

## ДЕКЛАРАЦИЯ ЗА ЕКСПЛОАТАЦИОННИ ПОКАЗАТЕЛИ

### DoP 0352

за инжекционна система fischer Superbond (Мазилка за слединсталирани връзки на арматурни пръти)

BG

1. Уникален идентификационен код на типа продукт: DoP 0352
2. Предвидена употреба/употреби: Система за слединсталирана арматурна връзка с хоросан за използване в бетон., Виж Приложението, по-специално Приложения B1- B10.
3. Производител: fischerwerke GmbH & Co. KG, Otto-Hahn-Straße 15, 79211 Denzlingen, Германия
4. Упълномощен представител: –
5. Система/системи за оценяване и проверка на постоянството на експлоатационните показатели: 1
6. Европейски документ за оценяване: ETAG 001, Part 5, April 2013, използвано като ЕАД  
 Европейска техническа оценка: ETA-13/0651; 2015-06-18  
 Орган за техническа оценка: DIBt- Deutsches Institut für Bautechnik  
 Нотифициран орган/органи: 2873 TU Darmstadt
7. Деклариран експлоатационни показатели:  
**Механична устойчивост и здравина (BWR 1)**  
 Характерна носимоспособност на опън (за статично и квази статично действие):  
 Сила на свързване на последващо закрепване на арматурни пръти: Приложение C1  
 Редукционен фактор: Приложение C1  
 Коефициент на усилване при минимална дължина на закрепване: Приложение C1  
  
**Пожарна безопасност (BWR 2)**  
 Реакция на огън: Клас (A1)  
  
**Пожароустойчивост:**  
 Сила на свързване при разстящи температури: NPD
8. Подходяща техническа документация и/или специфична техническа документация: –

Експлоатационните показатели на продукта, посочени по-горе, са в съответствие с декларираните експлоатационни показатели. Настоящата декларация за експлоатационни показатели се издава в съответствие с Регламент (ЕС) № 305/2011, като отговорността за нея се носи изцяло от посочения по-горе производител.

Подписано за и от името на производителя от:



Dr.-Ing. Oliver Geibig, Управляващ директор Бизнес звена и инженеринг  
 Tumlingen, 2023-12-01



Jürgen Grün, Управляващ директор Химия и качество

Тази Декларация за съответствие е изготвена на различни езици. В случай, че възникне спор, относно интерпретирането, трябва да се вземе предвид английската версия.

Приложението съдържа доброволна и допълнителна информация на английски език в обем и съдържание, надхвърлящи (независимо от езика) законовите изисквания.

## 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 fischer injection mortar Superbond in accordance with the regulations for reinforced concrete construction.

Reinforcing bars made of steel with a diameter  $\phi$  from 8 to 32 mm according to Annex A 4 or the fischer rebar anchor FRA sizes M12, M16, M20 and M24 according to Annex A 5 and injection mortar fischer injection mortar FIS SB are used for rebar connections. 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 connection of at least 50 years. The indications given on the working life cannot be interpreted as a guarantee given by the producer, but are to be regarded only as a means for choosing the right products in relation to the expected economically reasonable working life of the works.

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

#### 3.1 Mechanical resistance and stability (BWR 1)

| Essential characteristic                      | Performance   |
|-----------------------------------------------|---------------|
| Design values of the ultimate bond resistance | See Annex C 1 |

#### 3.2 Safety in case of fire (BWR 2)

| Essential characteristic | Performance                                         |
|--------------------------|-----------------------------------------------------|
| Reaction to fire         | Rebar connections satisfy requirements for Class A1 |
| Resistance to fire       | No performance assessed                             |

#### 3.3 Hygiene, health and the environment (BWR 3)

Regarding dangerous substances there may be requirements (e.g. transposed European legislation and national laws, regulations and administrative provisions) applicable to the products falling within the scope of this European Technical Assessment. In order to meet the provisions of Regulation (EU) No 305/2011, these requirements need also to be complied with, when and where they apply.

#### 3.4 Safety in use (BWR 4)

The essential characteristics regarding Safety in use are included under the Basic Works Requirement Mechanical resistance and stability.

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

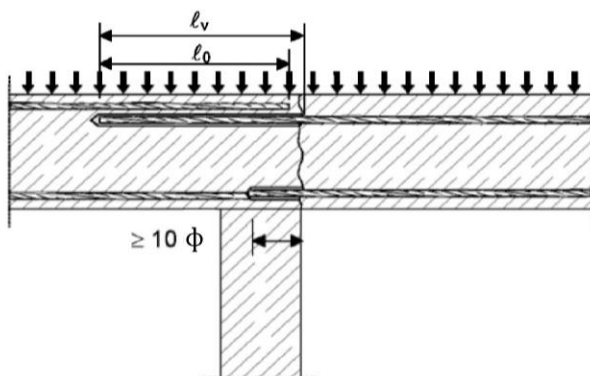
In accordance with guideline for European technical approval ETAG 001, April 2013 used as European Assessment Document (EAD) according to Article 66 Paragraph 3 of Regulation (EU) No 305/2011 the applicable European legal act is: [96/582/EC].

The system to be applied is: 1

## Installation anchor

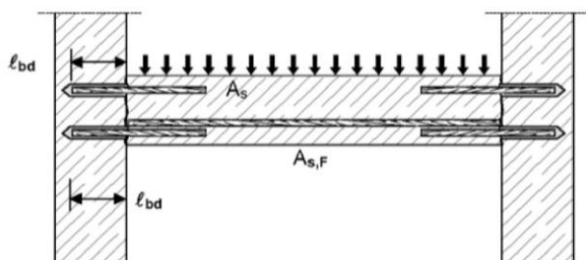
**Figure A1:**

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



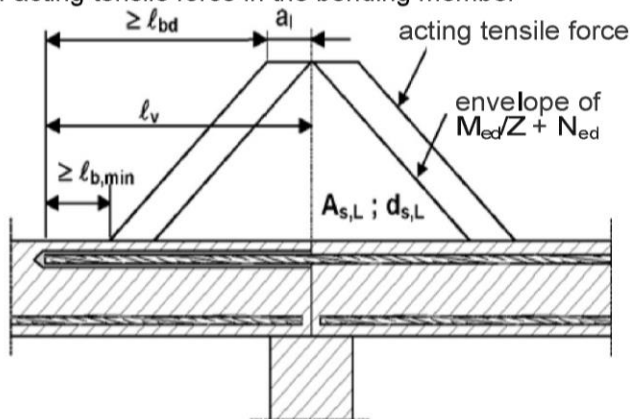
**Figure A3:**

End anchoring of slabs of beams (e.g. designed as simply supported)



