

INSTALLATION INSTRUCTIONS FOR FIELD ASSEMBLY OF BPI® BARSPLICER DoughNUT HEADS ON GRADE 60 THREADED REBARS [U.S. METRIC GRADE 420]

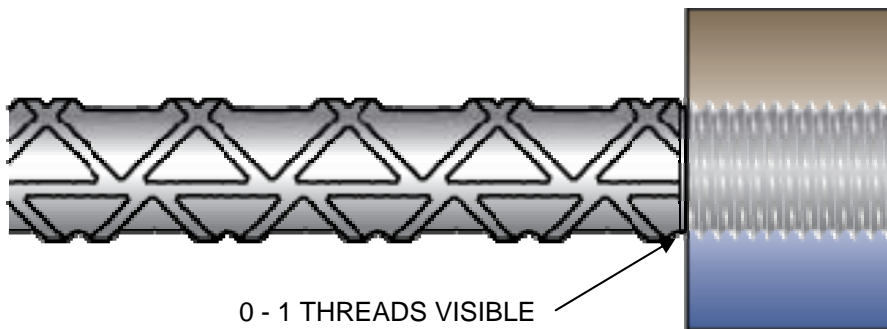
External rebar threads are protected by plastic caps which should be kept in place until the time of assembly. If missing, **obtain the correct caps** from the manufacturer or supplier. If you see minor external **thread damage**, try using a thread file to correct the problem. For other thread damage, it may be necessary to use a thread die tool. **DO NOT TRY TO ASSEMBLE DAMAGED THREADS.** You may cause premature binding. **DO NOT USE THIS DoughNUT HEAD IN CONJUNCTION WITH A REBAR WHICH IS LARGER OR SMALLER THAN THE INTENDED BAR SIZE. DO NOT USE WITH ANYTHING OTHER THAN UNIFIED NATIONAL COURSE (UNC) THREADS.** STORE DoughNUT HEADS IN A CLEAN, DRY PLACE UNTIL READY TO INSTALL.

- 1 When attaching the DoughNUT Head to the threaded rebar, remove the protective caps and then locate the head over the threaded bar end.

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 DoughNUT Head clockwise by hand. NOTE: If you feel the threads starting to prematurely bind, **DO NOT FORCE THEM. ASSEMBLE UNTIL THE THREADS OF THE DoughNUT HEAD ARE FULLY ENGAGED ONTO THE THREADED BAR END.**

ASSEMBLED CONNECTION



If the threaded rebar end does not properly engage into the Barsplicer DoughNUT Head during assembly, stop immediately. Disassemble 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. Reassemble 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 pipe wrench or chain wrench to snug and tighten the DoughNUT Head onto the bar end. **DO NOT WIRE TIE BARS UNTIL AFTER FULL ASSEMBLY.** In all cases, consider your own **personal safety**. Make sure you are securely positioned and that you will not slip or fall during installation.
- 4 Inspect the Headed assembly for proper thread engagement. For Barsplicer 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 threads can be double-checked by the application of a pipe wrench as described above. **IT IS NOT NECESSARY TO USE A TORQUE WRENCH OR APPLY A HIGH TORQUE VALUE.**
- 5 In the case of epoxy coated DoughNUT Heads and rebar, touch-up any damaged areas with an epoxy repair kit. Seal off the rebar at the point of entry of the rebar into the Head using epoxy repair material.

Please direct all assembly questions to BarSplice Products, Inc.