

Step 1

Prepare the 1st stage bar



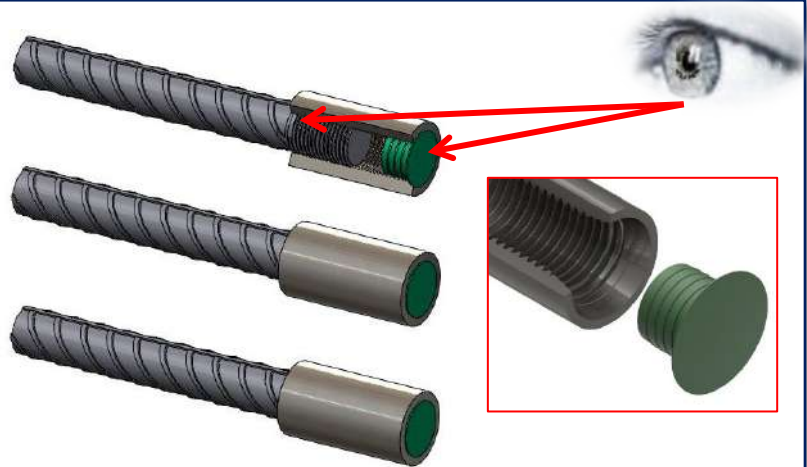
The threaded ends of the 1st stage bars are fully engaged inside the couplers.



The coupler cap is correctly fitted.



The chamfered side of the coupler must face the continuation bar.



Concreting 1st stage

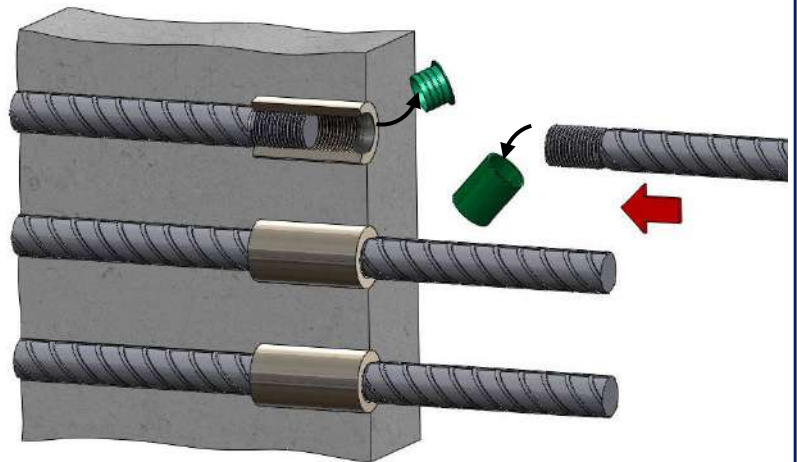
Step 2

Position the continuation bars

Remove the plastic caps from the couplers and the thread protection cap from the continuation bars.



Control that both caps are of the same colour.




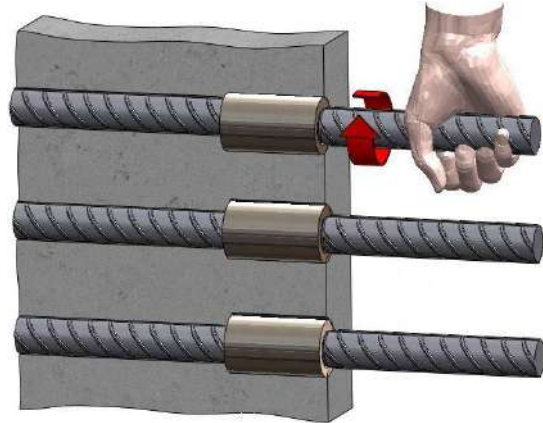
Fortec Assembly Instruction Standard Splices No 01 Rev.03_en - 25/08/2021

Step 3

Join the bars

Hand screw the continuation bar into the coupler. (A wrench may be used if it makes the operation easier).



 Full engagement of the thread is sufficient to develop the full tensile strength of the splice.

