WIT-PE 510 WITH THREADED ROD (METRIC)

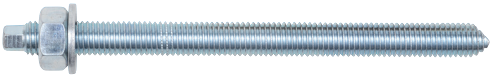
440 ml

585 ml

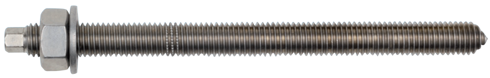
Approved for:
Concrete C20/25 to C50/60, non-cracked & cracked

Suitable for:
Concrete C12/15, Natural stone with dense structure

Cartridge sizes		Art. no.
440 ml	side-by-side	**5918 615 440**
585 ml	side-by-side	**5918 615 585**



Galvanized (5 microns): M8 - M30



Stainless steel - A4 (AISI 316): M8 - M30

Type of installation		
Pre-positioned	In-place	Stand-off
✓	✓	✓

Installation condition		
Dry concrete	Wet concrete	Flooded drill hole
✓	✓	✓

Drilling method		
Hammer drill	Diamond drill	Hollow drill
✓	-	✓

Applications




Approvals and certificates

ETA CE

Description	Authority/laboratory	Guideline for assessment	No./date of issue
European Technical Assessment	DIBt. Berlin	EAD 330499-01-0601	ETA-20/1038. 02.02.2021

Basic load data (for a single anchor)

All data in this section applies when:

- Installation is correct (see installation instructions)
- No edge distance and spacing influence
- Base material thickness and embedment depth are according to anchor characteristics
- Anchor material according is to specifications. steel grade 5.8 unless otherwise stated
- Concrete C 20/25, f_{ck} = 20 N/mm²
- Concrete C 50/60, f_{ck} = 60 N/mm²
- Temperature range I (min. base material temperature -40°C, max long term/short term base material temperature: +24°C/40°C).
- Dry or wet conditions of drill hole, hammer drilling

Characterstic resistance

Thread size				M8	M10	M12	M16	M20	M24	M27	M30
Effective anchorage depth		h_{ef}	[mm]	80	90	110	125	170	210	240	270
Non-cracked concrete											
Tension	C20/25	N_{Rk}	[kN]	18.0	29.0	42.0	68.8	109.0	149.7	182.9	218.2
	C50/60			18.0	29.0	42.0	78.0	122.0	176.0	230.0	280.0
Shear	≥ C20/25	V_{Rk}	[kN]	11.0	17.0	25.0	47.0	74.0	106.0	138.0	168.0
Cracked concrete											
Tension	C20/25	N_{Rk}	[kN]	14.1	19.8	29.0	44.0	74.8	95.0	122.1	152.7
	C50/60			15.5	21.8	31.9	48.4	82.2	104.5	134.4	167.9
Shear	≥ C20/25	V_{Rk}	[kN]	11.0	17.0	25.0	47.0	74.0	106.0	138.0	168.0

Design resistance

Thread size				M8	M10	M12	M16	M20	M24	M27	M30
Effective anchorage depth		h_{ef}	[mm]	80	90	110	125	170	210	240	270
Non-cracked concrete											
Tension	C20/25	N_{Rd}	[kN]	12.0	19.3	27.0	32.7	51.9	71.3	87.1	103.9
	C50/60			12.0	19.3	28.0	46.1	78.3	107.8	137.7	164.3
Shear	≥ C20/25	V_{Rd}	[kN]	8.8	13.6	20.0	37.6	59.2	84.8	110.4	134.4
Cracked concrete											
Tension	C20/25	N_{Rd}	[kN]	6.7	9.4	13.8	20.9	35.6	45.2	58.2	72.7
	C50/60			7.4	10.4	15.2	23.0	39.2	49.8	64.0	80.0
Shear	≥ C20/25	V_{Rd}	[kN]	8.8	13.6	20.0	37.6	59.2	84.8	110.4	134.4

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Recommended/allowable loads [1)]

Thread size				**M8**	**M10**	**M12**	**M16**	**M20**	**M24**	**M27**	**M30**
Effective anchorage depth		h_{ef}	[mm]	80	90	110	125	170	210	240	270
Non-cracked concrete											
Tension	C20/25	N_{rec}	[kN]	8.6	13.8	19.3	23.4	37.1	50.9	62.2	74.2
	C50/60			8.6	13.8	20.0	32.9	56.0	77.0	98.4	117.4
Shear	≥ C20/25	V_{rec}	[kN]	6.3	9.7	14.3	26.9	42.3	60.6	78.9	96.0
Cracked concrete											
Tension	C20/25	N_{rec}	[kN]	4.8	6.7	9.9	15.0	25.4	32.3	41.5	51.9
	C50/60			5.3	7.4	10.9	16.5	28.0	35.5	45.7	57.1
Shear	≥ C20/25	V_{rec}	[kN]	6.3	9.7	14.3	26.9	42.3	60.6	78.9	96.0

[1)] Material safety factor γ_M and safety factor for action γ_L = 1.4 are included. The material safety factor depends on the failure mode.

Design method (simplified)

Simplified version of the design method according to Eurocode 2 - Design of concrete structures - Part 4: Design of fastenings for use in concrete (EN 1992-4):

- Influence factors related to concrete strength, edge distance, spacing and others must be considered when applicable
- Valid for a group of anchors. The influencing factors must then be considered for each edge distance and spacing. The calculated design resistances are on the safe side. They will be lower than the exact values according to EN 1992-4. For an economical optimization, we recommend using the anchor design module of the Würth Technical Software II
- The design method is based on the simplification that no different loads are acting on individual anchors (no eccentricity)
- Temperature range 1 (min. base material temperature -40°C, max. long term/short term base material temperature: +24°C/40°C).
- Dry or wet conditions of drill hole, hammer drilling (Installation factors might apply for other drilling methods)
- Anchor material according to specifications, steel grade 5.8 unless otherwise stated in the tables

I. Tension loading

The decisive design resistance in tension is the lowest value of the following failure modes:

1. Steel failure $N_{Rd,s}$
2. Pull-out failure $N_{Rd,p} = N^0_{Rd,p} \cdot f_{b,N} \cdot f_{hef} \cdot f_{sx,p} \cdot f_{sy,p} \cdot f_{cx,1,p} \cdot f_{cx,2,p} \cdot f_{cy,p} \cdot f_{sus}$
3. Concrete cone failure $N_{Rd,c} = N^0_{Rd,c} \cdot f_{b,N} \cdot f_{hef} \cdot f_{sx} \cdot f_{sy} \cdot f_{cx,1} \cdot f_{cx,2} \cdot f_{cy}$
4. Concrete splitting failure $N_{Rd,sp} = N^0_{Rd,sp} \cdot f_{b;N} \cdot f_{hef} \cdot f_{sx,sp} \cdot f_{sy,sp} \cdot f_{cx,1,sp} \cdot f_{cx,2,sp} \cdot f_{cy,sp} \cdot f_h$

