

Declaration of Performance



Chemofast Injection System EP 1000 for post-installed rebar connections

DoP No. CF-00-107-04

1. Unique identification code of the product-type: CF-00-107 - EP 1000
2. Intended use/es: Injection system for post-installed rebar connections
3. Manufacturer: Annex: B1 - B11
Chemofast Anchoring GmbH
Hanns-Martin-Schleyer-Str. 26
47880 Willich, Deutschland
Fon: +49 2154 81230
Fax: +49 2154 812333
4. Authorised representative: -
5. AVCP System/s: 1
6. European Assessment Document: EAD 330087-01-0601 Edition: 06_2021
European Technical Assessment: ETA-19/0200 issued on 30.01.2025
Technical Assessment Body: Deutsches Institut für Bautechnik - DiBt
Notified body/ies: IFSW - TU Darmstadt NB 2873
7. Declared performance/s:

Mechanical resistance and stability (BWR 1)	
Essential Characteristics	Performance
Characteristic resistance under static and quasi-static load	
for working life 50 years	Annex: C1
for working life 100 years	Annex: C1
to steel failure of tension anchor	Annex: C1
Characteristic resistance under seismic loading	
for working life 50 years	Annex: C2
for working life 100 years	Annex: C2
Safety in case of fire (BWR 2)	
Essential Characteristics	Performance
Reaction to fire	Fasterner satisfy requirements for Class A1
Resistance to fire	Annex: C3 - C4

8. Appropriate Technical Documentation and/or Specific Technical Documentation: Not relevant

The performance of the product specified above is in conformity with the declared performance. In accordance with Regulation (EU) No. 305/2011, this declaration of performance is issued under the sole responsibility of the manufacturer named above.

Signed for and on behalf of the manufacturer by:

i.V. Philipp Strater
Head of Applications Engineering and Technology

i.V. Dr. Sven Mronga
Head of Quality Management

Willich, 13.03.2025

Rev. 08.00 - EN

Installation post installed rebar

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

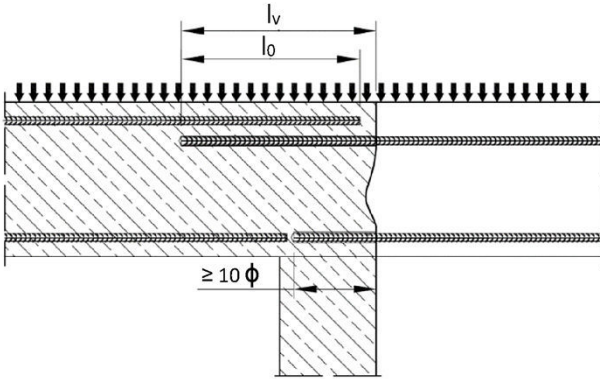


Figure A3: End anchoring of slabs or beams (e.g. designed as simply supported)

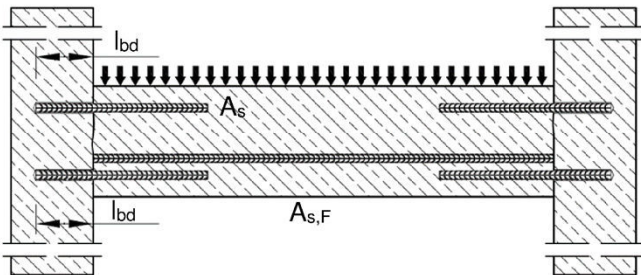


Figure A5: Anchoring of reinforcement to cover the line of acting tensile force

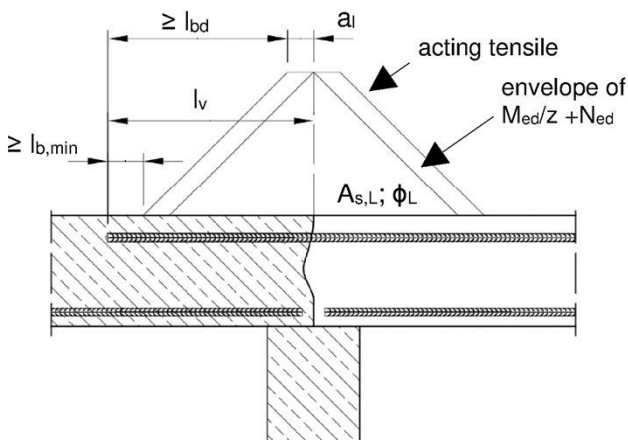


Figure A2: Overlapping joint at a foundation of a wall or column where the rebars are stressed in tension

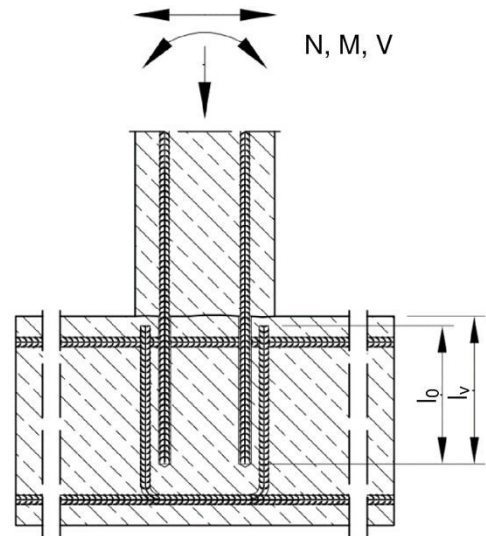
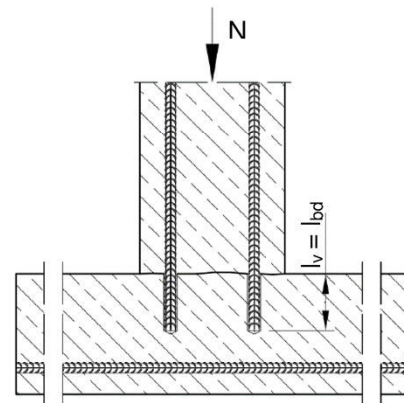


Figure A4: Rebar connection for components stressed primarily in compression. The rebars are stressed in compression



Note to Figure A1 to A5:

In the Figures no transverse reinforcement is plotted, the transverse reinforcement shall comply with EN 1992-1-1:2011.