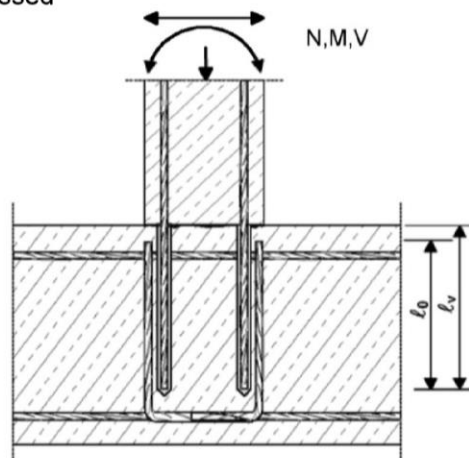
**Figure A5:**

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



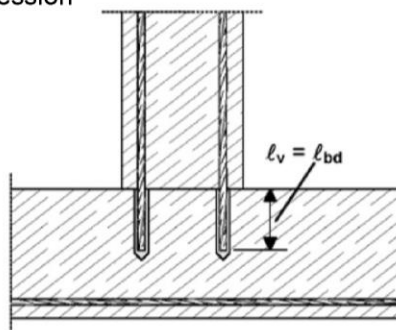
**Figure A2:**

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



**Figure A4:**

Rebar connection for stressed primarily in compression



### Note to Figure A1 to A5

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

Preparing of joints according to **Annex B 2**

## Rebar connection with fischer Superbond

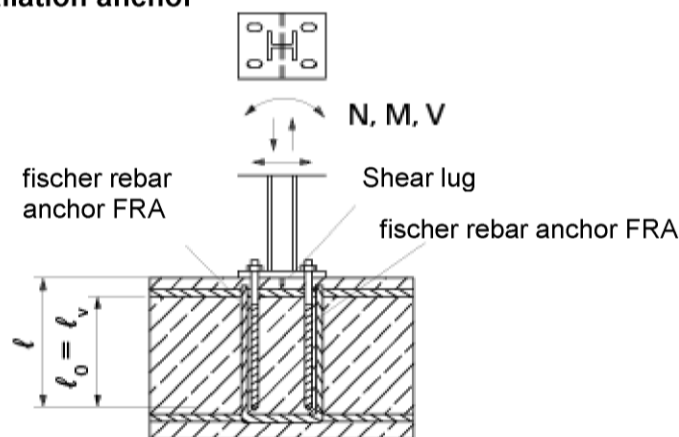
### Product description

Installed condition and examples of use for rebars

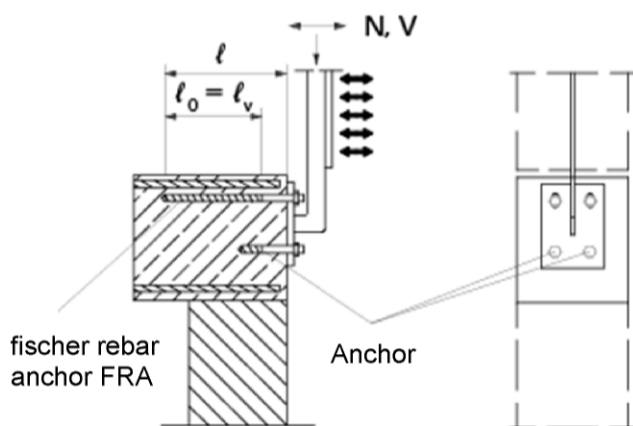
## Annex A 1

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## Installation anchor

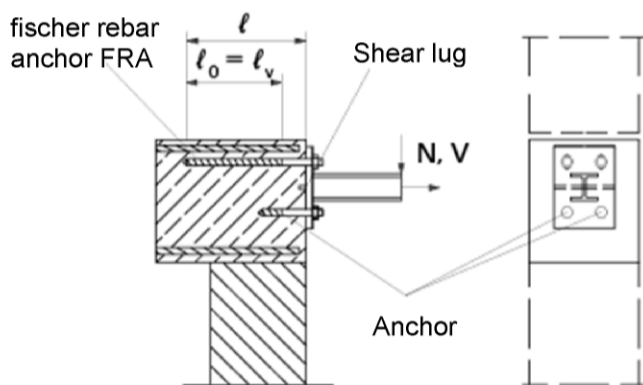


**Figure A6:** Lap to a foundation of a column under bending.



**Figure A7:** Lap of the anchoring of guardrail posts.

In the anchor plate, the drill holes for the rebar anchors have to be designed as elongated holes with axial direction to the shear force.



**Figure A8:** Lap of the anchoring of cantilevered buildings.

In the anchor plate, the drill holes for the rebar anchors have to be designed as elongated holes with axial direction to the shear load.

The required transverse reinforcement acc. to EN 1992-1-1:2004+AC:2010 is not shown in the figures.

**The fischer rebar anchor FRA may be only used for axial tensile force.** The tensile force must be transferred by lap to the existing reinforcement of the building. The transfer of the shear force has to be ensured by suitable measure, e.g. by means of shear force or anchors with European Technical Approval/Assessment (ETA)