1. Design steel tensile resistance

Table 1: Design value of steel resistance under tension load $N_{Rd,s}$ of a single anchor

Thread size				M8	M10	M12	M16	M20	M24	M27	M30
Effective anchorage depth		h_{ef}	[mm]	80	90	110	125	170	210	240	270
Design steel resistance	5.8	$N_{Rd,s}$	[kN]	12.0	19.3	28.0	52.0	81.3	117.3	153.3	186.7
	8.8	$N_{Rd,s}$	[kN]	19.3	30.7	44.7	83.3	130.7	188.0	245.3	299.3
	A4	$N_{Rd,s}$	[kN]	13.9	21.9	31.6	58.8	91.4	132.1	80.4	98.3

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2. Design combined pull-out and concrete cone resistance

$$N_{Rd,p} = N^0_{Rd,p} \cdot f_{b,N} \cdot f_{hef} \cdot f_{sx,p} \cdot f_{sy,p} \cdot f_{cx,1,p} \cdot f_{cx,2,p} \cdot f_{cy,p} \cdot f_{sus}$$

Table 2: Basic design resistance $N^0_{Rd,p}$ in case of combined pull-out and concrete cone failure of a single anchor

Thread size			M8	M10	M12	M16	M20	M24	M27	M30
Effective anchorage depth	h_{ef}	[mm]	80	90	110	125	170	210	240	270
Non-cracked concrete										
Combined pull-out and concrete cone resistance	$N^0_{Rd,p}$	[kN]	14.4	20.2	29.6	41.9	71.2	98.0	126.0	157.5
Cracked concrete										
Combined pull-out and concrete cone resistance	$N^0_{Rd,p}$	[kN]	6.7	9.4	13.8	20.9	35.6	45.2	58.2	72.7

- $s_{cr,p} = 7.3\, d\, (f_{sus} \cdot \tau_{Rk})^{0.5} \leq 3h_{ef}$
- $c_{cr,p} = s_{cr,p}/2$

Where τ_{Rk} is the value $\tau_{Rk,ucr}$ for non-cracked concrete C20/25

Table 3: Characteristic edge distance $c_{cr,p}$ and spacing $s_{cr,p}$ (f_{sus} = 1)

Thread size			M8	M10	M12	M16	M20	M24	M27	M30
Effective anchorage depth	h_{ef}	[mm]	80	90	110	125	170	210	240	270
Spacing	$s_{cr,p}$	[mm]	226	270	330	375	510	630	711	790
Edge distance	$c_{cr,p}$	[mm]	113	135	165	188	255	315	355	395

a. Influence of concrete strength

Table 4: Influence of concrete strength on combined pull-out and concrete cone resistance

Concrete strength classes (EN 206:2000)			C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
Characteristic compressive strength of concrete determined by testing cylinders[1)]	f_{ck}	[N/mm²]	12	16	20	25	30	35	40	45	50
Characteristic compressive strength of concrete determined by testing cube[2)]	$f_{ck,cube}$	[N/mm²]	15	20	25	30	37	45	50	55	60
Influencing factor	$f_{b,N}$	[-]	0.77	0.89	1.00	1.02	1.04	1.07	1.08	1.09	1.10

[1)] strength at 28 days of 150 mm diameter by 300 mm cylinders

[2)] strength at 28 days of 150 mm cubes

b. Influence of embedment depth

$$f_{hef} = \frac{h_{ef}}{h_{ef,typ}}$$

Consider the approved range of embedment $h_{ef,min} \leq h_{ef} \leq h_{ef,max}$ according to the table „installation parameters".

c. Influence of spacing

$$f_{sx,p} = f_{sy,p} = \left(1 + \left(n_{x(y)} - 1\right)\frac{s_{x(y)}}{s_{cr,p}}\right) \cdot \frac{1}{n_{x(y)}} \leq 1$$

Table 5: Influence of spacing on combined pull-out and concrete cone resistance

Number of fixing per direction	$s/s_{cr,p}$ 1)	0.10	0.15	0.20	0.25	0.30	0.35	0.40	0.45	0.50	0.55	0.60	0.65	0.70	0.75	0.70	0.75	0.90	0.95	≥ 1.0
2	$f_{sx,p,}\ f_{sy,p}$	0.55	0.58	0.60	0.63	0.65	0.68	0.70	0.73	0.75	0.78	0.80	0.83	0.85	0.88	0.85	0.88	0.95	0.98	1.00
3	$f_{sx,p,}\ f_{sy,p}$	0.40	0.43	0.47	0.50	0.53	0.57	0.60	0.63	0.67	0.70	0.73	0.77	0.80	0.83	0.80	0.83	0.93	0.97	1.00
4	$f_{sx,p,}\ f_{sy,p}$	0.33	0.36	0.40	0.44	0.48	0.51	0.55	0.59	0.63	0.66	0.70	0.74	0.78	0.81	0.78	0.81	0.93	0.96	1.00
5	$f_{sx,p,}\ f_{sy,p}$	0.28	0.32	0.36	0.40	0.44	0.48	0.52	0.56	0.60	0.64	0.68	0.72	0.76	0.80	0.76	0.80	0.92	0.96	1.00

[1)] Choose always the lowest value of the spacing s, when there are different spacings in one row

d. Influence of edge distance

$$f_{cx,1,p} = 0.7 + 0.3\frac{c_x}{c_{cr,p}} \leq 1 \qquad f_{cx,2,p} = f_{cy,p} = \left(1 + \frac{c_{x(y)}}{c_{cr,p}}\right) \cdot \frac{1}{2} \leq 1$$

Table 6: Influence of edge distance on combined pull-out and concrete cone resistance

$c/c_{cr,P}$	0.10	0.15	0.20	0.25	0.30	0.35	0.40	0.45	0.50	0.55	0.60	0.65	0.70	0.75	0.70	0.75	0.90	0.95	≥ 1.0
$f_{cx,1,p}$	0.73	0.75	0.76	0.78	0.79	0.81	0.82	0.84	0.85	0.87	0.88	0.90	0.91	0.93	0.91	0.93	0.97	0.99	1.00
$f_{cx,2,p}$ $f_{cy,p}$	0.55	0.58	0.60	0.63	0.65	0.68	0.70	0.73	0.75	0.78	0.80	0.83	0.85	0.88	0.85	0.88	0.95	0.98	1.00

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e. Influence of sustained loads

$$a_{sus} = \frac{N_{sus,d}}{N_{Ed}}$$

$N_{sus,d}$ = design value of sustained actions (permanent actions & permanent component of variable actions)

N_{Ed} = Value of total actions in tension loading at ultimate limit state

Table 7: Influence of sustained loads on combined pull-out and concrete cone resistance

a_{sus}	10%	20%	30%	40%	50%	60%	70%	80%	90%	100%
f_{sus}	1.00	1.00	1.00	1.00	1.00	1.00	0.90	0.80	0.70	0.60