Preparing of joints according to Annex B 2

Chemofast Injection system EP 1000 for rebar connection

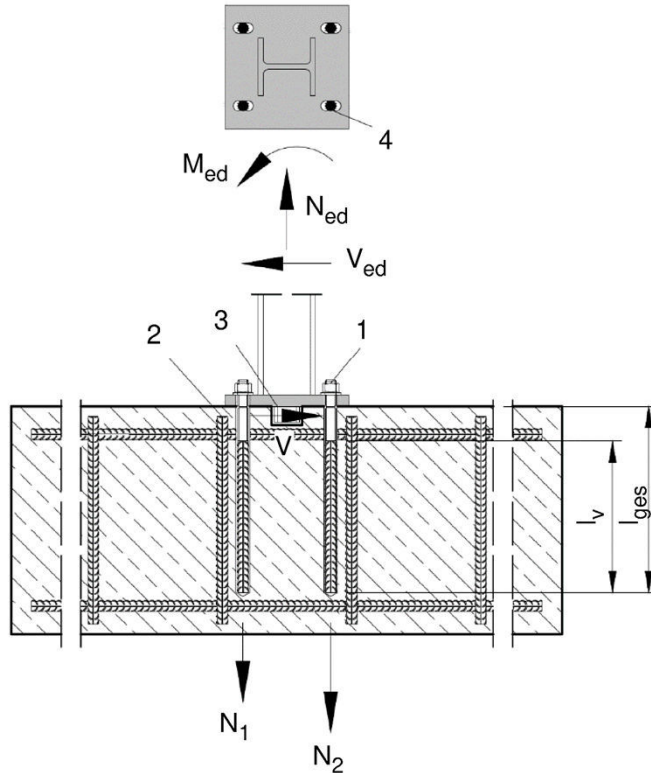
Product description

Installed condition and examples of use for rebars

Annex A 1

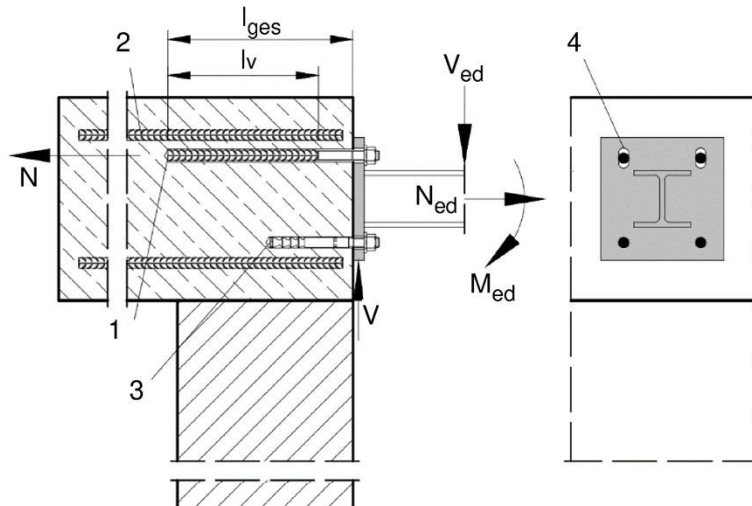
Installation tension anchor ZA

Figure A6: Anchorage of column to foundation with tension anchor ZA.



- 1 Tension anchor ZA (tension only)
- 2 Existing stirrup / reinforcement for overlap (lap splice)
- 3 Shear lug (or fastener loaded in shear)
- 4 Slotted hole with axial direction to the shear force

Figure A7: Anchorage of guardrail posts or cantilevered building components with tension anchor ZA and fastener.



- 1 Tension anchor ZA (tension only)
- 2 Existing stirrup / reinforcement for overlap (lap splice)
- 3 Fastener (or shear lug loaded in shear)
- 4 Slotted hole with axial direction to the shear force

Note to Figure A6 and A7: In the Figures no transverse reinforcement is plotted, the transverse reinforcement shall comply with EN 1992-1-1:2011. The tension anchor 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 measures, e.g. by means of shear lugs or anchors with European Technical Assessment (ETA). General construction rules see Annex B 3

Chemofast Injection system EP 1000 for rebar connection

Product description

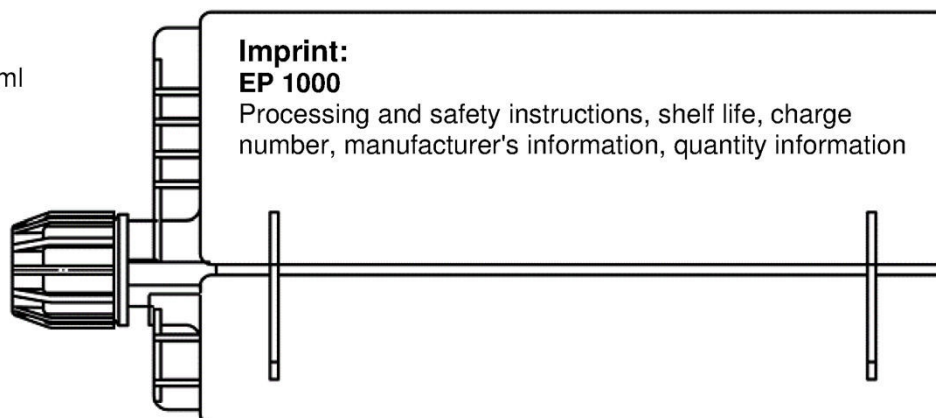
Installed condition and examples of use for tension anchors ZA

Annex A 2

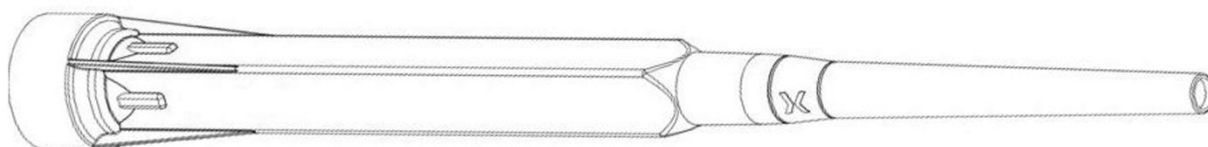
Cartridge system

Side-by-Side Cartridge:

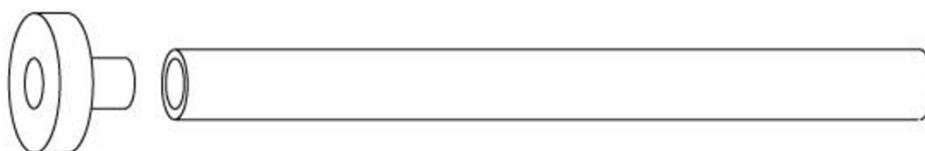
440 ml, 540 ml, 585 ml und 1400 ml



Static mixer



Piston plug VS and mixer extension VL

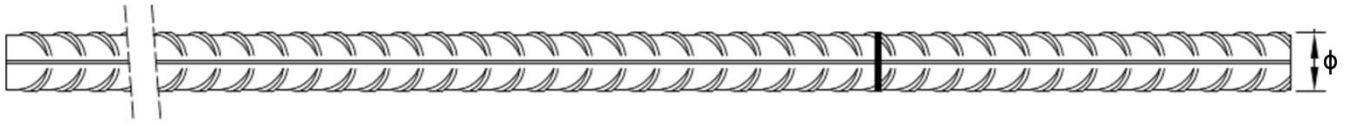


Chemofast Injection system EP 1000 for rebar connection

Product description
Injection system

Annex A 3

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



- Minimum value of related rip area $f_{R,min}$ according to EN 1992-1-1:2011
- Rib height of the bar shall be in the range $0,05\phi \leq h_{rib} \leq 0,07\phi$
(ϕ : Nominal diameter of the bar; h_{rib} : Rib height of the bar)

Table A1: Materials Rebar


Designation	Material
Rebar EN 1992-1-1:2011, Annex C	Bars and de-coiled rods class B or C f_{yk} and k according to NDP or NCI of EN 1992-1-1/NA $f_{uk} = f_{tk} = k \cdot f_{yk}$


