

ICC-ES Evaluation Report

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This report also contains:


- [City of LA Supplement](#)

Subject to renewal February 2027

- [FL Supplement](#)

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<p>DIVISION: 03 00 00— CONCRETE</p> <p>Section: 03 16 00— Concrete Anchors</p> <p>DIVISION: 05 00 00— METALS</p> <p>Section: 05 05 19—Post- Installed Concrete Anchors</p>	<p>REPORT HOLDER:</p> <p>CHEMOFAST ANCHORING GMBH</p>	<p>EVALUATION SUBJECT:</p> <p>CHEMOFAST EP 1000 ADHESIVE ANCHOR AND POST-INSTALLED REINFORCING BAR CONNECTION SYSTEM IN CRACKED AND UNCRACKED CONCRETE</p>	
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1.0 EVALUATION SCOPE

Compliance with the following codes:

- 2024, 2021, 2018, and 2015 [International Building Code® \(IBC\)](#)
- 2024, 2021, 2018, and 2015 [International Residential Code® \(IRC\)](#)
- 2013 *Abu Dhabi International Building Code (ADIBC)*[†]

[†]The ADIBC is based on the 2009 IBC. 2009 IBC code sections referenced in this report are the same sections in the ADIBC.

Property evaluated:

Structural

2.0 USES

Chemofast EP 1000 adhesive anchor and post-installed reinforcing bar connection system is used as anchorage to resist static, wind or earthquake (IBC Seismic Design Categories A through F) tension and shear loads in cracked and uncracked normal-weight concrete with $\frac{3}{8}$ -, $\frac{1}{2}$ -, $\frac{5}{8}$ -, $\frac{3}{4}$ -, $\frac{7}{8}$ -, 1-, and $1\frac{1}{4}$ -inch fractional diameter, and M8, M10, M12, M16, M20, M24, M27 and M30 metric diameter threaded steel rods and No. 3 through No. 10 fractional size and $\varnothing 8$, $\varnothing 10$, $\varnothing 12$, $\varnothing 14$, $\varnothing 16$, $\varnothing 20$, $\varnothing 25$, $\varnothing 28$ and $\varnothing 32$ metric size steel reinforcing bars in hammer-drilled holes. Use is limited to normal-weight concrete with a specified compressive strength, f_c , of 2,500 psi to 8,500 psi (17.2 MPa to 58.6 MPa) [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1].

Adhesive anchors with $\frac{3}{8}$ -, $\frac{1}{2}$ -, $\frac{5}{8}$ -, $\frac{3}{4}$ -, $\frac{7}{8}$ -, 1-, and $1\frac{1}{4}$ -inch fractional diameter, and M8, M10, M12, M16, M20, M24, M27 and M30 metric diameter threaded steel rods and No. 3 through No. 10 fractional size and $\varnothing 8$, $\varnothing 10$, $\varnothing 12$, $\varnothing 14$, $\varnothing 16$, $\varnothing 20$, $\varnothing 25$, $\varnothing 28$ and $\varnothing 32$ metric size steel reinforcing bars drilled with diamond core bits are used in uncracked normal-weight concrete only, to resist static, wind or earthquake (IBC Seismic Design Categories A and B only) tension and shear loads. Use is limited to normal-weight concrete with a specified compressive strength, f_c , of 2,500 psi to 8,500 psi (17.2 MPa to 58.6 MPa) [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1].

The anchor system complies with anchors as described in Section 1901.3 of the 2024, 2021, 2018 and 2015 IBC. The anchor systems may also be used where an engineered design is submitted in accordance with Section R301.1.3 of the IRC.

The post-installed reinforcing bar connection system is an alternative to cast-in-place reinforcing bars governed by ACI 318 and IBC Chapter 19.

3.0 DESCRIPTION

3.1 General:

The Chemofast EP 1000 Adhesive Anchor System is comprised of Chemofast EP 1000 two-component adhesive filled in cartridges, static mixing nozzles, dispensing tools, hole cleaning equipment and adhesive injection accessories, and steel anchor elements, which are continuously threaded steel rods or steel reinforcing bars (to form the Chemofast EP 1000 Adhesive Anchor System).

The primary components of the Chemofast EP 1000 Adhesive Anchor System, including the Chemofast EP 1000 adhesive cartridge, static mixing nozzle, dispenser, and steel anchor elements, are shown in [Figures 2 and 3](#) of this report. The manufacturer's printed installation instructions (MPII), included with each adhesive unit package, are shown in [Figure 6](#) of this report.

3.2 Materials:

3.2.1 Chemofast EP 1000 Adhesive: Chemofast EP 1000 adhesive is an injectable two-component epoxy adhesive. The two components are kept separate by means of a labeled dual-cylinder cartridge. The two components combine and react when dispensed through a static mixing nozzle, supplied by Chemofast, which is attached to the cartridge. Chemofast EP 1000 is available in 14.8-ounce (440 mL), 20-ounce (585 mL) and 47-ounce (1400 mL) cartridges. Each cartridge label is marked with the adhesive expiration date. The shelf life, as indicated by the expiration date, applies to an unopened cartridge stored in a dry, dark, and cool environment, in accordance with the MPII, as illustrated in [Figure 6](#) of this report.

3.2.2 Hole Cleaning Equipment:

3.2.2.1 Standard Equipment: Hole cleaning equipment is comprised of steel wire brushes supplied by Chemofast Anchoring GmbH, and air blowers which are shown in [Figure 1](#) of this report. The Chemofast dust extraction system shown in [Figure 1](#) of this report removes dust with a HEPA dust extractor during the hole drilling and cleaning operation.

3.2.2.2 Chemofast Hollow Drill Bit System: The Chemofast hollow drill bit system shown in [Figure 1](#) is comprised of Heller Duster Expert Hollow drill bit with carbide tips conforming to ANSI B212.15 attached to a class M vacuum that has a minimum air flow rating of 90cfm (150m³/h, 42l/s). The vacuum dust extractor system removes the drilling dust during the drilling operation, eliminating the need for additional hole cleaning.

3.2.3 Dispensers: Chemofast EP 1000 adhesive must be dispensed with manual dispensers, pneumatic dispensers, or electric powered dispensers supplied by Chemofast Anchoring GmbH.

3.2.4 Steel Anchor Elements:

3.2.4.1 Threaded Steel Rods for use in Post-Installed Anchor Applications: Threaded steel rods must be clean and continuously threaded (all-thread) in diameters described in [Tables 4 and 12](#) and [Figure 6](#) of this report. Specifications for grades of threaded rod, including the mechanical properties, and corresponding nuts and washers, are included in [Table 2](#) of this report. Carbon steel threaded rods must be furnished with a minimum 0.0002-inch-thick (0.005 mm) zinc electroplated coating complying with ASTM B633 SC1 or a minimum 0.0021-inch-thick (0.053 mm) mechanically deposited zinc coating complying with ASTM B695, Class 55. The stainless steel threaded rods must comply with [Table 2](#) of this report. Steel grades and types of material (carbon, stainless) for the washers and nuts must match the threaded rods. Threaded steel rods must be clean, straight, and free of indentations or other defects along their length. The embedded end may be flat cut or cut on the bias to a chisel point.

3.2.4.2 Steel Reinforcing Bars for use in Post-Installed Anchor Applications: Steel reinforcing bars must be deformed reinforcing bars as described in [Table 3](#) of this report. [Tables 8 and 16](#) and [Figure 6](#) summarize reinforcing bar size ranges. The embedded portions of reinforcing bars must be clean, straight, and free of mill scale, rust, mud, oil and other coatings (other than zinc) that may impair the bond with the adhesive. Reinforcing bars must not be bent after installation except as set forth in ACI 318-19 Section 26.6.3.2 (b) or ACI 318-14 Section 26.6.3.1 (b), as applicable, with the additional condition that the bars must be bent cold, and heating of reinforcing bars to facilitate field bending is not permitted.

3.2.4.3 Ductility: In accordance with ACI 318-19 and ACI 318-14 2.3, as applicable, in order for a steel anchor element to be considered ductile, the tested elongation must be at least 14 percent and reduction of area must be at least 30 percent. Steel elements with a tested elongation less than 14 percent or a reduction of area less than 30 percent, or both, are considered brittle. Specifications and physical properties of various steel materials are provided for threaded rods in [Table 2](#) and for reinforcing bars in [Table 3](#) of this report. Where values are nonconforming or unstated, the steel must be considered brittle.

3.2.4.4 Steel Reinforcing Bars for use in Post-Installed Reinforcing Bar Connections: Steel reinforcing bars used in post-installed reinforcing bar connections are deformed reinforcing bars (rebar), as depicted in [Figure 4](#). [Tables 20](#) and [21](#) summarize reinforcing bar size ranges. The embedded portions of reinforcing bars must be straight, and free of mill scale, rust and other coatings that may impair the bond with the adhesive. Reinforcing bars must not be bent after installation except as set forth in ACI 318-19 Section 26.6.3.2 (b) or ACI 318-14 Section 26.6.3.1 (b), as applicable, with the additional condition that the bars must be bent cold, and heating of reinforcing bars to facilitate field bending is not permitted.

3.3 Concrete:

Normal-weight concrete must comply with Sections 1903 and 1905 of the IBC. The specified compressive strength of the concrete must be from 2,500 psi to 8,500 psi (17.2 MPa to 58.6 MPa) [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1].

4.0 DESIGN AND INSTALLATION

4.1 Strength Design:

4.1.1 General: The design strength of anchors under the 2024 and 2021 IBC, as well as the 2024 and 2021 IRC must be determined in accordance with ACI 318-19 and this report. The design strength of anchors under the 2018 and 2015 IBC, as well as the 2018 and 2015 IRC, must be determined in accordance with ACI 318-14 and this report.