3. Design Concrete Cone Resistance

$$N_{Rd,c} = N^0_{Rd,c} \cdot f_{b,N} \cdot f_{sx} \cdot f_{sy} \cdot f_{cx,1} \cdot f_{cx,2} \cdot f_{cy}$$

No verification of splitting is required if at least one of the conditions is fulfilled:

a) The edge distance in all directions is $c \geq c_{cr,sp}$ for single fasteners and $c \geq 1.2\ c_{cr,sp}$ for fastener groups and the member depth is $h \geq h_{min}$ in both cases.

b) The characteristic resistance for concrete cone failure and pull-out failure is calculated for cracked concrete and reinforcement resists the splitting forces and limits the crack width to $w_k \leq 0.3$ mm

Table 8: Basic design resistance $N^0_{Rd,c}$ in case of concrete cone failure of a single anchor

Thread size			**M8**	**M10**	**M12**	**M16**	**M20**	**M24**	**M27**	**M30**
Effective anchorage depth	h_{ef}	[mm]	80	90	110	125	170	210	240	270
Non-cracked concrete										
Concrete cone resistance	$N^0_{Rd,c}$	[kN]	16.8	20.0	27.0	32.7	51.9	71.3	87.1	103.9
Cracked concrete										
Concrete cone resistance	$N^0_{Rd,c}$	[kN]	11.7	14.0	18.9	22.9	36.3	49.9	61.0	72.7

Table 9: Characteristic edge distance $c_{cr,N}$ and spacing $s_{cr,N}$

Thread size			**M8**	**M10**	**M12**	**M16**	**M20**	**M24**	**M27**	**M30**
Effective anchorage depth	h_{ef}	[mm]	80	90	110	125	170	210	240	270
Spacing	$s_{cr,N}$	[mm]	240	270	330	375	510	630	720	810
Edge distance	$c_{cr,N}$	[mm]	120	135	165	188	255	315	360	405

Above characteristic spacing and edge distances are given for the typical effective anchorage depths. Calculating for smaller depths leads to conservative load capacities. For calculation with bigger depths, use the following:

$s_{cr,N} = 3\ h_{ef}$ and $c_{cr,N} = 1.5\ h_{ef}$

a. Influence of concrete strength

Table 10: Influence of concrete strength on concrete cone resistance

Concrete strength classes (EN 206:2000)			C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
Characteristic compressive strength of concrete determined by testing cylinders[1]	f_{ck}	[N/mm²]	12	16	20	25	30	35	40	45	50
Characteristic compressive strength of concrete determined by testing cube[2]	$f_{ck,cube}$	[N/mm²]	15	20	25	30	37	45	50	55	60
Influencing factor	$f_{b,N}$	[-]	0.77	0.89	1.00	1.12	1.22	1.32	1.41	1.50	1.58

[1] strength at 28 days of 150 mm diameter by 300 mm cylinders

[2] strength at 28 days of 150 mm cubes

b. Influence of embedment depth

$$f_{hef} = \left(\frac{h_{ef}}{h_{ef,\,typ}}\right)^{1.5}$$

Consider the approved range of embedment $h_{ef,min} \leq h_{ef} \leq h_{ef,max}$ according to the table „anchor characteristics".

c. Influence of spacing

$$f_{sx} = f_{sy} = \left(1 + \left(n_{x(y)} - 1\right)\frac{s_{x(y)}}{s_{cr,N}}\right) \cdot \frac{1}{n_{x(y)}} \leq 1$$

Table 11: Influence of spacing on concrete cone resistance

Number of fixing per direction	$s/s_{cr,p}$ [1]	0.10	0.15	0.20	0.25	0.30	0.35	0.40	0.45	0.50	0.55	0.60	0.65	0.70	0.75	0.70	0.75	0.90	0.95	≥ 1.0
2	f_{sx}, f_{sy}	0.55	0.58	0.60	0.63	0.65	0.68	0.70	0.73	0.75	0.78	0.80	0.83	0.85	0.88	0.85	0.88	0.95	0.98	1.00
3	f_{sx}, f_{sy}	0.40	0.43	0.47	0.50	0.53	0.57	0.60	0.63	0.67	0.70	0.73	0.77	0.80	0.83	0.80	0.83	0.93	0.97	1.00
4	f_{sx}, f_{sy}	0.33	0.36	0.40	0.44	0.48	0.51	0.55	0.59	0.63	0.66	0.70	0.74	0.78	0.81	0.78	0.81	0.93	0.96	1.00
5	f_{sx}, f_{sy}	0.28	0.32	0.36	0.40	0.44	0.48	0.52	0.56	0.60	0.64	0.68	0.72	0.76	0.80	0.76	0.80	0.92	0.96	1.00

[1] Choose always the lowest value of the spacing s, when there are different spacings in one row

d. Influence of edge distance

$$f_{cx,1} = 0.7 + 0.3\,\frac{c_x}{c_{cr,N}} \leq 1 \qquad f_{cx,2} = f_{cy} = \left(1 + \frac{c_{x(y)}}{c_{cr,N}}\right) \cdot \frac{1}{2} \leq 1$$

Table 12: Influence of edge distance on concrete cone resistance

$c/c_{cr,N}$	0.10	0.15	0.20	0.25	0.30	0.35	0.40	0.45	0.50	0.55	0.60	0.65	0.70	0.75	0.70	0.75	0.90	0.95	≥ 1.0
$f_{cx,1}$	0.73	0.75	0.76	0.78	0.79	0.81	0.82	0.84	0.85	0.87	0.88	0.90	0.91	0.93	0.91	0.93	0.97	0.99	1.00
$f_{cx,2}$ / f_{cy}	0.55	0.58	0.60	0.63	0.65	0.68	0.70	0.73	0.75	0.78	0.80	0.83	0.85	0.88	0.85	0.88	0.95	0.98	1.00

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4. Design splitting resistance

$$N_{Rd,sp} = N^0_{Rd,sp} \cdot f_{b,N} \cdot f_{hef} \cdot f_{sx,sp} \cdot f_{sy,sp} \cdot f_{cx,1,sp} \cdot f_{cx,2,sp} \cdot f_{cy,sp} \cdot f_h$$

Table 13: Design resistance $N_{Rd,sp}$ in case of concrete splitting failure of a single anchor

Thread size			M8	M10	M12	M16	M20	M24	M27	M30
Effective anchorage depth	h_{ef}	[mm]	80	90	110	125	170	210	240	270
Non-cracked concrete										
Concrete splitting resistance	$N^0_{Rd,c}$	[kN]	14.4	20.0	27.0	32.7	51.9	71.3	87.1	103.9

Table 14: Characteristic edge distance $c_{cr,sp}$ and spacing $s_{cr,sp}$

Thread size			M8	M10	M12	M16	M20	M24	M27	M30
Effective anchorage depth	h_{ef}	[mm]	80	90	110	125	170	210	240	270
Spacing	$s_{cr,sp}$	[mm]	360	420	528	600	816	1008	1152	1296
Edge distance	$c_{cr,sp}$	[mm]	180	210	264	300	408	504	576	648
Minimum member thickness	h_{min}	[mm]	110	120	140	161	218	266	304	340