Chemofast Injection system EP 1000 for rebar connection

Product description
Specifications Rebar

Annex A 4

Tension Anchor: ZA-M12 up to ZA-M24

Marking: e.g.  12 A4

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

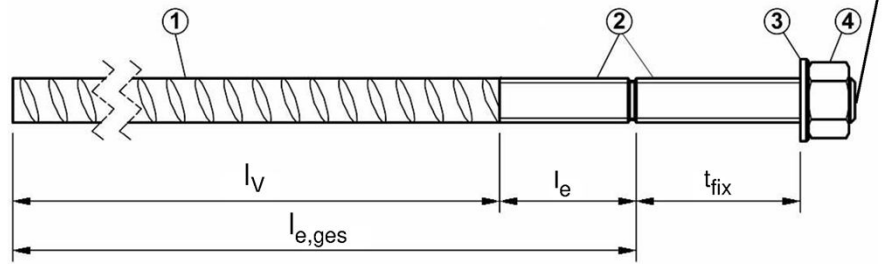


Table A2: Materials Tension Anchor ZA

Part	Designation	Material											
		ZA vz				ZA A4				ZA HCR			
		M12	M16	M20	M24	M12	M16	M20	M24	M12	M16	M20	M24
1	Reinforcement bar	Class B according to NDP or NCI of EN 1992-1-1/NA $f_{uk} = f_{tk} = k \cdot f_{yk}$											
	f_{yk} [N/mm ²]	500				500				500			
2	Threaded rod	Steel, zinc plated according to EN ISO 683-4:2018 or EN 10263:2021				Stainless steel, 1.4362, 1.4401, 1.4404, 1.4571, EN 10088-1:2014				High corrosion resistant steel, 1.4529, 1.4565, EN 10088-1:2014			
3	Washer	Steel, zinc plated according to EN ISO 683-4:2018 or EN 10263:2017				Stainless steel, 1.4362, 1.4401, 1.4404, 1.4571, EN 10088-1:2014				High corrosion resistant steel, 1.4529, 1.4565, EN 10088-1:2014			
4	Nut												

Table A3: Dimensions and installation parameters

Size			ZA-M12	ZA-M16	ZA-M20	ZA-M24	
Diameter of threaded rod	d_s	[mm]	12	16	20	24	
Diameter of reinforcement bar	ϕ	[mm]	12	16	20	25	
Drill hole diameter	d_o	[mm]	14 or 16	20	25	30 or 32	
Diameter of clearance hole in fixture	d_f	[mm]	14	18	22	26	
With across nut flats	SW	[mm]	19	24	30	36	
Stress area	A_s	[mm ²]	84	157	245	353	
Effective embedment depth	l_v	[mm]	according to static calculation				
Length of bonded thread	plated	l_e	[mm]	≥ 20	≥ 20	≥ 20	≥ 20
	A4/HCR			≥ 100	≥ 100	≥ 100	≥ 100
Minimum thickness of fixture	min t_{fix}	[mm]	5	5	5	5	
Maximum thickness of fixture	max t_{fix}	[mm]	3000	3000	3000	3000	
Maximum installation torque	max T_{inst}	[Nm]	50	100	150	150	

Chemofast Injection system EP 1000 for rebar connection

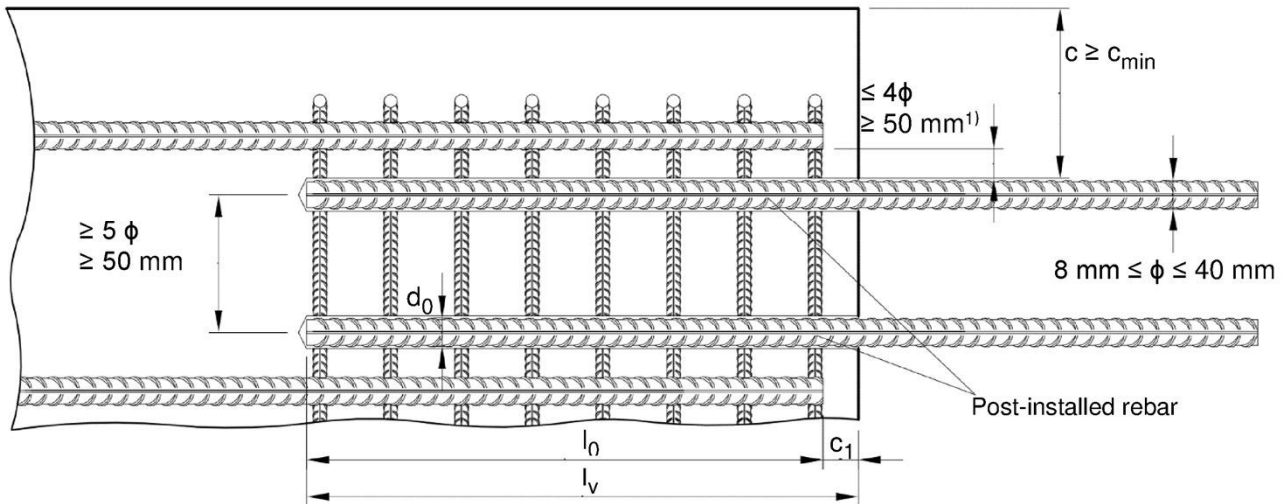
Product description
Specifications Tension Anchor ZA

Annex A 5

Specification of the intended use			
Anchorage subject to:		Working life 50 years	Working life 100 years
HD: Hammer drilling HDB: Hammer drilling with hollow drill bit CD: Compressed air drilling DD: Diamond drilling	static and quasi-static loads	Ø8 to Ø40 ZA-M12 to ZA-M24	Ø8 to Ø40 ZA-M12 to ZA-M24
	seismic action	Ø10 to Ø40	Ø10 to Ø40
	fire exposure	Ø8 to Ø40 ZA-M12 to ZA-M24	Ø8 to Ø40 ZA-M12 to ZA-M24
Temperature Range:	- 40°C to +80°C (max long-term temperature +50 °C and max short-term temperature +80 °C)		
<p>Base materials:</p> <ul style="list-style-type: none"> - Reinforced or unreinforced normal weight concrete according to EN 206:2013 + A1:2016. - Strength classes C12/15 to C50/60 according to EN 206:2013 + A1:2016. - Maximum chloride content of 0,40% (CL 0.40) related to the cement content according to EN 206:2013 + A1:2016. - Non-carbonated concrete. <p>Note: In case of a carbonated surface of the existing concrete structure the carbonated layer shall be removed in the area of the post-installed rebar connection with a diameter of $\phi + 60$ mm prior to the installation of the new rebar.</p> <p>The depth of concrete to be removed shall correspond to at least the minimum concrete cover in accordance with EN 1992-1-1:2011. The foregoing may be neglected if building components are new and not carbonated and if building components are in dry conditions.</p> <p>Use conditions (Environmental conditions) with tension anchor ZA:</p> <ul style="list-style-type: none"> - Structures subject to dry internal conditions (all materials). - For all other conditions according to EN 1993-1-4:2006+A1:2015 corresponding to corrosion resistance class: <ul style="list-style-type: none"> • Stainless steel Stahl A4 according to Annex A 4, Table A1: CRC III • High corrosion resistance steel HCR according to Annex A 4, Table A1: CRC V <p>Design:</p> <ul style="list-style-type: none"> - Anchorages are designed under the responsibility of an engineer experienced in anchorages and concrete work. - Verifiable calculation notes and drawings are prepared taking account of the forces to be transmitted. - Design according to EN 1992-1-1:2011, EN 1992-1-2:2011 and Annex B 2 and B 3. - The actual position of the reinforcement in the existing structure shall be determined on the basis of the construction documentation and taken into account when designing. <p>Installation:</p> <ul style="list-style-type: none"> - Dry or wet concrete. It must not be installed in flooded holes. - Overhead installation allowed. - Hole drilling by hammer drill (HD), hollow drill (HDB), diamond drill (DD) or compressed air drill mode (CD). - The installation of post-installed rebar resp. tension anchors shall be done only by suitable trained installer and under supervision on site; the conditions under which an installer may be considered as suitable trained and the conditions for supervision on site are up to the Member States in which the installation is done. - Check the position of the existing rebars (if the position of existing rebars is not known, it shall be determined using a rebar detector suitable for this purpose as well as on the basis of the construction documentation and then marked on the building component for the overlap joint). 			
Chemofast Injection system EP 1000 for rebar connection		Annex B 1	
Intended use Specifications			

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 1992-1-1:2011.
- The joints for concreting must be roughened to at least such an extent that aggregate protrude.



