

DECLARATION OF PERFORMANCE No 51/SZ/15

1. Unique identification code of the product-type: **WCF-EASF, WCF-EASF-E**

2. Intended use/es:

Product	Intended use
Resin for post-installed rebar connections	System for post-installed rebar connection with mortar for use in concrete, see appendix , especially Annexes B1 to B9

3. Manufacturer: **KLIMAS Sp. z o.o.
ul. Wincentego Witosa 135/137
Kuźnica Kiedrzyńska 42-233 Mykanów**

4. Authorised representative: **not applicable**

5. System/s of AVCP: **System 1**

6. European Assessment Document: **a) The guidelines EAD – ETAG 001, Part 1 and Part 5, edition 2013
b) European Technical Assessments – ETA-15/0703 of 22/10/2015
c) TECHNICKÝ A ZKUSEBNÍ ÚSTAV STAVEBNÍ PRAHA s.p.
d) Identification number of notified body– 1020**

7. Declared performance/s:

Mechanical resistance and stability (BWR 1)

Essential characteristic	Performance
Design values of the ultimate bond resistance	See appendix , especially Annex C1

Safety in case of fire (BWR 2)

Essential characteristic	Performance
Reaction to fire	Anchorage satisfy requirements for Class A1
Resistance to fire	No performance assessed

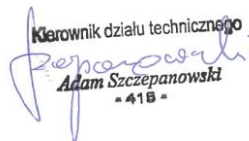
8. Appropriate Technical Documentation and/or Specific Technical Documentation: **not applicable**

The performance of the product identified above is in conformity with the set of declared performance/s. This declaration of performance is issued, in accordance with Regulation (EU) No 305/2011, under the sole responsibility of the manufacturer identified above.

Signed for and on behalf of the manufacturer by:

*Kuźnica Kiedrzyńska
23.11.2016r.
(place and date of issue)*

Adam Szczepanowski



(signature)

*This declaration replaces the declaration from
23.11.2015.*

This DoP has been prepared in different languages. In case there is a dispute on the interpretation the english version shall always prevail.

The Appendix includes voluntary and complementary information in English language exceeding the (language-neutrally specified) legal requirements.

1. Technical description of the product

The WCF-EASF and WCF-EASF-E (extended curing time) injection system is used for the connection, by anchoring or overlap joint, of reinforcing bars (rebars) in existing structures made of normal weight concrete. The design of the post-installed rebar connections is done in accordance with the regulations for reinforced concrete constructions.

Reinforcing bars made of steel with a diameter d from 8 to 25 mm and WCF-EASF, WCF-EASF-E chemical mortar are used for rebar connections. The steel element is placed into a drilled hole filled with injection mortar and is anchored via the bond between embedded element, injection mortar and concrete.

The illustration and the description of the product are given in Annex A.

2. Specification of the intended use in accordance with the applicable EAD

The performances given in Section 3 are only valid if the anchor is used in compliance with the specifications and conditions given in Annex B.

The provisions made in this European Technical Assessment are based on an assumed working life of the anchor of 50 years. The indications given on the working life cannot be interpreted as a guarantee given by the producer, but are to be regarded only as a means for choosing the products in relation to the expected economically reasonable working life of the works.

3. Performance of the product and references to the methods used for its assessment

3.1 Mechanical resistance and stability (BWR 1)

Essential characteristic	Performance
Design values of the ultimate bond resistance	See Annex C 1

3.2 Safety in case of fire (BWR 2)

Essential characteristic	Performance
Reaction to fire	Anchorage satisfy requirements for Class A1
Resistance to fire	No performance assessed

3.3 Hygiene, health and environment (BWR 3)

Regarding dangerous substances contained in this European Technical Assessment, there may be requirements applicable to the products falling within its scope (e.g. transposed European legislation and national laws, regulations and administrative provisions). In order to meet the provisions of the Regulation (EU) No 305/2011, these requirements need also to be complied with, when and where they apply.