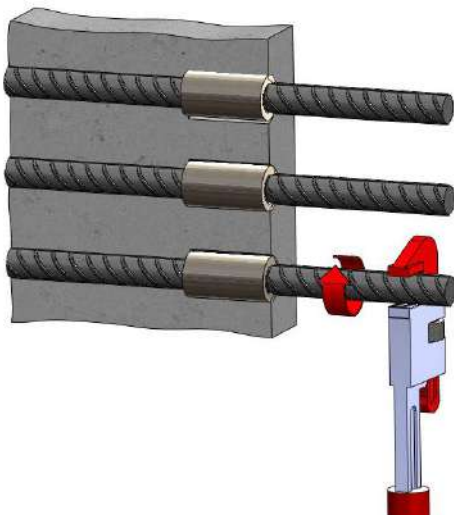


Step 4

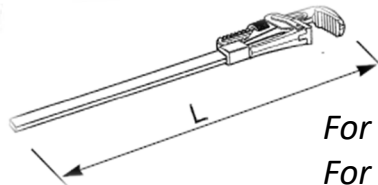
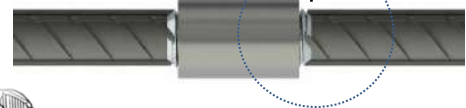
Lock the splices

Use a Stillson or pipe wrench on the continuation bar. No specific torque amount is required.

-  Locking the splice ensures that its permanent elongation meets the code requirement.
-  The rebar threaded length visible outside of the coupler after full engagement and tightening shall not exceed three pitches.



Max 3 pitches visible outside the coupler after tightening



- For $\varnothing \leq 32$: $L \geq 60 \text{ cm (24")}$
- For $32 < \varnothing \leq 40$: $L \geq 75 \text{ cm (30")}$
- For $40 < \varnothing \leq 50$: $L \geq 100 \text{ cm (40")}$

Fortec Assembly instruction Position Type B No 02 Rev.04_en 05/13/2022

Step 1

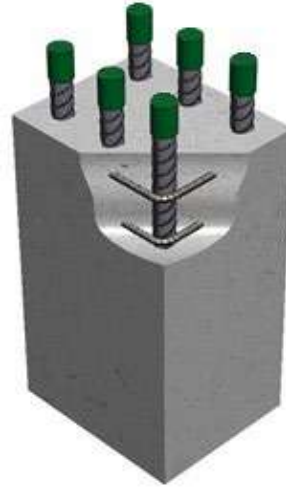
Prepare the 1st stage bar



Check that the thread protection caps are fully engaged onto the 1st stage bars.



Check that the coupler cap is correctly fitted.



Concreting 1st stage

Step 2

Position the continuation bars

Remove the thread protections from the first stage bars and bring the continuation bars in butt-to-butt contact



Control that the couplers are fully engaged on the 1st stage bars.



For ease of installation, check that the chamfer of the coupler engaged on the continuation bar is facing the 1st stage bar.



Fortec Assembly instruction Position Type B No 02 Rev.04_en 05/13/2022

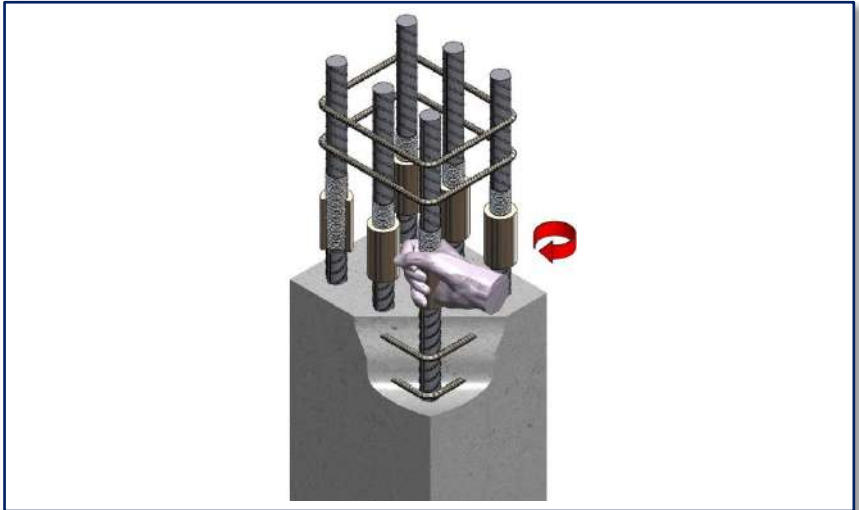
Step 3

Hand screw the coupler out of the continuation bar and onto the first stage bar. (A wrench may be used if it makes the operation easier).



Full engagement of the thread is sufficient to develop the full tensile strength of the splice.

Join the bars



Step 4

Use a Stillson or pipe wrench on the continuation bar. No specific torque amount is required.

