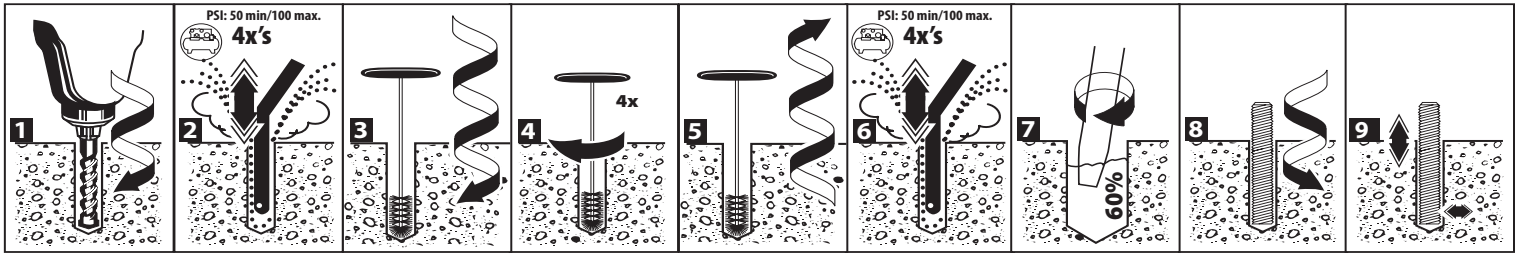


C6 Adhesive Anchor Installation Instructions



- 1** • Use a rotary hammer drill or pneumatic air drilling machine with a drill bit complying with ANSI B212.15.1994 tolerance standards.
 - Drill depth is a minimum four times rod diameter thru maximum nine times rod diameter.
 - Use a drill bit equal to the rod diameter plus 1/16 inch (for 3/8 inch ϕ and 1/2 inch ϕ) and 1/8" (for 5/8 inch ϕ and above).
 - The 3/8 inch ϕ and 1/2 inch ϕ are acceptable for overhead, horizontal, and floor installation direction. The 5/8 inch ϕ and larger permitted for horizontal and floor installation direction only. Use hole plug E038 or E012 for overhead only.
 - Per construction specification, adhere to minimum spacing, minimum edge distance, and minimum member thickness.
- 2** • Oscillate a clean air nozzle in and out of the hole four times, for a total of four seconds, starting at the bottom, with contaminant free compressed air exhausting hole until visually clean (i.e., no trace oils, antifreeze, et cetera).
 - If hole is water filled or contains sludge/debris; the hole can be cleaned with pressured water for optimum cleaning method versus compressed air.
- 3** • Select and insert an appropriately sized Red Head wire brush from part no. SB038, SB012, SB058, SB034, SB078, SB010, SB125, or match color to anchor diameter. See chart on back page.
 - Insert brush into the hole with a clockwise motion, while completing one full turn for every 1/2" forward advancement further until bottom is reached. For faster and more suitable cleaning, attach the brush to a drill.
- 4** • Twist/Spin the brush four full turns at bottom of the hole.
- 5** • Using a clockwise motion, for every full turn of the brush, pull the brush 1/2" out of the hole.
 - Air clean the dust (or water clean the slurry) off the brush to prevent clogging of brush.
- 6** • Oscillate clean air nozzle in and out of the hole four times, for a total of four seconds, starting at the bottom with contaminant free compressed air exhausting hole until visually clean.
 - Leave no dust, slurry, or ice in the hole.
- 7** • Assemble Red Head supplied cartridge and nozzle.
 - Place assembly into a hand, battery, or pneumatic injection tool. Dispense mixed adhesive outside of hole until uniform color is achieved.
 - Insert the nozzle tip to the far end of the hole, inject the adhesive at an angle from the bottom into the hole and leave the nozzle tip always slightly below the fill level. In a slow circular direction, work the adhesive into the side of the hole, filling slowly to prevent air entrapment, until the hole is filled 60% full.
- 8** • Insert an oil, rust, and scale free rod to the bottom of hole with a counterclockwise motion to prevent air entrapment.
 - Install rod into adhesive-filled hole without delay.
 - Ensure that the adhesive fills voids, crevices and uniformly coats rod and concrete to the bottom of hole.
 - After installing the anchor, the gap between the rod and the concrete must be completely filled with adhesive.
 - If the working time has not expired, the rod can be removed from the under-filled holes and additional adhesives can be injected into the hole. Otherwise the installation shall be rejected. For flush application, trowel off excess.
- 9** • Jiggle rod slightly, immediately after installation, and do not disturb during working time table.
 - See table 1 for cure time.