Above characteristic spacing and edge distances are given for the typical effective anchorage depth. Calculating for smaller depths leads to conservative load capacities. For calculation with bigger depths, use the following:

$$s_{cr,sp} = 2 \cdot c_{cr,sp} \quad \text{and} \quad c_{cr,sp} = \left\{ h_{ef} \le 2\, h_{ef} \cdot \left(2.5 - \left(\frac{h_{min}}{h_{ef}}\right)\right) \le 2.4\, h_{ef} \right\}$$

and h_{min} according to the table „anchor characteristics".

a. Influence of concrete strength

Table 15: Influence of concrete strength on splitting resistance

Concrete strength classes (EN 206:2000)			C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
Characteristic compressive strength of concrete determined by testing cylinders [1)]	f_{ck}	[N/mm²]	12	16	20	25	30	35	40	45	50
Characteristic compressive strength of concrete determined by testing cube [2)]	$f_{ck,cube}$	[N/mm²]	15	20	25	30	37	45	50	55	60
Influencing factor	$f_{b,N}$	[-]	0.77	0.89	1.00	1.12	1.22	1.32	1.41	1.50	1.58

[1)] strength at 28 days of 150 mm diameter by 300 mm cylinders

[2)] strength at 28 days of 150 mm cubes

b. Influence of embedment depth

$$f_{hef} = \left(\frac{h_{ef}}{h_{ef,typ}}\right)^{1.5}$$

Consider the approved range of embedment $h_{ef,min} \leq h_{ef} \leq h_{ef,max}$ according to the table „anchor characteristics“.

c. Influence of spacing

$$f_{sx,sp} = f_{sy,sp} = \left(1 + \left(n_{x(y)} - 1\right)\frac{s_{x(y)}}{s_{cr,sp}}\right) \cdot \frac{1}{n_{x(y)}} \leq 1$$

Table 16: Influence of spacing on splitting resistance

Number of fixing per direction	$s/s_{cr,sp}$ [1]	0.10	0.15	0.20	0.25	0.30	0.35	0.40	0.45	0.50	0.55	0.60	0.65	0.70	0.75	0.70	0.75	0.90	0.95	≥ 1
2	$f_{sx,sp}$, $f_{sy,sp}$	0.55	0.58	0.60	0.63	0.65	0.68	0.70	0.73	0.75	0.78	0.80	0.83	0.85	0.88	0.85	0.88	0.95	0.98	1.00
3	$f_{sx,sp}$, $f_{sy,sp}$	0.40	0.43	0.47	0.50	0.53	0.57	0.60	0.63	0.67	0.70	0.73	0.77	0.80	0.83	0.80	0.83	0.93	0.97	1.00
4	$f_{sx,sp}$, $f_{sy,sp}$	0.33	0.36	0.40	0.44	0.48	0.51	0.55	0.59	0.63	0.66	0.70	0.74	0.78	0.81	0.78	0.81	0.93	0.96	1.00
5	$f_{sx,sp}$, $f_{sy,sp}$	0.28	0.32	0.36	0.40	0.44	0.48	0.52	0.56	0.60	0.64	0.68	0.72	0.76	0.80	0.76	0.80	0.92	0.96	1.00

[1] Choose always the lowest value of the spacing s, when there are different spacings in one row

d. Influence of edge distance

$$f_{cx,1,sp} = 0.7 + 0.3\,\frac{c_x}{c_{cr,sp}} \leq 1 \qquad\qquad f_{cx,2,sp} = f_{cy,sp} = \left(1 + \frac{c_{x(y)}}{c_{cr,sp}}\right) \cdot \frac{1}{2} \leq 1$$

Table 17: Influence of edge distance on splitting resistance

$c/c_{cr,sp}$	0.10	0.15	0.20	0.25	0.30	0.35	0.40	0.45	0.50	0.55	0.60	0.65	0.70	0.75	0.70	0.75	0.90	0.95	≥ 1
$f_{cx,1}$	0.73	0.75	0.76	0.78	0.79	0.81	0.82	0.84	0.85	0.87	0.88	0.90	0.91	0.93	0.91	0.93	0.97	0.99	1.00
$f_{cx,2}$ / f_{cy}	0.55	0.58	0.60	0.63	0.65	0.68	0.70	0.73	0.75	0.78	0.80	0.83	0.85	0.88	0.85	0.88	0.95	0.98	1.00

e. Influence of concrete member thickness

$$f_h = \left(\frac{h}{h_{min}}\right)^{2/3} \leq max\left(1; \left(\frac{h_{ef} + 1.5c_1}{h_{min}}\right)^{2/3}\right)$$

Table 18: Influence of concrete member thickness on splitting resistance

h/h_{min}	1	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	1.9	2	2.1	2.2	2.3	2.4	2.3	2.4	2.7	2.8	2.9
f_h	1.00	1.07	1.13	1.19	1.25	1.31	1.37	1.42	1.48	1.53	1.59	1.64	1.69	1.74	1.79	1.74	1.79	1.94	1.99	2.00

WIT-PE 510 WITH THREADED ROD (METRIC)

II. Shear loading

The decisive design resistance in shear is the lowest value of the following failure modes:

1. Steel failure V_{Rds}
2. Concrete pry-out failure $V_{Rd,c} = k \cdot min\ \{N_{Rd,p;} N_{Rd,c}\}$
3. Concrete edge failure $V_{Rd,c} = V^0_{Rd,c} \cdot f_{b,V} \cdot f_{hef,V} \cdot f_{s,V} \cdot f_{c1,V} \cdot f_{c2,V} \cdot f_a \cdot f_h$

1. Design steel shear resistance

Table 19: Design value of steel resistance $V_{Rd,s}$ of a single anchor

Thread size				M8	M10	M12	M16	M20	M24	M27	M30
Effective anchorage depth		h_{ef}	[mm]	80	90	110	125	170	210	240	270
Design steel resistance	5.8	$V_{Rd,s}$	[kN]	8.8	13.6	20.0	37.6	59.2	84.8	110.4	134.4
	8.8		[kN]	12.0	18.4	27.2	50.4	78.4	112.8	147.2	179.2
	A4		[kN]	8.3	12.8	19.2	35.3	55.1	79.5	48.3	58.8

2. Design concrete pry-out resistance

$$V_{Rd.c} = k_8 \cdot min\ \{N_{Rd.p};N_{Rd.c}\}$$

Table 20: factor k_8 for calculating design pry-out resistance

Thread size			M8	M10	M12	M16	M20	M24	M27	M30
Effective anchorage depth	h_{ef}	[mm]	80	90	110	125	170	210	240	270
Concrete pry-out resistance factor	k_8	[-]	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0

3. Design concrete edge resistance

$$V_{Rd,c} = V^0_{Rd,c} \cdot f_{b,V} \cdot f_{hef,V} \cdot f_{s,V} \cdot f_{c1,V} \cdot f_{c2,V} \cdot f_a \cdot f_h$$

Verification of concrete edge failure may be omitted for single fasteners and groups with an edge distance in all directions $c \geq max\ (10\ h_{ef}\ ;\ 60\ d)$. For anchorages with more than one edge, the resistance for all edges shall be calculated. The smallest value should be used in the verification.