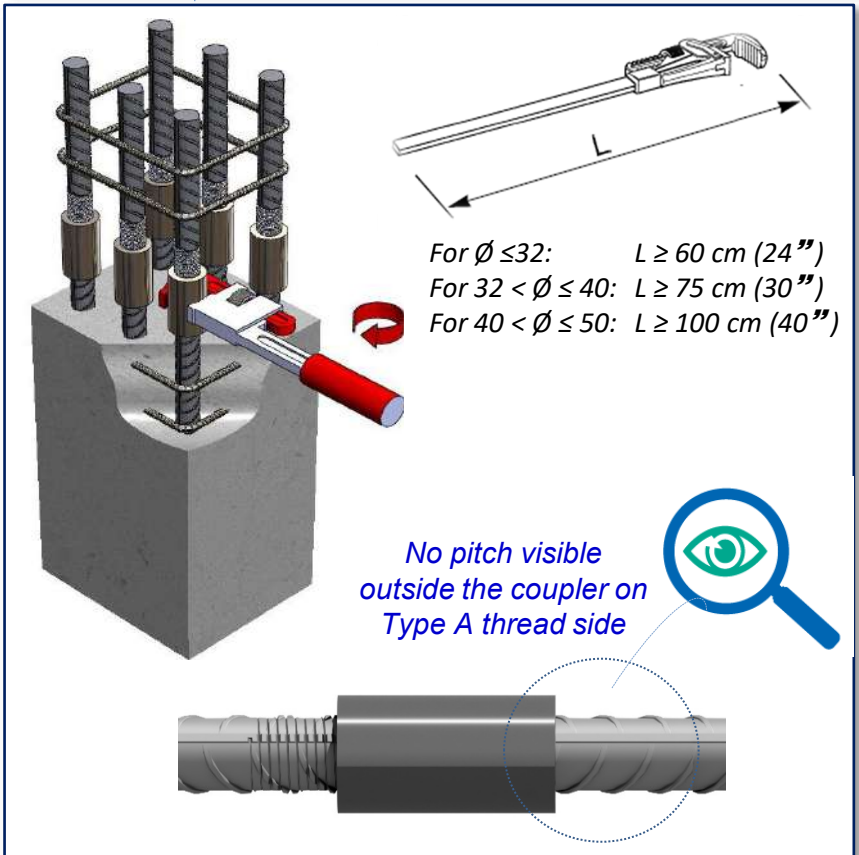


Locking the splice ensures that its permanent elongation meets the code requirement.



No pitch should be visible after proper engagement. (For Type A thread only, not applicable for the Type B thread that is extended on the ribs).

Lock the splices

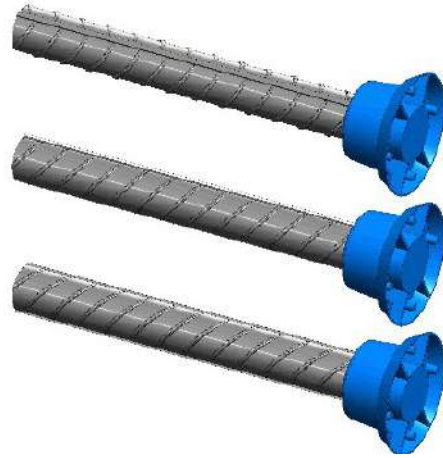


Step 1

Prepare the 1st stage bar



Check that the thread protection caps, and pocket formers are fully engaged onto the 1st stage bars.



Concreting 1st stage

Step 2

Position the continuation bars

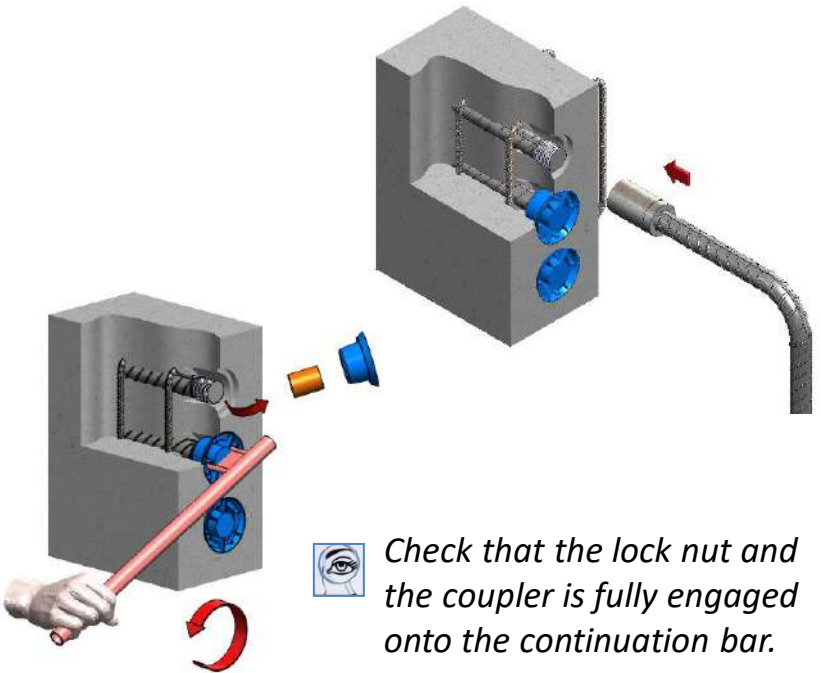
Remove the Pocket Formers and Thread Protection Caps from the 1st stage bars and bring the continuation bars ends in butt-to-butt contact.