3.4 Safety in use (BWR 4)

For basic requirement safety in use the same criteria are valid as for Basic Requirement Mechanical resistance and stability.

3.5 Sustainable use of natural resources (BWR 7)

For the sustainable use of natural resources no performance was determined for this product.

3.6 General aspects relating to fitness for use

Durability and serviceability are only ensured if the specifications of intended use according to Annex B 1 are kept.

4. Assessment and verification of constancy of performance (AVCP) system applied with reference to its legal base

According to the Decision 96/582/EC of the European Commission¹ the system of assessment verification of constancy of performance (see Annex V to Regulation (EU) No 305/2011) given in the following table apply.

Product	Intended use	Level or class	System
Metal anchors for use in concrete	For fixing and/or supporting concrete structural elements or heavy units such as cladding and suspended ceilings	-	1

5. Technical details necessary for the implementation of the AVCP system, as provided in the applicable EAD

5.1 Tasks of the manufacturer

The manufacturer shall exercise permanent internal control of production. All the elements, requirements and provisions adopted by the manufacturer shall be documented in a systematic manner in the form of written policies and procedures, including records of results performed. This production control system shall ensure that the product is in conformity with this European Technical Assessment.

The manufacturer may only use raw materials stated in the technical documentation of this European Technical Assessment.

The factory production control shall be in accordance with the control plan which is a part of the technical documentation of this European Technical Assessment. The control plan is laid down in the context of the factory production control system operated by the manufacturer and deposited at Technical and Test Institute for Construction Prague.² The results of factory production control shall be recorded and evaluated in accordance with the provisions of the control plan.

The manufacturer shall, on the basis of a contract, involve a body which is notified for the tasks referred to in section 4 in the field of anchors in order to undertake the actions laid down in section 5.2. For this purpose, the control plan referred to in this section and section 5.2 shall be handed over by the manufacturer to the notified body involved.

The manufacturer shall make a declaration of performance, stating that the construction product is in conformity with the provisions of this European Technical Assessment.

¹ Official Journal of the European Communities L 254 of 08.10.1996

² The control plan is a confidential part of the documentation of the European Technical Assessment, but not published together with the ETA and only handed over to the approved body involved in the procedure of AVCP.

5.2 Tasks of the notified bodies

The notified body shall retain the essential points of its actions referred to above and state the results obtained and conclusions drawn in a written report.

The notified certification body involved by the manufacturer shall issue a certificate of constancy of performance of the product stating the conformity with the provisions of this European Technical Assessment.

In cases where the provisions of the European Technical Assessment and its control plan are no longer fulfilled the notified body shall withdraw the certificate of constancy of performance and inform Technical and Test Institute for Construction Prague without delay.