TABLE 1: SPECIFICATIONS AND DETAILS FOR INSTALLATION OF ANCHORS IN CONCRETE WITH

EPCON C6 ADHESIVE

Property	Threaded Rod Diameter (d)															
	3/8"		1/2"		5/8"		3/4"		7/8"		1"		1-1/4"			
Tensile stress area of rod (in ²)	A_{se}		0.078		.142		.226		.335		.462		.606		.969	
Nominal carbide bit diameter size (in.)	d₀		7/16		9/16		3/4		7/8		1		1-1/8		1-3/8	
Effective embedment depth (in.)	h_{ef} min/max		1-1/2 3-3/8		2 4-1/2		2-1/2 5-5/8		3 6-3/4		3-1/2 7-7/8		4 9		5 11-1/4	
Min./Max. Hole depth (in.)	h₀ min/max		1-11/16 3-9/16		2-3/16 4-11/16		2-11/16 5-13/16		3-3/16 6-15/16		3-3/4 8-1/8		4-1/8 9-1/4		5-1/4 11-1/2	
Minimum Slab thickness (in.)	h_{min}		4 5		4 6		4 7		5 8		8 10		6 11		8 13	
Maximum Tightening Torque for pretension (Clamping) (ft-lb)	T_{inst}		13		22		55		106		156		276		370	

For SI: 1 inch= 25.4mm, 1 lbf= 4.45N, 1ft-lbf=1.356N-m, 1psi= .006895MPa

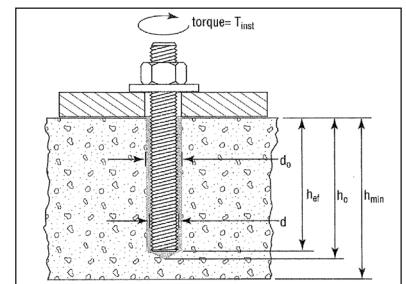
1 Adhesives must be installed in substrates at temperatures of at least 15°F to 150°F.

For Installations in substrates at temperatures below 15°F or above 150°F the substrates must be conditioned to proper temperatures during working time.

2 Working time is the maximum time from the end of mixing to when the insertion of the anchor into the adhesive shall be completed.

3 Cure time is the minimum time from the end of working time to when the anchor may be torque or loaded. Anchors are to be undisturbed during the cure time.

ANCHOR INSTALLATION

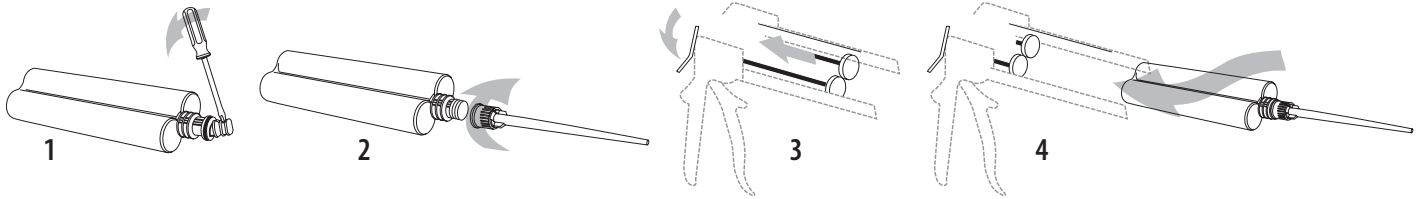


BASE MATERIAL ¹ (F°/C°)	WORKING TIME ²	FULL CURE TIME
120°/ 49°	4 minutes	1 hour
110°/ 43°	4 minutes	1 hour
90°/ 32°	5 minutes	1 hour
80°/ 26°	6 minutes	1 hour
70°/ 21°	7 minutes	1 hour
60°/ 16°	7 minutes	2 hours
50°/ 10°	7 minutes	2 hours
40°/ 4°	7 minutes	24 hours
15°/ -9°	6 minutes	24 hours

¹ Cartridge must be equal to 70° F or greater.

² Working time is the maximum time required to complete the insertion of the anchor into the mixed adhesive.

TABLE 2: Assembly instructions / TABLA 2: Instrucciones de ensamblado / TABLEAU 2 : Instructions d'assemblage



Assembly Instructions

1. For C6-18: Snap off cartridge tip.
2. Thread nozzle assembly onto cartridge.
3. Release lever and pull back pistons on the Epcon Manual Injection Tool. For Pneumatic or Battery Powered Tool, retract the pistons back.
4. Insert cartridge into bracket of Injection Tool. Cartridge to be parallel with pistons during use.

Instrucciones de ensamblado

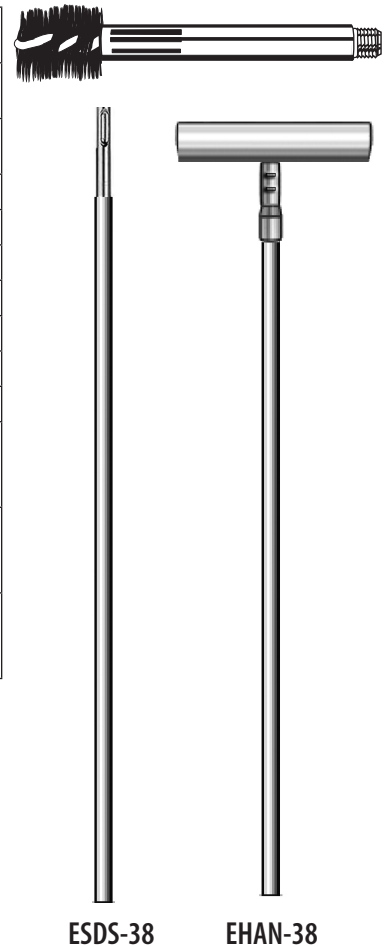
1. Para C6-18: Desprenda la punta del cartucho.
2. Enrosque el conjunto de la boquilla en el cartucho.
3. Suelte la palanca y tire hacia atrás los pistones en la herramienta de inyección manual del sistema Epcon. Para una herramienta neumática o a baterías, retraiga los pistones.
4. Inserte el cartucho en el soporte de la herramienta de inyección. El cartucho debe estar paralelo a los pistones al usar la herramienta.

