parallel to surface edge and to existing rebar.
Where applicable use Hilti drilling aid HIT-BH.

Drilling aid: for holes l_v > 20 cm use drilling aid.

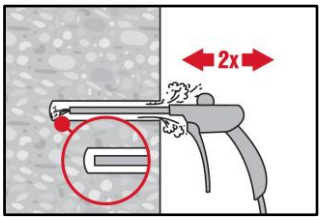




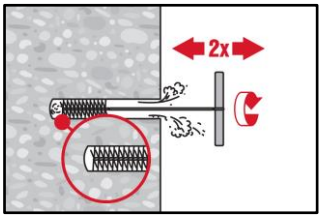
Ensure that the drill hole is parallel to the existing rebar.
Three different options can be considered:
- Hilti drilling aid HIT-BH
- Lath or spirit level
- Visual check

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

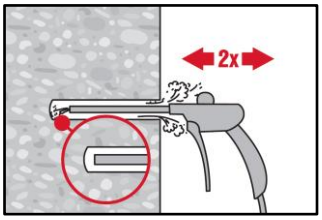
Compressed Air Cleaning (CAC) for hammer drilled holes:
for all drill hole diameters d_0 and all drill hole depths $h_0 \leq 20 \cdot \phi$.



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.

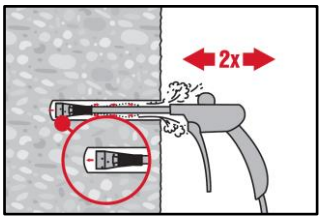


Brush 2 times with the specified brush (see Table B4) by inserting the steel brush Hilti HIT-RB to the back of the hole (if needed with extension) in a twisting motion and removing it.
The brush must produce natural resistance as it enters the drill hole (brush Ø ≥ drill hole Ø) - if not the brush is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

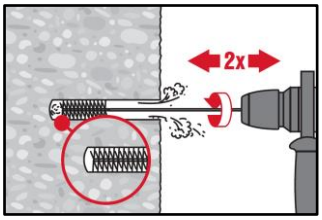


Blow again with compressed air 2 times until return air stream is free of noticeable dust.

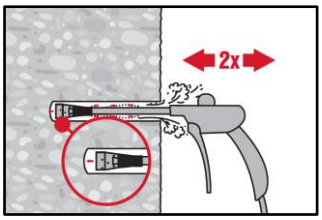
Compressed Air Cleaning (CAC) for hammer drilled holes:
for drill holes deeper than 250 mm (for ϕ10 and ϕ12) or deeper than 20·ϕ (for ϕ > 12 mm)



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.
Safety tip:
Do not inhale concrete dust.

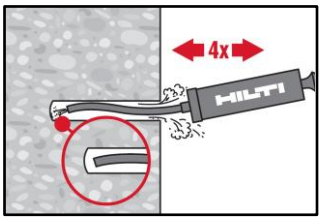


Screw the round steel brush HIT-RB in one end of the brush extension(s) HIT-RBS, so that the overall length of the brush is sufficient to reach the base of the drill hole. Attach the other end of the extension to the TE-C/TE-Y chuck.
Safety tip:
Start machine brushing operation slowly.
Start brushing operation once the brush is inserted in the drill hole.

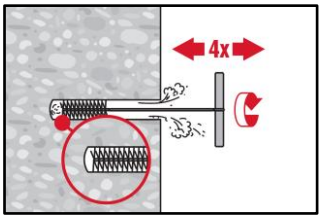


Use the appropriate air nozzle Hilti HIT-DL (see Table B4).
Blow 2 times from the back of the hole over the whole length with oil-free compressed air until return air stream is free of noticeable dust.
Safety tip:
Do not inhale concrete dust.
Use of the dust collector Hilti HIT-DRS is recommended.