## Rebar connection with fischer Superbond

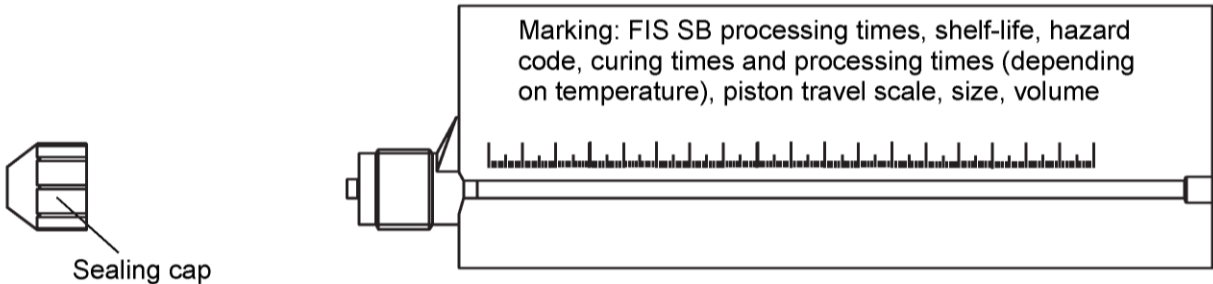
### Product description

Installed condition and examples of use for rebar anchor FRA

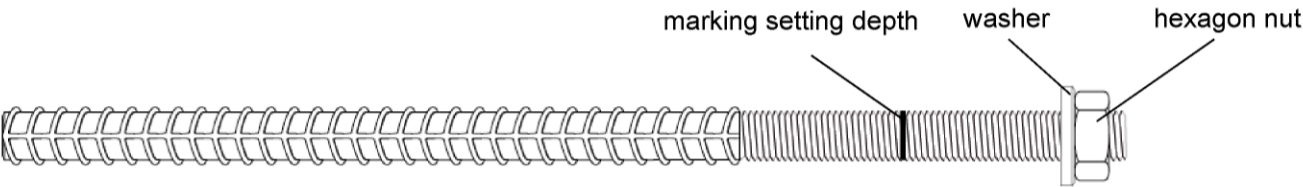
## Annex A 2

**Injection cartridge fischer FIS SB**

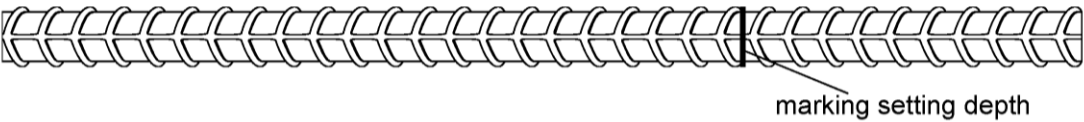
Sizes: 390 ml; 585 ml; 1100 ml,1500 ml



**fischer rebar anchor FRA M12, M16, M20, M24**



**Reinforcing bar (rebar)  $\phi$  8,  $\phi$  10,  $\phi$  12,  $\phi$  14,  $\phi$  16,  $\phi$  20,  $\phi$  25,  $\phi$  28,  $\phi$  32**



**Rebar connection with fischer Superbond**

**Product description**

Injection mortar; rebar anchor FRA; reinforcing bar

**Annex A 3**

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Figure A9: Properties of reinforcing bars (rebar)



- The minimum value of related rip area  $f_{R,min}$  according to EN 1992-1-1:2004+AC:2010
- The maximum outer rebar diameter over the rips shall be:
  - The nominal diameter of the rip  $\phi + 2 * h$  ( $h \leq 0,07 * \phi$ )
  - ( $\phi$ : Nominal diameter of the bar; h: rip height of the bar)

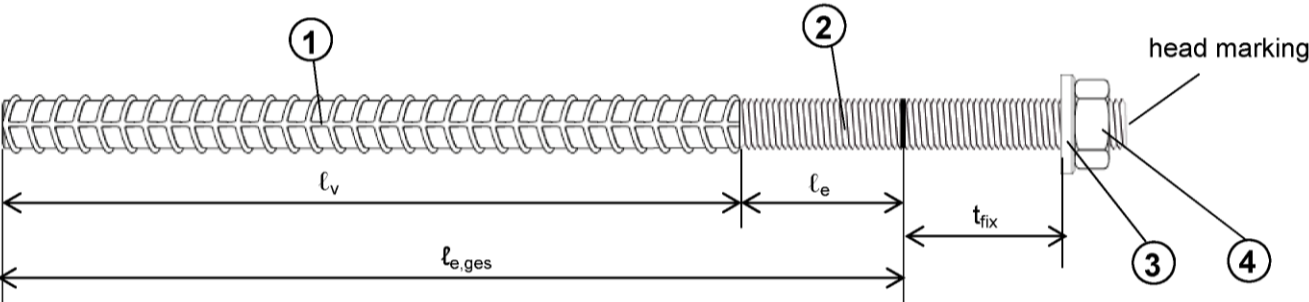
Table A1: Materials of rebars

| Designation                                          | Reinforcing bar (rebar)                                                                                                                          |
|------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------|
| Reinforcing bar<br>EN 1992-1-1:2004+AC:2010, Annex C | Bars and de-coiled rods class B or C with<br>$f_{yk}$ and k according to NDP or NCL of EN 1992-1-1/NA:2013<br>$f_{uk} = f_{tk} = k \cdot f_{yk}$ |

Rebar connection with fischer Superbond

Product description  
Properties and materials of rebars

Figure A10: Properties of fischer rebar anchors FRA



Head marking e.g.:  FRA (for stainless steel)

 FRA C (for high corrosion-resistant steel)

Table A2: Installation parameters for fischer rebar anchors FRA

| Threaded diameter                                       |                                | M12                        | M16          | M20 | M24 |
|---------------------------------------------------------|--------------------------------|----------------------------|--------------|-----|-----|
| Nominal diameter of the bar                             | $\phi$ [mm]                    | 12                         | 16           | 20  | 25  |
| Width across flat                                       | SW [mm]                        | 19                         | 24           | 30  | 36  |
| Nominal drill bit diameter                              | $d_0$ [mm]                     | 14 <sup>2)</sup>           | 16           | 10  | 25  |
| Drill hole depth( $h_0 = l_{e,ges}$ )                   | $l_{e,ges}$ [mm]               | $l_v + l_e$                |              |     |     |
| Effective embedment depth                               | $l_v$ [mm]                     | acc. to static calculation |              |     |     |
| Distance concrete surface to welded join                | $l_e$ [mm]                     | 100                        |              |     |     |
| Diameter of clearance hole in the fixture <sup>1)</sup> | Pre-positioned $\leq d_f$ [mm] | 14                         | 18           | 22  | 26  |
|                                                         | Push through $\leq d_f$ [mm]   | 18                         | 22           | 26  | 32  |
| Minimum thickness of concrete member                    | $h_{min}$ [mm]                 | $h_0+30 \geq 100$          | $h_0 + 2d_0$ |     |     |
| Maximum torque moment                                   | $T_{inst,max}$ [Nm]            | 50                         | 100          | 150 | 150 |