- 1) If the clear distance between lapped bars exceeds 4ϕ but at least 50 mm, then the lap length shall be increased by the difference between the clear bar distance and 4ϕ but at least 50 mm.

The following applies to Figure B1:

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 1992-1-1:2011, Section 4.4.1.2
ϕ	diameter of post-installed rebar
l_0	lap length, according to EN 1992-1-1:2011, Section 8.7.3
l_v	effective embedment depth, $\geq l_0 + c_1$
d_0	nominal drill bit diameter, see Annex B 5

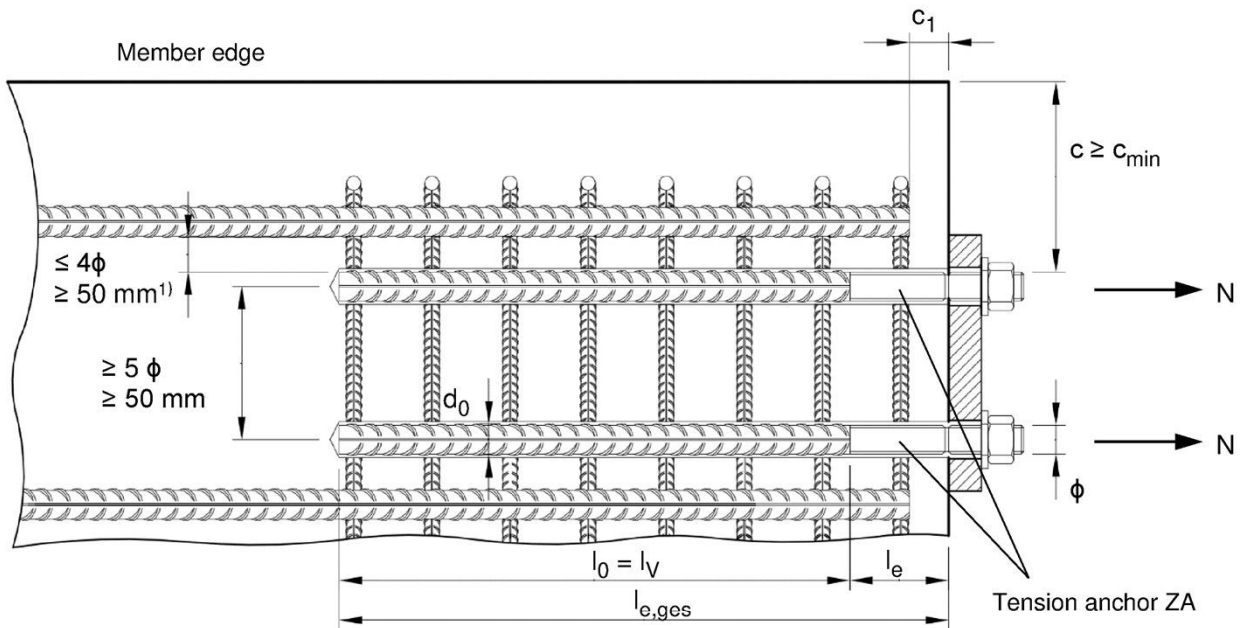
Chemofast Injection system EP 1000 for rebar connection

Intended use
General construction rules for post-installed rebars

Annex B 2

Figure B2: General construction rules for tension anchors ZA

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



1) If the clear distance between lapped bars exceeds 4ϕ but at least 50 mm, then the lap length shall be increased by the difference between the clear bar distance and 4ϕ but at least 50 mm.

The following applies to Figure B2:

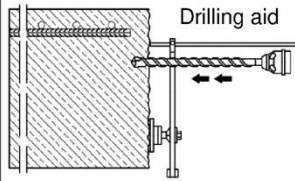
c	concrete cover of tension anchor ZA
c_1	concrete cover at end-face of existing rebar
c_{min}	minimum concrete cover according to Table B1 and to EN 1992-1-1:2011, Section 4.4.1.2
ϕ	diameter of tension anchor
l_0	lap length, according to EN 1992-1-1:2011, Section 8.7.3
l_v	effective embedment depth
l_e	length of bonded thread
$l_{e,ges}$	overall embedment depth, $\geq l_0 + c_2$
d_0	nominal drill bit diameter, see Annex B 5

Chemofast Injection system EP 1000 for rebar connection

Intended use
General construction rules for tension anchors ZA

Annex B 3

Table B1: Minimum concrete cover $c_{min}^{1)}$ of post-installed rebar and tie rod ZA depending of drilling method

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

1) see Annex B 2, Figure B1 and Annex B 3, Figure B2





Comments: The minimum concrete cover acc. EN 1992-1-1:2011 must be observed.

For the minimum concrete cover $c_{min,seis}$ in case of a seismic action, see Table B2.

Table B2: Minimum concrete cover $min c_{min,seis}$

Drilling method	Design conditions	Distance to 1st edge	Distance to 2nd edge
HD: Hammer drilling HDB: Hammer drilling with hollow drill bit CD: Compressed air drilling	Edge	$\geq 2 \phi$	$\geq 2 \phi$
	Corner	$\geq 2 \phi$	$\geq 2 \phi$
DD: Diamond drilling	Edge	$\geq 4 \phi$	$\geq 8 \phi$
	Corner	$\geq 6 \phi$	$\geq 6 \phi$

Table B3: Dispensing tools

Cartridge type/size	Hand tool		Pneumatic tool
Side-by-side cartridges 440 ml, 540 ml, 585 ml	 <p>e.g. SA 296C585</p>	 <p>e.g. Type H 244 C</p>	 <p>e.g. Type TS 444 KX</p>
Side-by-side cartridges 1400 ml	-	-	 <p>e.g. Type TS 471</p>

All cartridges could also be extruded by a battery tool.