Issued in Prague on 22.10.2015

Figure A1: Overlap joint for rebar connections of slabs and beams

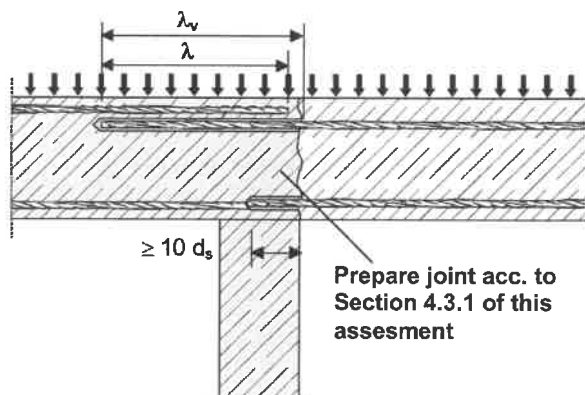


Figure A3: End anchoring of slabs or beams, designed as simply supported

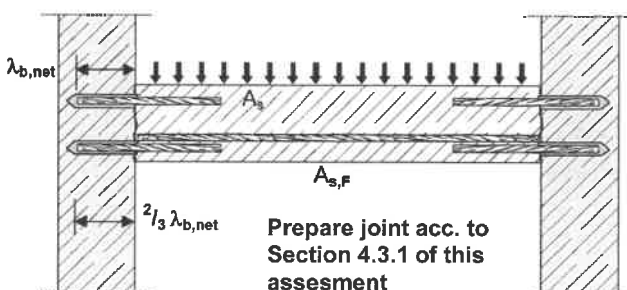


Figure A5: Anchoring of reinforcement to cover the line of acting tensile force

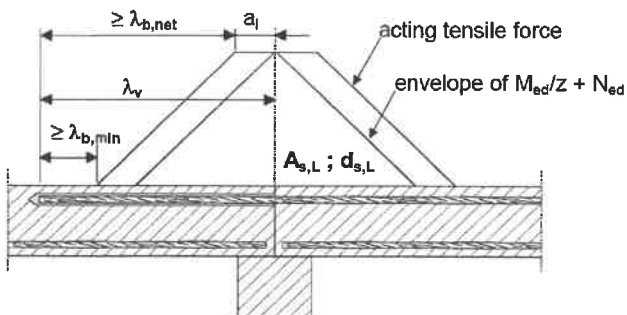


Figure A2: Overlap joint at a foundation of a column or wall where the rebars are stressed in tension

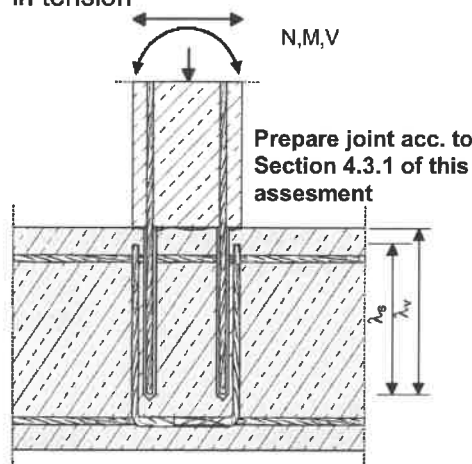
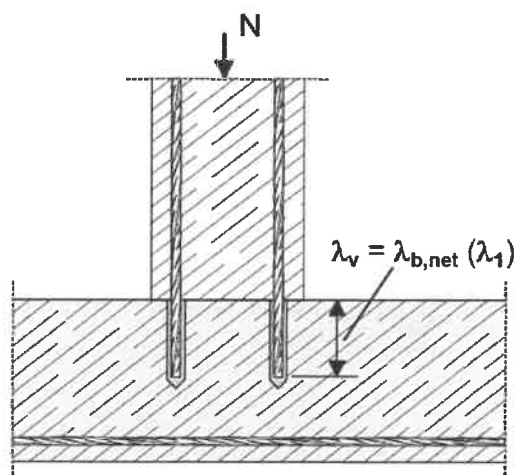


Figure A4: Rebar connection for components stressed primarily in compression. The rebars are stressed in compression.



Note to Figure A1 to A5:

In the Figures no transverse reinforcement is plotted, the transverse reinforcement as required by EC 2 shall be present.

The shear transfer between old and new concrete shall be designed according to EC2.

WCF-EASF, WCF-EASF-E

Product description

Installed condition and examples of use for rebars

Annex A 1

Mortar cartridges

Coaxial cartridge

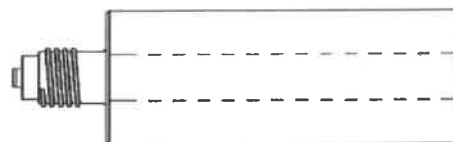
WCF-EASF, WCF-EASF-E

150 ml

380 ml

400 ml

410 ml

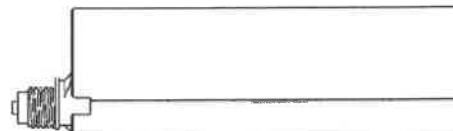


Side by side cartridge

WCF-EASF, WCF-EASF-E

350 ml

825 ml



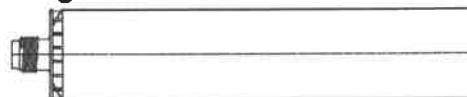
Two part foil in a single piston component cartridge