<sup>1)</sup> For bigger clearance holes in the fixture see chapter 1.1 of the TR 029

<sup>2)</sup> Both drill bit diameters can be used

Table A3: Materials of fischer rebar anchors FRA

| Part | Description                           | Materials                                                                                 |                                                                                                          |
|------|---------------------------------------|-------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------|
|      |                                       | FRA                                                                                       | FRA C                                                                                                    |
| 1    | Reinforcing bar                       | B500B acc. to DIN 488-1:2009                                                              |                                                                                                          |
| 2    | Round bar with partial or full thread | Stainless steel acc. to EN 10088-1:2014                                                   | High corrosion-resistant steel acc. to EN 10088-1:2014                                                   |
| 3    | Washer                                | Stainless steel acc. to EN 10088-1:2014                                                   | High corrosion-resistant steel acc. to EN 10088-1:2014                                                   |
| 4    | Hexagon nut                           | Stainless steel acc. to EN 10088-1:2014<br>Strength class 80;<br>acc. to EN ISO 3506:2009 | High corrosion-resistant steel acc. to EN 10088-1:2014<br>Strength class 80;<br>acc. to EN ISO 3506:2009 |

Rebar connection with fischer Superbond

Product description  
Properties and materials of fischer rebar anchors FRA

Annex A 5

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## Specifications of intended use

### Anchorage subject to:

Static and quasi-static loads

### Base materials:

- Reinforced or unreinforced normal weight concrete according to EN 206-1:2013  
Strength classes C12/15 to C50/60 according to EN 206-1:2013
- Maximum chloride concrete of 0,40% (CL 0.40) related to the cement content according to EN 206-1:2013
- Non-carbonated concrete

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

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

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

### Temperature Range:

- $-40^{\circ}\text{C}$  to  $+80^{\circ}\text{C}$  (max. short term temperature  $+80^{\circ}\text{C}$  and max long term temperature  $+50^{\circ}\text{C}$ )

### Use conditions (Environmental conditions) for fischer rebar anchors FRA:

- Structures subject to dry internal conditions exists (fischer rebar anchors FRA and FRA C)
- Structures subject to external atmospheric exposure (including industrial and marine environment) and to permanently damp internal condition, if no particular aggressive conditions exist (fischer rebar anchors FRA and FRA C)
- Structures subject to external atmospheric exposure and to permanently damp internal condition, if other particular aggressive conditions exist (fischer rebar anchors FRA C)

Note: Particular aggressive conditions are e.g. permanent, alternating immersion in seawater or the splash zone of seawater, chloride atmosphere of indoor swimming pools or atmosphere with extreme chemical pollution (e.g. in desulphurization plants or road tunnels where de-icing materials are used)

### Design:

- Anchorages are designed under the responsibility of an engineer experienced in anchorages and concrete work
- Verifiable calculation notes and drawings are prepared taking account of the forces to be transmitted
- Design according to EN 1992-1-1:2004+AC:2010 and Annex B 2 and Annex B3
- The actual position of the reinforcement in the existing structure shall be determined on the basis of the construction documentation and taken into account when designing

### Installation:

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

## Rebar connection with fischer Superbond

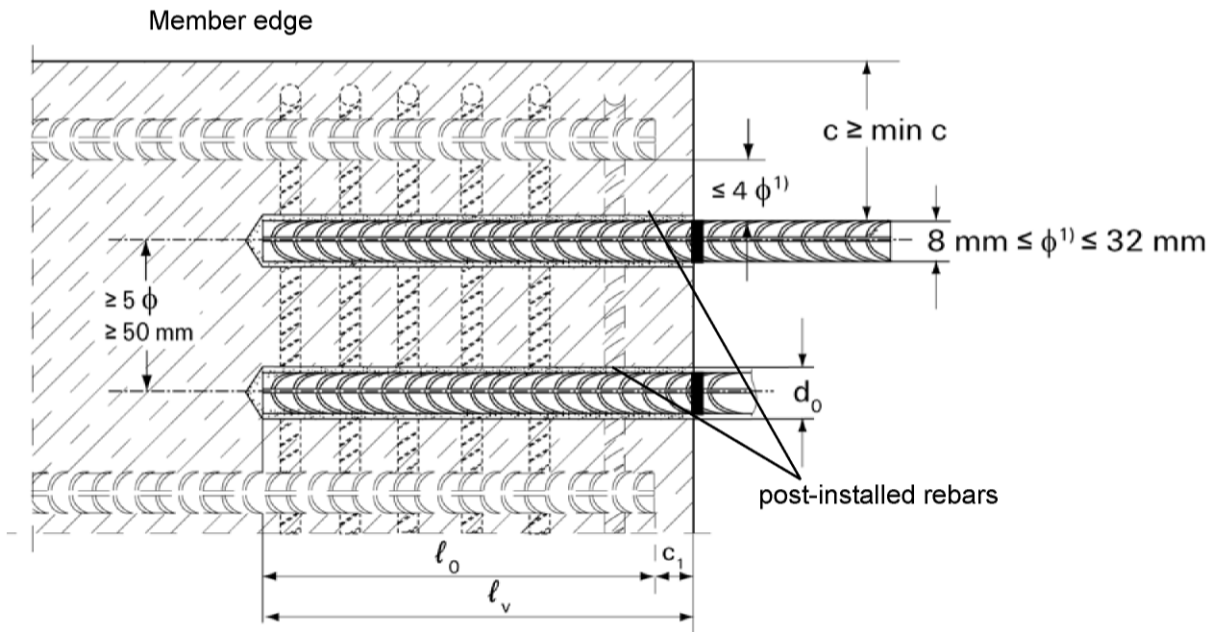
Intended use  
Specifications

## Annex B 1

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**Figure B1: General construction rules for post-installed rebars**

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



<sup>1)</sup> If the clear distance between lapped bars exceeds  $4 \phi$  then the lap length shall be increased by the difference between the clear bar distance and  $4 \phi$