Table 21: Design resistance $V^0_{Rd,c}$ in case of concrete edge failure

Thread size			M8	M10	M12	M16	M20	M24	M27	M30
Effective anchorage depth	h_{ef}	[mm]	80	90	110	125	170	210	240	270
Non-cracked concrete										
Basic design edge resistance	$V^0_{Rd,c}$	[kN]	2.8	3.6	4.6	5.8	8.3	10.3	13.1	15.2
Cracked concrete										
Basic design edge resistance	$V^0_{Rd,c}$	[kN]	2.0	2.5	3.2	4.1	5.9	7.3	9.3	10.7

a. Influence of concrete strength

Table 22: Influence of concrete strength on concrete edge resistance

Concrete strength classes (EN 206:2000)			C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
Characteristic compressive strength of concrete determined by testing cylinders[1]	f_{ck}	[N/mm²]	12	16	20	25	30	35	40	45	50
Characteristic compressive strength of concrete determined by testing cube[2]	$f_{ck,cube}$	[N/mm²]	15	20	25	30	37	45	50	55	60
Influencing factor	$f_{b,N}$	[-]	0.77	0.89	1.00	1.12	1.22	1.32	1.41	1.50	1.58

[1] strength at 28 days of 150 mm diameter by 300 mm cylinders

[2] strength at 28 days of 150 mm cubes

b. Influence of embedment depth

Table 23: Influence of embedment depth on concrete edge resistance

h_{ef}/d	4	5	6	7	8	9	10	11	≥ 12
$f_{hef,V}$	0.87	0.91	0.94	0.97	1.00	1.02	1.05	1.07	1.08

[1] Always choose the lowest value of the spacing s, when there are different spacing in the row closest to the edge.

c. Influence of spacing

In groups loaded perpendicular to the edge only two adjacent anchors closest and parallel to the edge carry the load. The smallest spacing should be used for the verification.

$$f_{s,V} = \frac{1}{3} \cdot \frac{s}{c_1} + 1 \leq 2$$

Table 24: Influence of spacing on concrete edge resistance

s/c_1[1]	0.50	0.60	0.70	0.80	0.90	1.00	1.20	1.40	1.60	1.80	2.00	2.20	2.40	2.60	2.80	2.60	2.80
$f_{s,V}$	1.17	1.20	1.23	1.27	1.30	1.33	1.40	1.47	1.53	1.60	1.67	1.73	1.80	1.87	1.93	1.87	1.93

[1] Always choose the lowest value of the spacing s. when there are different spacing in the row closest to the edge.

d. Influence of edge distance c_1

Table 25: Influence of edge distance c_1 on concrete edge resistance

$c_{1/d}$	4	8	12	15	20	30	40	50	60	100	150	200
$f_{c1,V}$	0.47	1.19	2.05	2.76	4.05	6.95	10.22	13.76	17.54	34.66	59.52	87.35

e. Influence of edge distance c_2

$$f_{c2,V} = \left(\frac{1}{2} + \frac{1}{3}\frac{c_2}{c_1}\right)\left(0.7 + 0.3\frac{c_2}{1.5c_1}\right) \leq 1$$

Table 26: Influence of edge distance c_2 on concrete edge resistance

c_2/c_1 [1]	1	1.1	1.2	1.3	1.4	1.5
$f_{c,V}$	0.75	0.80	0.85	0.90	0.95	1.00

[1] Distance to the second edge: $c_1 \leq c_2$

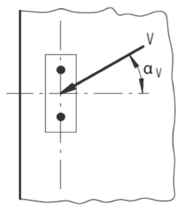
f. Influence of load direction

$$f_{\alpha} = \sqrt{\frac{1}{cos^2\alpha_V + \left(\frac{sin\alpha_V}{2}\right)^2}} \leq 2$$

Table 27: Influence of load direction on concrete edge resistance

α [1]	0	10	20	30	40	50	60	70	80	90
$f_{\alpha,V}$	1.00	1.01	1.05	1.11	1.20	1.34	1.51	1.72	1.92	2.00

[1] For a ≥ 90° the component of the shear load acting away from the edge may be neglected and the verification may be done with component acting parallel to the edge only.



g. Influence of concrete member thickness

$$f_{h,V} = \left(\frac{h}{1.5c_1}\right)^{1/2}$$

Table 28: Influence of concrete member thickness on edge resistance

h/c_1	0.1	0.2	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1	1.1	1.2	1.3	1.4	≥ 1.50
$f_{h,V}$	0.26	0.37	0.45	0.52	0.58	0.63	0.68	0.73	0.77	0.82	0.86	0.89	0.93	0.97	1.00

Structural verification

N_{Ed} = Design value of tension load acting on a fastener
V_{Ed} = Design value of a shear load acting on a fastener

	Failure mode	Verification
1	Steel failure of fastener [1)]	$\left(\frac{N_{Ed}}{N_{Rd}}\right)^2 + \left(\frac{V_{Ed}}{V_{Rd}}\right)^2 \leq 1$ If N_{Ed} and V_{Ed} are different for the individual fasteners of the group, the interaction shall be verified for all fasteners.
2	Failure modes other than steel failure	$\left(\frac{N_{Ed}}{N_{Rd,i}}\right)^{1.5} + \left(\frac{V_{Ed}}{V_{Rd,i}}\right)^{1.5} \leq 1$ or $\left(\frac{N_{Ed}}{N_{Rd,i}}\right) + \left(\frac{V_{Ed}}{V_{Rd,i}}\right) \leq 1.2$ With $N_{Ed} / N_{Rd,i} \leq 1$ and $V_{Ed} / V_{Rd,i} \leq 1$ The largest value of $N_{Ed} / N_{Rd,i}$ and $V_{Ed} / V_{Rd,i}$ for the different failure modes shall be taken.