Control that the couplers are fully engaged on the 1st stage bars.



For ease of installation, check that the chamfer of the coupler engaged on the continuation bar is facing the 1st stage bar.



Check that the lock nut and the coupler is fully engaged onto the continuation bar.

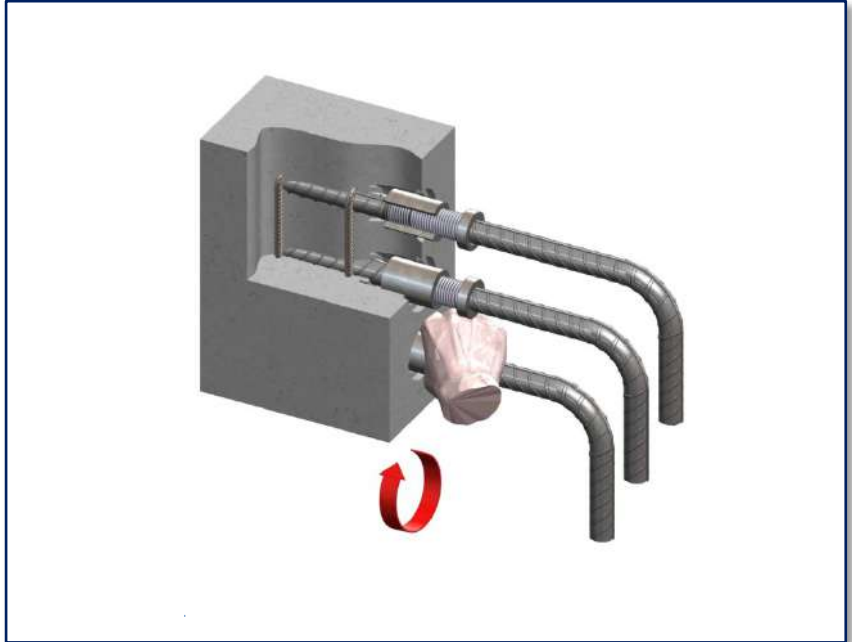
Step 3

Hand screw the coupler out of the continuation bar and onto the first stage bar. (A wrench may be used if it makes the operation easier).



Full engagement of the thread is sufficient to develop the full tensile strength of the splice.

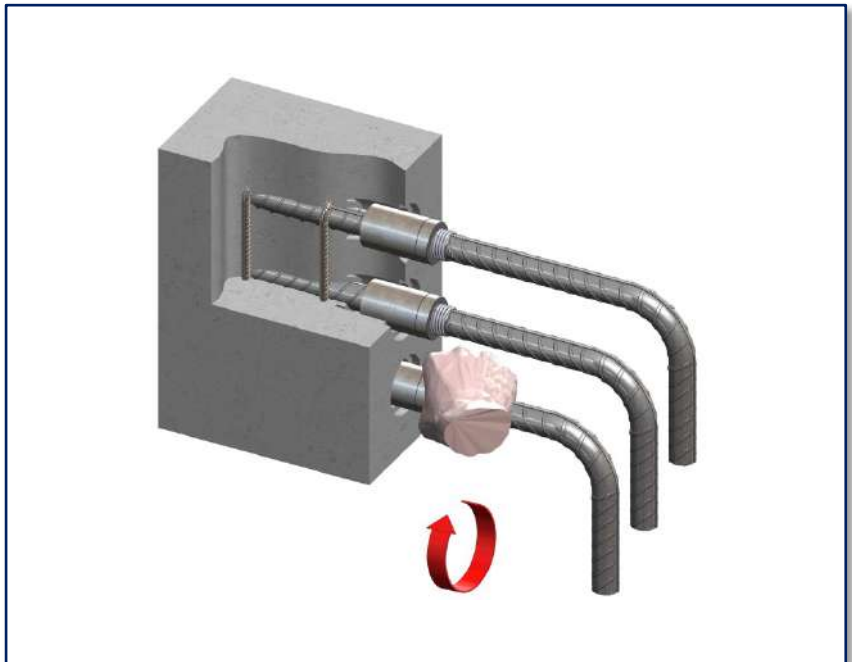
Join the bars



Step 4

Hand screw the lock nuts out of the continuation bars until contact with the couplers