WCF-EASF, WCF-EASF-E

170 ml

300 ml

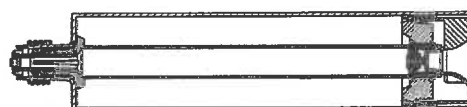
850 ml



Peeler cartridge

WCF-EASF, WCF-EASF-E

280 ml

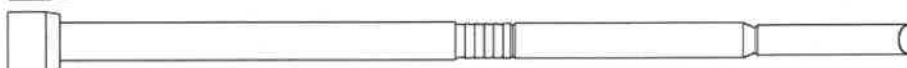


Mixing nozzle

NN

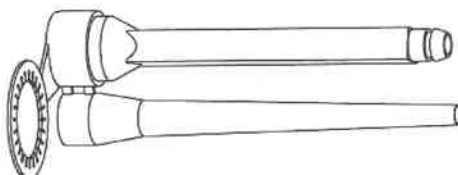


LN



Mixing nozzle TB is recommended for holes depth greater than 400 mm.

SN



WCF-EASF, WCF-EASF-E

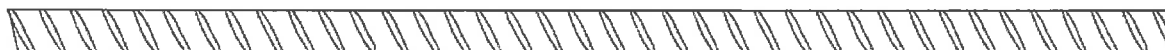
Product description

Injection system

Annex A 2

Rebar Ø8, Ø10, Ø12, Ø 14, Ø16, Ø20, Ø25

Figure A6: Reinforcing bar



Minimum value of related rib area $f_{R,min}$ according to EN 1992-1-1:2004.

- The maximum outer rebar diameter over the ribs shall be:
Nominal diameter of the rib $d + 2 \cdot h$ ($h \leq 0,07 \cdot d$)
(d: nominal diameter of the bar; h: rib height of the bar)

Table A1: Materials

Product form		Bars and de-coiled rods	
Class		B	C
Characteristic yield strength f_{yk} or $f_{0,2k}$ (MPa)		400 to 600	
Minimum value of $k = (f_t / f_y)_k$		$\geq 1,08$	$\geq 1,15$ < 1,35
Characteristic strain at maximum force ϵ_{uk} (%)		$\geq 5,0$	$\geq 7,5$
Bendability		Bend / Rebend test	
Maximum deviation from nominal mass (individual bar) (%)	Nominal bar size (mm)		
	≤ 8	$\pm 6,0$	
	> 8	$\pm 4,5$	
Bond: Minimum relative rib area, $f_{R,min}$	Nominal bar size (mm)		
	8 to 12	0,040	
	> 12	0,056	

WCF-EASF, WCF-EASF-E

Product description
Rebar and materials

Annex A 3

Specifications of intended use

Anchorage subject to:

- Static and quasi-static load.

Base materials

- Reinforced or unreinforced normal weight concrete according to EN 206-1:2000-12
- Strength classes C12/15 to C50/60 according to EN 206-1:2000-12.
- Maximum chloride concrete of 0,40% (CL 0.40) related to the cement content according to EN 206-1:2000-12.
- Non-carbonated concrete.

Note: In case of a carbonated surface of the existing concrete structure the carbonated layer shall be removed in the area of the post installed rebar connection (with a diameter $d_s + 60$ mm) prior to the installation of the new rebar. The depth of concrete to be removed shall correspond to at least minimum concrete cover in accordance with EN 1992-1-1:2004.

The foregoing may be neglected if building components are new and not carbonated.

Temperature range:

- -40°C to $+80^{\circ}\text{C}$ (max. short. term temperature $+80^{\circ}\text{C}$ and max. long term temperature $+50^{\circ}\text{C}$)

Use conditions (Environmental conditions)

- The rebars may be installed in dry or wet concrete.

Design:

- The anchorages are designed under the responsibility of an engineer experienced in anchorages and concrete work.
- Verifiable calculation notes and drawings are prepared taking account of the forces to be transmitted.
- Design according to EN 1992-1-1:2004
- The position of the reinforcement in the existing structure shall be determined on the basis of the construction documentation and taken into account when designing.