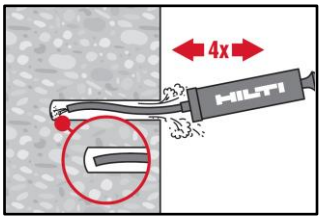
Manual Cleaning (MC) for hammer drilled holes:
for drill hole diameters $d_0 \leq 20$ mm and all drill hole depths $h_0 \leq 10 \cdot \phi$.



The Hilti hand pump may be used for blowing out drill holes up to diameters $d_0 \leq 20$ mm and drill hole depths $h_0 \leq 10 \cdot \phi$.
Blow out at least 4 times from the back of the drill hole until return air stream is free of noticeable dust.

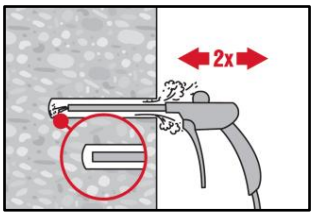


Brush 4 times with the specified brush (see Table B4) by inserting the steel brush Hilti HIT-RB to the back of the hole (if needed with extension) in a twisting motion and removing it.
The brush must produce natural resistance as it enters the drill hole (brush Ø ≥ drill hole Ø) - if not the brush is too small and must be replaced with the proper brush diameter.



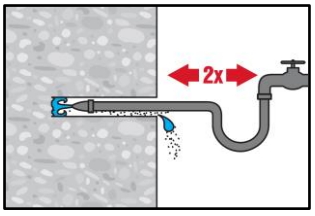
Blow again with the Hilti hand pump at least 4 times until return air stream is free of noticeable dust.

Compressed Air without brushing: for hammer drilled holes: For drill hole diameters $d_0 \leq 32$ mm

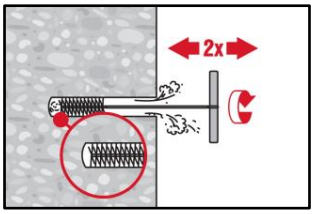


Blow 2 times from the back of the hole (if needed with nozzle extension) over the whole length with oil-free compressed air (min. 6 bar at 6 m³/h) until return air stream is free of noticeable dust.

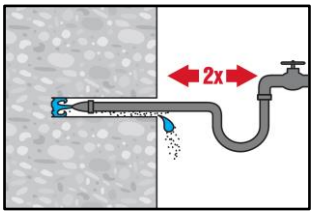
Cleaning of diamond cored holes: for all drill hole diameters d_0 and all drill hole depths h_0.



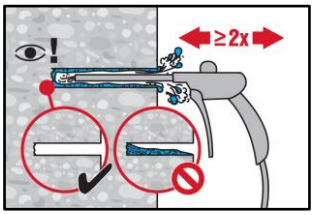
Flush 2 times by inserting a water hose (water-line pressure) to the back of the hole until water runs clear.



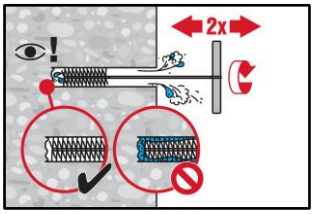
Brush 2 times with the specified brush (see Table B6) by inserting the steel brush Hilti HIT-RB to the back of the hole (if needed with extension) in a twisting motion and removing it.
The brush must produce natural resistance as it enters the drill hole (brush Ø ≥ drill hole Ø) - if not the brush is too small and must be replaced with the proper brush diameter.



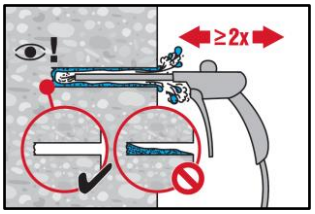
Flush 2 times by inserting a water hose (water-line pressure) to the back of the hole until water runs clear.



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

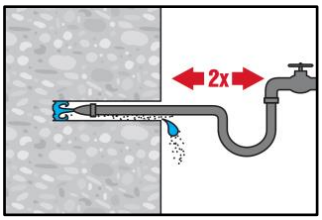


Brush 2 times with the specified brush size (brush Ø ≥ drill hole Ø, see Table B6) by inserting the steel brush Hilti HIT-RB to the back of the hole (if needed with extension) in a twisting motion and removing it.
The brush must produce natural resistance as it enters the drill hole – if not the brush is too small and must be replaced with the proper brush diameter.