- $c$  concrete cover of post-installed rebar  
 $c_1$  concrete cover at end-face of existing rebar  
 $\min c$  minimum concrete cover according to Table B1 and to EN 1992-1-1:2004+AC:2010, Section 4.4.1.2  
 $\phi$  nominal diameter of the bar  
 $\ell_0$  lap length, according to EN 1992-1-1:2004+AC:2010, Section 8.7.3  
 $\ell_v$  effective embedment depth,  $\geq \ell_0 + c_1$   
 $d_0$  nominal drill bit diameter, see Annex B 5

## Rebar connection with fischer Superbond

### Intended use

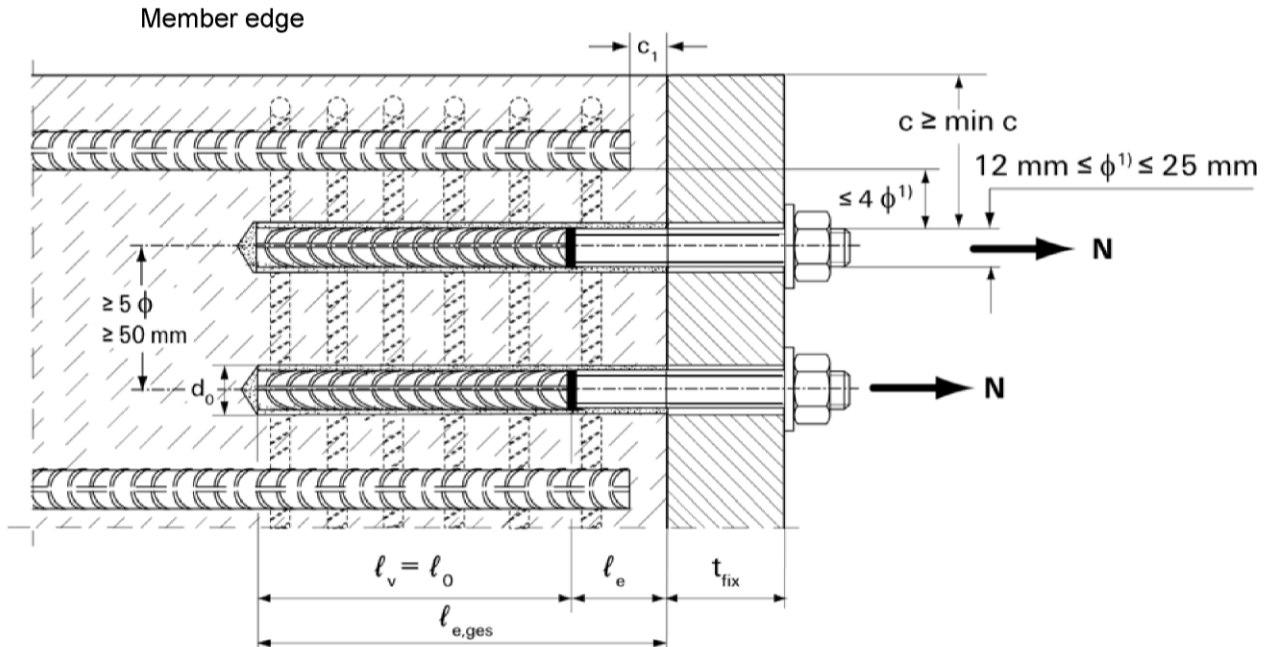
General construction rules for post-installed rebars

## Annex B 2

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**Figure B2: General construction rules for post-installed rebar anchors FRA**

- Only tension forces in the axis of the FRA may be transmitted
- The tension force must be transferred via an overlap joint to the reinforcement in the building part.
- The transmission of the shear load shall be ensured by appropriate additional measures, e.g. by shear lugs or by anchors with an European Technical Assessment (ETA).
- In the anchor plate, the holes for the tension anchor shall be executed as elongated holes with the axis in the direction of the shear force.



<sup>1)</sup> If the clear distance between lapped bars exceeds  $4\phi$  then the lap length shall be increased by the difference between the clear bar distance and  $4\phi$

|                |                                                                                               |
|----------------|-----------------------------------------------------------------------------------------------|
| $c$            | concrete cover of post-installed FRA                                                          |
| $c_1$          | concrete cover at end-face of existing rebar                                                  |
| $\min c$       | minimum concrete cover according to Table B1 and to EN 1992-1-1:2004+AC:2010, Section 4.4.1.2 |
| $\phi$         | nominal diameter of the bar                                                                   |
| $\ell_0$       | lap length, according to EN 1992-1-1:2004+AC:2010, Section 8.7.3                              |
| $\ell_{e,ges}$ | overall embedment depth, $\geq \ell_v + \ell_e$                                               |
| $\ell_e$       | length of the bonded in threaded part                                                         |
| $d_0$          | nominal drill bit diameter, see Annex B 5                                                     |
| $t_{fix}$      | thickness of the fixture                                                                      |
| $\ell_v$       | effective embedment depth                                                                     |

## Rebar connection with fischer Superbond

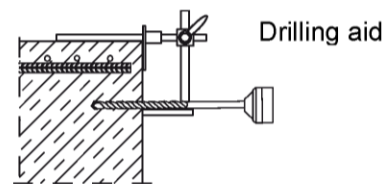
### Intended use

General construction rules for post-installed rebar anchors FRA

## Annex B 3

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**Table B1:**  
Minimum concrete cover  $c^{1)}$  depending of  
the drilling method and the drilling  
tolerance



| Drilling method         | Nominal diameter of the bar $\phi$ [mm] | Minimum concrete cover min c |                                   |
|-------------------------|-----------------------------------------|------------------------------|-----------------------------------|
|                         |                                         | Without drilling aid [mm]    | With drilling aid [mm]            |
| Hammer drilling         | $\leq 20$                               | 30 mm + 0,06 $\ell_v$        | 30 mm + 0,02 $\ell_v \geq 2 \phi$ |
|                         | $\geq 25$                               | 40 mm + 0,06 $\ell_v$        | 40 mm + 0,02 $\ell_v \geq 2 \phi$ |
| Compressed air drilling | $\leq 20$                               | 50 mm + 0,08 $\ell_v$        | 50 mm + 0,02 $\ell_v$             |
|                         | $\geq 25$                               | 60 mm + 0,08 $\ell_v$        | 60 mm + 0,02 $\ell_v$             |

<sup>1)</sup> See Annex B2, Figure B1 and Annex B3, Figure B2

Note: The minimum concrete cover as specified in EN 1992-1-1:2004+AC:2010 must be observed