The strength design of anchors must comply with ACI 318-19 17.5.1.2 or ACI 318-14 17.3.1, as applicable, except as required in ACI 318-19 17.10 or ACI 318-14 17.2.3, as applicable.

Design parameters are provided in [Tables 4](#) through [21](#) of this report. Strength reduction factors, ϕ , as given in ACI 318-19 17.5.3 or ACI 318-14 17.3.3, as applicable, must be used for load combinations calculated in accordance with Section 1605.1 of the 2024 and 2021 IBC or Section 1605.2 of the 2018 and 2015 IBC, or ACI 318-19 and ACI 318-14 5.3, as applicable.

4.1.2 Static Steel Strength in Tension: The nominal static steel strength of a single anchor in tension, N_{sa} , in accordance with ACI 318-19 17.6.1.2 or ACI 318-14 17.4.1.2, as applicable, and the associated strength reduction factors, ϕ , in accordance with ACI 318-19 17.5.3 or ACI 318-14 17.3.3, as applicable, are provided in [Tables 4](#), [8](#), [12](#) and [16](#) of this report for the corresponding anchor steel.

4.1.3 Static Concrete Breakout Strength in Tension: The nominal static concrete breakout strength of a single anchor or group of anchors in tension, N_{cb} or N_{cbg} , must be calculated in accordance with ACI 318-19 17.6.2 or ACI 318-14 17.4.2, as applicable, with the following addition:

The basic concrete breakout strength of a single anchor in tension, N_b , must be calculated in accordance with ACI 318-19 17.6.2.2 or ACI 318-14 17.4.2.2, as applicable, using the values of $k_{c,cr}$ and $k_{c,uncl}$ as provided in [Tables 5](#), [9](#), [13](#) and [17](#) of this report. Where analysis indicates no cracking in accordance with ACI 318-19 17.6.2.5 or ACI 318-14 17.4.2.6, as applicable, N_b must be calculated using $k_{c,uncl}$ and $\Psi_{c,N} = 1.0$. For anchors in lightweight concrete see ACI 318-19 17.2.4 or ACI 318-14 17.2.6, as applicable. The value of f'_c used for calculation must be limited to 8,000 psi (55 MPa) in accordance with ACI 318-19 17.3.1 or ACI 318-14 17.2.7, as applicable. Additional information for the determination of nominal bond strength in tension is given in Section 4.1.4 of this report.

4.1.4 Static Bond Strength in Tension: The nominal static bond strength of a single adhesive anchor or group of adhesive anchors in tension, N_a or N_{ag} , must be calculated in accordance with ACI 318-19 17.6.5 or ACI 318-14 17.4.5, as applicable.

Bond strength values ($\tau_{k,cr}$, $\tau_{k,uncl}$) are a function of concrete compressive strength, concrete state (cracked, uncracked), installation conditions (dry concrete, water-saturated concrete, water-filled holes), hole drilling method (hammer drilling, including Chemofast hollow drill bit, diamond core drilling) and concrete substrate temperature range. Special inspection level is qualified as periodic for all anchors except as described in Section 4.4 of this report (the selection of continuous special inspection level does not provide an increase in

anchor category or associated strength reduction factor for design). The following table summarizes the requirements:

DRILLING / CLEANING METHOD	CONCRETE STATE	BOND STRENGTH	CONCRETE COMPRESSIVE STRENGTH	PERMISSIBLE INSTALLATION CONDITIONS	ASSOCIATED STRENGTH REDUCTION FACTOR
Hammer drill (or Chemofast Hollow drill bit)	Cracked	$\tau_{k,cr}$	f'_c	Dry concrete	ϕ_d
				Water-saturated concrete	ϕ_{ws}
				Water-filled hole (flooded)	$K_{wrf} \cdot \phi_{wrf}$
	Uncracked	$\tau_{k,uncr}$	f'_c	Dry concrete	ϕ_d
				Water-saturated concrete	ϕ_{ws}
				Water-filled hole (flooded)	$K_{wrf} \cdot \phi_{wrf}$
Diamond core drilled	Uncracked	$\tau_{k,uncr}$	f'_c	Dry concrete	ϕ_d
				Water-saturated concrete	ϕ_{ws}
				Water-filled hole (flooded)	$K_{wrf} \cdot \phi_{wrf}$

Strength reduction factors for determination of the bond strength are given in [Tables 6, 7, 10, 11, 14, 15](#) and 18 of this report. Adjustments to the bond strength may also be made for increased concrete compressive strength as noted in the footnotes to the corresponding tables and this section. Bond strengths must also be multiplied by the factor K_{wrf} where holes are water-filled at the time of anchor installation (flooded).

The bond strength values in [Tables 6, 7, 10, 11, 14, 15](#) and 18 of this report correspond to concrete compressive strength f'_c equal to 2,500 psi (17.2 MPa). For concrete compressive strength, f'_c between 2,500 psi and 8,000 psi (17.2 MPa and 55 MPa), the tabulated characteristic bond strength may be increased by a factor of $(f'_c / 2,500)^{0.10}$ for hammer drill (or Chemofast Hollow drill bit). For diamond core drilled, the tabulated characteristic bond strength may be increased by a factor of $(f'_c / 2,500)^{0.20}$ [For SI: $(f'_c / 17.2)^{0.10}$ or $(f'_c / 17.2)^{0.20}$ respectively] [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1]. Where applicable, the modified bond strength values must be used in lieu of $\tau_{k,cr}$ and $\tau_{k,uncr}$ in ACI 318-19 Equations (17.6.5.1.2b) and (17.6.5.2.1) or ACI 318-14 Equations (17.4.5.1d) and (17.4.5.2), as applicable.

The resulting nominal bond strength must be multiplied by the associated strength reduction factor ϕ_d , ϕ_{ws} or $K_{wrf} \cdot \phi_{wrf}$, as applicable.

4.1.5 Static Steel Strength in Shear: The nominal static steel strength of a single anchor in shear as governed by the steel, V_{sa} , in accordance with ACI 318-19 17.7.1.2 or ACI 318-14 17.5.1.2, as applicable, and the strength reduction factor, ϕ , in accordance with ACI 318-19 17.5.3 or ACI 318-14 17.3.3, as applicable, are given in [Tables 4, 8, 12](#) and [16](#) of this report for the corresponding anchor steel.

4.1.6 Static Concrete Breakout Strength in Shear: The nominal static concrete breakout strength of a single anchor or group of anchors in shear, V_{cb} or V_{cbg} , must be calculated in accordance with ACI 318-19 17.7.2 or ACI 318-14 17.5.2, as applicable, based on information given in [Tables 5, 9, 13](#) and [17](#) in this report.

The basic concrete breakout strength of a single anchor in shear, V_b , must be calculated in accordance with ACI 318-19 17.7.2.2 or ACI 318-14 17.5.2.2, as applicable using the values of d given in [Tables 4, 8, 12](#) and [16](#) for the corresponding anchor steel in lieu of d_a (2024, 2021, 2018 and 2015 IBC). In addition, h_{ef} must be substituted for ℓ_e . In no case shall ℓ_e exceed $8d$. The value of f'_c shall be limited to a maximum of 8,000 psi (55 MPa) in accordance with ACI 318-19 17.3.1 or ACI 318-14 17.2.7, as applicable.

4.1.7 Static Concrete Pryout Strength in Shear: The nominal static pryout strength of a single anchor or group of anchors in shear, V_{cp} or V_{cpg} , shall be calculated in accordance with ACI 318-19 17.7.3 or ACI 318-14 17.5.3, as applicable.

4.1.8 Interaction of Tensile and Shear Forces: For designs that include combined tension and shear, the interaction of tension and shear loads must be calculated in accordance with ACI 318-19 17.8 or ACI 318-14 17.6, as applicable.

4.1.9 Minimum Member Thickness h_{min} , Anchor Spacing s_{min} , Edge Distance c_{min} : In lieu of ACI 318-19 17.9.2 or ACI 318-14 17.7.1 and 17.7.3, as applicable, values of s_{min} and c_{min} described in this report must be observed for anchor design and installation. The minimum member thicknesses, h_{min} , described in this report must be observed for anchor design and installation. For adhesive anchors that will remain untorqued, ACI 318-19 17.9.3 or ACI 318-14 17.7.4 applies, as applicable.

For anchors that will be torqued during installation, the maximum torque, T_{max} , must be reduced for edge distances less than the values given in [Tables 5](#) and [13](#), as applicable. T_{max} is subject to the edge distance, c_{min} , and anchor spacing, s_{min} , and shall comply with the following requirements:

INSTALLATION TORQUE SUBJECT TO EDGE DISTANCE			
NOMINAL ANCHOR SIZE, D	MINIMUM EDGE DISTANCE, c_{min}	MINIMUM ANCHOR SPACING, s_{min}	MAXIMUM TORQUE, T_{max}
$5/8$ in. to 1 in. M16 to M27	1.75 in. (45 mm)	5d	0.45 · T_{max}
$1\ 1/4$ in. M30	2.75 in. (70 mm)		

For values of T_{max} , see [Figure 6](#) of this report.

4.1.10 Critical Edge Distance c_{ac} and $\psi_{cp,Na}$: The modification factor, $\psi_{cp,Na}$, must be determined in accordance with ACI 318-19 17.6.5.5 or ACI 318-14 17.4.5.5, as applicable, except as noted below:

For all cases where $c_{Na}/c_{ac} < 1.0$, $\psi_{cp,Na}$ determined from ACI 318-19 Eq. 17.6.5.5.1b or ACI 318-14 Eq. 17.4.5.5b, as applicable, need not be taken less than c_{Na}/c_{ac} . For all other cases, $\psi_{cp,Na}$ shall be taken as 1.0.