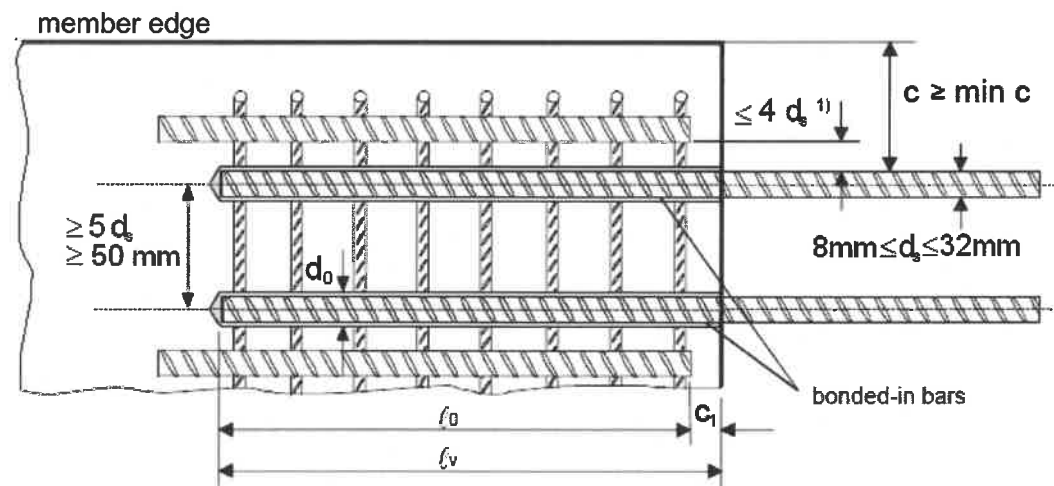
Installation:

- Dry or wet concrete.
- It must not be installed in flooded holes.
- Hole drilling by hammer drill or compressed air drill mode.
- The installation of post-installed rebars shall be done only by suitable trained installer and under supervision on site. The conditions under which an installer may be considered as suitable trained and the conditions for supervision on site are up to the Member States in which the installation is done.
- Check the position of the existing rebars

WCF-EASF, WCF-EASF-E	Annex B 1
Intended use Specifications	

Figure B1: General design rules of construction for bonded-in rebars

- Only tension forces in the axis of the rebar may be transmitted
- The transfer of shear forces between new concrete and existing structure shall be designed additionally according to EN 1992-1-1.
- The joints for concreting must be roughened to at least such an extent that aggregate protrude.



1) If the clear distance between lapped bars exceeds $4d_s$ then the lap length shall be increased by the difference between the clear bar distance and $4d_s$

- c concrete cover of bonded-in bar
 c_1 concrete cover at end-face of bonded-in bar
 $\min c$ minimum concrete cover acc. Table B1 of this assessment
 d_s diameter of bonded-in bar
 l_0 lap length acc. to EN 1992-1-1:2004
 l_v effective embedment depth $\geq l_0 + c_1$
 d_0 nominal drill bit diameter, see Table B3

WCF-EASF, WCF-EASF-E	Annex B 2
Intended use General design rules of construction	

Table B1: Minimum concrete cover min c of the bonded-in rebar depending on drilling method

Drilling method	Without drilling aid
Hammer drilling	$30\text{mm} + 0,06 \ell_v \geq 2 d_s$
Compressed air drilling	$50\text{ mm} + 0,08 \ell_v$

Table B2: Minimum anchorage length¹⁾ and lap lengths for C20/25 and maximum installation length ℓ_{\max} for good bond conditions.