Screw the lock nuts



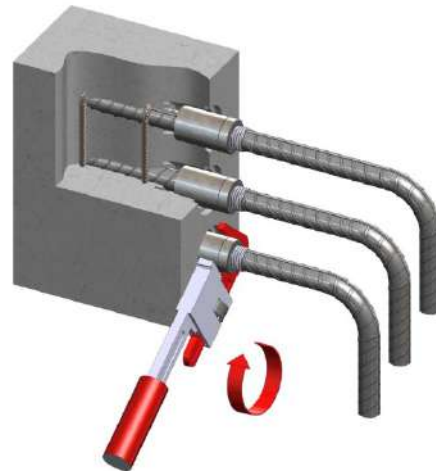
Fortec Assembly instruction Position Type C No 03 Rev.07_en 05/13/2022


Step 5


Lock the splices

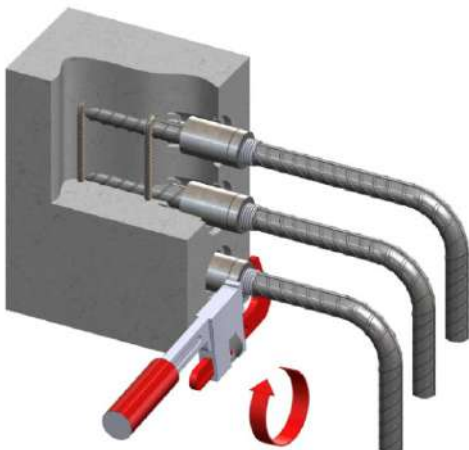
Use a stillson or pipe wrench to tighten the couplers and the lock nuts. No specific torque amount is required.

If the bar is bent and must face a specific direction, orientate it and hold it throughout the tightening and locking operations.

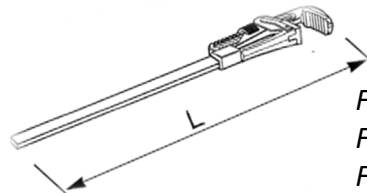
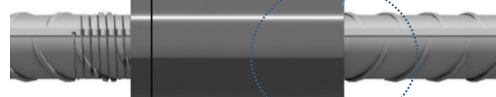


 Locking the splice ensures that its permanent elongation meets the code requirement.

 No pitch should be visible after proper engagement. (For Type A thread only, not applicable for the Type C thread that is extended on the ribs).





No pitch visible outside the coupler on Type A thread side



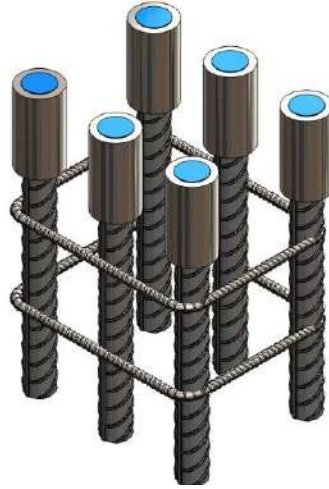
For $\varnothing \leq 32$: $L \geq 60$ cm (24")
 For $32 < \varnothing \leq 40$: $L \geq 75$ cm (30")
 For $40 < \varnothing \leq 50$: $L \geq 100$ cm (40")

Step 1

 The threaded end of the bars are fully engaged inside the couplers.

 The coupler cap is correctly fitted.

Prepare the 1st stage bar



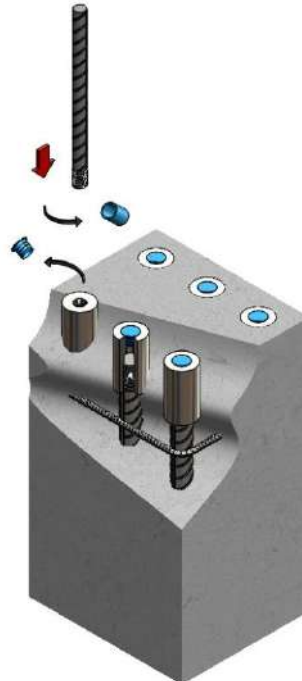
Concreting 1st stage

Step 2

Remove the plastic caps from the couplers and the thread protection from the continuation bars.

 Both caps are of the same colour.

Prepare the continuation bars



Assembly Instruction N° AI-FT 05 E Rev 02 - 21 /03/2018

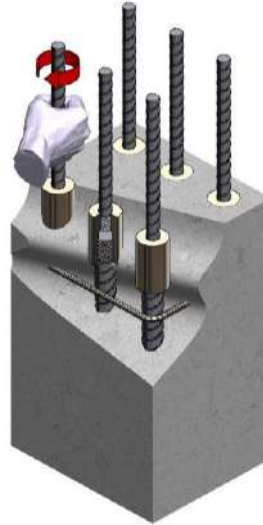
Step 3

Hand screw the continuation bars into the couplers. (A wrench may be used if it makes the operation easier).