The critical edge distance, c_{ac} must be calculated according to Eq. 17.6.5.5.1c for ACI 318-19 or Eq. 17.4.5.5c for ACI 318-14, in lieu of ACI 318-19 17.9.5 or ACI 318-14 17.7.6, as applicable.

$$c_{ac} = h_{ef} \left(\frac{\tau_{k,uncr}}{1160} \right)^{0.4} \cdot \left[3.1 - 0.7 \frac{h}{h_{ef}} \right]$$

(Eq. 17.6.5.5.1c for ACI 318-19 or Eq. 17.4.5.5c for ACI 318-14)

where

$\left[\frac{h}{h_{ef}} \right]$ need not be taken as larger than 2.4; and

$\tau_{k,uncr}$ = the characteristic bond strength stated in the tables of this report whereby $\tau_{k,uncr}$ need not be taken as larger than:

$$\tau_{k,uncr} = \frac{k_{uncr} \sqrt{h_{ef} f'_c}}{\pi \cdot d_a} \quad \text{Eq. (4-1)}$$

4.1.11 Requirements for Seismic Design Categories C, D, E and F: In structures assigned to Seismic Design Category C, D, E or F under the IBC or IRC, anchors must be designed in accordance with ACI 318-19 17.10 or ACI 318-14 17.2.3, as applicable. Modifications to ACI 318-19 Section 17.10 or ACI 318-14 Section 17.2.3 shall be applied under Section 1905.7 of the 2024 IBC or Section 1905.1.8 of the 2021, 2018 and 2015 IBC, as applicable.

The nominal steel shear strength, V_{sa} , must be adjusted by $\alpha_{V,seis}$ as given in [Tables 4](#), [8](#), [12](#) and [16](#) for the corresponding anchor steel. The nominal bond strength $\tau_{k,cr}$ must be adjusted by $\alpha_{N,seis}$ as given in [Tables 6](#) and [14](#) for threaded rods, and [Tables 10](#) and [18](#) for reinforcing bars.

4.2 Strength Design of Post-Installed Reinforcing Bars:

4.2.1 General: The design of straight post-installed deformed reinforcing bars must be determined in accordance with ACI 318 rules for cast-in-place reinforcing bar development and splices and this report. Examples of typical applications for the use of post-installed reinforcing bars are illustrated in [Figure 4](#) of this report.

4.2.2 Determination of bar development length l_d : Values of l_d must be determined in accordance with the ACI 318 development and splice length requirements for straight cast-in-place reinforcing bars.

Exceptions:

1. For uncoated and zinc-coated (galvanized) post-installed reinforcing bars, the factor Ψ_e shall be taken as 1.0. For all other cases, the requirements in ACI 318-19 Table 25.4.2.5 or ACI 318-14 Table 25.4.2.4 shall apply.
2. When using alternate methods to calculate the development length (e.g. anchor theory), the applicable factors for post-installed anchors generally apply.

4.2.3 Minimum Member Thickness, h_{min} , Minimum Concrete Cover, $c_{c,min}$, Minimum Concrete Edge Distance, $c_{b,min}$, Minimum Spacing, $s_{b,min}$: For post-installed reinforcing bars, there is no limit on the minimum member thickness. In general, all requirements on concrete cover and spacing applicable to straight cast-in-bars designed in accordance with ACI 318 shall be maintained.

For post-installed reinforcing bars installed at embedment depths greater than $20d$ ($h_{ef} > 20d$), the minimum concrete cover shall be as follows:

REBAR SIZE	MINIMUM CONCRETE	COVER, $c_{c,min}$
$db \leq \text{No. 6}$	1 3/16 in. (30mm)	
$\text{No. 6} < db \leq \text{No. 11}$	1 9/16 in. (40 mm)	

The following requirements apply for minimum concrete edge and spacing for $h_{ef} > 20d$:

Required minimum edge distance for post-installed reinforcing bars (measured from the center of the bar):

$$c_{b,min} = d_o/2 + c_{c,min}$$

Required minimum center-to-center spacing between post-installed bars:

$$s_{b,min} = d_o + c_{c,min}$$

Required minimum center-to-center spacing from existing (parallel reinforcing):

$$s_{b,min} = db/2 \text{ (existing reinforcing)} + d_o/2 + c_{c,min}$$

4.2.4 Design Strength in Seismic Design Categories C, D, E and F: In structures assigned to Seismic Category C, D, E or F under the IBC or IRC, design of straight post-installed reinforcing bars must consider the provisions of ACI 318-19 or ACI 318-14 Chapter 18, as applicable.

4.2.5 Design in Fire Resistive Construction Conditions: For post-installed reinforcing bars, the relationship of bond stress to temperature under fire conditions suitable for use in determining conformance with fire resistance rating requirements is as given in [Figure 5](#).

For temperatures above θ_{max} of 538°F (281°C), $\tau_{fire}(\theta) = 0$. The bond stress $\tau_{fire}(\theta)$, shall not exceed 1,090 psi (7.5 N/mm²).

Where θ is the temperature in the concrete at the post-installed reinforcing bar in °F (for psi) or °C (for N/mm²), as applicable.

Determination of the temperature in the concrete at the location of the post-installed reinforcing bar is dependent on the geometry of the concrete members under consideration, and its calculation is the responsibility of the design professional. The design professional shall use the bond strength / temperature curves in [Figure 5](#) along with a determination of the temperature in the concrete appropriate for the member geometry under consideration to calculate the reinforcing bar development length l_d .

4.3 Installation

Installation parameters are illustrated in [Figures 2, 4 and 5](#) of this report. Installation must be in accordance with ACI 318-19 26.7.2 or ACI 318-14 17.8.1 and 17.8.2. Anchor locations must comply with this report and the plans and specifications approved by the code official. Installation of the Chemofast EP 1000 Adhesive Anchor System must conform to the manufacturer's printed installation instructions included in each unit package as described in [Figure 6](#) of this report.

The adhesive anchor system may be installed in downwards, horizontally and upwardly inclined orientation applications (e.g. overhead). If the bottom or back of the bore hole is not reached with the mixing nozzle, a mixer extension tube, supplied by Chemofast must be attached to the mixing nozzle as described in [Figure 6](#) of this report. Additionally, horizontal or upwardly inclined orientation applications of all bore hole depths, and downwards applications with a bore hole depth of more than 10 inch (250 mm) are to be installed using piston plugs for the $\frac{5}{8}$ -inch and M16 through $1\frac{1}{4}$ -inch and M30 diameter threaded steel rods, and No. 5 and $\varnothing 16$ through No. 10 and $\varnothing 32$, steel reinforcing bars, installed in the specified hole diameter, and attached to the mixing nozzle and extension tube supplied by Chemofast as described in [Figure 6](#) in this report. For installation with the $\frac{3}{8}$ -inch, $\frac{1}{2}$ -inch, M8, M10 and M12 diameter threaded steel rods, and No. 3, No. 4, $\varnothing 8$, $\varnothing 10$ and $\varnothing 12$ steel reinforcing bars only, a piston plug is not required.

Installation of anchors in horizontal or upwardly inclined orientations shall be fully restrained from movement throughout the specified curing period through the use of temporary wedges, external supports, or other methods. Where temporary restraint devices are used, their use shall not result in impairment of the anchor shear resistance.

4.4 Special Inspection:

Periodic special inspection must be performed where required in accordance with Section 1705.1.1 and Table 1705.3 of the 2024, 2021, 2018, and 2015 IBC and this report. The special inspector must be on the jobsite initially during anchor installation to verify the anchor type, adhesive expiration date, anchor dimensions, concrete type, concrete compressive strength, hole dimensions, hole cleaning procedures, anchor spacing, edge distances, concrete thickness, anchor embedment, tightening torque, and adherence to the manufacturer's printed installation instructions.

The special inspector must verify the initial installations of each type and size of adhesive anchor by construction personnel on site. Subsequent installations of the same anchor type and size by the same construction personnel are permitted to be performed in the absence of the special inspector. Any change in the anchor product being installed or the personnel performing the installation requires an initial inspection. For ongoing installations over an extended period, the special inspector must make regular inspections to confirm correct handling and installation of the product.

Continuous special inspection of adhesive anchors installed in horizontal or upwardly inclined orientations to resist sustained tension loads must be performed in accordance with ACI 318-19 26.13.3.2e or ACI 318-14 17.8.2.4, 26.7.1(h) and 26.13.3.2 (c), as applicable.

Under the IBC, additional requirements as set forth in Sections 1705, 1706 or 1707 must be observed, where applicable.

5.0 CONDITIONS OF USE:

The Chemofast EP 1000 Adhesive Anchor and Post Installed Reinforcing Bar Connection System described in this report complies with, or is a suitable alternative to what is specified in, those codes listed in Section 1.0 of this report, subject to the following conditions:

- 5.1 Chemofast EP 1000 adhesive anchors and post-installed reinforcing bars must be installed in accordance with the manufacturer's printed installation instructions included with each cartridge and provided in [Figure 6](#) of this report.
- 5.2 Anchors [$\frac{3}{8}$ -, $\frac{1}{2}$ -, $\frac{5}{8}$ -, $\frac{3}{4}$ -, $\frac{7}{8}$ -, 1-, and $1\frac{1}{4}$ -inch fractional diameter and M8, M10, M12, M16, M20, M24, M27 and M30 metric diameter threaded steel rods, and No. 3 through No. 10 fractional size and $\varnothing 8$, $\varnothing 10$, $\varnothing 12$, $\varnothing 14$, $\varnothing 16$, $\varnothing 20$, $\varnothing 25$, $\varnothing 28$ and $\varnothing 32$ metric steel reinforcing bars] described in this report must be installed in cracked and uncracked normal-weight concrete having a specified compressive strength $f'_c = 2,500$ psi to 8,500 psi (17.2 MPa to 58.6 MPa) [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1].