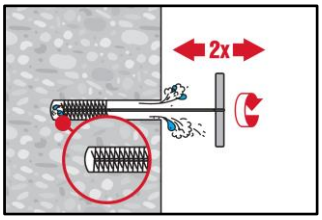


Blow again with compressed air 2 times until return air stream is free of noticeable dust and water.

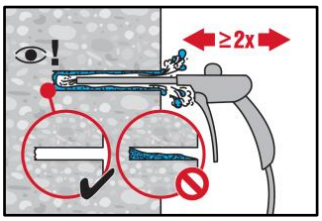
Cleaning of diamond cored holes with roughening with Hilti Roughening tool TE-YRT:
for all drill hole diameters d_0 and all drill hole depths h_0.



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

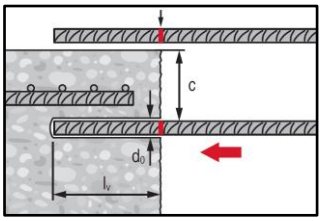


Brush 2 times with the specified brush (see Table B6) by inserting the steel brush Hilti HIT-RB to the back of the hole (if needed with extension) in a twisting motion and removing it.
The brush must produce natural resistance as it enters the drill hole (brush Ø ≥ drill hole Ø) - if not the brush is too small and must be replaced with the proper brush diameter.



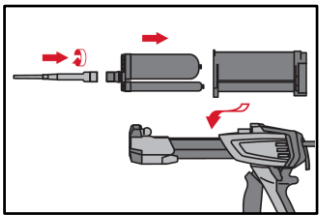
Blow 2 times from the back of the hole (if needed with nozzle extension) over the whole length with oil-free compressed air (min. 6 bar at 6 m³/h) until return air stream is free of noticeable dust and water.
For drill hole diameters ≥ 32 mm the compressor has to supply a minimum air flow of 140 m³/h.

Rebar preparation

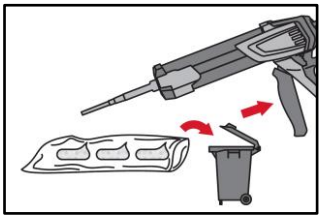


Before use, make sure the rebar is dry and free of oil or other residue.
Mark the embedment depth on the rebar (e.g. with tape) → l_v.
Insert rebar in drill hole to verify hole and setting depth l_v.

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.

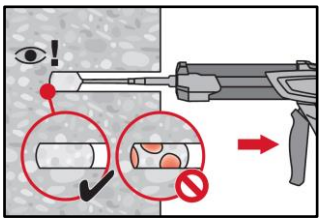


The foil pack opens automatically as dispensing is initiated. Depending on the size of the foil pack an initial amount of adhesive has to be discarded. Discarded quantities are:

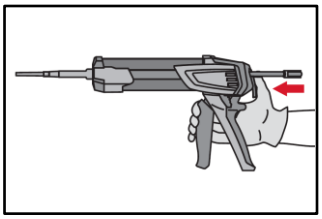
3 strokes	for 330 ml foil pack,
4 strokes	for 500 ml foil pack,
65 ml	for 1400 ml foil pack.

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)

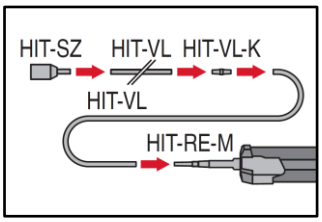


Inject the adhesive starting at the back of the hole, slowly withdrawing the mixer with each trigger pull.
Fill approximately 2/3 of the drill hole to ensure that the annular gap between the anchor and the concrete is completely filled with adhesive along the embedment length.