Rebar		$\ell_{b,\min}$	$\ell_{0,\min}$	ℓ_{\max}
$\varnothing d_s$ [mm]	$f_{y,k}$ [N/mm ²]	[mm]	[mm]	[mm]
8	500	113	200	400
10	500	142	200	500
12	500	170	200	600
14	500	198	210	700
16	500	227	240	800
20	500	284	300	1000
25	500	354	375	1000

¹⁾ According to EN 1992-1-1: $\ell_{b,\min}$ (8.6) and $\ell_{0,\min}$ (8.11) for good bond conditions and $\alpha_6 = 1,0$ with maximum yield stress $\sigma_{sd} = 435\text{ N/mm}^2$ for rebar B500-B and $\gamma_M = 1,15$ and maximum installation length.

WCF-EASF, WCF-EASF-E**Intended use**

Minimum concrete cover
 Minimum anchorage length
 Maximum installation length

Annex B 3

Table B3: Drilling diameter and maximum anchorage depth

Rebar diameter $d_{nom}^{1)}$	Nominal drilling diameter d_{cut}	Max permissible embedment depth l_v
[mm]	[mm]	[mm]
8	12 (10)	400
10	14 (12)	500
12	16	600
14	18	700
16	20	800
20	25	1000
25	32	1000

¹⁾ The maximum outer rebar diameter over the ribs shall be:
nominal diameter of the bar $d_{nom} + 0,20 d_{nom}$

Table B4: Processing and Load time

WCF-EASF		
Application temperature	Processing time	Load time
+5 to +10°C	10 mins	145 mins
+10 to +15°C	8 mins	85 mins
+15 to +20°C	6 mins	75 mins
+20 to +25°C	5 mins	50 mins
+25 to +30°C	4 mins	40 mins

Processing time refers to the highest temperature in the range.

Load time refers to the lowest temperature in the range.

Cartridge must be conditioned to a minimum +5°C.

WCF-EASF-E		
Application temperature	Processing time	Load time
+15 to +20°C	15 mins	5 hours
+20 to +25°C	10 mins	145 mins
+25 to +30°C	7.5 mins	85 mins
+30 to +35°C	5 mins	50 mins
+35 to +40°C	3.5 mins	40 mins

Processing time refers to the highest temperature in the range.

Load time refers to the lowest temperature in the range.

Cartridge must be conditioned to a minimum +15°C.

WCF-EASF, WCF-EASF-E

Intended use

Maximum anchorage depth

Processing and Load time

Annex B 4

Table B5: Applicator gun

Applicator gun		Cartridge	Applicator gun		Cartridge
A		Coaxial 380ml 400ml 410ml	B		Side by side 350ml
C		Foil capsule 170ml 300ml 550ml	D		Foil capsule 170ml 300ml Peeler 280ml
E		Coaxial 150ml	F		Side by side 825ml
G		Foil capsule 850ml	H		Side by side 825ml

WCF-EASF, WCF-EASF-E**Intended use**
Applicator gun**Annex B 5**

Table B6: Brush

Sizes		Ø8	Ø10	Ø12	Ø14	Ø16	Ø20	Ø25
Drill hole diameter d ₀	[mm]	12(10)	14(12)	16	18	20	25	32
Brushes head diameter	[mm]	14	14	19	22	22	29	40
Brushes head length	[mm]	75						

If required use additional accessories and extension for air nozzle and brush to reach back of hole.

Max. hole depth	Brush / extension configuration	Part
250 mm	Standard brush	(a)
550 mm	Brush head unit + handle unit	(b)+(c)
850 mm	Brush head unit + extension piece + handle unit	(b)+(d)+(c)
1150 mm	Brush head unit + 2x extension piece + handle unit	(b)+(d)+(d)+(c)

Part (a)**Part (b)****Part (c)****Part (d)****Table B7: Extension hose for deep holes**

Sizes		Ø8	Ø10	Ø12	Ø14	Ø16	Ø20	Ø25
Hole diameter	[mm]	10	12	16	18	20	25	32
Extension hose	[mm]	9			14			
Resin stopper	[mm]	-	-	-	-	18	22	30

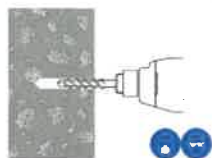
WCF-EASF, WCF-EASF-E**Intended use**

Brush

Extension hose for deep holes

Annex B 6

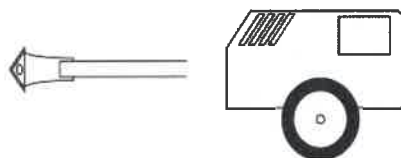
Drilling the hole



Drill hole to the required embedment depth using a hammer-drill with carbide drill bit set in rotation hammer mode, or a compressed air drill.