Full engagement of the thread is sufficient to develop the full tensile strength of the splice.

Join the bars



Step 4

Use a stilson or pipe wrench on the continuation bars. No specific torque amount is required.

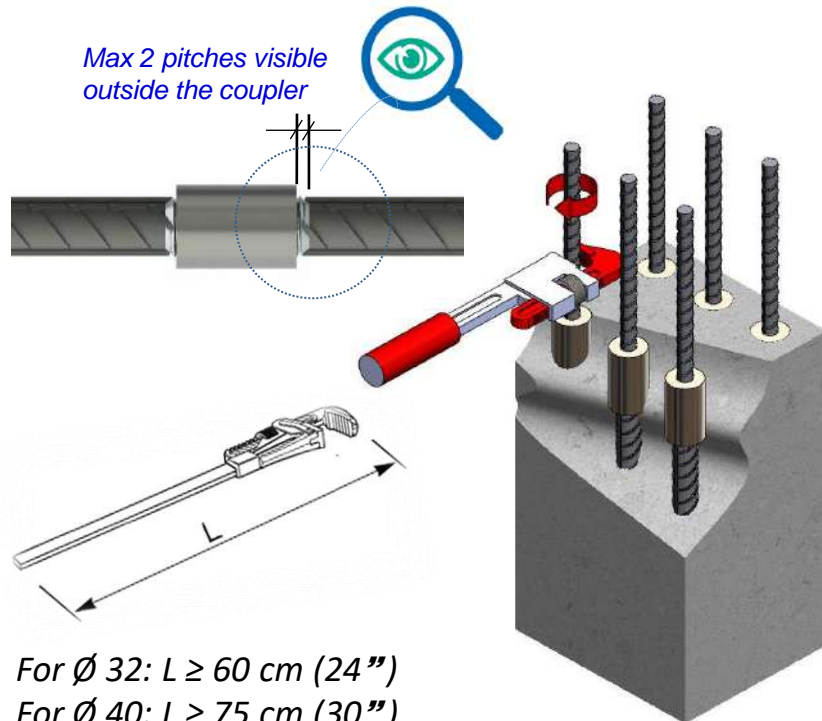


Locking the splice ensures that its permanent elongation meets the code requirement.



The rebar threaded length visible outside of the coupler shall not exceed two pitches (Not taking into account the thread that is extended on the ribs).

Lock the splices



For $\varnothing 32$: $L \geq 60$ cm (24")
 For $\varnothing 40$: $L \geq 75$ cm (30")
 For $\varnothing 50$: $L \geq 100$ cm (40")

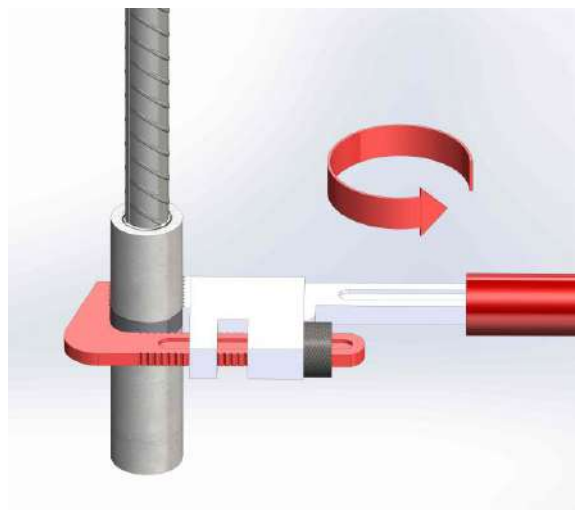
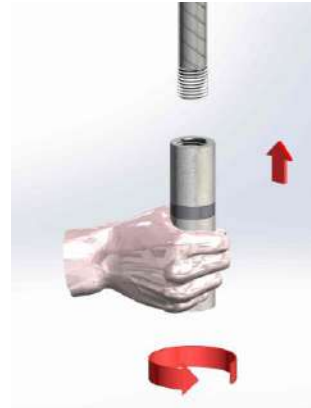
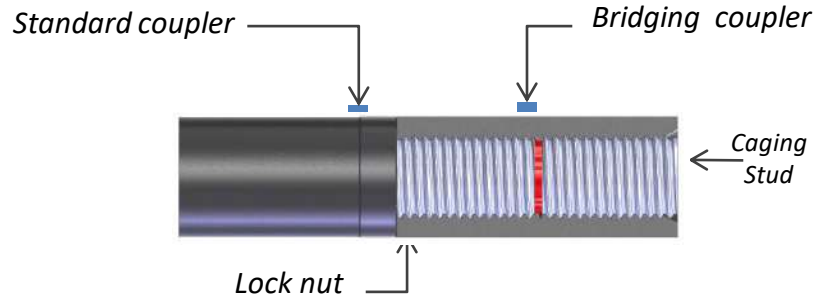
Step 1

The FT Caging assemblies set are delivered fully assembled as one set.