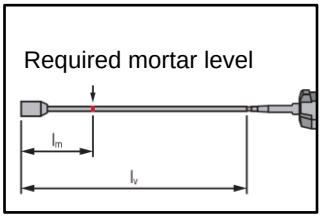


After injection is completed, depressurize the dispenser by pressing the release trigger. This will prevent further adhesive discharge from the mixer.

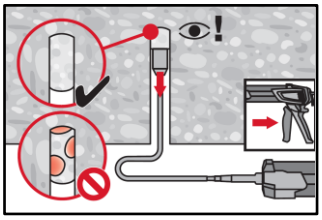
Injection method for drill hole depth > 250 mm or overhead applications



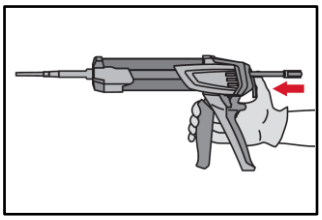
Assemble mixing nozzle HIT-RE-M, extension(s) and piston plug HIT-SZ (see Table B4, B5 or B6).
For combinations of several injection extensions use coupler HIT-VL-K.
A substitution of the injection extension for a plastic hose or a combination of both is permitted.
The combination of HIT-SZ piston plug with HIT-VL 16 pipe and then HIT-VL 16 tube support proper injection.



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: $l_m = l_v \cdot (1{,}2 \cdot (\phi^2 / d_0^2) - 0{,}2)$

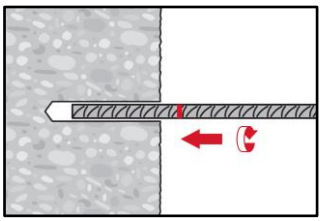


For overhead installation the injection is only possible with the aid of extensions and piston plugs. Assemble HIT-RE-M mixer, extension(s) and appropriately sized piston plug (see Table B4, B5 or B6). Insert piston plug to back of the hole and inject adhesive. During injection the piston plug will be naturally extruded out of the drill hole by the adhesive pressure.

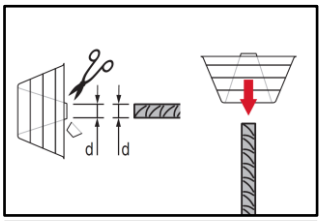


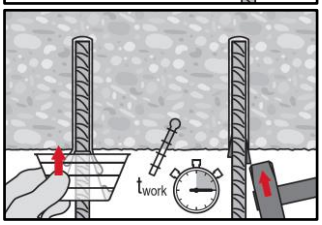
After injection is completed, depressurize the dispenser by pressing the release trigger. This will prevent further adhesive discharge from the mixer.

Setting the element: before use, verify that the element is dry and free of oil and other contaminants.

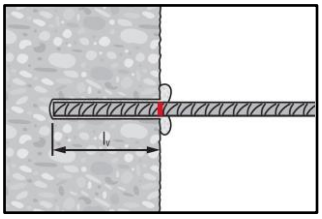


For easy installation insert the rebar into the drill hole while slowly twisting until the embedment mark is at the concrete surface level.



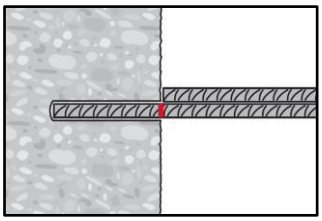


For overhead application:
During insertion of the rebar mortar might flow out of the drill hole. For collection of the flowing mortar HIT-OHC may be used.
Support the rebar and secure it from falling until mortar has started to harden, e.g. using wedges HIT-OHW.

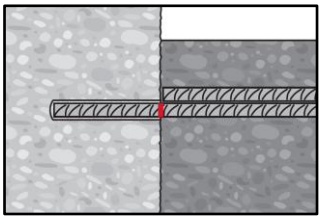


After installing the rebar, the annular gap must be completely filled with mortar.
Proper installation:

- desired anchoring embedment l_v is reached: embedment mark at concrete surface.
- excess mortar flows out of the drill hole 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.