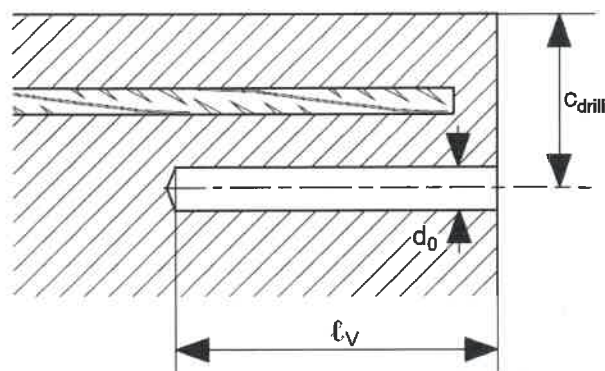
Rotary hammer drilling



Compressed air drill

Before drilling remove carbonized concrete.

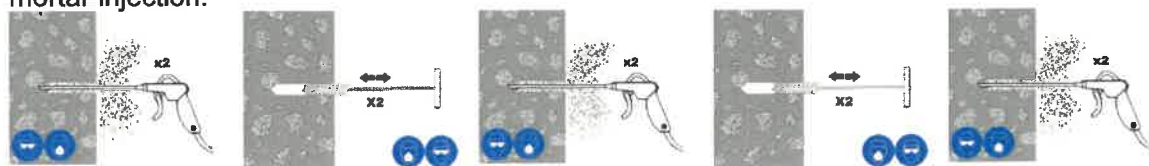
In case of aborted drill hole the drill hole shall be filled with mortar.



- Observe concrete coverage c , as per setting plan and Table B1
- Drill parallel to the edge and to existing rebar

Cleaning the hole

The borehole must be free of dust, debris, water, ice, oil, grease and other contaminants prior to mortar injection.



- Blowing 2 time from the back of the hole with oil-free compressed air (min. 6 bar) until return air stream is free of noticed dust.
- Brushing 2 time with the special brush size (brush $\varnothing \geq$ borehole \varnothing) by inserting the brush to the back of the hole in a twisting motion. The brush shall produce natural resistance as it enters the anchor hole. If this is not the case, please use a new brush or a brush with a larger diameter.
- Repeat operation 1 and 2.
- Blowing 1 time again with compressed air until return air stream is free of noticeable dust.

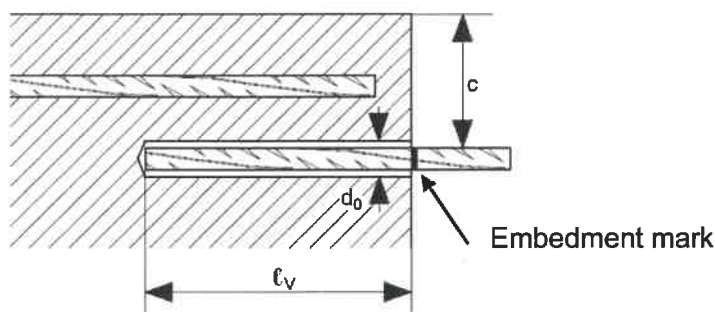
WCF-EASF, WCF-EASF-E

Intended use
Installation instructions I

Annex B 7

Mortar injection

If the hole collects water after initial cleaning,
this water must be removed before injecting the resin.



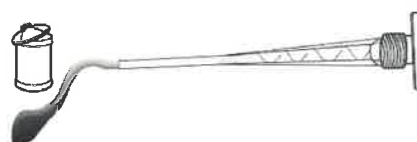
Before use, make sure the rebar is dry and free of oil or other residue.