[1)] This verification is not required in case of shear load with lever arm

WIT-PE 510 WITH THREADED ROD (METRIC)

Design bond strength

Service temperature for working life of 50 years

	Base material temperature	Maximum long-term base material temperature	Maximum short-term base material temperature
Temperature range I	- 40°C to +40°C	+24°C	+40°C
Temperature range II	- 40°C to +60°C	+35°C	+60°C
Temperature range III	- 40°C to +70°C	+43°C	+70°C

Working life of 50 years

1- Non-cracked concrete

Thread size				**M8**	**M10**	**M12**	**M16**	**M20**	**M24**	**M27**	**M30**
Design bond resistance in non-cracked concrete C20/25 in hammer drilled holes (HD), with hollow drill bit (HDB), and compressed air drilled holes (CD)											
Temperature range I	Dry, wet concrete and flooded bore holee	$\tau_{Rd,ucr}$	[N/mm²]	7.14	7.14	7.14	6.67	6.67	6.19	6.19	6.19
Temperature range II				4.76	4.76	4.76	4.52	4.52	4.29	4.29	4.29
Temperature range III				3.33	3.33	3.33	3.10	3.10	2.86	2.86	2.86

2- Cracked concrete

Thread size				**M8**	**M10**	**M12**	**M16**	**M20**	**M24**	**M27**	**M30**
Design bond resistance in cracked concrete C20/25 in hammer drilled holes (HD), with hollow drill bit (HDB), and compressed air drilled holes (CD)											
Temperature range I	Dry, wet concrete and flooded bore holee	$\tau_{Rd,ucr}$	[N/mm²]	3.33	3.33	3.33	3.33	3.33	2.86	2.86	2.86
Temperature range II				2.38	2.38	2.38	2.38	2.38	2.14	2.14	2.14
Temperature range III				1.67	1.67	1.67	1.67	1.67	1.43	1.43	1.43

Reduction factors

Working life of 50 years

1- Non-cracked concrete

Thread size				M8	M10	M12	M16	M20	M24	M27	M30
Reduction factor for non-cracked concrete C20/25 in hammer drilled holes (HD), with hollow drill bit (HDB), and compressed air drilled holes (CD)											
Temperature range I	Dry, wet concrete and flooded bore hole	$\tau_{Rd,ucr}$	[N/mm^2]	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00
Temperature range II				0.67	0.67	0.67	0.68	0.68	0.69	0.69	0.69
Temperature range III				0.47	0.47	0.47	0.46	0.46	0.46	0.46	0.46

2- Cracked concrete

Thread size				M8	M10	M12	M16	M20	M24	M27	M30
Reduction factor for in cracked concrete C20/25 in hammer drilled holes (HD), with hollow drill bit (HDB), and compressed air drilled holes (CD)											
Temperature range I	Dry, wet concrete and flooded bore hole	$\tau_{Rd,ucr}$	[N/mm^2]	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00
Temperature range II				0.71	0.71	0.71	0.71	0.71	0.75	0.75	0.75
Temperature range III				0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50

WIT-PE 510 WITH THREADED ROD (METRIC)

Mechanical characteristics

Steel grade	Thread size			M8	M10	M12	M16	M20	M24	M27	M30
	Stressed cross section	A_s	[mm²]	37	58	84	157	245	352	459	561
	Section modulus	W	[mm³]	31	62	109	277	541	935	1387	1874
4.6	Yield strength	f_y	[N/mm²]	240	240	240	240	240	240	240	240
	Tensile strength	f_u	[N/mm²]	400	400	400	400	400	400	400	400
	Design bending moment	$M^0_{Rd,s}$	[Nm]	9.0	18.0	31.1	79.6	155.7	268.9	398.8	538.9
4.8	Yield strength	f_y	[N/mm²]	320	320	320	320	320	320	320	320
	Tensile strength	f_u	[N/mm²]	400	400	400	400	400	400	400	400
	Design bending moment	$M^0_{Rd,s}$	[Nm]	12.0	24.0	41.6	106.4	208.0	359.2	532.8	720.0
5.6	Yield strength	f_y	[N/mm²]	300	300	300	300	300	300	300	300
	Tensile strength	f_u	[N/mm²]	500	500	500	500	500	500	500	500
	Design bending moment	$M^0_{Rd,s}$	[Nm]	11.4	22.2	38.9	99.4	194.0	335.3	498.8	672.5
5.8	Yield strength	f_y	[N/mm²]	400	400	400	400	400	400	400	400
	Tensile strength	f_u	[N/mm²]	500	500	500	500	500	500	500	500
	Design bending moment	$M^0_{Rd,s}$	[Nm]	15.2	29.6	52	132.8	259.2	448	666.4	898.4
8.8	Yield strength	f_y	[N/mm²]	640	640	640	640	640	640	640	640
	Tensile strength	f_u	[N/mm²]	800	800	800	800	800	800	800	800
	Design bending moment	$M^0_{Rd,s}$	[Nm]	24.0	48.0	84.0	212.8	415.2	716.8	1066.4	1437.6
A4-50	Yield strength	f_y	[N/mm²]	210	210	210	210	210	210	210	210
	Tensile strength	f_u	[N/mm²]	500	500	500	500	500	500	500	500
	Design bending moment	$M^0_{Rd,s}$	[Nm]	8.0	15.5	27.7	70.2	136.6	235.7	349.6	472.7
A4-70	Yield strength	f_y	[N/mm²]	450	450	450	450	450	450	-	-
	Tensile strength	f_u	[N/mm²]	700	700	700	700	700	700	-	-
	Design bending moment	$M^0_{Rd,s}$	[Nm]	16.7	33.3	59.0	148.7	291.0	502.6	-	-

Material specifications

Part	Designation	Material				
Steel, zinc plated (Steel acc. to EN 10087:1998 or EN 10263:2001)						
- zinc plated	≥ 5 µm	acc. to EN ISO 4042:1999				
- hot-dip galvanized	≥ 40 µm	acc. to EN ISO 1461:2009 and EN ISO 10684:2004+AC:2009				
- sherardized	≥ 45 µm	acc. to EN ISO 17668:2016				
1	Anchor rod	Property class		Characteristic tensile strength	Characteristic yield strength	Elongation at fracture
		acc. to EN ISO 898-1:2013	4.6	$f_{uk} = 400\ N/mm^2$	$f_{yk} = 240\ N/mm^2$	A5 > 8%
			4.8	$f_{uk} = 400\ N/mm^2$	$f_{yk} = 320\ N/mm^2$	A5 > 8%
			5.6	$f_{uk} = 500\ N/mm^2$	$f_{yk} = 300\ N/mm^2$	A5 > 8%
			5.8	$f_{uk} = 500\ N/mm^2$	$f_{yk} = 400\ N/mm^2$	A5 > 8%
			8.8	$f_{uk} = 800\ N/mm^2$	$f_{yk} = 640\ N/mm^2$	A5 > 12% [3)]
2	Hexagon nut	acc. to EN ISO 898-2:2012	4	for anchor rod class 4.6 or 4.8		
			5	for anchor rod class 5.6 or 5.8		
			8	for anchor rod class 8.8		
3a	Washer	Steel, zinc plated, hot-dip galvanized or sherardized (e.g.: EN ISO 887:2006, EN ISO 7089:2000, EN ISO 7093:2000, or EN ISO 7094:2000)				
3b	Filling washer	Steel, zinc plated, hot-dip galvanized or sherardized				
4	Internal threaded anchor rod	Property class		Characteristic tensile strength	Characteristic yield strength	Elongation at fracture
		acc. to EN ISO 898-1:2013	5.8	$f_{uk} = 500\ N/mm^2$	$f_{yk} = 400\ N/mm^2$	A5 > 8%
			8.8	$f_{uk} = 800\ N/mm^2$	$f_{yk} = 640\ N/mm^2$	A5 > 8%