Chemofast Injection system EP 1000 for rebar connection

Intended use
Minimum concrete cover
Dispensing tools

Annex B 4

Table B4: Brushes, piston plugs, max anchorage depth and mixer extension, hammer (HD), diamond (DD) and compressed air (CD) drilling

Bar size ϕ [mm]	Tension anchor ϕ [mm]	Drill bit - ϕ			d_b Brush - ϕ [mm]	$d_{b,min}$ min. Brush - ϕ [mm]	Piston plug	Cartridge: 440, 540 or 585 ml				Cartridge: 1400 ml		
		HD	DD	CD				Hand or battery tool		Pneumatic tool		Pneumatic tool		
								$l_{v,max}$ [mm]	Mixer extension	$l_{v,max}$ [mm]	Mixer extension	$l_{v,max}$ [mm]	Mixer extension	
8	-	10			RB10	11,5	10,5	-	250	VL10/0,75 or VL16/1,8	250	VL10/0,75 or VL16/1,8	250	
	-				RB12	13,5	12,5	-	700		800		800	
10	-	12			RB14	15,5	14,5	VS14	250		250		250	
	-								700		1000		1000	
12	ZA-M12	14			RB16	17,5	16,5	VS16	250		250		250	
	-	16							700		1300		1200	
14	-	18			RB18	20,0	18,5	VS18	700		1300		1400	
16	ZA-M16	20			RB20	22,0	20,5	VS20	500		VL10/0,75 or VL16/1,8		1600	VL16/1,8
20	ZA-M20	25	-	RB25	27,0	25,5	VS25	1000					2000	
	-	-	26	RB26	28,0	26,5	VS25	1000					2000	
22	-	28			RB28	30,0	28,5	VS28		1000		2000		
24/25	ZA-M24	30			RB30	32,0	30,5	VS30		1000		2000		
	-	32			RB32	34,0	32,5	VS32		1000		2000		
28	-	35			RB35	37,0	35,5	VS35		1000		2000		
32/34	-	40			RB40	43,5	40,5	VS40		1000		2000		
36	-	45			RB45	47,0	45,5	VS45		1000		2000		
40	-	-	52	52	RB52	54,0	52,5	VS52		-		-	-	
	-	55	-	55	RB55	58,0	55,5	VS55	-	-	-			

Table B5: Brushes, piston plugs, max anchorage depth and mixer extension, hammer drilling with hollow drill bit system (HDB)

Bar size ϕ [mm]	Tension anchor ϕ [mm]	Drill bit - ϕ HDB [mm]	d_b Brush - ϕ	$d_{b,min}$ min. Brush - ϕ	Piston plug	Cartridge: 440, 540 or 585 ml				Cartridge: 1400 ml			
						Hand or battery tool		Pneumatic tool		Pneumatic tool			
						$l_{v,max}$ [mm]	Mixer extension	$l_{v,max}$ [mm]	Mixer extension	$l_{v,max}$ [mm]	Mixer extension		
8	-	10	No cleaning Required		-	250	VL10/0,75 or VL16/1,8	250	VL10/0,75 or VL16/1,8	250	VL10/0,75 or VL16/1,8		
	-	12		-	700	800		800					
10	-	14		VS14	250	250		250					
	-				700	1000		1000					
12	ZA-M12	16		VS16	250	250		250					
14	-	18		VS18	700	1300		1200					
16	ZA-M16	20		VS20	500	VL10/0,75 or VL16/1,8		1000		VL10/0,75 or VL16/1,8		1000	VL10/0,75 or VL16/1,8
20	ZA-M20	25		VS25									
22	-	28		VS28									
24/25	ZA-M24	30		VS30									
	-	32		VS32									
28	-	35		VS35									
32/34	-	40		VS40									

Chemofast Injection system EP 1000 for rebar connection

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

Annex B 5

Cleaning and installation tools

HDB – Hollow drill bit system



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

Hand pump

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



Manual slide valve

(min 6 bar)



Brush RB



Piston Plug VS



Brush extension RBL



Table B6: Working time and curing time

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

1) After Initial curing time has elapsed, the installation of the connecting reinforcement and the construction of the formwork can be continued

2) The minimum curing time is only valid for dry base material.
In wet base material the curing time must be doubled.

Chemofast Injection system EP 1000 for rebar connection

Intended Use

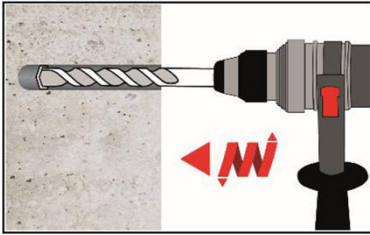
Cleaning and installation tools
Working time and curing time

Annex B 6

Installation instructions

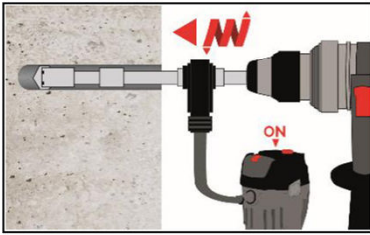
Attention: Before drilling, remove carbonated concrete and clean contact areas (see Annex B1)
In case of aborted drill hole: the drill hole shall be filled with mortar.

Drilling of the bore hole



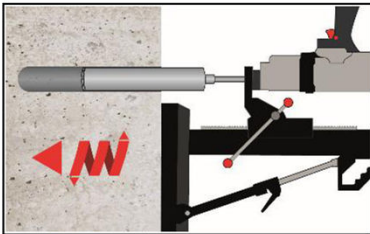
1a. Hammer drilling (HD) / Compressed air drilling (CD)

Drill a hole to the required embedment depth.
Drill bit diameter according to Table B4.
Proceed with Step 2 (MAC or CAC).



1b. Hollow drill bit system (HDB) (see Annex B 6)

Drill a hole to the required embedment depth.
Drill bit diameter according to Table B5.
The hollow drilling system removes the dust and cleans the bore hole.
Proceed with Step 3.



1c. Diamond drilling (DD)

Drill a hole to the required embedment depth required
Drill bit diameter according to Table B4.
Proceed with Step 2 (SPCAC).

Chemofast Injection system EP 1000 for rebar connection

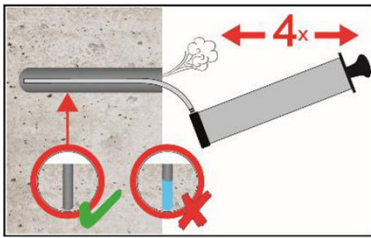
Intended use
Installation instruction

Annex B 7

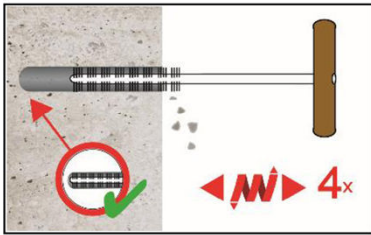
Installation instructions (continuation)

Manual Air Cleaning (MAC)

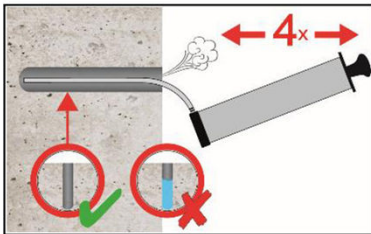
for drill hole diameter $d_0 \leq 20\text{mm}$ and drill hole depth $h_0 \leq 10\phi$ with drilling method HD/CD



Attention! Standing water in the bore hole must be removed before cleaning.
2a. Blow the bore hole clean minimum 4x from the bottom or back by hand pump (Annex B 6).



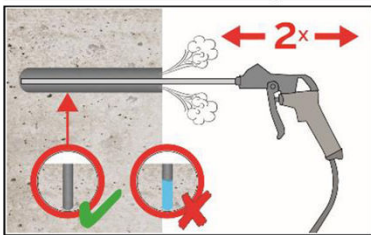
2b. Brush the bore hole minimum 4x with brush RB according to Table B4 over the entire embedment depth in a twisting motion (if necessary, use a brush extension RBL).