Adhesive anchors with $\frac{3}{8}$ -, $\frac{1}{2}$ -, $\frac{5}{8}$ -, $\frac{3}{4}$ -, $\frac{7}{8}$ -, 1-, and $1\frac{1}{4}$ -inch fractional diameter, and M8, M10, M12, M16, M20, M24, M27 and M30 metric diameter threaded steel rods and No. 3 through No. 10 fractional size and $\varnothing 8$, $\varnothing 10$, $\varnothing 12$, $\varnothing 14$, $\varnothing 16$, $\varnothing 20$, $\varnothing 25$, $\varnothing 28$ and $\varnothing 32$ metric size steel reinforcing bars drilled with diamond core bits are used in uncracked normal-weight concrete only, to resist static, wind or earthquake (IBC Seismic Design Categories A and B only) tension and shear loads. Use is limited to normal-weight concrete with a specified compressive strength, $f'_c = 2,500$ psi to 8,500 psi (17.2 MPa to 58.6 MPa) [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1].

- 5.3** The values of f_c used for calculation purposes must not exceed 8,000 psi (55 MPa).
- 5.4** Anchors and post-installed reinforcing bars must be installed in concrete base materials in holes predrilled in accordance with the instructions provided in [Figure 6](#) of this report.
- 5.5** Loads applied to the anchors must be adjusted in accordance with Section 1605.1 of the 2024 and 2021 IBC or Section 1605.2 of the 2018 and 2015 IBC for strength design.
- 5.6** In structures assigned to Seismic Design Categories C, D, E, and F under the IBC or IRC, anchor strength must be adjusted in accordance with Section 4.1.11 of this report.
- 5.7** Chemofast EP 1000 adhesive anchors are permitted to be installed in concrete that is cracked or that may be expected to crack during the service life of the anchor, subject to the conditions of this report.
- 5.8** Strength design values are established in accordance with Section 4.1 of this report.
- 5.9** Minimum anchor spacing and edge distance as well as minimum member thickness must comply with the values described in this report.
- 5.10** Prior to anchor installation, calculations and details demonstrating compliance with this report must be submitted to the code official. The calculations and details must be prepared by a registered design professional where required by the statutes of the jurisdiction in which the project is to be constructed.
- 5.11** Anchors and post-installed reinforcing bars are not permitted to support fire-resistive construction. Where not otherwise prohibited by the code, Chemofast EP 1000 adhesive anchors are permitted for installation in fire-resistive construction provided that at least one of the following conditions is fulfilled:
- Anchors and post-installed reinforcing bars are used to resist wind or seismic forces only.
 - Anchors and post-installed reinforcing bars that support gravity load-bearing structural elements are within a fire-resistive envelope or a fire-resistive membrane, are protected by approved fire-resistive materials, or have been evaluated for resistance to fire exposure in accordance with recognized standards.
 - Anchors and post-installed reinforcing bars are used to support nonstructural elements.
 - Post-installed reinforcing bars designed in accordance with Section 4.2.5 of this report.
- 5.12** Since an ICC-ES acceptance criteria for evaluating data to determine the performance of adhesive anchors subjected to fatigue or shock loading is unavailable at this time, the use of these anchors under such conditions is beyond the scope of this report.
- 5.13** Use of zinc-plated carbon steel threaded rods or steel reinforcing bars is limited to dry, interior locations.
- 5.14** Use of hot-dipped galvanized carbon steel and stainless steel rods is permitted for exterior exposure or damp environments.
- 5.15** Steel anchoring materials in contact with preservative-treated and fire-retardant-treated wood shall be of zinc-coated steel or stainless steel. The minimum coating weights for zinc-coated steel shall be in accordance with ASTM A153.
- 5.16** Periodic special inspection must be provided in accordance with Section 4.4 in this report. Continuous special inspection for anchors installed in horizontal or upwardly inclined orientations to resist sustained tension loads must be provided in accordance with Section 4.4 of this report.
- 5.17** Installation of anchors and post-installed reinforcing bars in horizontal or upwardly inclined orientations to resist sustained tension loads must be performed by personnel certified by an applicable certification program in accordance with ACI 318-19 26.7.2(e) or ACI 318-14 17.8.2.2 or 17.8.2.3, as applicable.
- 5.18** Chemofast EP 1000 adhesive anchors and post-installed reinforcing bars may be used to resist tension and shear forces in floor, wall for overhead installations into concrete with a temperature between 40°F and 104°F (5°C and 40°C) for threaded rods and rebar.
- 5.19** Anchors and post-installed reinforcing bars shall not be used for installations where the concrete temperature can vary from 40°F (5°C) or less to 80°F (27°C) or higher within a 12-hour period. Such applications may include but are not limited to anchorage of building façade systems and other applications subject to direct sun exposure.
- 5.20** Chemofast EP 1000 adhesive is manufactured in Willich, Germany, under a quality control program with inspections by ICC-ES.

6.0 EVIDENCE SUBMITTED



Data in accordance with the [ICC-ES Acceptance Criteria for Post-installed Adhesive Anchors in Concrete \(AC308\)](#), dated February 2023, editorially revised February 2024, which incorporates requirements in ACI 355.4-11 and ACI 355.4-19 for use in cracked and uncracked concrete.

7.0 IDENTIFICATION

- 7.1 The ICC-ES mark of conformity, electronic labeling, or the evaluation report number (ICC-ES ESR-4246) along with the name, registered trademark, or registered logo of the report holder must be included in the product label.
- 7.2 Additionally, Chemofast EP 1000 adhesive is identified by packaging labeled with the manufacturer's name (Chemofast Anchoring GmbH) and address, anchor name, the lot number, and the expiration date. Threaded rods, nuts, washers, and deformed reinforcing bars are standard steel anchor elements and must conform to applicable national or international specifications as set forth in [Tables 2](#) and [3](#) of this report.
- 7.3 The report holder's contact information is the following:

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info@chemofast.de

TABLE 1—DESIGN TABLE INDEX

DESIGN STRENGTH ¹ - THREADED RODS		Fractional	Metric
	Steel Strength - N_{sa} , V_{sa}	Table 4	Table 12
	Concrete Strength - N_{pn} , N_{sb} , N_{sbg} , N_{cb} , N_{cbg} , V_{cb} , V_{cbg} , V_{cp} , V_{cpg}	Table 5	Table 13
	Bond Strength ² - N_a , N_{ag}	Tables 6 and 7	Tables 14 and 15
DESIGN STRENGTH ¹ - REINFORCING STEEL		Fractional	Metric
	Steel Strength - N_{sa} , V_{sa}	Table 8	Table 16
	Concrete Strength - N_{pn} , N_{sb} , N_{sbg} , N_{cb} , N_{cbg} , V_{cb} , V_{cbg} , V_{cp} , V_{cpg}	Table 9	Table 17
	Bond Strength ² - N_a , N_{ag}	Tables 10 and 11	Tables 18 and 19
	Determination of development length for post-installed reinforcing bar connections	Table 20	Table 21

¹Ref. ACI 318-19 17.5.2 or ACI 318-14 17.3.1.1, as applicable.

²See Section 4.1.4 of this evaluation report.

TABLE 2—SPECIFICATIONS AND PHYSICAL PROPERTIES OF COMMON CARBON AND STAINLESS STEEL THREADED ROD MATERIALS¹

THREADED ROD SPECIFICATION		MINIMUM SPECIFIED ULTIMATE STRENGTH, f_{uta}	MINIMUM SPECIFIED YIELD STRENGTH 0.2 PERCENT OFFSET, f_{ya}	f_{uta}/f_{ya}	ELONGATION, MIN. PERCENT ¹¹	REDUCTION OF AREA, MIN. PERCENT	SPECIFICATION FOR NUTS ¹²
CARBON STEEL	ASTM A193 ² Grade B7 all sizes	psi (MPa) 125,000 (862)	105,000 (724)	1.19	16	50	ASTM A194 / A563 Grade DH
	ASTM A36 ³ / F1554 ⁴ , Grade 36 all sizes	psi (MPa) 58,000 (400)	36,000 (250)	1.61	23	40	ASTM A194 / A563 Grade A
	ASTM F1554 ⁴ Grade 55	psi (MPa) 75,000 (517)	55,000 (380)	1.36	23	40	
	ASTM F1554 ⁴ Grade 105	psi (MPa) 125,000 (860)	105,000 (724)	1.19	15	45	ASTM A194 / A563 Grade DH
	ASTM A449 ⁵ 3/8 to 1 in.	psi (MPa) 120,000 (830)	92,000 (635)	1.30	14	35	
	ASTM A449 ⁵ 1 1/4 in	psi (MPa) 105,000 (720)	81,000 (560)	1.30	14	35	
	ASTM F568M ⁶ Class 5.8 (equivalent to ISO 898-1)	psi (MPa) 72,500 (500)	58,000 (400)	1.25	10	35	ASTM A563 Grade DH DIN 934 (8-A2K) ¹³
	ISO 898-1 ⁷ Class 5.8	MPa (psi) 500 (72,500)	400 (58,000)	1.25	22	-	EN ISO 4032 Grade 6
	ISO 898-1 ⁷ Class 8.8	MPa (psi) 800 (116,000)	640 (92,800)	1.25	12	52	EN ISO 4032 Grade 8
STAINLESS STEEL	ASTM F593 ⁸ CW1 3/8 to 5/8 in. (316)	psi (MPa) 100,000 (690)	65,000 (450)	1.54	20	-	ASTM F594 Alloy Group 1, 2 or 3
	ASTM F593 ⁸ CW2 3/4 to 1 1/4 in. (316)	psi (MPa) 85,000 (590)	45,000 (310)	1.89	25	-	
	ASTM A193/A193M ⁹ Grade B8/B8M2, Class 2B	psi (MPa) 95,000 (655)	75,000 (515)	1.27	25	40	ASTM A194/A194M
	ISO 3506-1 ¹⁰ A4-70 (M8-M24)	MPa (psi) 700 (101,500)	450 (65,250)	1.56	40	-	EN ISO 4032
	ISO 3506-1 ¹⁰ A4-50 (M27-M30)	MPa (psi) 500 (72,500)	210 (30,450)	2.38	40	-	EN ISO 4032

¹Adhesive must be used with continuously threaded carbon or stainless steel rod (all-thread) having thread characteristics complying with ANSI B1.1 UNC Coarse Thread Series.

