

## 18.0 FIELD ASSEMBLY OF TAPER GRIP-TWIST DoughNUT TERMINATIONS

**FABRICATOR IS RESPONSIBLE FOR PROVIDING THESE INSTRUCTIONS TO THE PLACER AND/OR CONTRACTOR.**

These instructions only pertain to the field assembly of Termination Heads to Male Taper Threaded Grip-Twist couplers. If the fabricator has pre-assembled the heads to the couplers, then except for inspection (step 4) these instructions do not apply.

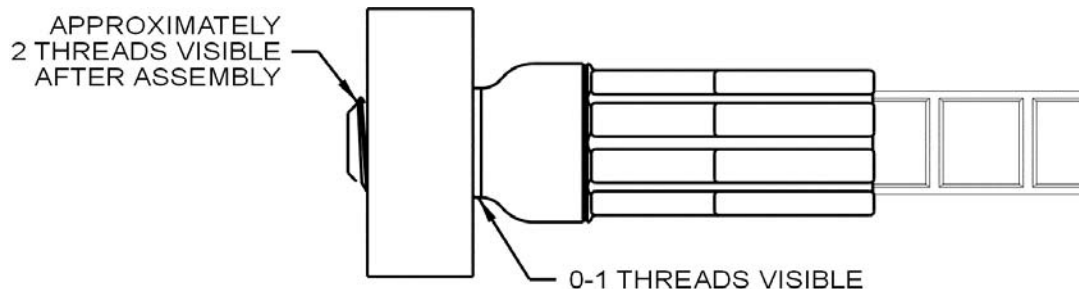
Male threads are protected by color-coded plastic caps, which should be kept in place until the time of assembly. If missing, **obtain the correct caps** from the manufacturer. If you see minor external **thread damage**, try using a thread file to correct the problem. For other thread damage, it may be necessary to use a thread cleaner tool. **DO NOT TRY TO ASSEMBLE DAMAGED THREADS.** You may cause premature binding. Care must be taken to install the proper size rebar and Termination unit in the correct location. Note: All Male couplers are marked with rebar size and material code. **DO NOT USE THIS TERMINATION IN CONJUNCTION WITH A REBAR WHICH IS LARGER OR SMALLER THAN THE INTENDED BAR SIZE. STORE TERMINATION HEADS AND MALE COUPLERS IN A CLEAN, DRY PLACE UNTIL READY TO INSTALL.**

1 When attaching the Termination Head to the Male coupler, first remove the protective cap and then locate the head over the male thread.

Just before assembly, check both internal and external threads for cleanliness. Clean off any foreign matter. **DO NOT USE CORROSIVE ACIDS.** Any thread damage must be corrected as noted above before installation.

2 Rotate the Termination Head clockwise by hand. If you feel the threads starting to prematurely bind, **DO NOT FORCE THEM. ASSEMBLE UNTIL THE THREADS OF THE TERMINATION HEAD ARE FULLY ENGAGED ONTO THE MALE COUPLER.** Usually, this takes 4 to 5 turns.

### ASSEMBLED CONNECTION



*If the threads of the Termination Head do not properly engage onto the male coupler during assembly, stop immediately. Disassemble the connection to determine the problem. Possible causes of mis-assembly may be either mis-matched thread sizes, or threads are contaminated with (ex.) concrete, dirt, or threads have been damaged. Re-assemble only after the problem has been identified and corrected.*

3 To be certain that the threads have been fully engaged and to be assured the head will not loosen, use a chain wrench or pipe wrench to snug and tighten the Termination Head onto the taper Male coupler. Always consider your own **personal safety**. Make sure you are securely positioned and that you will not slip or fall during installation. Use only good quality wrenches that will not round-out.

4 Inspect the Termination unit for proper swaged length and thread engagement. For taper threads, some variation in the number of exposed threads is natural due to thread tolerance build-up and thread run-out. In general, it is usual to see 0 to 1 threads after full assembly as shown above. Fully assembled taper threads can be double-checked by the application of a chain or pipe wrench as described above. **IT IS NOT NECESSARY TO USE A TORQUE WRENCH OR APPLY A HIGH TORQUE VALUE.**

Please direct all assembly questions to BarSplice Products, Inc. (937) 275-8700.