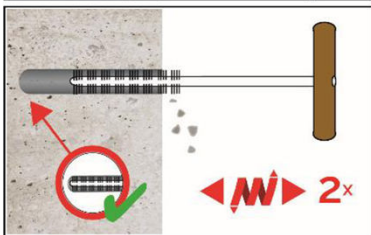
2c. Finally blow the bore hole clean minimum 4x from the bottom or back by hand pump (Annex B 6).

Compressed Air Cleaning (CAC):

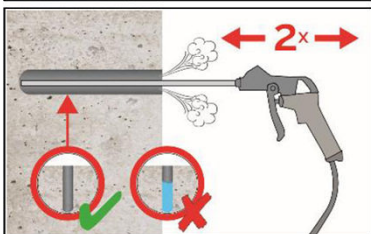
All diameter with drilling method HD/CD



Attention! Standing water in the bore hole must be removed before cleaning.
2a. Blow the bore hole clean minimum 2x with compressed air (min. 6 bar, oil-free) (Annex B 6) over the entire embedment depth until return air stream is free of noticeable dust. (If necessary, an extension shall be used.)



2b. Brush the bore hole minimum 2x with brush RB according to Table B4 over the entire embedment depth in a twisting motion. (If necessary, a brush extension shall be used.)



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

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

Chemofast Injection system EP 1000 for rebar connection

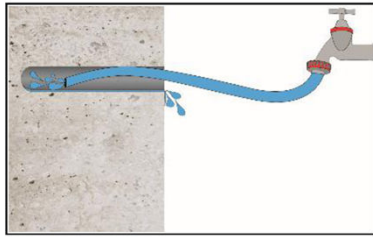
Intended use
Installation instructions (continuation)

Annex B 8

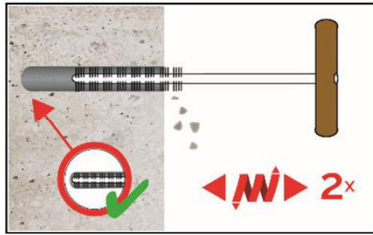
Installation instructions (continuation)

Flush & Compressed Air Cleaning (SPCAC):

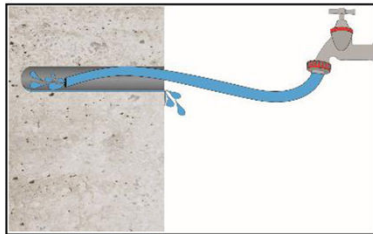
All diameter with drilling method DD



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

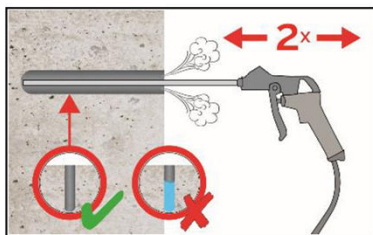


2b. Brush the bore hole minimum 2x with brush RB according to Table B4 over the entire embedment depth in a twisting motion. (If necessary, a brush extension shall be used.)

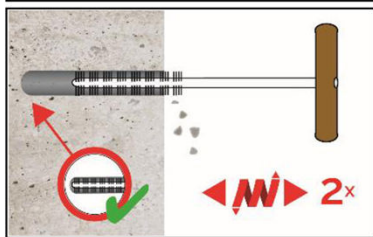


2c. Flushing again with water until clear water comes out.

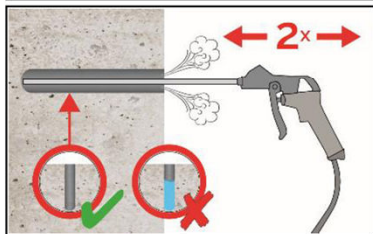
Attention! Standing water in the bore hole must be removed before proceeding.



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



2e. Brush the bore hole minimum 2x with brush RB according to Table B4 over the entire embedment depth in a twisting motion. (If necessary, a brush extension shall be used.)



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

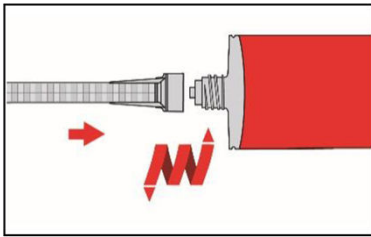
Protect cleaned bore hole against re-contamination in an appropriate way. If necessary, repeat cleaning process directly before dispensing the mortar. In-flowing water must not contaminate the bore hole again.

Chemofast Injection system EP 1000 for rebar connection

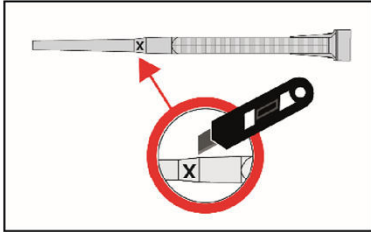
Intended use
Installation instructions (continuation)

Annex B 9

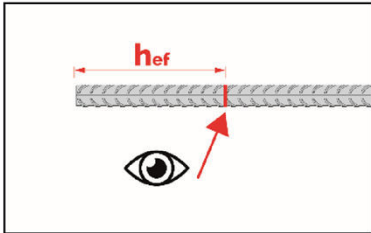
Installation instructions (continuation)



3. Screw on static-mixing nozzle PM-19E, and load the cartridge into an appropriate dispensing tool.
For every working interruption longer than the maximum working time t_{work} (Annex B 6) as well as for new cartridges, a new static-mixer shall be used.



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



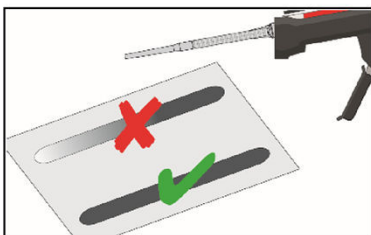
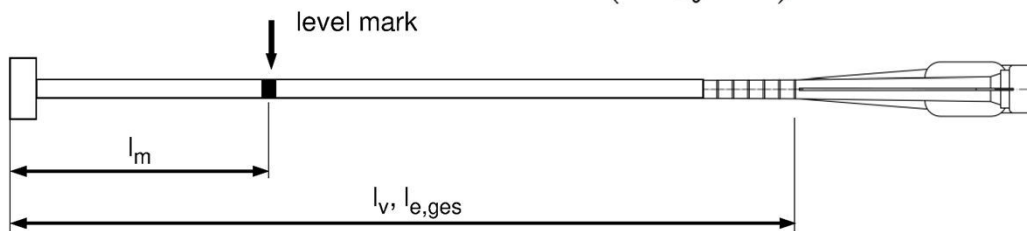
4. Mark embedment depth on the reinforcing bar .
The reinforcing bar shall be free of dirt, grease, oil or other foreign material.

5. Mark mixer nozzle and extension with mortar level mark l_m and anchorage depth l_v resp. $l_{e,ges}$

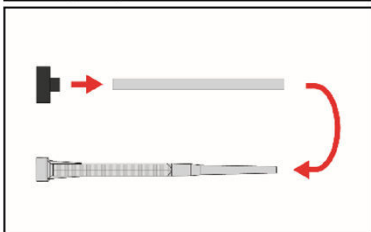
Quick estimation: $l_m = 1/3 \cdot l_v$

Optimum mortar volume:

$$l_m = l_v \text{ resp. } l_{e,ges} \cdot \left(1,2 \cdot \frac{\phi^2}{d_0^2} - 0,2 \right)$$



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



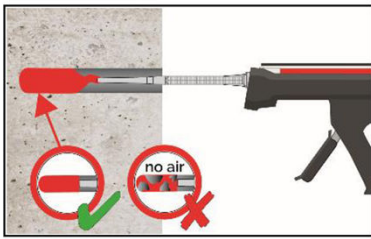
7. Piston plugs VS and mixer nozzle extensions VL shall be used according to Table B4 or B5.
Assemble mixing nozzle, mixer extension and piston plug before injecting mortar.