Assemble the caging set onto the first stage bar, with the standard coupler on top side.

Lock the standard coupler with a stilson or pipe wrench.
No specific torque is required.

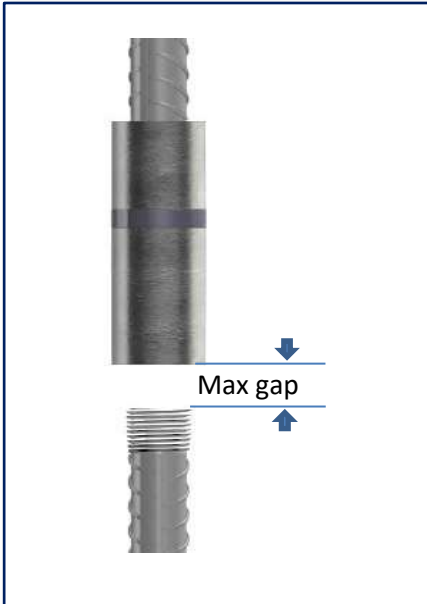
Installation of the caging set



Step 2

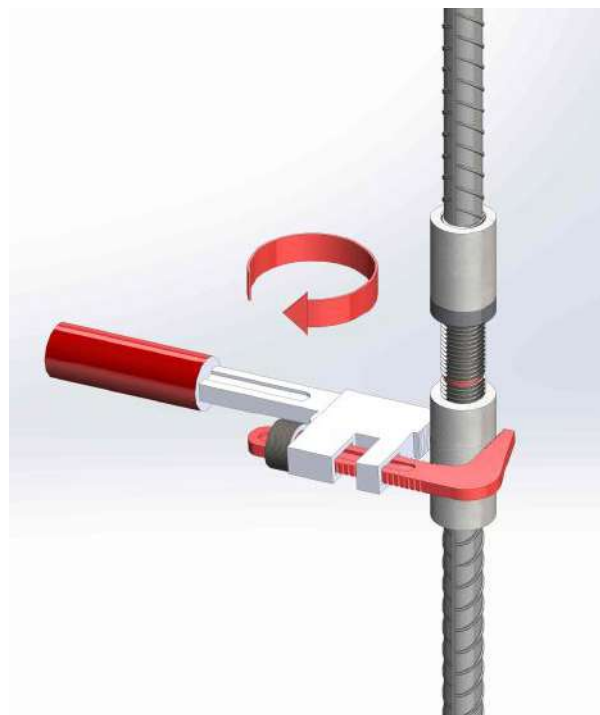
Connect the bars

Bring the bars as close as possible from one another. The gap between the bar ends must not exceed the values given in the table on the right.



Bar size	Max gap [mm]
16	16
20	20
25	25
28, 30	28
32	32
40R	43
40	50
50R	50
50	60

Lock the bridging coupler on the bottom bar with a pipe or stilson wrench. No specific torque is required.

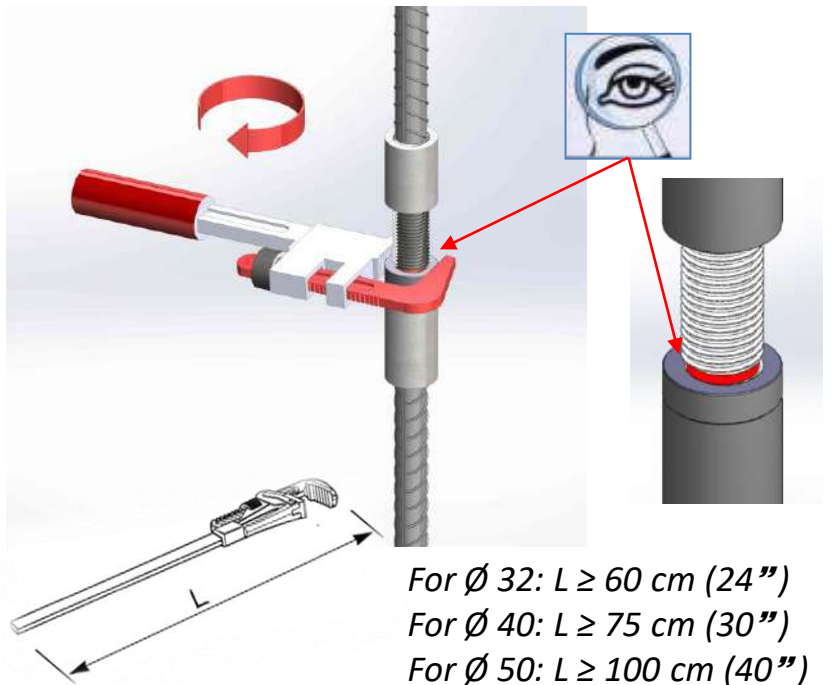


Step 3

Lock the splice by tightening the lock nut with a pipe or stilson wrench. No specific torque is required.

