European Technical Assessment

ETA-09/0089
of 9 December 2015

English translation prepared by DIBt - Original version in German language

General Part

Technical Assessment Body issuing the European Technical Assessment:
Deutsches Institut für Bautechnik

Trade name of the construction product
Rebar connection with fischer injection mortar FIS EM

Product family
to which the construction product belongs
Post-installed rebar connection with fischer injection mortar FIS EM

Manufacturer
fischerwerke GmbH & Co. KG
Otto-Hahn-Straße 15
79211 Denzlingen
DEUTSCHLAND

Manufacturing plant
fischerwerke

This European Technical Assessment contains
20 pages including 3 annexes which form an integral part of this assessment

This European Technical Assessment is issued in accordance with Regulation (EU) No 305/2011, on the basis of
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Specific Part

1 **Technical description of the product**

The subject of this approval is the post-installed connection, by anchoring or overlap connection joint, of reinforcing bars (rebars) in existing structures made of normal weight concrete, using the injection mortar fischer FIS EM in accordance with the regulations for reinforced concrete construction.

Reinforcing bars made of steel with a diameter $\phi$ from 8 to 40 mm or the fischer rebar anchor FRA sizes M12, M16, M20 and M24 and injection mortar FIS EM 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 anchor 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)**

<table>
<thead>
<tr>
<th>Essential characteristic</th>
<th>Performance</th>
</tr>
</thead>
<tbody>
<tr>
<td>Design values of the ultimate bond resistance</td>
<td>See Annex C 1</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Essential characteristic</th>
<th>Performance</th>
</tr>
</thead>
<tbody>
<tr>
<td>Reaction to fire</td>
<td>Rebar connections satisfy requirements for Class A1</td>
</tr>
<tr>
<td>Resistance to fire</td>
<td>No performance assessed</td>
</tr>
</tbody>
</table>

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

5 Technical details necessary for the implementation of the AVCP system, as provided for in the applicable EAD

Technical details necessary for the implementation of the AVCP system are laid down in the control plan deposited with Deutsches Institut für Bautechnik.

Issued in Berlin on 9 December 2015 by Deutsches Institut für Bautechnik

Uwe Bender
Head of Department

beglaubigt:

Baderschneider
**Installation anchor**

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

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

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

**Figure A4:**
Rebar connection for stressed primarily in compression

**Figure A5:**
Anchoring of reinforcement to cover the enveloped line of acting tensile force in the bending member

≥ l_{bd}

acting tensile force

Note to Figure A1 to A5:

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

Preparing of joints according to Annex B 2

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**Rebar connection with fischer Injection mortar FIS EM**

**Product description**

Installed condition and examples of use for rebars

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Annex A 1
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 fischer rebar anchors FRA have to be designed as elongated holes with axial direction to the shear force.

**Figure A8:** Lap of the anchoring of cantilevered building components.
In the anchor plate, the drill holes for the fischer rebar anchors FRA 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 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)

<table>
<thead>
<tr>
<th>Rebar connection with fischer Injection mortar FIS EM</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Product description</strong></td>
</tr>
<tr>
<td>Installed condition and examples of use for fischer rebar anchor FRA</td>
</tr>
</tbody>
</table>

Annex A 2
Injection cartridge fischer FIS EM
Sizes: 390 ml; 585 ml; 1100 ml, 1500 ml

Marking: FIS EM processing times, shelf-life, hazard code, curing times and processing times (depending on temperature), piston travel scale, size, volume

Sealing cap

Static mixer FIS MR or FIS UMR

fischer rebar anchor FRA M12, M16, M20, M24
marking setting depth
washer
hexagon nut

Reinforcing bar (rebar)
φ6, φ10, φ12, φ14, φ16, φ20, φ22, φ24, φ25, φ26, φ28, φ30, φ32, φ34, φ36, φ40
marking setting depth

Rebar connection with fischer Injection mortar FIS EM

<table>
<thead>
<tr>
<th>Product description</th>
<th>Annex A 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>Injection mortar; rebar anchor FRA; reinforcing bar</td>
<td></td>
</tr>
</tbody>
</table>
Figure A9: Properties of reinforcing bars (rebar)

- The minimum value of related rip area $f_{rt,min}$ 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 $\phi + 2 \cdot h$ (h ≤ 0.07 * $\phi$)
  - ($\phi$: Nominal diameter of the bar; h: rip height of the bar)