Chemofast Injection system EP 1000 for rebar connection

Intended Use
Installation instructions (continuation)

Annex B 10

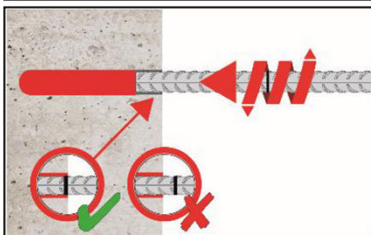
Installation instructions (continuation)



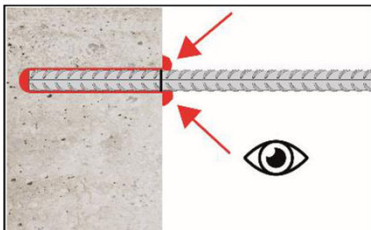
8a. Injecting mortar without piston plug VS:
Starting at bottom of the hole and fill the hole with adhesive until the mortar level mark is visible. (If necessary, a mixer nozzle extension shall be used.) Slowly withdraw of the static mixing nozzle avoid creating air pockets. Observe the temperature related working time t_{work} (Annex B 6).



8b. Injecting mortar with piston plug VS:
Insert piston plug to bottom of the hole and fill the hole with mortar until mortar level mark l_m is visible. (If necessary, a mixer nozzle extension shall be used.) During injection the piston plug is pushed out of the bore hole by the back pressure of the mortar. Observe the temperature related working time t_{work} (Annex B 6).



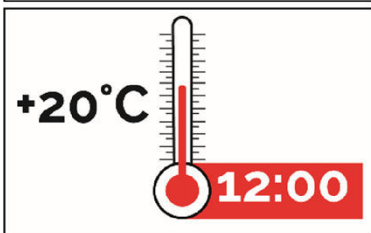
9. Insert the reinforcing bar while turning slightly up to the embedment mark.



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



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



12. Temperature related curing time t_{cure} (Annex B 6) must be observed. After initial curing time $t_{cure,ini}$ has elapsed, the installation of the connecting reinforcement and the formwork can be continued. The full load to the reinforcing bar may be applied after the full curing time t_{cure} has elapsed.

Chemofast Injection system EP 1000 for rebar connection

Intended Use
Installation instructions (continuation)

Annex B 11

Table C1: Characteristic tension resistance for tension anchor ZA									
Tension Anchor			ZA-M12	ZA-M16	ZA-M20	ZA-M24			
Steel, zinc plated (ZA vz)									
Characteristic tension resistance	$N_{Rk,s}$	[kN]	67	125	196	282			
Partial factor	$\gamma_{Ms,N}$	[-]	1,4						
Stainless Steel (ZA A4 or ZA HCR)									
Characteristic tension resistance	$N_{Rk,s}$	[kN]	67	125	171	247			
Partial factor	$\gamma_{Ms,N}$	[-]	1,4		1,3	1,4			
Minimum anchorage length and minimum lap length under static or quasi-static loading									
The minimum anchorage length $l_{b,min}$ and the minimum lap length $l_{0,min}$ according to EN 1992-1-1:2011 ($l_{b,min}$ acc. to Eq. 8.6 and Eq. 8.7 and $l_{0,min}$ acc. to Eq. 8.11) shall be multiply by the amplification factor $\alpha_{lb} = \alpha_{lb,100y}$ according to Table C2.									
Table C2: Amplification factor $\alpha_{lb} = \alpha_{lb,100y}$ related to concrete class and drilling method; working life 50 and 100 years									
Concrete class	Drilling method		Bar size		Amplification factor $\alpha_{lb} = \alpha_{lb,100y}$				
C12/15 to C50/60	all drilling methods		8 mm to 40 mm ZA-M12 to ZA-M24		1,0				
Table C3: Reduction factor $k_b = k_{b,100y}$ for all drilling methods; working life 50 and 100 years									
Rebar	Concrete class								
ϕ	C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
8 to 40 mm ZA-M12 to ZA-M24	1,0								
Table C4: Design values of the ultimate bond stress $f_{bd,PIR}$ and $f_{bd,PIR,100y}$ in N/mm² for all drilling methods and for good conditions; working life 50 and 100 years									
$f_{bd,PIR} = k_b \cdot f_{bd}$ $f_{bd,PIR,100y} = k_{b,100y} \cdot f_{bd}$ with f_{bd} : Design value of the ultimate bond stress in N/mm ² considering the concrete classes, the rebar diameter, the drilling method for good bond condition (for all other bond conditions multiply the values by $\eta_1 = 0.7$) and recommended partial factor $\gamma_c = 1,5$ according to EN 1992-1-1:2011. $k_b, k_{b,100y}$: Reduction factor according to Table C3									
Rebar	Concrete class								
ϕ	C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
8 to 32 mm ZA-M12 to ZA-M24	1,6	2,0	2,3	2,7	3,0	3,4	3,7	4,0	4,3
34 mm	1,6	2,0	2,3	2,6	2,9	3,3	3,6	3,9	4,2
36 mm	1,5	1,9	2,2	2,6	2,9	3,3	3,6	3,8	4,1
40 mm	1,5	1,8	2,1	2,5	2,8	3,1	3,4	3,7	4,0
Chemofast Injection system EP 1000 for rebar connection							Annex C 1		
Performances Characteristic tension resistance for tension anchor, Minimum anchorage length and minimum lap length, Amplification factor, Reduction factor and Design values of ultimate bond resistance									

Minimum anchorage length and minimum lap length under seismic action

The minimum anchorage length $l_{b,min}$ and the minimum lap length $l_{0,min}$ according to EN 1992-1-1:2011 ($l_{b,min}$ acc. to Eq. 8.6 and Eq. 8.7 and $l_{0,min}$ acc. to Eq. 8.11) shall be multiply by the amplification factor $\alpha_{lb,seis} = \alpha_{lb,seis,100y}$ according to Table C5.

Table C5: Amplification factor $\alpha_{lb,seis} = \alpha_{lb,seis,100y}$ related to concrete class and drilling method; working life 50 and 100 years

Concrete class	Drilling method	Bar size	Amplification factor $\alpha_{lb,seis} = \alpha_{lb,seis,100y}$
C16/20 to C50/60	all drilling methods	10 mm to 40 mm	1,0

Table C6: Reduction factor $k_{b,seis} = k_{b,seis,100y}$ for all drilling methods; working life 50 and 100 years

Rebar ϕ	Concrete classes								
	C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
10 to 40 mm	No performance assessed	1,0							

Table C7: Design values of the ultimate bond stress $f_{bd,PIR,seis}$ and $f_{bd,PIR,seis,100y}$ in N/mm² for all drilling methods and for good conditions; working life 50 and 100 years

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

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

mit

f_{bd} : Bemessungswert der Verbundspannung in N/mm², in Abhängigkeit von der Betonfestigkeitsklasse und dem Stabdurchmesser für gute Verbundbedingungen (für alle anderen Verbundbedingungen sind die Werte mit $\eta_1 = 0,7$ zu multiplizieren) und einem empfohlenen Teilsicherheitsbeiwert $\gamma_c = 1,5$ gemäß EN 1992-1-1:2011.