Mark embedment depth on the rebar (e.g. with tape) l_v

Insert rebar in borehole, to verify hole and setting depth l_v

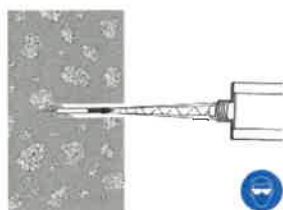
- Check expiration date: See imprint on cartridge. Do not use an expired product
- Foil pack temperature:
Must be between +5°C and +40°C when in use
- Base material temperature at time of installation:
Must be between +5°C and +40°C
- Instructions for transport and storage:
Keep in a cool, dry and dark place at +5°C to +20°C achieve maximum shelf life

Select the appropriate static mixer nozzle for the installation, open the cartridge/foil and screw onto the mouth of the cartridge. Insert the cartridge into the correct applicator gun.



Extrude the first part of the cartridge to waste until an even colour has been achieved without streaking in the resin

If necessary, cut the extension tube to the depth of the hole and push onto the end of the mixer nozzle, and (for rebars 16 mm dia. or more) fit the correct resin stopper to the other end. Attach extension tubing and resin stopper.

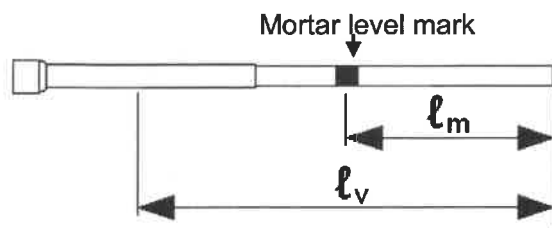


Insert the mixer nozzle (resin stopper / extension tube if applicable) to the bottom of the hole. Begin to extrude the resin and slowly withdraw the mixer nozzle from the hole ensuring that there are no air voids as the mixer nozzle is withdrawn. Fill the hole to approximately $\frac{1}{2}$ to $\frac{3}{4}$ full and remove the mixer nozzle completely.

WCF-EASF, WCF-EASF-E

Intended use
Installation instructions II

Annex B 8

Inserting the rebar

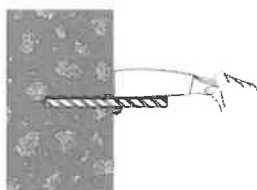
Mark the required mortar level ℓ_m and embedment depth ℓ_v with tape or marker on the injection extension.

Quick estimation: $\ell_m = 1/2 \cdot \ell_v$

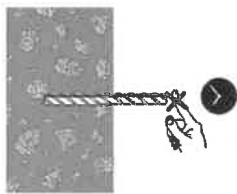
Continue injection until the mortar level mark ℓ_m becomes visible.



Insert the rebar, free from oil or other release agents, to the bottom of the hole using a back and forth twisting motion ensuring all the threads are thoroughly coated. Adjust to the correct position within the stated working time.



Any excess resin should be expelled from the hole evenly around the steel element showing that the hole is full. This excess resin should be removed from around the mouth of the hole before it sets.



Leave the anchor to cure.

Do not disturb the anchor until the appropriate loading/curing time has elapsed depending on the substrate conditions and ambient temperature.

WCF-EASF, WCF-EASF-E

Intended use
Installation instructions III

Annex B 9

Table C1: Design values of the ultimate bond resistance $f_{bd}^{1)}$ in N/mm² for all drilling methods for good bond conditions

Rebar Ø d _s [mm]	Concrete class								
	C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
8 to 16	1,6	2,0	2,3	2,7	3,0	3,4	3,7	4,0	4,3
20								3,7	
25								3,0	

¹⁾ Tabulated values f_{bd} are valid for good bond conditions according to EN 1992-1-1. For all other bond conditions multiply the values for f_{bd} by 0,7.

WCF-EASF, WCF-EASF-E

Performances

Design values of the ultimate bond resistance

Annex C 1