²Standard Specification for Alloy-Steel and Stainless steel Bolting Materials for High temperature of High Pressure service and Other Special Purpose Applications.

³Standard Specification for Carbon Structural steel

⁴Standard Specification for Anchor Bolts, Steel 36, 55 and 105-ksi Yield Strength.

⁵Standard Specification for Hex Cap Screws, Bolts and Studs, Heat Treated, 120/105/50 ksi Minimum Tensile Strength, General Use.

⁶Standard Specification for Carbon and Alloy Steel external Threaded Metric Fasteners.

⁷Mechanical properties of fasteners made of carbon steel and alloy steel - Part 1: Bolts, Screws and Studs.

⁸Standard Specification for Alloy-Steel and Stainless Steel Bolting for High Temperature or High Pressure Service and Other Special Purpose Applications.

⁹Standard Specification for Stainless Steel Bolts, Hex Cap Screws, and Studs.

¹⁰Mechanical properties of corrosion-resistant stainless steel fasteners - Part 1: Bolts, Screws and Studs.

¹¹Based on 2-in. (50 mm) gauge length except for ASTM A193, which is based on a gauge length of 4d.

¹²Nuts and washers of other grades and style having specified proof load stress greater than the specified grade and style are also suitable. Nuts must have specified proof load stresses equal to or greater than the minimum tensile strength of the specified threaded rod.

¹³Nuts for metric rods.

TABLE 3—SPECIFICATIONS AND PHYSICAL PROPERTIES OF COMMON CARBON REINFORCING BARS

REINFORCING SPECIFICATION	UNITS	MINIMUM SPECIFIED ULTIMATE STRENGTH, f_{uta}	MINIMUM SPECIFIED YIELD STRENGTH, f_{ya}
A996 ⁴ Grade 60	psi (MPa)	90,000 (620)	60,000 (414)
ASTM A615 ¹ , ASTM A706 ² , A757 ³ Grade 60	psi (MPa)	80,000 (550)	60,000 (414)
ASTM A615 ¹ , Grade 40	psi (MPa)	60,000 (415)	40,000 (275)
DIN 488 ⁵ BSt 500	MPa (psi)	550 (80,000)	500 (72,500)

¹Standard Specification for Deformed and Plain Carbon-Steel Bars for Concrete Reinforcement.
²Standard Specification for Low-Alloy Steel Deformed and Plain Bars for Concrete Reinforcement.
³Standard specification for Zinc-Coated (Galvanized) steel Bars for Concrete Reinforcement.
⁴Standard specification for Rail-Steel and Axle-steel Deformed bars for Concrete Reinforcement.
⁵Reinforcing steel, reinforcing steel bars; dimensions and masses.

Drilling and cleaning	Tool	Accessories and Shrouds	Vacuum
Dust extraction system for standard drilling and cleaning equipment		 SDS-Plus and SDS-Max Drill Bit  Capture Device CAT# 01128	 Dust Extractor
Chemofast hollow drill bit system	Rotary Drill Hammer	 Heller Duster Expert SDS-Plus and SDS-Max Hollow Drill Bit	 Class M vacuum with a minimum air flow rating of 90cfm (150m ³ /h resp. 42l/s).

FIGURE 1—CHEMOFAST DUST REMOVAL DRILLING SYSTEM WITH HEPA DUST EXTRACTOR OPTIONS

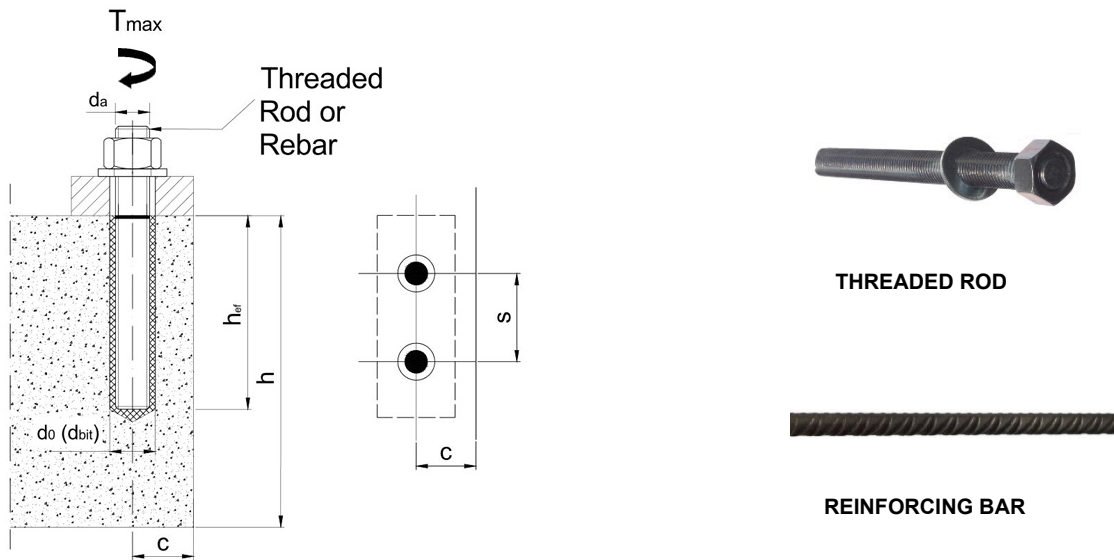


FIGURE 2—INSTALLATION PARAMETERS FOR THREADED RODS AND REINFORCING BARS

TABLE 4—STEEL DESIGN INFORMATION FOR U.S. CUSTOMARY UNIT THREADED ROD¹

DESIGN INFORMATION		Symbol	Units	Nominal Rod Diameter (inch)						
				3/8	1/2	5/8	3/4	7/8	1	1 1/4
Threaded rod O.D.		<i>d</i>	in. (mm)	0.375 (9.5)	0.500 (12.7)	0.625 (15.9)	0.750 (19.1)	0.875 (22.2)	1.000 (25.4)	1.250 (31.8)
Threaded rod effective cross-sectional area		<i>A_{se}</i>	in. ² (mm ²)	0.0775 (50)	0.1419 (92)	0.2260 (146)	0.3345 (216)	0.4617 (298)	0.6057 (391)	0.9691 (625)
ASTM A36/F1554, Grade 36	Nominal strength as governed by steel strength (for a single anchor)	<i>N_{sa}</i>	lb (kN)	4,495 (20.0)	8,230 (36.6)	13,110 (58.3)	19,400 (86.3)	26,780 (119.1)	35,130 (156.3)	56,210 (250.0)
		<i>V_{sa}</i>	lb (kN)	2,695 (12.0)	4,940 (22.0)	7,860 (35.0)	11,640 (51.8)	16,070 (71.4)	21,080 (93.8)	33,725 (150.0)
	Reduction factor for seismic shear	$\alpha_{V,seis}$	-	0.73						
	Strength reduction factor for tension ²	ϕ	-	0.75						
				Strength reduction factor for shear ²						
				0.65						
ASTM F1554 Grade 55	Nominal strength as governed by steel strength (for a single anchor)	<i>N_{sa}</i>	lb (kN)	5,815 (25.9)	10,645 (47.6)	16,950 (75.5)	25,090 (111.7)	34,630 (154.1)	45,430 (202.1)	72,685 (323.1)
		<i>V_{sa}</i>	lb (kN)	3,490 (15.5)	6,385 (28.6)	10,170 (45.3)	15,055 (67)	20,780 (92.5)	27,260 (121.3)	43,610 (193.9)
	Reduction factor for seismic shear	$\alpha_{V,seis}$	-	0.73						
	Strength reduction factor for tension ²	ϕ	-	0.75						
				Strength reduction factor for shear ²						
				0.65						
ASTM A193 Grade B7 ASTM F1554 Grade 105	Nominal strength as governed by steel strength (for a single anchor)	<i>N_{sa}</i>	lb (kN)	9,685 (43.1)	17,735 (78.9)	28,250 (125.7)	41,810 (186.0)	57,710 (256.7)	75,710 (336.8)	121,135 (538.8)
		<i>V_{sa}</i>	lb (kN)	5,810 (25.9)	10,640 (47.3)	16,950 (75.4)	25,085 (111.6)	34,625 (154.0)	45,425 (202.1)	72,680 (323.3)
	Reduction factor for seismic shear	$\alpha_{V,seis}$	-	0.73						
	Strength reduction factor for tension ²	ϕ	-	0.75						
				Strength reduction factor for shear ²						
				0.65						
ASTM A449	Nominal strength as governed by steel strength (for a single anchor)	<i>N_{sa}</i>	lb (kN)	9,300 (41.4)	17,030 (76.2)	27,120 (120.9)	40,140 (178.8)	55,405 (246.7)	72,685 (323.7)	101,755 (450.0)
		<i>V_{sa}</i>	lb (kN)	5,580 (24.8)	10,220 (45.7)	16,270 (72.5)	24,085 (107.3)	33,240 (148)	43,610 (194.2)	61,055 (270.0)
	Reduction factor for seismic shear	$\alpha_{V,seis}$	-	0.73						
	Strength reduction factor for tension ²	ϕ	-	0.75						
				Strength reduction factor for shear ²						
				0.65						
ASTM F688M Class 5.8	Nominal strength as governed by steel strength (for a single anchor)	<i>N_{sa}</i>	lb (kN)	5,620 (25)	10,290 (46)	16,385 (73)	24,250 (108)	33,470 (149)	43,910 (195.5)	70,260 (312.5)
		<i>V_{sa}</i>	lb (kN)	3,370 (15)	6,175 (27.6)	9,830 (43.8)	14,550 (64.8)	20,085 (89.4)	26,350 (117.3)	42,155 (187.5)
	Reduction factor for seismic shear	$\alpha_{V,seis}$	-	0.73						
	Strength reduction factor for tension ²	ϕ	-	0.65						
				Strength reduction factor for shear ²						
				0.60						
ASTM F593 CW Stainless	Nominal strength as governed by steel strength (for a single anchor)	<i>N_{sa}</i>	lb (kN)	7,750 (34.5)	14,190 (63.1)	22,600 (100.5)	28,430 (126.5)	39,245 (174.6)	51,485 (229.0)	82,370 (366.4)
		<i>V_{sa}</i>	lb (kN)	4,650 (20.7)	8,515 (37.9)	13,560 (60.3)	17,060 (75.9)	23,545 (104.7)	30,890 (137.4)	49,425 (219.8)
	Reduction factor for seismic shear	$\alpha_{V,seis}$	-	0.73						
	Strength reduction factor for tension ²	ϕ	-	0.65						
				Strength reduction factor for shear ²						
				0.60						
ASTM A193/A193M Grade B8/B8M2, Class 2B	Nominal strength as governed by steel strength (for a single anchor)	<i>N_{sa}</i>	lb (kN)	7,365 (32.8)	13,480 (60.3)	21,470 (95.6)	31,780 (141.5)	43,860 (195.2)	57,540 (256.1)	92,065 (409.4)
		<i>V_{sa}</i>	lb (kN)	4,420 (19.7)	8,090 (36.2)	12,880 (57.4)	19,070 (84.9)	26,320 (117.1)	34,525 (153.7)	55,240 (245.6)
	Reduction factor for seismic shear	$\alpha_{V,seis}$	-	0.73						
	Strength reduction factor for tension ²	ϕ	-	0.75						
				Strength reduction factor for shear ²						
				0.65						