Instructions d'assemblage

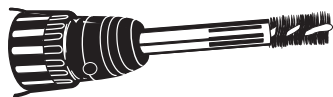
1. Pour C6-18 : Casser l'embout de la cartouche.
2. Visser l'ensemble de buse sur la cartouche.
3. Relâcher le levier et tirer les pistons de l'outil d'injection manuelle Epcon vers l'arrière. En ce qui concerne l'outil pneumatique ou à piles, rétracter les pistons vers l'arrière.
4. Insérer la cartouche dans le support de l'outil d'injection. La cartouche doit être parallèle aux pistons durant l'usage.

TABLE 3: Brush Specifications* / TABLA 3: Especificaciones del cepillo / TABLEAU 3 : Spécifications de la brosse*

Brush Color	Part No.	Threaded Anchor Diameter (in)	Rebar	Drill Bit Diameter (in)	Brush Diameter (in)
Color del cepillo	N.º de parte	Diámetro del anclaje roscado (pulg.)	Varilla reforzada	Diámetro de la broca (pulg.)	Diámetro del cepillo (pulg.)
Couleur de la brosse	Nº de pièce	Diamètre de l'ancrage fileté (po)	Barre d'armature	Diamètre du foret (po)	Diamètre de la brosse (po)
Grey / Gris / Grise	SB038	3/8	No. 3	7/16	5/8
Brown / Café / Brune	SB012	1/2	—	9/16	3/4
Green / Verde / Verte	SB058	5/8	No. 5	3/4	1
Yellow / Amarillo / Jaune	SB034	3/4	No. 6	7/8	1-1/4
Red / Rojo / Rouge	SB078	7/8	—	1	1-1/2
Purple / Morado / Violette	SB010	1	No. 7	1-1/8	1-5/8
Blue / Azul / Bleue	SB125	1-1/4	—	1-3/8	1-3/4
Part No. N.º de parte Nº de pièce	Description (Extensions come without brushes) Descripción (las extensiones vienen sin cepillos) Description (les rallonges sont offertes sans brosse)				
ESDS-38	Wire brush 12" usable extension with SDS+ adaptor Extensión útil de 12" de cepillo de alambre con adaptador SDS+ Rallonge utilisable de 12 po de brosse en acier avec adaptateur SDS+				
EHAN-38	Wire brush 12" usable extension with T-Handle Extensión útil de 12" de cepillo de alambre con mango en T Rallonge utilisable de 12 po de brosse en acier avec poignée en T				



- * Proper hole cleaning using a wire brush is essential to achieve optimum performance. Brush may be used up to 50 holes depending on concrete strength. Brushes required for installation of No. 4, No. 8 rebar and larger are available with lead time.
- * La limpieza adecuada del agujero usando un cepillo de alambre es esencial para lograr un desempeño óptimo. El cepillo se puede usar hasta para 50 agujeros, dependiendo de la resistencia del concreto. Los cepillos necesarios para la instalación de barra reforzada N.º 4, 8 y más grandes, se pueden obtener con un plazo de entrega.
- * Un nettoyage adéquat du trou à l'aide d'une brosse métallique est essentiel à l'obtention d'une performance optimale. La brosse peut servir au nettoyage d'un nombre allant jusqu'à 50 trous suivant la résistance du béton. Les brosses nécessaires pour l'installation des barres n° 4, n° 8 et au-dessus sont disponibles avec un délai de fabrication.



For faster & easier hole-cleaning use the Red Head Brush in a drill

1. Use Table 3 to ensure that the proper brush is used for the hole/drill bit diameter.
2. Insert the brush into the drill and tighten.
3. Follow steps 3, 4, 5, & 6 from Table 1.

Para limpiar el agujero de manera más rápida y fácil use el cepillo Red Head Brush en un taladro

1. Use la Tabla 3 para asegurarse de que se use el cepillo adecuado para el diámetro del agujero y la broca.
2. Inserte el cepillo en el taladro y ajuste.
3. Siga los pasos 3, 4, 5 y 6 de la Tabla 1.

Pour un nettoyage de trou plus rapide et plus facile, utiliser la brosse Red Head avec une perceuse

1. Se reporter au Tableau 3 pour s'assurer d'utiliser la brosse appropriée pour le diamètre du trou/foret.
2. Insérer la brosse dans la perceuse et serrer.
3. Suivre les étapes 3, 4, 5 et 6 indiquées au Tableau 1.