Table A1: Materials of rebars

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

Rebar connection with fischer Injection mortar FIS EM

Product description
Properties and materials of rebar

Annex A 4
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

<table>
<thead>
<tr>
<th>Threaded diameter</th>
<th>M12</th>
<th>M16</th>
<th>M20</th>
<th>M24</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nominal bar size</td>
<td>φ [mm]</td>
<td>12</td>
<td>16</td>
<td>20</td>
</tr>
<tr>
<td>Width across flat</td>
<td>SW [mm]</td>
<td>19</td>
<td>24</td>
<td>30</td>
</tr>
<tr>
<td>Nominal drill bit diameter</td>
<td>d₀ [mm]</td>
<td>14</td>
<td>16</td>
<td>20</td>
</tr>
<tr>
<td>Depth of drill hole (h₀ = l₀ges)</td>
<td>l₀ges [mm] = l₀ + l_v</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Effective anchorage depth</td>
<td>l_v [mm]</td>
<td>acc. to static calculation</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Distance concrete surface to welded join</td>
<td>l_e [mm]</td>
<td>100</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Diameter of clearance hole in the fixture</td>
<td>Pre-positioned ≤ d_f [mm]</td>
<td>14</td>
<td>18</td>
<td>22</td>
</tr>
<tr>
<td></td>
<td>Push through ≤ d_f [mm]</td>
<td>18</td>
<td>22</td>
<td>26</td>
</tr>
<tr>
<td>Minimum thickness of concrete member</td>
<td>h_min [mm] ≥ 100</td>
<td>h₀ + 30</td>
<td>h₀ + 2d₀</td>
<td></td>
</tr>
<tr>
<td>Maximum torque moment</td>
<td>T_{inst,max} [Nm]</td>
<td>50</td>
<td>100</td>
<td>150</td>
</tr>
</tbody>
</table>

1) For bigger clearance holes in the fixture see chapter 1.1 of the TR 029  
2) Both drill bit diameters can be used

Table A3: Materials of fischer rebar anchors FRA

<table>
<thead>
<tr>
<th>Part</th>
<th>Description</th>
<th>Materials</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Reinforcing bar</td>
<td>FRA B500B acc. to DIN 488-1:2009</td>
</tr>
<tr>
<td>2</td>
<td>Round bar with partial or full thread</td>
<td>Stainless steel acc. to EN 10088-1:2014</td>
</tr>
<tr>
<td>4</td>
<td>Hexagon nut</td>
<td>Stainless steel acc. to EN 10088-1:2014; Strength class 80; acc. to EN ISO 3506:2009</td>
</tr>
</tbody>
</table>

Rebar connection with fischer Injection mortar FIS EM

| Product description | Properties and materials of fischer rebar anchors FRA | Annex A 5 |
Specifications of intended use

Anchorages subject to:
Static and quasi-static loads

Base materials:
- Reinforced or unreinforced normal weight concrete according to EN 206:2013,
- Strength classes C12/15 to C50/60 according to EN 206:2013
- Maximum chloride conrete of 0,40% (CL 0.40) related to the cement content according to EN 206:2013
- 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 d + 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°C to +80°C (max. short term temperature +80°C and max long term temperature +50°C)

Use conditions (Environmental conditions) for fischer rebar anchors FRA:
- Structures subject to dry internal conditions (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
- 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 hammer drill, compressed air drill or diamond drill mode
- The installation of post-installed rebar respectively fischer rebar anchor FRA 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)
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

![Diagram of post-installed rebars]

1) 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 $4\phi$

<table>
<thead>
<tr>
<th>Symbol</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>$c$</td>
<td>Concrete cover of post-installed rebar</td>
</tr>
<tr>
<td>$c_1$</td>
<td>Concrete cover at end-face of existing rebar</td>
</tr>
<tr>
<td>$\text{min } c$</td>
<td>Minimum concrete cover according to Table B1 and to EN 1992-1-1:2004+AC:2010, Section 4.4.1.2</td>
</tr>
<tr>
<td>$\phi$</td>
<td>Diameter of post-installed rebar</td>
</tr>
<tr>
<td>$\xi_0$</td>
<td>Lap length, according to EN 1992-1-1:2004+AC:2010, Section 8.7.3</td>
</tr>
<tr>
<td>$\xi$</td>
<td>Effective embedment depth, $\geq \xi_0 + c_1$</td>
</tr>
<tr>
<td>$d_0$</td>
<td>Nominal drill bit diameter, see Annex B 5</td>
</tr>
</tbody>
</table>

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Rebar connection with fischer Injection mortar FIS EM

Intended use
General construction rules for post-installed rebars

Annex B 2
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.

