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Prior to following the instructions below, verify that this document is the latest version in use. The latest version can be found at www.barsplice.com.

INSTALLATION INSTRUCTIONS FOR FIELD ASSEMBLY OF BPI® BARSPLICER DOUGHNUT™ HEADED DEVICES ON BPI® THREADED REINFORCEMENT BAR

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

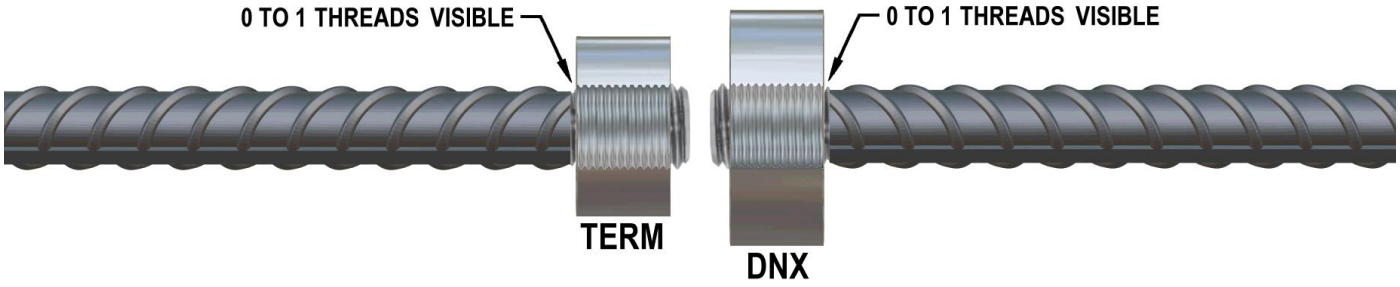
If the fabricator has pre-assembled the heads to the threaded bar, these instructions do not apply except for their inspection in step 4.

External rebar threads are protected by plastic caps which should be kept in place until time of assembly. If missing, obtain the correct caps from the manufacturer. If thread damage is discovered, it must be corrected before assembly to avoid premature binding. Minor thread damage can be fixed using a thread file, or a thread cleaning tool. For other thread damage, it may be necessary to use a thread die tool. DO NOT TRY TO ASSEMBLE DAMAGED THREADS. All DOUGHNUT headed devices are marked with the intended rebar size. DO NOT USE WITH REBAR THAT IS LARGER OR SMALLER THAN THE INTENDED BAR SIZE, OR WITH REBAR THREADS OTHER THAN UNIFIED NATIONAL COURSE (UNC). STORE DOUGHNUT HEADED DEVICES AND BPI® THREADED BAR IN A CLEAN, DRY PLACE UNTIL READY TO INSTALL.

1) Remove the protective cap from threaded rebar and check both external (rebar) and internal (DOUGHNUT) threads for cleanliness. Clean off any debris and/or foreign matter. **DO NOT USE CORROSIVE ACIDS**. Any thread damage must be corrected as noted above prior to installation.

2) Locate the DOUGHNUT headed device over the threaded rebar and rotate clockwise by hand. If you feel the threads starting to prematurely bind, **DO NOT FORCE THEM**. Continue to rotate until FULLY ENGAGED and SNUG on the threaded bar end. See **FIGURE 1** for assembled connection.

FIGURE 1: ASSEMBLED CONNECTION



NOTE: If the DOUGHNUT threads do not properly engage the rebar threads during assembly, stop immediately. Disassemble the connection to determine the problem. Possible causes of mis-assembly may be mis-matched thread sizes, contaminated threads (i.e. concrete, dirt, etc.) or damaged threads. Re-assemble only after the problem has been identified and corrected.

3) A chain wrench or pipe wrench can be used to snug and tighten the DOUGHNUT headed device onto the threaded rebar as needed. Always consider your own **personal safety**. Make sure you are securely positioned and that you will not slip or fall during installation.

4) After assembly, inspect for proper thread engagement of the DOUGHNUT. For Barsplicer threads, some variation in the number of exposed threads is natural due to the thread tolerance and run-out. In general, it is typical to see 0 to 1 complete thread(s) on the bearing face side after full assembly, per **FIGURE 1**. If needed, fully assembled threads can be double-checked using a chain wrench or pipe wrench as described above, to ensure the head is snug. **IT IS NOT NECESSARY TO USE A TORQUE WRENCH OR APPLY A HIGH TORQUE VALUE.**

5) When installing epoxy coated DOUGHNUT heads on epoxy coated rebar, touch-up any exposed or damaged areas, and seal off the rebar threads at the points of entry into the DOUGHNUT, using epoxy repair kit. When installing galvanized DOUGHNUT heads on galvanized rebar, touch-up any exposed or damaged areas, and seal off the rebar threads at the points of entry into the DOUGHNUT, using a zinc-rich cold galvanizing paint.

Please direct all assembly questions to BarSplice Products, Inc.