**Table B2:**  
Dispensers and cartridge sizes correspondending to maximum embedment depth  $\ell_{v,max}$

| Rebar /FRA                   | Manual and accu dispenser              |        | Pneumatic dispenser                    |        |         |      |        |
|------------------------------|----------------------------------------|--------|----------------------------------------|--------|---------|------|--------|
|                              | Cartridge size                         |        | Cartridge size                         |        |         |      |        |
|                              | 390 ml;                                | 585 ml | 390 ml                                 | 585 ml | 1500 ml |      |        |
| $\phi$ [mm]                  | $\ell_{v,max} / \ell_{e,ges,max}$ [mm] |        | $\ell_{v,max} / \ell_{e,ges,max}$ [mm] |        |         |      |        |
| 8                            | 1000                                   | 1000   | 1400                                   | 2000   | 2000    | 2500 | 3000   |
| 10                           |                                        |        |                                        |        |         |      |        |
| 12                           |                                        |        |                                        |        |         |      |        |
| 14                           |                                        |        |                                        |        |         |      |        |
| 16                           |                                        |        |                                        |        |         |      |        |
| 20                           | 600                                    | 600    |                                        |        |         |      |        |
| 25                           |                                        |        |                                        |        |         |      |        |
| 28                           |                                        |        |                                        |        |         |      |        |
| 32                           |                                        |        |                                        |        |         |      |        |
|                              |                                        |        |                                        |        |         |      |        |
| Minimum concrete temperature | - 15°C                                 |        |                                        |        |         |      |        |
| Maximum concrete temperature | + 40°C                                 |        |                                        |        |         |      | + 20°C |

**Table B3: Working times  $t_{work}$  and curing times  $t_{cure}$**

| Temperature in the anchorage base [°C] | Minimum processing time $t_{work}$ [minutes]<br><b>FIS SB</b> | Minimum curing time $t_{cure}$ [minutes]<br><b>FIS SB</b> |
|----------------------------------------|---------------------------------------------------------------|-----------------------------------------------------------|
| $\geq -15$ to $-10$                    | 60                                                            | 36 hours                                                  |
| $> -10$ to $-5$                        | 30                                                            | 24 hours                                                  |
| $> -5$ to $\pm 0$                      | 20                                                            | 8 hours                                                   |
| $> \pm 0$ to $+5$                      | 13                                                            | 4 hours                                                   |
| $> +5$ to $+10$                        | 9                                                             | 120                                                       |
| $> +10$ to $+20$                       | 5                                                             | 60                                                        |
| $> +20$ to $+30$                       | 4                                                             | 45                                                        |
| $> +30$ to $+40$                       | 2                                                             | 30                                                        |

If the temperature in the concrete falls below 0°C the cartridge has to be warmed up to +15°C.

## Rebar connection with fischer Superbond

### Intended use

Minimum concrete cover/ Maximum embedment depth per dispenser and cartridge size/ Working times and curing times

## Annex B 4

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**Table B4:****Installation tools for drilling and cleaning the bore hole and injection of the mortar**

| Rebar /<br>FRA<br>φ [mm] | Drilling and cleaning                                |    |                                                      |        |                                                |      |                            | Injection                 |                               |        |  |
|--------------------------|------------------------------------------------------|----|------------------------------------------------------|--------|------------------------------------------------|------|----------------------------|---------------------------|-------------------------------|--------|--|
|                          | Nominal drill<br>bit diameter<br>d <sub>0</sub> [mm] |    | Diameter of<br>cutting edge<br>d <sub>cut</sub> [mm] |        | Steel brush<br>diameter<br>d <sub>b</sub> [mm] |      | Cleaning<br>nozzle<br>[mm] | Extension<br>tube<br>[mm] | Injection adapter<br>[colour] |        |  |
|                          |                                                      |    |                                                      |        |                                                |      |                            |                           |                               |        |  |
| 8                        | 10 <sup>1)</sup>                                     | 12 | ≤ 10,5                                               | ≤ 12,5 | 11,0                                           | 12,5 | 11                         | 9                         | -                             | white  |  |
| 10                       | 12 <sup>1)</sup>                                     | 14 | ≤ 12,5                                               | ≤ 14,5 | 12,5                                           | 15   |                            |                           | white                         | blue   |  |
| 12                       | 14 <sup>1)</sup>                                     | 16 | ≤ 14,5                                               | ≤ 16,5 | 15                                             | 17   |                            |                           | blue                          | red    |  |
| 14                       | 18                                                   |    | ≤ 18,5                                               |        | 19                                             |      | 15                         | 9 or 15                   | yellow                        |        |  |
| 16                       | 20                                                   |    | ≤ 20,55                                              |        | 25                                             |      |                            |                           | 19                            | green  |  |
| 20                       | 25                                                   |    | ≤ 25,55                                              |        | 26,5                                           |      |                            |                           |                               | black  |  |
| 25                       | 30                                                   |    | ≤ 30,55                                              |        | 32                                             |      | 28                         |                           |                               | grey   |  |
| 28                       | 35                                                   |    | ≤ 35,70                                              |        | 37                                             |      |                            |                           | brown                         |        |  |
| 32                       | 40                                                   |    | ≤ 40,70                                              |        | 42                                             |      |                            |                           | 38                            | nature |  |

<sup>1)</sup>Both drill bit diameters can be used

**Rebar connection with fischer Superbond**

**Intended use**

Installation tools for drilling and cleaning the bore hole and injection installation of the mortar

**Annex B 5**

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## Safety regulations



Review the Material Safety Data Sheet (MSDS) before use for proper and safe handling!

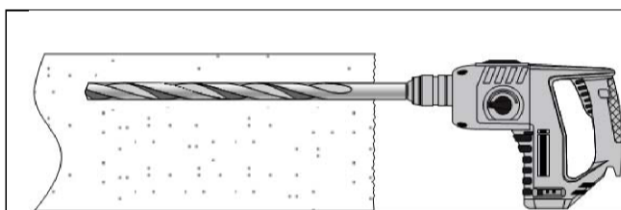
Wear well-fitting protective goggles and protective gloves when working with mortar fischer FIS SB

Important: Observe the instructions for use provided with each cartridge.