1) 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
- $\ell_{e,\text{ges}}$ overall embedment depth, $\geq \ell_v + \ell_e$
- $d_0$ nominal drill bit diameter, see Annex B 5
- $\ell_e$ length of the bonded in threaded part
- $t_{\text{fix}}$ thickness of the fixture
- $\ell_v$ effective embedment depth

Rebar connection with fischer Injection mortar FIS EM

<table>
<thead>
<tr>
<th>Intended use</th>
<th>Annex B 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>General construction rules for post-installed rebar anchors FRA</td>
<td></td>
</tr>
</tbody>
</table>
Table B1: Minimum concrete cover $c$ depending of the drilling method and the drilling tolerance

<table>
<thead>
<tr>
<th>Drilling method</th>
<th>Nominal diameter of the bar $\phi$ [mm]</th>
<th>Without drilling aid [mm]</th>
<th>With drilling aid [mm]</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hammer drilling</td>
<td>$\leq 20$</td>
<td>$30 \text{ mm} + 0.06 , \ell_c$</td>
<td>$30 \text{ mm} + 0.02 , \ell_c \geq 2 , \phi$</td>
</tr>
<tr>
<td></td>
<td>$\geq 22$</td>
<td>$40 \text{ mm} + 0.06 , \ell_c$</td>
<td>$40 \text{ mm} + 0.02 , \ell_c \geq 2 , \phi$</td>
</tr>
<tr>
<td>Pneumatic drilling</td>
<td>$\leq 20$</td>
<td>$50 \text{ mm} + 0.08 , \ell_c$</td>
<td>$50 \text{ mm} + 0.02 , \ell_c$</td>
</tr>
<tr>
<td></td>
<td>$\geq 22$</td>
<td>$60 \text{ mm} + 0.08 , \ell_c$</td>
<td>$60 \text{ mm} + 0.02 , \ell_c$</td>
</tr>
<tr>
<td>Diamond drilling</td>
<td>$\leq 20$</td>
<td>$30 \text{ mm} + 0.06 , \ell_c$</td>
<td>$30 \text{ mm} + 0.02 , \ell_c \geq 2 , \phi$</td>
</tr>
<tr>
<td></td>
<td>$\geq 22$</td>
<td>$40 \text{ mm} + 0.06 , \ell_c$</td>
<td>$40 \text{ mm} + 0.02 , \ell_c \geq 2 , \phi$</td>
</tr>
</tbody>
</table>

1) 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 cartride sizes corresponding to maximum embedment depth $l_{v,\text{max}}$

<table>
<thead>
<tr>
<th>Rebar /FRA</th>
<th>Manual dispenser</th>
<th>Accu and pneumatic dispenser (small)</th>
<th>Pneumatic dispenser (large)</th>
</tr>
</thead>
<tbody>
<tr>
<td>$\phi$ [mm]</td>
<td>$l_{v,\text{max}} / l_{\text{tube},\text{max}}$ [mm]</td>
<td>$l_{v,\text{max}} / l_{\text{tube},\text{max}}$ [mm]</td>
<td>$l_{v,\text{max}} / l_{\text{tube},\text{max}}$ [mm]</td>
</tr>
<tr>
<td>8</td>
<td>1000</td>
<td>1000</td>
<td>1800</td>
</tr>
<tr>
<td>10</td>
<td>1200</td>
<td>1500</td>
<td>1300</td>
</tr>
<tr>
<td>14</td>
<td>22 / 24 / 25</td>
<td>700</td>
<td>1000</td>
</tr>
<tr>
<td>16</td>
<td>30 / 32 / 34</td>
<td>500</td>
<td>2000</td>
</tr>
<tr>
<td>20</td>
<td>8</td>
<td>18</td>
<td></td>
</tr>
<tr>
<td>36</td>
<td>40</td>
<td>40</td>
<td></td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Temperature in the anchorage base $[\text{°C}]$</th>
<th>Max. working time$^1$ $t_{\text{work}}$ [minutes]</th>
<th>Minimum curing time$^2$ $t_{\text{cure}}$ [hours]</th>
</tr>
</thead>
<tbody>
<tr>
<td>$+5$ to $+10$</td>
<td>120</td>
<td>40</td>
</tr>
<tr>
<td>$&gt;+10$ to $+20$</td>
<td>30</td>
<td>18</td>
</tr>
<tr>
<td>$&gt;+20$ to $+30$</td>
<td>14</td>
<td>10</td>
</tr>
<tr>
<td>$&gt;+30$ to $+40$</td>
<td>7</td>
<td>5</td>
</tr>
</tbody>
</table>

