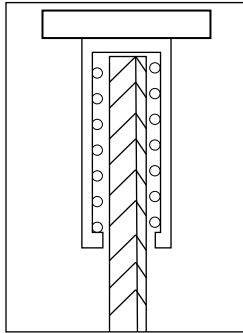
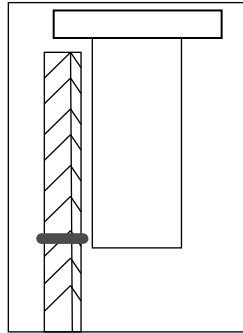


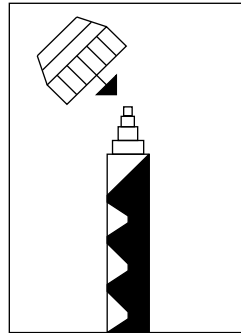
Installation Procedures for HRC 652 Coupler onto existing bars



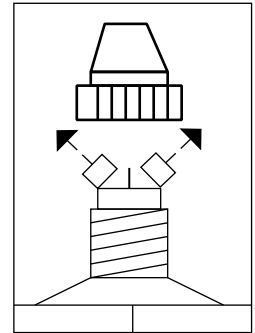
1. Fit coupler over existing rebar. Grind end and/or longitudinal ribs if necessary to insure fit.



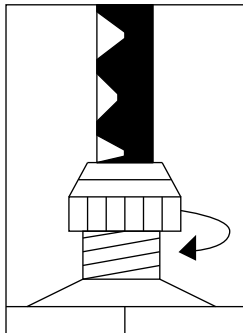
2. Hold coupler against rebar, with rebar end against the head, and mark the length of rebar which will be embedded with an o-ring or marker.



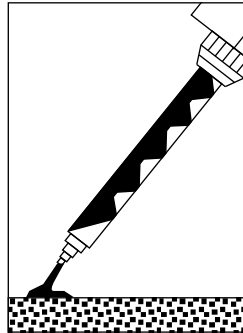
3. Use only HRC 601 or USP CIA-Gel 7000 epoxy. On the epoxy injector place retaining nut over mixing nozzle.



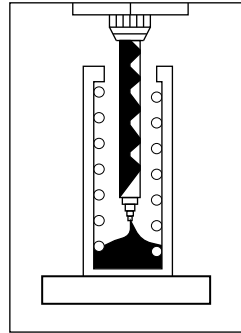
4. Be sure mixing elements are in mixing nozzle. Remove cap and D-shaped plugs.



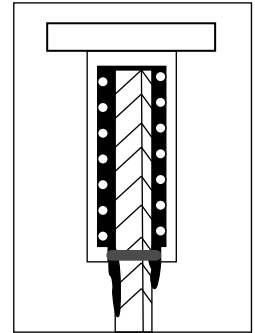
5. Place mixing nozzle and retaining nut over cartridge opening and tighten. Place cartridge into injection tool.



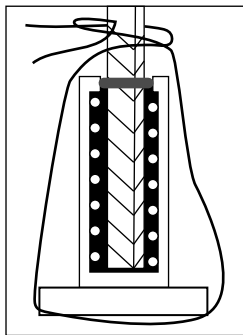
6. Discard a portion of adhesive until proper mixing is achieved. Blended epoxy should be consistent gray color. Do not use epoxy which is not blended.



7. Inject epoxy starting from bottom of coupler and slowly withdraw to avoid air pockets. Fill to 3/4 capacity of coupler.



8. Slowly push coupler onto existing rebar so that the mark is at the end of the coupler thus insuring proper embedment.



9. For certain applications support or tie-wire should be used to hold the embedment position during bolt-up time.

Temp (°F)	Bolt-up Time (hrs)
40 - 50	12
51 - 60	8
61 - 70	6
71 - 80	4
>80	4

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