WIT-PE 510 WITH THREADED ROD (METRIC)

Part	Designation	Material				
Stainless steel A2 (Material 1.4301 / 1.4303 / 1.4307 / 1.4567 or 1.4541, acc. to EN 1088-1:2014) **Stainless steel A4** (Material 1.4401 / 1.4404 / 1.4571 / 1.4362 or 1.4578, acc. to EN 10088-1:2014) **High corrosion resistance steel** (Material 1.4529 or 1.4565, acc. to EN 10088-1:2014)						
1	Anchor rod [1,4]	Property class		Characteristic tensile strength	Characteristic yield strength	Elongation at fracture
		acc. to EN ISO 3506-1:2009	50	f_{uk} = 400 N/mm^2	f_{yk} = 240 N/mm^2	A5 > 12% [3]
			70	f_{uk} = 400 N/mm^2	f_{yk} = 320 N/mm^2	A5 > 12% [3]
			80	f_{uk} = 500 N/mm^2	f_{yk} = 300 N/mm^2	A5 > 12% [3]
2	Hexagon nut [1,4]	acc. to EN ISO 3506-1:2009	50	for anchor rod class 50		
			70	for anchor rod class 70		
			80	for anchor rod class 80		
3a	Washer	Stainless steel A2 (Material 1.4301 / 1.4303 / 1.4307 / 1.4567 or 1.4541, acc. to EN 1088-1:2014) Stainless steel A4 (Material 1.4401 / 1.4404 / 1.4571 / 1.4362 or 1.4578, acc. to EN 10088-1:2014) HCR: Material 1.4529 or 1.4565, acc. to EN 10088-1:2014 (e.g.: EN ISO 887:2006, EN ISO 7089:2000, EN ISO 7093:2000, or EN ISO 7094:2000)				
3b	Filling washer	Stainless steel A4. High corrosion resistance steel				
4	Internal threaded anchor rod [1,2]	Property class		Characteristic tensile strength	Characteristic yield strength	Elongation at fracture
		acc. to EN ISO 3506-1:2009	50	f_{uk} = 500 N/mm^2	f_{yk} = 210 N/mm^2	A5 > 8%
			70	f_{uk} = 700 N/mm^2	f_{yk} = 450 N/mm^2	A5 > 8%

1) Property class 70 for anchor rods up to M24 and Internal threaded anchor rods up to IG-M16

2) for IG-M20 only property class 50

3) A_5 > 8% fracture elongation if no requirement for performance category C2 exists

4) Property class 80 only for stainless steel A4

Working and curing times

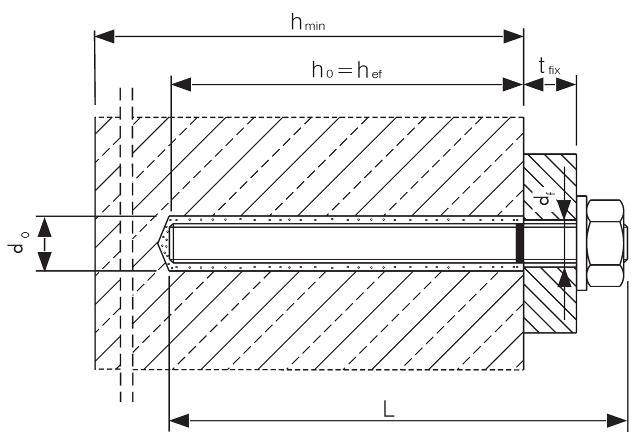
Temperature of base material	Gelling – working time	Min. curing time – dry conditions[1]
5°C to 9°C	80 min	60 h
10°C to 14°C	60 min	48 h
15°C to 19°C	40 min	24 h
20°C to 24°C	30 min	12 h
25°C to 34°C	12 min	10 h
35°C to 39°C	8 min	7 h
+40°C	8 min	4 h

[1] for wet base material the curing time must be doubled

Installation parameters

Anchor size			M8	M10	M12	M16	M20	M24	M27	M30
Diameter of element	$d = d_{nom}$	[mm]	8	10	12	16	20	24	27	30
Nominal drill hole diameter	d_0	[mm]	10	12	14	18	22	28	30	35
Effective anchorage depth	$h_{ef,min}$	[mm]	60	60	70	80	90	96	108	120
	$h_{ef,max}$	[mm]	160	200	240	320	400	480	540	600
Diameter of clearance in hole in the fixture	Prepositioned installation $d_f \leq$	[mm]	9	12	14	18	22	26	30	33
	Push through installation df	[mm]	12	14	16	20	24	30	33	40
Maximum torque moment	max $T_{inst} \leq$	[Nm]	10	20	40 [1]	60	100	170	250	300
Minimum thickness of member	h_{min}	[mm]	h_{ef} + 30 mm ≥ 100 mm			$h_{ef} + 2d_0$				
Minimum spacing	s_{min}	[mm]	40	50	60	75	95	115	125	140
Minimum edge distance	c_{min}	[mm]	35	40	45	50	60	65	75	80

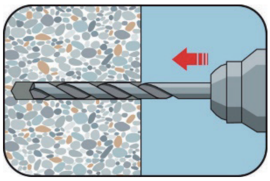
[1] Maximum torque moment for M12 with steel Grade 4.6 is 35 Nm



WIT-PE 510 WITH THREADED ROD (METRIC)

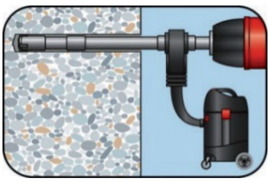
Installation instructions

A) Bore hole drilling



1a. Hammer (HD) or compressed air drilling (CD)

Drill a hole into the base material to the size and embedment depth required by the selected reinforcing bar. Proceed with Step B1.
In case of aborted drill hole, the drill hole shall be filled with mortar.



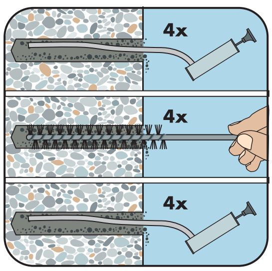
1b. Hollow drill bit system (HDB)

Drill a hole into the base material to the size and embedment depth required by the selected reinforcing bar. This drilling system removes the dust and cleans the bore hole during drilling (all conditions). Proceed with Step C.
In case of aborted drill hole, the drill hole shall be filled with mortar.

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

B1) Bore hole cleaning

MAC: Cleaning for dry and wet bore holes with diameter d0 ≤ 20 mm and bore hole depth h ≤ 10 dnom (non-cracked concrete only!)