1) For installation temperature lower than $10^\circ\text{C}$ the mortar FIS EM must be tempered to $20^\circ\text{C}$
2) Maximum time from the beginning of injection to rebar setting and positioning
3) For wet concrete the curing time must be doubled

Rebar connection with fischer Injection mortar FIS EM

<table>
<thead>
<tr>
<th>Intended use</th>
<th>Annex B 4</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum concrete cover/ Maximum embedment depth per dispenser and cartride size/ Working times and curing times</td>
<td></td>
</tr>
</tbody>
</table>
### Table B4: Installation tools for drilling and cleaning the bore hole and injection of the mortar

<table>
<thead>
<tr>
<th>Nominal drill bit diameter $d_b$ [mm]</th>
<th>Diameter of cutting edge $d_{cut}$ [mm]</th>
<th>Steel brush diameter $d_s$ [mm]</th>
<th>Cleaning nozzle [mm]</th>
<th>Extension tube [mm]</th>
<th>Injection adapter [colour]</th>
</tr>
</thead>
<tbody>
<tr>
<td>8</td>
<td>$10^{(1)}$, $12^{(1)}$ ≤ 10,50 ≤ 12,50</td>
<td>11,0</td>
<td>12,5</td>
<td>11</td>
<td>nature</td>
</tr>
<tr>
<td>10</td>
<td>$12^{(1)}$, $14^{(1)}$ ≤ 12,50 ≤ 14,50</td>
<td>12,5</td>
<td>15</td>
<td>9</td>
<td>nature blue</td>
</tr>
<tr>
<td>12/ FRA 12</td>
<td>$14^{(1)}$, $16^{(1)}$ ≤ 14,50 ≤ 16,50</td>
<td>15</td>
<td>17</td>
<td>15</td>
<td>blue red</td>
</tr>
<tr>
<td>14</td>
<td>18 ≤ 18,50</td>
<td>19</td>
<td></td>
<td>19</td>
<td>yellow</td>
</tr>
<tr>
<td>16/ FRA 16</td>
<td>20 ≤ 20,55</td>
<td>21,5</td>
<td></td>
<td>28</td>
<td>9 or 15</td>
</tr>
<tr>
<td>20/ FRA 20</td>
<td>25 ≤ 25,55</td>
<td>26,5</td>
<td></td>
<td>38</td>
<td>red</td>
</tr>
<tr>
<td>22 / 24</td>
<td>30 ≤ 30,55</td>
<td>32</td>
<td></td>
<td></td>
<td>yellow</td>
</tr>
<tr>
<td>25/ FRA 24</td>
<td>30 ≤ 30,55</td>
<td>32</td>
<td></td>
<td></td>
<td>nature</td>
</tr>
<tr>
<td>26 / 28</td>
<td>35 ≤ 35,70</td>
<td>37</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>30 / 32 / 34</td>
<td>40 ≤ 40,70</td>
<td>42</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>36</td>
<td>45 ≤ 45,70</td>
<td>47</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>40</td>
<td>55 ≤ 55,70</td>
<td>58</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

1) Both drill bit diameters can be used

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**Rebar connection with fischer Injection mortar FIS EM**

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

Annex B 5
### Safety regulations

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

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

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, a pneumatic drill or a diamond drill in drilling mode.

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 $t_s > 20$ 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 Injection mortar FIS EM

**Intended use**
Installation instruction part 1
2. Cleaning the bore hole

Hammer- and pneumatic drilling

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

Diamond drilling

Break away the drill core and remove it

Flush the bore hole until the water comes clear

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.

Fix an adequate steel brush with an extension into a drilling machine and brush the bore hole two times

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.

Rebar connection with fischer Injection mortar FIS EM

Intended use
Installation instruction part 2

Annex B 7
3. Rebar preparation and cartridge preparation

Before use, make sure the rebar or the rebar anchor FRA is dry and free of oil or other residue. Mark the embedment depth $l_e$ on the rebar (e.g. with tape). Insert rebar in borehole, to verify hole and setting depth $l_s$, resp. $l_{e,\text{gap}}$.

### Injection system preparation

No. 1.
Twist off the sealing cap

No. 2.
Twist on the static mixer (the spiral in the static mixer must be clearly visible).