## 1. Drill hole

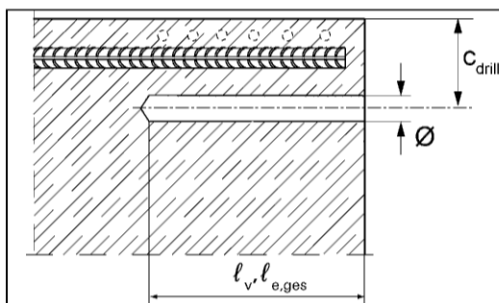
Note: Before drilling, remove carbonized concrete; clean contact areas (see Annex B 1)

In case of aborted drill hole the drill hole shall be filled with mortar.



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

Drill bit sizes see Table B4.

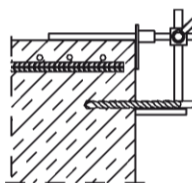
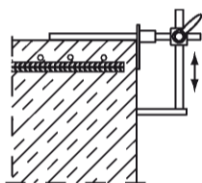


Measure and control concrete cover  $c$

$$c_{\text{drill}} = c + \phi / 2$$

Drill parallel to surface edge and to existing rebar

Where applicable use fischer drilling aid.



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

Three different options can be considered:

- A) fischer drilling aid
- B) Slat or spirit level
- C) Visual check

## Rebar connection with fischer Superbond

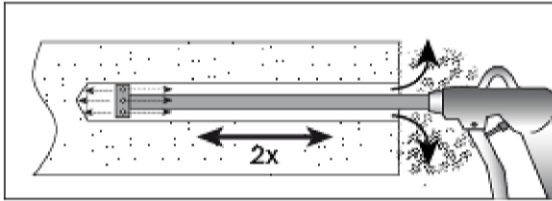
### Intended use

Installation instruction part 1

## Annex B 6

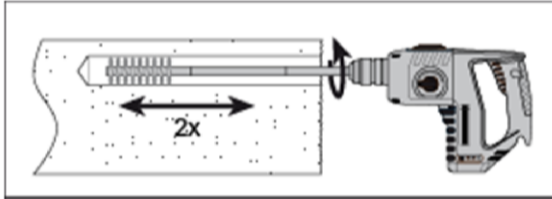
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## 2.1 Compressed air cleaning



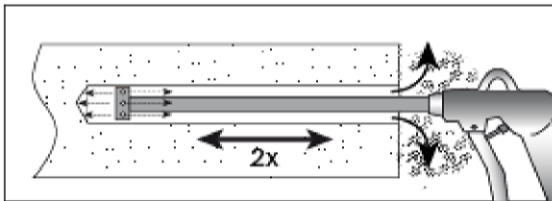
### Blowing

two times from the back of the hole with oil-free compressed air (min. 6 bar) until return air stream is free of noticeable dust.



### Brushing (with power drill)

two times with the specified brush size (brush diameter >: borehole diameter) by inserting the round steel brush to the back of the hole in a twisting motion. The brush shall produce natural resistance as it enters the anchor hole. If this is not the case, please use a new brush or a brush with a larger diameter. For appropriate brushes see Table B4.



### Blowing

two times from the back of the hole with oil-free compressed air (min. 6 bar) until return air stream is free of noticeable dust.

## 2.2 Manual Cleaning:

Manual cleaning is permitted for hammer drilled boreholes up to hole diameters  $d_0 \leq 18$  mm and depths  $l_v$  resp.  $l_{e,ges} \leq 160$  mm

|  |                                                                                                                                                                                                                                                                                                                                                                                                  |
|--|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <b>Blowing</b><br>two strokes with fischer blow up pump from the back of the hole until return air stream is free of noticeable dust                                                                                                                                                                                                                                                             |
|  | <b>Brushing</b><br>two times with the specified brush size (brush diameter borehole diameter $d_0$ ) by inserting the round steel wire brush to the back of the hole with a twisting motion. The brush shall produce natural resistance as it enters the anchor hole. If this is not the case, please use a new brush or a brush with a larger diameter.<br>For appropriate brushes see Table B4 |
|  | <b>Blowing</b><br>two strokes with fischer blow-out pump from the back of the hole until return air stream is free of noticeable dust                                                                                                                                                                                                                                                            |
|  | Manual cleaning :<br>fischer hand pump recommended for blowing out bore holes with diameters $d_0 \leq 18$ mm and bore hole depth $l_v$ respectively $l_{e,ges} \leq 160$ mm                                                                                                                                                                                                                     |

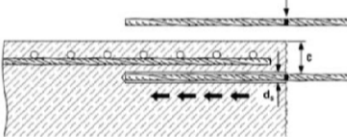
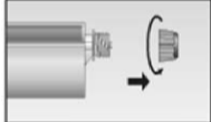
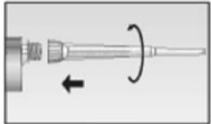
## Rebar connection with fischer Superbond

**Intended use**  
Installation instruction part 2

## Annex B 7

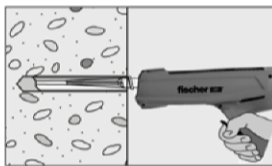
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### 3. Rebar preparation and cartridge preparation

|                                                                                   |                                                                                                                                                                                                                                                                                         |
|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p>Before use, make asure that the rebar is dry and free of oil or other residue.<br/>Mark the embedment depth on the rebar (e.g. with tape) <math>\ell_v</math><br/>Insert rebar in borehole, to verify hole and setting depth <math>\ell_v</math> resp. <math>\ell_{e,ges}</math></p> |
| <b>Injection system preparation</b>                                               |                                                                                                                                                                                                                                                                                         |
|  | <p>No. 1: Twist off the sealing cap</p>                                                                                                                                                                                                                                                 |
|  | <p>No. 2: Twist on the static mixer (the spiral in the static mixer must be clearly visible).</p>                                                                                                                                                                                       |
|  | <p>No. 3: Place the cartridge into a suitable dispenser.</p>                                                                                                                                                                                                                            |
|  | <p>No. 4: Press approximate 10 cm of material out until the resin is evenly grey in colour. Don` t use mortar that is not uniformly grey.</p>                                                                                                                                           |