2a. Starting from the bottom or back of the bore hole, blow the hole clean with a hand pump a minimum of four times until return air stream is free of noticeable dust.

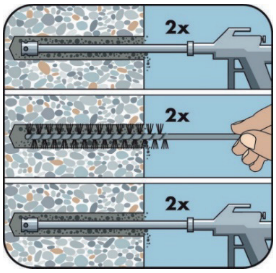
2b. Check brush diameter. Brush the hole with an appropriate sized wire brush > $d_{b,min}$ a minimum of four times in a twisting motion. If the bore hole ground is not reached with the brush, a brush extension shall be used.

2c. Finally blow the hole clean again with a hand pump a minimum of four times until return air stream is free of noticeable dust.

After cleaning, the bore hole has to be protected against re-contamination in an appropriate way until dispensing the mortar in the bore hole. If necessary, the cleaning has to be repeated directly before dispensing the mortar. In-flowing water must no contaminate the bore hole again.

B2) Bore hole cleaning

CAC: Cleaning for dry, wet and water-filled bore holes for all diameters in non-cracked and cracked concrete



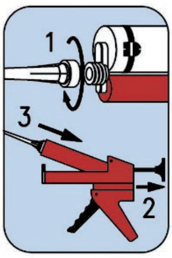
2a. Starting from the bottom or back of the bore hole, blow the hole clean with compressed air (min. 6 bar) a minimum of two times until return air stream is free of noticeable dust. If the bore hole ground is not reached an extension shall be used.

2b. Check brush diameter. Brush the hole with an appropriate sized wire brush > $d_{b,min}$ a minimum of two times. If the bore hole ground is not reached with the brush, a brush extension shall be used.

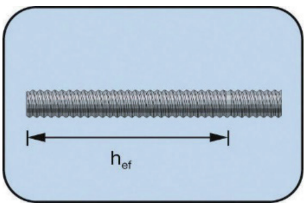
2c. Finally blow the hole clean again with compressed air (min. 6 bar) a minimum of two times until return air stream is free of noticeable dust. If the bore hole ground is not reached, an extension shall be used.

After cleaning, the bore hole has to be protected against re-contamination in an appropriate way until dispensing the mortar in the bore hole. If necessary, the cleaning has to be repeated directly before dispensing the mortar. In-flowing water must no contaminate the bore hole again.

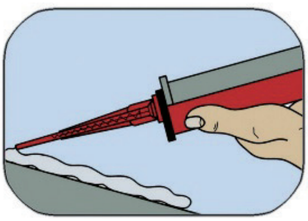
C) Preparation of bar and cartridge



3a. Attach the supplied static-mixing nozzle to the cartridge and load the cartridge into the correct dispensing tool. For every working interruption longer than the recommended working time as well as for every new cartridge, a new static-mixer shall be used.

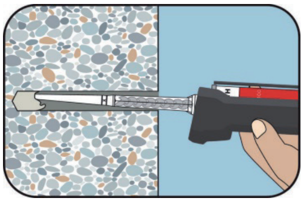
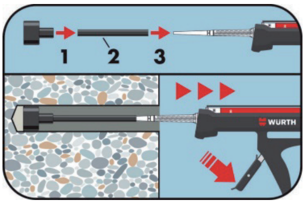
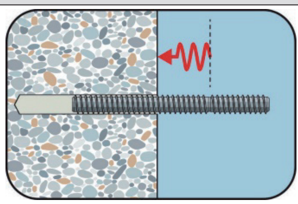
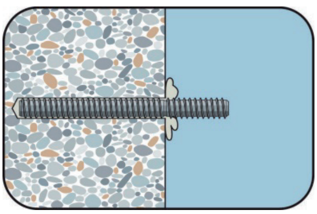
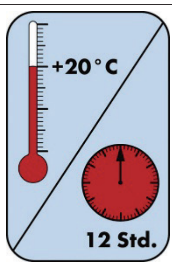
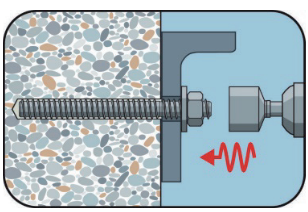


3b. Prior to inserting the anchor rod into the filled bore hole, the position of the embedment depth shall be marked on the anchor rod. After that, insert the rod in the empty hole to verify hole and depth lv. The anchor should be free of dirt, grease, oil and other foreign material.



3c. Prior to dispensing into the bore hole, squeeze out separately the mortar until it shows a consistent grey or red color (minimum of three full strokes) and discard non-uniformly mixed adhesive components.

WIT-PE 510 WITH THREADED ROD (METRIC)

D) Filling the bore hole		
 	**4.**	Starting from the bottom or back of the cleaned bore hole, fill the hole up to approximately two-thirds with adhesive. Slowly withdraw the static mixing nozzle as the hole fills to avoid creating air pockets. If the bottom or back of the anchor hole is not reached, an appropriate extension nozzle must be used. Observe the gel-/working times. Piston plugs and mixer nozzle extensions shall be used for the following applications: • Horizontal assembly (horizontal direction) and ground erection (vertical downwards direction): Drill bit-Ø $d_0 \geq 18$ mm and embedment depth hef > 250 mm • Overhead assembly (vertical upwards direction): Drill bit-Ø $d_0 \geq 18$ mm
E) Setting the rebar		
	**5a.**	Push the anchor rod into the bore hole while turning slightly to ensure positive distribution of the adhesive until the embedment depth is reached. The rod should be free of dirt, grease, oil or other foreign material.
	**5b.**	After inserting the anchor, the annular gap between the anchor rod and concrete, in case of a push through installation, in addition to the fixture, must be completely filled with mortar. Be sure that the anchor rod is inserted in the bore hole until the embedment mark is at the concrete surface and that excess mortar is visible at the top of the hole. If these requirements are not maintained, the application has to be renewed. For overhead installation, fix embedded part (e.g. with wedges).
	**5c.**	Allow the adhesive to cure to the specified time prior to applying any load or torque. Do not move or load the anchor until it is fully cured.
	**5d.**	After full curing, the add-on part can be installed with up to the max. torque by using a calibrated torque wrench. In case of prepositioned installation, the annular gap between the anchor and fixture can be optionally filled with mortar. Therefore, substitute the washer by the filling washer and connect the mixer reduction nozzle to the tip of the mixer. The annular gap is filled with mortar when mortar oozes out of the washer.

Filling quantity

Anchor type: M8 - M30

Anchor size			M8	M10	M12	M16	M20	M24	M27	M30
Nominal drill hole diameter	d_0	[mm]	10	12	14	18	22	28	30	35
Drill depth	h_0 / h_1	[mm]	= h_{ef}							
Filling volume per 10mm embedment depth		[ml]	0.53	0.70	0.89	1.27	1.78	3.35	3.22	5.10

Assumed waste of 15 % included.