No. 3.
Place the cartridge into a suitable dispenser.

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.

4. Inject mortar into borehole
4.1 borehole depth ≤ 250 mm:

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. 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.

After injecting, depressurize the dispenser by pressing the release trigger. This will prevent further mortar discharge from the mixing nozzle.

---

**Rebar connection with fischer Injection mortar FIS EM**

<table>
<thead>
<tr>
<th>Intended use</th>
<th>Installation instruction part 3</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Annex B 8</td>
</tr>
</tbody>
</table>
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 \( l_e \) resp. \( l_{e,ges} \) with tape or marker on the injection extension tube.

  a) Estimation:
  \[
  l_m = \frac{1}{3} \cdot l_e \quad \text{resp.} \quad l_{m} = \frac{1}{3} \cdot l_{e,ges}
  \]

  b) Precise formula for optimum mortar volume:
  \[
  l_m = l_e \cdot l_{e,ges} \left(1,2 \cdot \frac{d_2}{d_0} - 0.2\right) \quad [\text{mm}]
  \]

- 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.

  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.

  When using an injection adapter continue injection until the mortar level mark \( l_m \) becomes visible.

  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 Injection mortar FIS EM

**Intended use**
Installation instruction part 4

---

Annex B 9
4.2 Insert rebar

For each installation insert the rebar / rebar anchor FRA slowly twisted into the borehole until the embedment mark is at the concrete surface level.

For overhead installation support the rebar / rebar anchor FRA and secure it from falling till mortar started to harden, e.g. using wedges.

After installing the rebar or FRA the annular gap must be completely filled with mortar.

Proper installation
- Desired anchoring embedment is reached \( \xi \): embedment mark at concrete surface.
- Excess mortar flows out of the borehole after the rebar has been fully inserted until the embedment mark.

Observe the working time "\( t_{\text{work}} \)" (see Table B3), which varies according to temperature of base material. Minor adjustments to the rebar / rebar anchor FRA position may be performed during the working time.

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

Rebar connection with fischer Injection mortar FIS EM

<table>
<thead>
<tr>
<th>Intended use</th>
<th>Annex B 10</th>
</tr>
</thead>
<tbody>
<tr>
<td>Installation instruction part 5</td>
<td></td>
</tr>
</tbody>
</table>
Minimum anchorage length and minimum lap length

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

Table C1: Factor related to concrete class and drilling method

<table>
<thead>
<tr>
<th>Concrete class</th>
<th>Drilling method</th>
<th>Factor</th>
</tr>
</thead>
<tbody>
<tr>
<td>C12/15 to C50/60</td>
<td>Hammer drilling and pneumatic drilling</td>
<td>1,0</td>
</tr>
<tr>
<td>C12/15 to C50/60</td>
<td>Diamond drilling</td>
<td>1,3</td>
</tr>
</tbody>
</table>

Table C2: Design values of the ultimate bond resistance \( f_{\text{bd}} \) in N/mm²

According to EN 1992-1-1: 2004+AC:2010 for good bond conditions (for all other bond conditions multiply the values by 0.7)

**Hammer drill or pneumatic drill**

<table>
<thead>
<tr>
<th>Rebar / FRA</th>
<th>Bond resistance ( f_{\text{bd}} ) [N/mm²]</th>
<th>Concrete class</th>
</tr>
</thead>
<tbody>
<tr>
<td>( \phi ) [mm]</td>
<td>C12/15</td>
<td>C16/20</td>
</tr>
<tr>
<td>8 to 25</td>
<td>1,6</td>
<td>2,0</td>
</tr>
<tr>
<td>26 to 40</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Diamond drill**

<table>
<thead>
<tr>
<th>Rebar / FRA</th>
<th>Bond resistance ( f_{\text{bd}} ) [N/mm²]</th>
<th>Concrete class</th>
</tr>
</thead>
<tbody>
<tr>
<td>( \phi ) [mm]</td>
<td>C12/15</td>
<td>C16/20</td>
</tr>
<tr>
<td>8 to 12</td>
<td>1,6</td>
<td>2,0</td>
</tr>
<tr>
<td>14 to 25</td>
<td></td>
<td></td>
</tr>
<tr>
<td>26 to 40</td>
<td>1,6</td>
<td>2,0</td>
</tr>
</tbody>
</table>

Rebar connection with fischer Injection mortar FIS EM

**Performances**

- Minimum anchorage length and minimum lap length
- Design values of ultimate bond resistance \( f_{\text{bd}} \)

Annex C 1