¹Values provided for common rod material types based on specified strengths and calculated in accordance with ACI 318-19 Eq. 17.6.1.2 and Eq. 17.7.1.2b or ACI 318-14 Eq. 17.4.1.2 and Eq. 17.5.1.2b, as applicable. Nuts and washers must comply with requirements for the rod.

²The tabulated value of ϕ applies when the load combinations of Section 1605.1 of the 2024 or 2021 IBC or Section 1605.2 of the 2018 or 2015 IBC, ACI 318-19 and ACI 318-14 5.3, as applicable, as set forth in ACI 318-19 17.5.3 or ACI 318-14 17.3.3, as applicable, are used.

TABLE 5—CONCRETE BREAKOUT DESIGN INFORMATION FOR U.S. CUSTOMARY UNIT THREADED ROD IN HOLES DRILLED WITH ALL DRILLING METHODS¹

DESIGN INFORMATION	Symbol	Units	Nominal Rod Diameter (inch)						
			3/8	1/2	5/8	3/4	7/8	1	1 1/4
Effectiveness factor for cracked concrete	$k_{c,cr}$	in-lb (SI)	17 (7)						
Effectiveness factor for uncracked concrete	$k_{c,uncr}$	in-lb (SI)	24 (10)						
Min. anchor spacing	s_{min}	in. (mm)	1 7/8 (48)	2 1/2 (64)	3 (76)	3 3/4 (95)	4 1/4 (108)	4 3/4 (121)	5 7/8 (149)
Min. edge distance	c_{min}	in. (mm)	1 5/8 (41)	1 3/4 (44)	2 (51)	2 3/8 (60)	2 1/2 (64)	2 3/4 (70)	3 1/4 (82)
					See Section 4.1.9 of this report for smaller edge distance with 0.45 T_{max}				
Min. member thickness	h_{min}	in. (mm)	$h_{ef} + 1 1/4$ ($h_{ef} + 30$)		$h_{ef} + 2d_o^3$				
Critical edge distance - splitting (for uncracked concrete) ²	c_{ac}	-	See Section 4.1.10 of this report.						
Critical anchor spacing – splitting	s_{ac}	-	$2 \cdot c_{ac}$						
Strength reduction factor for tension, concrete failure modes, Condition B ²	ϕ	-	0.65						
Strength reduction factor for shear, concrete failure modes, Condition B ²	ϕ	-	0.70						

For **SI**: 1 inch = 25.4 mm, 1 lbf = 4.448 N, 1 psi = 0.06894 MPa.
 For **pound-inch** units: 1 mm = 0.03937 inches, 1 N = 0.2248 lbf, 1 MPa = 145.0 psi.

¹Additional setting information is described in [Figure 6](#), installation instructions.
²The strength reduction factor applies when the load combinations from the IBC or ACI 318 are used and the requirements of ACI 318-19 17.5.3 or ACI 318-14 17.3.3(c), as applicable, for Condition B (supplement reinforcement not present) are met. For installations where complying reinforcement can be verified, the applicable strength reduction factors described in ACI 318-19 17.5.3 or ACI 318-14 17.3.3(c), as applicable, may be used for Condition A (supplement reinforcement present).
³ d_o = hole diameter.



VARIOUS AVAILABLE TWO-COMPONENT CARTRIDGES



STATIC MIXING NOZZLE



CHEMOFAST DISPENSER

FIGURE 3—EP 1000 ADHESIVE ANCHOR SYSTEM

TABLE 6—BOND STRENGTH DESIGN INFORMATION FOR U.S. CUSTOMARY UNIT THREADED ROD IN HOLES DRILLED WITH A HAMMER DRILL AND CARBIDE BIT (OR CHEMOFAST HOLLOW CARBIDE DRILL BIT)¹

DESIGN INFORMATION			Symbol	Units	Nominal Rod Diameter (inch)						
					3/8	1/2	5/8	3/4	7/8	1	1 1/4
Minimum embedment			$h_{ef,min}$	in. (mm)	2 ³ / ₈ (60)	2 ³ / ₄ (70)	3 ¹ / ₈ (79)	3 ¹ / ₂ (89)	3 ¹ / ₂ (89)	4 (102)	5 (127)
Maximum embedment			$h_{ef,max}$	in. (mm)	7 ¹ / ₂ (191)	10 (254)	12 ¹ / ₂ (318)	15 (381)	17 ¹ / ₂ (445)	20 (508)	25 (635)
Temperature range A: 110°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete		$\tau_{k,uncr}$	psi (N/mm ²)	2,475 (17.1)	2,400 (16.5)	2,315 (16.0)	2,235 (15.4)	2,155 (14.9)	2,075 (14.3)	1,915 (13.2)
	Characteristic bond strength in cracked concrete		$\tau_{k,cr}$	psi (N/mm ²)	1,150 (7.9)	1,415 (9.8)	1,455 (10.0)	1,515 (10.4)	1,535 (10.6)	1,555 (10.7)	1,550 (10.7)
Temperature range B: 110°F / 153°F ^{2,3}	Characteristic bond strength in uncracked concrete		$\tau_{k,uncr}$	psi (N/mm ²)	2,845 (19.6)	2,755 (19.0)	2,665 (18.4)	2,570 (17.7)	2,480 (17.1)	2,385 (16.5)	2,205 (15.2)
	Characteristic bond strength in cracked concrete		$\tau_{k,cr}$	psi (N/mm ²)	1,325 (9.1)	1,630 (11.2)	1,675 (11.5)	1,740 (12.0)	1,765 (12.2)	1,785 (12.3)	1,785 (12.3)
Temperature range C: 122°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete		$\tau_{k,uncr}$	psi (N/mm ²)	2,325 (16.0)	2,250 (15.5)	2,175 (15.0)	2,100 (14.5)	2,025 (14.0)	1,950 (13.4)	1,800 (12.4)
	Characteristic bond strength in cracked concrete		$\tau_{k,cr}$	psi (N/mm ²)	1,145 (7.9)	1,390 (9.6)	1,400 (9.6)	1,420 (9.8)	1,440 (9.9)	1,460 (10.1)	1,455 (10.0)
Temperature range D: 140°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete		$\tau_{k,uncr}$	psi (N/mm ²)	1,105 (7.6)	1,065 (7.4)	1,030 (7.1)	995 (6.9)	960 (6.6)	925 (6.4)	855 (5.9)
	Characteristic bond strength in cracked concrete		$\tau_{k,cr}$	psi (N/mm ²)	650 (4.5)	660 (4.6)	665 (4.6)	675 (4.6)	685 (4.7)	690 (4.8)	690 (4.8)
CAC ⁴ cleaning	Dry Concrete	Anchor category	-	-	1						
		Strength reduction factor	ϕ_d	-	0.65						
	Water-saturated Concrete	Anchor category	-	-	1						
		Strength reduction factor	ϕ_{ws}	-	0.65						
	Water-filled holes	Anchor category	-	-	3						
		Strength reduction factor	ϕ_{wf}	-	0.45						
Modification factor for water filled holes		K_{wf}	-	1.0							
HDB ⁴ cleaning	Dry Concrete	Anchor category	-	-	1						
		Strength reduction factor	ϕ_d	-	0.65						
	Water-saturated Concrete	Anchor category	-	-	2						
		Strength reduction factor	ϕ_{ws}	-	0.55						
	Water-filled holes	Anchor category	-	-	3						
		Strength reduction factor	ϕ_{wf}	-	0.45						
		Modification factor for water filled holes	K_{wf}	-	1.0						
		Not applicable	-	-	0.87	0.91	0.95	1.0			
Reduction factor for seismic tension			$\alpha_{N,seis}$	-	1		0.98	0.97	0.95	0.92	

¹Bond strength values correspond to concrete compressive strength $f'_c = 2,500$ psi [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1]. For concrete compressive strength, f'_c between 2,500 psi and 8,000 psi, the tabulated characteristic bond strength may be increased by a factor of $(f'_c / 2500)^{0.1}$ [For SI: $(f'_c / 17.2)^{0.1}$]. See Section 4.1.4 of this report.