$k_{b,seis}, k_{b,seis,100y}$: Reduktionsfaktor gem. Tabelle C6

Rebar ϕ	Concrete classes								
	C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
10 to 32 mm	No performance assessed	2,0	2,3	2,7	3,0	3,4	3,7	4,0	4,3
34 mm		2,0	2,3	2,6	2,9	3,3	3,6	3,9	4,2
36 mm		1,9	2,2	2,6	2,9	3,3	3,6	3,8	4,1
40 mm		1,8	2,1	2,5	2,8	3,1	3,4	3,7	4,0

Chemofast Injection system EP 1000 for rebar connection

Performances

Minimum anchorage length and minimum lap length, Amplification factor, Reduction factor and Design values of ultimate bond stress under seismic action

Annex C 2

Design value of the ultimate bond stress $f_{bd,fi}$, $f_{bd,fi,100y}$ at increased temperature for concrete classes C12/15 to C50/60, (all drilling methods); working life 50 and 100 years:

The design value of the bond stress $f_{bd,fi}$ at increased temperature has to be calculated by the following equation:

For working life 50 years: $f_{bd,fi} = k_{fi}(\theta) \cdot f_{bd,PIR} \cdot \gamma_c / \gamma_{M,fi}$

with: $\theta \leq 278^\circ\text{C}$: $k_{fi}(\theta) = 4673,8 \cdot \theta^{-1,598} / (f_{bd,PIR} \cdot 4,3) \leq 1,0$

$\theta > 278^\circ\text{C}$: $k_{fi}(\theta) = 0$

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

with: $\theta \leq 278^\circ\text{C}$: $k_{fi,100y}(\theta) = 4673,8 \cdot \theta^{-1,598} / (f_{bd,PIR,100y} \cdot 4,3) \leq 1,0$

$\theta > 278^\circ\text{C}$: $k_{fi,100y}(\theta) = 0$

$f_{bd,fi}$, $f_{bd,fi,100y}$ Design value of the ultimate bond stress at increased temperature in N/mm²

θ Temperature in °C in the mortar layer.

$k_{fi}(\theta)$, $k_{fi,100y}(\theta)$ Reduction factor at increased temperature.

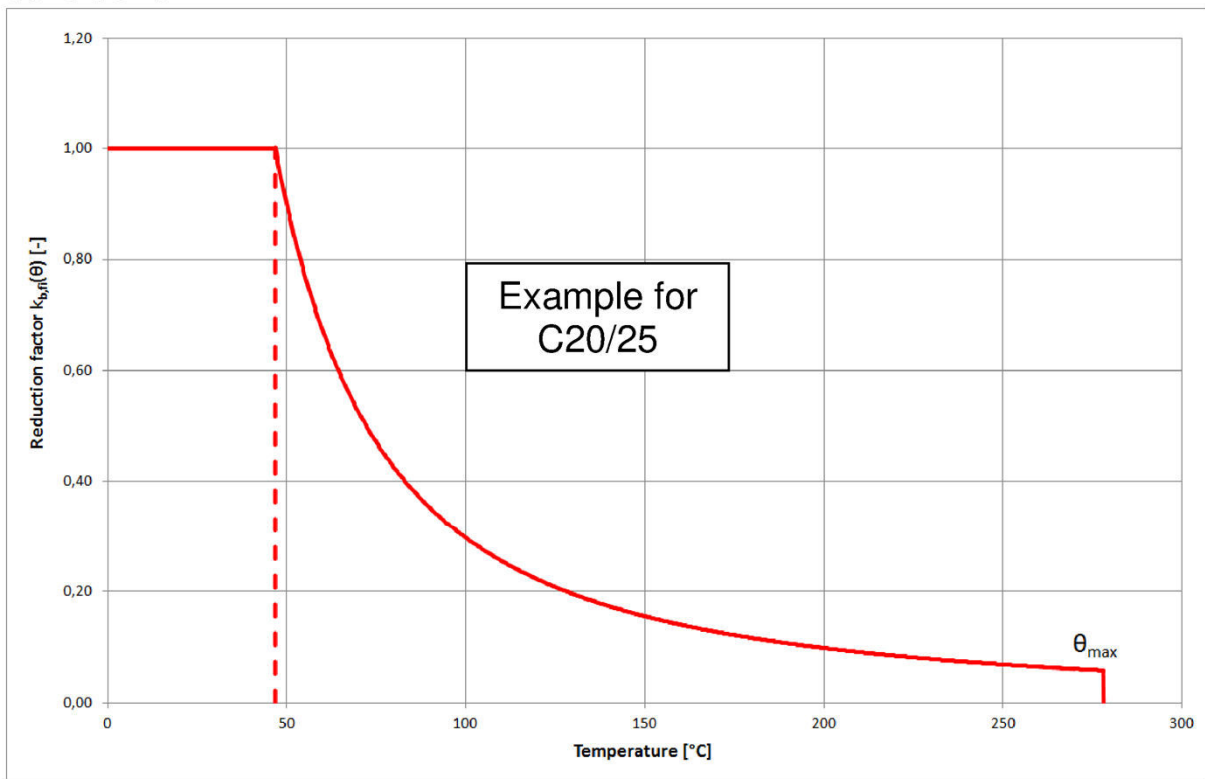
$f_{bd,PIR}$, $f_{bd,PIR,100y}$ Design value of the bond stress $f_{bd,PIR} = f_{bd,PIR,100y}$ in N/mm² in cold condition according to Table C4 considering the concrete classes, the rebar diameter, the drilling method and the bond conditions according to EN 1992-1-1:2011.

γ_c = 1,5, recommended partial factor according to EN 1992-1-1:2011

$\gamma_{M,fi}$ = 1,0, recommended partial factor according to EN 1992-1-2:2011

For evidence at increased temperature the anchorage length shall be calculated according to EN 1992-1-1:2011 Equation 8.3 using the temperature-dependent design value of ultimate bond stress $f_{bd,fi}$, $f_{bd,fi,100y}$.

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



Chemofast Injection system EP 1000 for rebar connection

Performances

Design value of ultimate bond stress at increased temperature

Annex C 3

Table C8: Characteristic tension resistance for tension anchor ZA under fire exposure

Tension Anchor				ZA-M12	ZA-M16	ZA-M20	ZA-M24
Steel, zinc plated (ZA vz)							
Characteristic tension resistance	R30	$N_{Rk,s,fi}$	[kN]	2,3	4,0	6,3	9,0
	R60			1,7	3,0	4,7	6,8
	R90			1,5	2,6	4,1	5,9
	R120			1,1	2,0	3,1	4,5
Stainless Steel (ZA A4 or ZA HCR)							
Characteristic tension resistance	R30	$N_{Rk,s,fi}$	[kN]	3,4	6,0	9,4	13,6
	R60			2,8	5,0	7,9	11,3
	R90			2,3	4,0	6,3	9,0
	R120			1,8	3,2	5,0	7,2
Chemofast Injection system EP 1000 for rebar connection				Annex C 4			
Performances Characteristic tension resistance for tension anchor ZA under fire exposure							