### 4. Inject mortar into borehole

#### 4.1 borehole depth $\leq 250$ mm:

|                                                                                     |                                                                                                                                                                                                                                                                                                                                        |
|-------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p>Inject the mortar from the back of the hole towards the front and slowly withdraw the mixing nozzle step by step after each trigger pull.<br/>Fill holes approximately 2/3 full, or as required to ensure that the annular gap between the rebar and the concrete is completely filled with adhesive over the embedment length.</p> |
|  | <p>After injecting, depressurize the dispenser by pressing the release trigger. This will prevent further mortar discharge from the mixing nozzle.</p>                                                                                                                                                                                 |

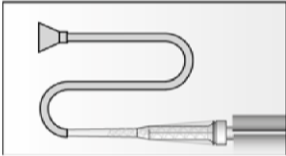
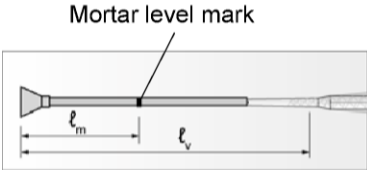
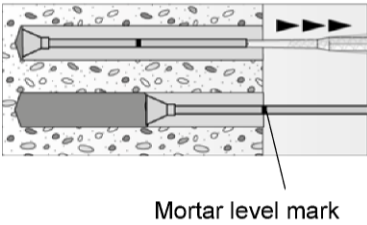
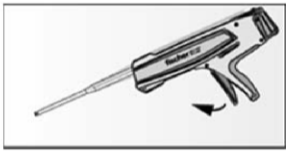
### Rebar connection with fischer Superbond

**Intended use**  
Installation instruction part 3

### Annex B 8

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4.2 borehole depth > 250 mm:

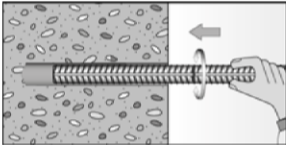
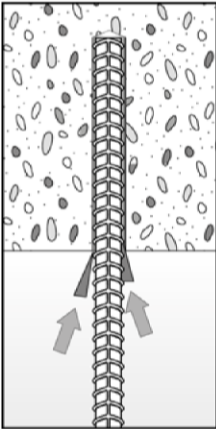
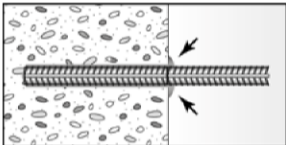
|                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |
|------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|   | Assemble mixing nozzle FIS MR or FIS UMR, extension tube and injection adapter (see Table B 4)                                                                                                                                                                                                                                                                                                                                                                                                                                      |
|   | Mark the required mortar level $l_m$ and embedment depth $l_v$ resp. $l_{e,ges}$ with tape or marker on the injection extension tube.<br><br>a) Estimation:<br>$l_m = \frac{1}{3} * l_v \text{ resp. } l_m = \frac{1}{3} * l_{e,ges}$<br>b) Precise formula for optimum mortar volume:<br>$l_m = l_v \text{ resp. } l_{e,ges} \left( \left( 1,2 * \frac{d_s^2}{d_o^2} - 0,2 \right) \right) [\text{mm}]$                                                                                                                            |
|   | Insert injection adapter to back of the hole. Begin injection allowing the pressure of the injected adhesive mortar to push the injection adapter towards the front of the hole.<br><br>Fill holes approximately 2/3 full, or as required to ensure that the annular gap between the rebar and the concrete is completely filled with adhesive over the embedment length.<br><br>When using an injection adapter continue injection until the mortar level mark $l_m$ becomes visible.<br><br>Maximum embedment depth see Table B 2 |
|  | After injecting, depressurize the dispenser by pressing the release trigger. This will prevent further mortar discharge from the mixing nozzle.                                                                                                                                                                                                                                                                                                                                                                                     |

Rebar connection with fischer Superbond

Intended use  
Installation instruction part 4

Annex B 9

### 4.3 Insert rebar

|                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                              |
|-------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|    | <p>For each installation insert the rebar slowly twisted into the borehole until the embedment mark is at the concrete surface level.</p>                                                                                                                                                                                                                                                    |
|    | <p>Support the rebar and secure it from falling till mortar started to harden, e.g. using wedges.</p>                                                                                                                                                                                                                                                                                        |
|    | <p>After installing the rebar the annular gap must be completely filled with mortar.</p> <p>Proper installation</p> <ul style="list-style-type: none"> <li>• Desired anchoring embedment is reached <math>\ell_v</math>: embedment mark at concrete surface.</li> <li>• Excess mortar flows out of the borehole after the rebar has been fully inserted until the embedment mark.</li> </ul> |
|  | <p>Observe the working time "<math>t_{work}</math>" (see Table B3), which varies according to temperature of base material. Minor adjustments to the rebar position may be performed during the working time</p> <p>Full load may be applied only after the curing time "<math>t_{cure}</math>" has elapsed (see Table B 3)</p>                                                              |

### Rebar connection with fischer Superbond

**Intended use**  
Installation instruction part 5

### Annex B 10

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Minimum anchorage length and minimum lap length

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

Table C1: Factor related to concrete class and drilling method

| Concrete class   | Drilling method                             | Factor |
|------------------|---------------------------------------------|--------|
| C12/15 to C50/60 | Hammer drilling and compressed air drilling | 1,0    |

Table C2: Design values of the ultimate bond resistance  $f_{bd}$  in N/mm<sup>2</sup> for hammer drilling and compressed air drilling

According to EN 1992-1-1: 2004+AC:2010 for good bonds conditions (for all other bond conditions multiply the values by 0,7)

| Rebar<br><br>$\phi$ [mm] | Bond resistance $f_{bd}$ [N/mm <sup>2</sup> ] |        |        |        |        |        |        |        |        |
|--------------------------|-----------------------------------------------|--------|--------|--------|--------|--------|--------|--------|--------|
|                          | Concrete class                                |        |        |        |        |        |        |        |        |
|                          | C12/15                                        | C16/20 | C20/25 | C25/30 | C30/37 | C35/45 | C40/50 | C45/55 | C50/60 |
| 8 to 32                  | 1,6                                           | 2,0    | 2,3    | 2,7    | 3,0    | 3,4    | 3,7    | 4,0    | 4,3    |

Rebar connection with fischer Superbond

Performances

Minimum anchorage length and minimum lap length  
Design values of ultimate bond resistance  $f_{bd}$

Annex C 1