²Characteristic bond strengths are for sustained loads including dead and live loads. For load combinations consisting of short-term loads only such as wind, bond strengths may be increased by 10 percent for temperature range A and B, by 16 percent for temperature range C, and by 144 percent for temperature range D.

³Short term elevated concrete temperatures are those that occur over brief intervals, e.g. as result of diurnal cycling. Long term concrete temperatures are roughly constant over significant periods of time.

Temperature range A: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 110°F (43°C);

Temperature range B: Maximum short term temperature = 153°F (67°C), maximum long term temperature = 110°F (43°C);

Temperature range C: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 122°F (50°C);

Temperature range D: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 140°F (60°C).

⁴CAC: compressed air cleaning see [Figure 6](#); HDB: cleaning during drilling action with hollow drill bit system

TABLE 7—BOND STRENGTH DESIGN INFORMATION FOR U.S. CUSTOMARY UNIT THREADED ROD IN HOLES DRILLED WITH A CORE DRILL AND DIAMOND CORE BIT ¹

DESIGN INFORMATION			Symbol	Units	Nominal Rod Diameter (inch)						
					3/8	1/2	5/8	3/4	7/8	1	1 1/4
Minimum embedment			$h_{ef,min}$	in. (mm)	2 3/8 (60)	2 3/4 (70)	3 1/8 (79)	3 1/2 (89)	3 1/2 (89)	4 (102)	5 (127)
Maximum embedment			$h_{ef,max}$	in. (mm)	7 1/2 (191)	10 (254)	12 1/2 (318)	15 (381)	17 1/2 (445)	20 (508)	25 (635)
Temperature range C: 122°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete		$\tau_{k,uncr}$	psi (N/mm ²)	1,565 (10.8)	1,455 (10.0)	1,375 (9.5)	1,310 (9.0)	1,260 (8.7)	1,220 (8.4)	1,150 (7.9)
	SPCAC ⁴ cleaning	Dry Concrete	Anchor category	-	-	1					
Strength reduction factor			ϕ_{bc}	-	0.65						
Water-saturated Concrete		Anchor category	-	-	1	2					
		Strength reduction factor	ϕ_{ws}	-	0.65	0.55					
Water-filled holes		Anchor category	-	-	3						
		Strength reduction factor	ϕ_{wf}	-	0.45						
	Modification factor for water filled holes	K_{wf}	-	1.0	0.99	0.96	0.95	0.93	0.90		

¹Bond strength values correspond to concrete compressive strength $f'_c = 2,500$ psi [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1]. For concrete compressive strength, f'_c between 2,500 psi and 8,000 psi, the tabulated characteristic bond strength may be increased by a factor of $(f'_c / 2500)^{0.2}$ [For SI: $(f'_c / 17.2)^{0.2}$]. See Section 4.1.4 of this report.

²Characteristic bond strengths are for sustained loads including dead and live loads. For load combinations consisting of short-term loads only such as wind, bond strengths may be increased by 4 percent for temperature range C.

³Short term elevated concrete temperatures are those that occur over brief intervals, e.g. as result of diurnal cycling. Long term concrete temperatures are roughly constant over significant periods of time.

Temperature range C: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 122°F (50°C).

⁴SPCAC: see [Figure 6](#)

TABLE 8—STEEL DESIGN INFORMATION FOR U.S. CUSTOMARY UNIT REINFORCING BARS ¹

DESIGN INFORMATION		Symbol	Units	Nominal Bar Size							
				No. 3	No. 4	No. 5	No. 6	No. 7	No. 8	No. 9	No. 10
Reinforcing bar O.D.		d	in. (mm)	0.375 (9.5)	0.500 (12.7)	0.625 (15.9)	0.750 (19.1)	0.875 (22.2)	1.000 (25.4)	1.125 (28.6)	1.250 (31.8)
Reinforcing bar effective cross-sectional area		A_{se}	in. ² (mm ²)	0.110 (71)	0.200 (129)	0.310 (200)	0.440 (284)	0.600 (387)	0.790 (510)	1.000 (645)	1.270 (819)
ASTM A996 Grade 60	Nominal strength as governed by steel strength (for a single anchor)	N_{sa}	lb (kN)	9,900 (44.0)	18,000 (80.1)	27,900 (124.1)	39,600 (176.0)	54,000 (240.0)	71,100 (316.0)	90,000 (400.0)	114,300 (508.0)
		V_{sa}	lb (kN)	5,940 (26.4)	10,800 (48.0)	16,740 (74.5)	23,760 (105.7)	32,400 (144.1)	42,660 (189.8)	54,000 (240.2)	68,580 (305.0)
	Reduction factor for seismic shear	$\alpha_{V,seis}$	-	0.76							
	Strength reduction factor for tension ²	ϕ	-	0.65							
	Strength reduction factor for shear ²	ϕ	-	0.60							
ASTM A615, A706, A757 Grade 60	Nominal strength as governed by steel strength (for a single anchor)	N_{sa}	lb (kN)	8,800 (39.1)	16,000 (71.2)	24,800 (110.3)	35,200 (156.6)	48,000 (213.5)	63,200 (281.1)	80,000 (355.9)	101,600 (452.0)
		V_{sa}	lb (kN)	5,280 (23.5)	9,600 (42.7)	14,880 (66.2)	21,120 (93.9)	28,800 (128.1)	37,920 (168.7)	48,000 (213.5)	60,960 (271.2)
	Reduction for seismic shear	$\alpha_{V,seis}$	----	0.76							
	Strength reduction factor ϕ for tension ²	ϕ	----	0.75							
	Strength reduction factor ϕ for shear ²	ϕ	----	0.65							
ASTM A615 Grade 40	Nominal strength as governed by steel strength (for a single anchor)	N_{sa}	lb (kN)	6,600 (29.4)	12,000 (53.4)	18,600 (82.7)	26,400 (117.4)	In accordance with ASTM A615, Grade 40 bars are furnished only in sizes No. 3 through No. 6			
		V_{sa}	lb (kN)	3,960 (17.6)	7,200 (32.0)	11,160 (49.6)	15,840 (70.5)				
	Reduction factor for seismic shear	$\alpha_{V,seis}$	-	0.76							
	Strength reduction factor for tension ²	ϕ	-	0.65							
	Strength reduction factor for shear ²	ϕ	-	0.60							

¹Values provided for common bar material types based on specified strengths and calculated in accordance with ACI 318-19 Eq. 17.6.1.2 and Eq. 17.7.1.2b or ACI 318-14 Eq. 17.4.1.2 and Eq. 17.5.1.2b, as applicable.

²The tabulated value of ϕ applies when the load combinations of Section 1605.1 of the 2024 and 2021 IBC or Section 1605.2 of the 2018 and 2015 IBC, or ACI 318-19 and ACI 318-14 5.3, as applicable, as set forth in ACI 318-19 17.5.3 or ACI 318-14 17.3.3, as applicable, are used.

³In accordance with ASTM A615, Grade 40 bars are furnished only in sizes No. 3 through No. 6.

TABLE 9—CONCRETE BREAKOUT DESIGN INFORMATION FOR U.S. CUSTOMARY UNIT REINFORCING BARS IN HOLES DRILLED WITH ALL DRILLING METHODS¹

DESIGN INFORMATION	Symbol	Units	Nominal Bar Size							
			No. 3	No. 4	No. 5	No. 6	No. 7	No. 8	No. 9	No.10
Effectiveness factor for cracked concrete	$k_{c,cr}$	in.-lb (SI)	17 (7)							
Effectiveness factor for uncracked concrete	$k_{c,uncr}$	in.-lb (SI)	24 (10)							
Min. anchor spacing	s_{min}	in. (mm)	1 ⁷ / ₈ (48)	2 ¹ / ₂ (64)	3 ¹ / ₈ (79)	3 ³ / ₄ (95)	4 ³ / ₈ (111)	5 (127)	5 ⁵ / ₈ (143)	6 ¹ / ₄ (159)
Min. edge spacing ⁴	c_{min}	in. (mm)	1 ⁵ / ₈ (41)	1 ³ / ₄ (44)	2 (51)	2 ³ / ₈ (60)	2 ¹ / ₂ (64)	2 ³ / ₄ (70)	3 (76)	3 ¹ / ₄ (82)
Min. member thickness	h_{min}	in. (mm)	$h_{ef} + 1\frac{1}{4}$ ($h_{ef} + 30$)		$h_{ef} + 2d_o$ ³					
Critical edge spacing – splitting (for uncracked concrete) ²	c_{ac}	-	See Section 4.1.10 of this report.							
Critical anchor spacing – splitting	s_{ac}	-	2 · c_{ac}							
Strength reduction factor for tension, concrete failure modes, Condition B ²	ϕ	-	0.65							
Strength reduction factor for shear, concrete failure modes, Condition B ²	ϕ	-	0.70							

¹Additional setting information is described in [Figure 6](#), installation instructions.

²The strength reduction factor applies when the load combinations from the IBC or ACI 318 are used and the requirements of ACI 318-19 17.5.3 or ACI 318-14 17.3.3(c), as applicable, for Condition B (supplement reinforcement not present) are met. For installations where complying reinforcement can be verified, the applicable strength reduction factors described in ACI 318-19 17.5.3 or ACI 318-14 17.3.3(c), as applicable, may be used for Condition A (supplement reinforcement present).

³ d_o = hole diameter.

⁴The edge distances, c_{min} less than the values given in the table may be reduced subject to the anchor spacing, s_{min} in accordance with Section 4.1.9.