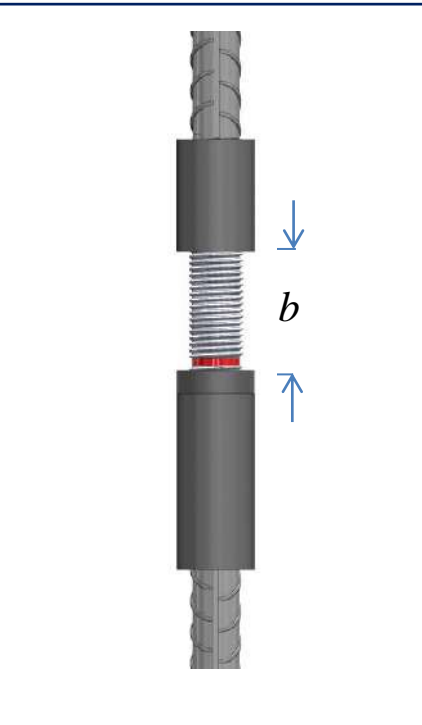
Control that there are no apparent threads beyond the groove.

Lock the splice



If the groove cannot be visualized clearly, an alternative method is to measure the distance "b" from the standard coupler to lock nut.

Check that "b" does not exceed the values given in the table on the right.



Bar size	b Max [mm]
16	46
20	58
25	67
28, 30	79
32	84
40R	110
40	115
50R	130
50	141

Assembly Instruction N° AI-FT 04 E Rev 02 - 21 /03/2018

Step 1

Remove plastic cap from the thread protection. Screw the anchor plate onto the Fortec reinforcing bar.

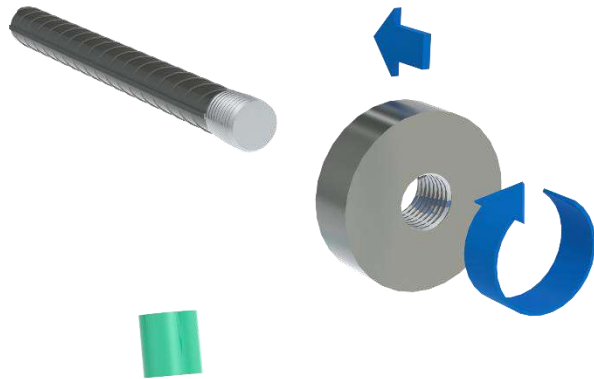


Before screwing the plate on, check that the thread on the bar is not an extended thread meant for a position splice.



After screwing the plate, check that its thread fully engages the thread of the reinforcing bar.

The continuation bars

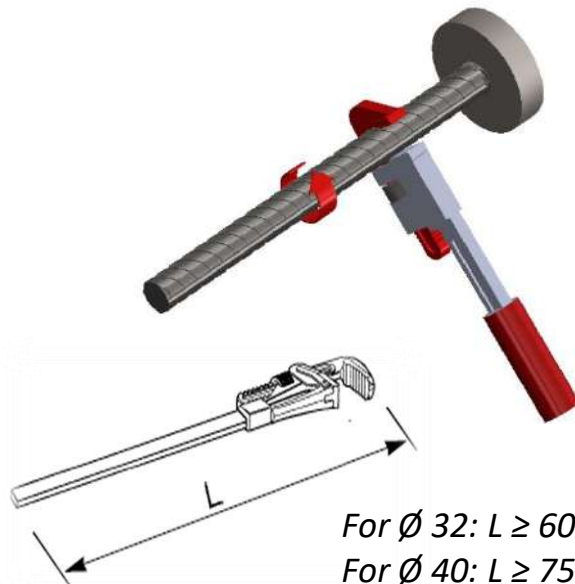


Step 2



Locking the splice ensures that its permanent elongation meets the code requirement.

Lock the splices



For $\varnothing 32$: $L \geq 60$ cm (24")
For $\varnothing 40$: $L \geq 75$ cm (30")
For $\varnothing 50$: $L \geq 100$ cm (40")