Full load may be applied only after the curing time t_{cure} has elapsed (see Table B3).

Essential characteristic under seismic loading:

Minimum anchorage length, minimum lap length and design values for bond resistance:

- Hammer drilling,
- Hammer drilling with Hilti hollow drill bit TE-CD, TE-YD,
- Compressed air drilling,
- Diamond coring (dry),
- Diamond coring with roughening with Hilti Roughening tool TE-YRT.

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 Tables C1. The design bond resistance $f_{bd,seis}$ is given in Table C3. It is obtained by multiplying the design bond resistance f_{bd} according to EN 1992-1-1 (Eq. 8.3) by the bond efficiency factor $k_{b,seis}$ according to Table C2.

The minimum concrete cover between the value according to Table B1 and $c_{min,seis} = 2\ \phi$ applies.

Table C1: Amplification factor α_{lb}

Bar diameter	Amplification factor α_{lb} [-]							
	Concrete class							
	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 10 to ϕ 40	1,0							

Table C2: Seismic bond efficiency factor $k_{b,seis}$

Bar diameter	Bond efficiency factor $k_{b,seis}$ [-]							
	Concrete class							
	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 10 to ϕ 40	1,00							

Table C3: Design values of the bond resistance $f_{bd,seis}$ [1)]

Bar diameter	Bond resistance $f_{bd,seis}$ [N/mm²]							
	Concrete class							
	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 10 to ϕ 32	2,0	2,3	2,7	3,0	3,4	3,7	4,0	4,3
ϕ 34	2,0	2,3	2,6	2,9	3,3	3,6	3,9	4,2
ϕ 36	1,9	2,2	2,6	2,9	3,2	3,5	3,8	4,1
ϕ 40	1,8	2,1	2,5	2,8	3,1	3,4	3,7	3,9

1) According to EN 1992-1-1 for good bond conditions. For all other bond conditions multiply the values by 0,7.

Essential characteristic under seismic loading:

Minimum anchorage length, minimum lap length and design values for bond resistance:

- Diamond coring (wet).

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 Tables C4. The design bond resistance $f_{bd,seis}$ is given in Table C6. It is obtained by multiplying the design bond resistance f_{bd} according to EN 1992-1-1 (Eq. 8.3) by the bond efficiency factor $k_{b,seis}$ according to Table C5.

The minimum concrete cover between the value according to Table B1 and $c_{min,seis} = 2\ \phi$ applies.

Table C4: Amplification factor α_{lb}

Bar diameter	Amplification factor [-]							
	Concrete class							
	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 12	1,0							
ϕ 13 to ϕ 36	Linear interpolation between diameters							
ϕ 40	1,0			1,2	1,3	1,4		

Table C5: Seismic bond efficiency factor $k_{b,seis}$

Bar diameter	Bond efficiency factor $k_{b,seis}$ [-]							
	Concrete class							
	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 12	1,00							0,93
ϕ 13 to ϕ 32	1,00					0,91	0,84	0,79
ϕ 34 to ϕ 40	1,00		0,86	0,75	0,69	0,63	0,58	0,54

Table C6: Design values of the bond resistance $f_{bd,seis}$[1)]

Bar diameter	Bond resistance $f_{bd,seis}$ [N/mm²]							
	Concrete class							
	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
ϕ 12	2,0	2,3	2,7	3,0	3,4	3,7	4,0	4,0
ϕ 13 to ϕ 32	2,0	2,3	2,7	3,0	3,3	3,4	3,4	3,4
ϕ 34	1,9	2,3	2,3	2,3	2,3	2,3	2,3	2,3
ϕ 36	1,9	2,2	2,2	2,2	2,2	2,2	2,2	2,2
ϕ 40	1,8	2,1	2,1	2,1	2,1	2,1	2,1	2,1

1) According to EN 1992-1-1 for good bond conditions. For all other bond conditions multiply the values by 0,7.