TABLE 10—BOND STRENGTH DESIGN INFORMATION FOR U.S. CUSTOMARY UNIT REINFORCING BARS IN HOLES DRILLED WITH A HAMMER DRILL AND CARBIDE BIT (OR CHEMOFAST HOLLOW CARBIDE DRILL BIT)¹

DESIGN INFORMATION		Symbol	Units	Nominal Bar Size							
				No. 3	No. 4	No. 5	No. 6	No. 7	No. 8	No. 9	No. 10
Minimum embedment		$h_{ef,min}$	in. (mm)	2 ³ / ₈ (60)	2 ³ / ₄ (70)	3 ¹ / ₈ (79)	3 ¹ / ₂ (89)	3 ¹ / ₂ (89)	4 (102)	4 ¹ / ₂ (114)	5 (127)
Maximum embedment		$h_{ef,max}$	in. (mm)	7 ¹ / ₂ (191)	10 (254)	12 ¹ / ₂ (318)	15 (381)	17 ¹ / ₂ (445)	20 (508)	22 ¹ / ₂ (572)	25 (635)
Temperature range A: 110°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete	$\tau_{k,uncr}$	psi (N/mm ²)	2,060 (14.2)	2,035 (14.0)	2,015 (13.9)	1,990 (13.7)	1,965 (13.6)	1,945 (13.4)	1,920 (13.2)	1,895 (13.1)
	Characteristic bond strength in cracked concrete	$\tau_{k,cr}$	psi (N/mm ²)	1,350 (9.3)	1,740 (12.0)	1,725 (11.9)	1,695 (11.7)	1,680 (11.6)	1,650 (11.4)	1,635 (11.3)	1,605 (11.1)
Temperature range B: 110°F / 153°F ^{2,3}	Characteristic bond strength in uncracked concrete	$\tau_{k,uncr}$	psi (N/mm ²)	2,365 (16.3)	2,340 (16.1)	2,315 (16.0)	2,285 (15.8)	2,260 (15.6)	2,235 (15.4)	2,205 (15.2)	2,180 (15.0)
	Characteristic bond strength in cracked concrete	$\tau_{k,cr}$	psi (N/mm ²)	1,550 (10.7)	2,000 (13.8)	1,985 (13.7)	1,945 (13.4)	1,930 (13.3)	1,895 (13.1)	1,880 (13.0)	1,845 (12.7)
Temperature range C: 122°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete	$\tau_{k,uncr}$	psi (N/mm ²)	1,935 (13.3)	1,915 (13.2)	1,890 (13.0)	1,870 (12.9)	1,845 (12.7)	1,825 (12.6)	1,805 (12.4)	1,780 (12.3)
	Characteristic bond strength in cracked concrete	$\tau_{k,cr}$	psi (N/mm ²)	1,340 (9.2)	1,635 (11.4)	1,620 (11.2)	1,590 (11.0)	1,580 (10.9)	1,550 (10.7)	1,535 (10.6)	1,510 (10.4)
Temperature range D: 140°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete	$\tau_{k,uncr}$	psi (N/mm ²)	915 (6.3)	905 ⁵ (6.3)	895 (6.2)	885 (6.1)	875 (6.0)	865 (6.0)	855 (5.9)	845 (5.8)
	Characteristic bond strength in cracked concrete	$\tau_{k,cr}$	psi (N/mm ²)	780 (95.4)	775 (5.3)	770 (5.3)	755 (5.2)	750 (5.2)	735 (5.1)	730 (5.0)	715 (4.9)
CAC ⁴ cleaning	Dry Concrete	Anchor category	-	-	1						
		Strength reduction factor	ϕ_d	-	0.65						
	Water-saturated Concrete	Anchor category	-	-	1						
		Strength reduction factor	ϕ_{ws}	-	0.65						
	Water-filled holes	Anchor category	-	-	3						
		Strength reduction factor	ϕ_{wf}	-	0.45						
Modification factor for water filled holes		K_{wf}	-	1.0							
HDB ⁴ cleaning	Dry Concrete	Anchor category	-	-	1						
		Strength reduction factor	ϕ_d	-	0.65						
	Water-saturated Concrete	Anchor category	-	-	2						
		Strength reduction factor	ϕ_{ws}	-	0.55						
	Water-filled holes	Anchor category	-	-	3						
		Strength reduction factor	ϕ_{wf}	-	0.45						
		Modification factor for water filled holes	K_{wf}	-	0.86	0.91	0.95	1			
Reduction factor for seismic tension		$\alpha_{N,seis}$	-	1			0.98	0.97	0.95	0.92	

¹Bond strength values correspond to concrete compressive strength $f'_c = 2,500$ psi [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1]. For concrete compressive strength, f'_c between 2,500 psi and 8,000 psi, the tabulated characteristic bond strength may be increased by a factor of $(f'_c / 2500)^{0.1}$ [For SI: $(f'_c / 17.2)^{0.1}$]. See Section 4.1.4 of this report.

²Characteristic bond strengths are for sustained loads including dead and live loads. For load combinations consisting of short-term loads only such as wind, bond strengths may be increased by 10 percent for temperature range A and B, by 16 percent for temperature range C, and by 144 percent for temperature range D.

³Short term elevated concrete temperatures are those that occur over brief intervals, e.g. as result of diurnal cycling. Long term concrete temperatures are roughly constant over significant periods of time.

Temperature range A: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 110°F (43°C);

Temperature range B: Maximum short term temperature = 153°F (67°C), maximum long term temperature = 110°F (43°C);

Temperature range C: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 122°F (50°C)

Temperature range D: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 140°F (60°C).

⁴CAC: compressed air cleaning see [Figure 6](#); HDB: cleaning during drilling action with hollow drill bit system.

⁵Not applicable for installation with HDB cleaning in water-filled holes for short term loads only.

TABLE 11—BOND STRENGTH DESIGN INFORMATION FOR U.S. CUSTOMARY UNIT REINFORCING BARS IN HOLES DRILLED WITH A CORE DRILL AND DIAMOND CORE BIT¹

DESIGN INFORMATION		Symbol	Units	Nominal Bar Size								
				No. 3	No. 4	No. 5	No. 6	No. 7	No. 8	No. 9	No. 10	
Minimum embedment		$h_{ef,min}$	in. (mm)	2 ³ / ₈ (60)	2 ³ / ₄ (70)	3 ¹ / ₈ (79)	3 ¹ / ₂ (89)	3 ¹ / ₂ (89)	4 (102)	4 ¹ / ₂ (114)	5 (127)	
Maximum embedment		$h_{ef,max}$	in. (mm)	7 ¹ / ₂ (191)	10 (254)	12 ¹ / ₂ (318)	15 (381)	17 ¹ / ₂ (445)	20 (508)	22 ¹ / ₂ (572)	25 (635)	
Temperature range C: 122°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete		$\tau_{k,uncr}$	psi (N/mm ²)	1,620 (11.2)	1,545 (10.6)	1,485 (10.2)	1,440 (9.9)	1,405 (9.7)	1,370 (9.5)	1,345 (9.3)	1,320 (9.1)
	SPCAC ⁴ cleaning	Dry Concrete	Anchor category	–	–	1						
Strength reduction factor			ϕ_d	–	0.65							
Water-saturated Concrete		Anchor category	–	–	2							
		Strength reduction factor	ϕ_{ws}	–	0.55							
Water-filled holes		Anchor category	–	–	3							
		Strength reduction factor	ϕ_{wft}	–	0.45							
	Modification factor for water filled holes	K_{wft}	–	0.90								

¹Bond strength values correspond to concrete compressive strength $f'_c = 2,500$ psi [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1]. For concrete compressive strength, f'_c between 2,500 psi and 8,000 psi, the tabulated characteristic bond strength may be increased by a factor of $(f'_c / 2500)^{0.2}$ [For SI: $(f'_c / 17.2)^{0.2}$]. See Section 4.1.4 of this report.

²Characteristic bond strengths are for sustained loads including dead and live loads. For load combinations consisting of short-term loads only such as wind, bond strengths may be increased by 4 percent for temperature range C.

³Short term elevated concrete temperatures are those that occur over brief intervals, e.g. as result of diurnal cycling. Long term concrete temperatures are roughly constant over significant periods of time.

Temperature range C: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 122°F (50°C).

⁴SPCAC: see [Figure 6](#)

TABLE 12—STEEL DESIGN INFORMATION FOR METRIC THREADED ROD¹

DESIGN INFORMATION	Symbol	Units	Nominal Rod Diameter (mm)								
			M8	M10	M12	M16	M20	M24	M27	M30	
Threaded rod O.D.	<i>d</i>	mm (in.)	8 (0.31)	10 (0.39)	12 (0.47)	16 (0.63)	20 (0.79)	24 (0.94)	27 (1.06)	30 (1.18)	
Threaded rod effective cross-sectional area	<i>A_{se}</i>	mm ² (in. ²)	36.6 (0.57)	58.0 (0.090)	84.3 (0.131)	157 (0.243)	245 (0.380)	353 (0.547)	459 (0.711)	561 (0.870)	
ISO 898-1 Class 5.8	Nominal strength as governed by steel strength (for a single anchor)	<i>N_{sa}</i>	kN (lb)	18.3 (4,114)	29.0 (6,518)	42.2 (9,473)	78.5 (17,643)	122.5 (27,532)	176.5 (39,668)	229.5 (51,580)	280.5 (63,043)
		<i>V_{sa}</i>	kN (lb)	11.0 (2,470)	14.5 (3,260)	25.3 (5,684)	47.1 (10,586)	73.5 (16,519)	105.9 (23,801)	137.7 (30,948)	168.3 (37,826)
	Reduction factor for seismic shear	$\alpha_{V,seis}$	-	0.78							
	Strength reduction factor for tension ²	ϕ	-	0.65							
	Strength reduction factor for shear ²	ϕ	-	0.60							
ISO 898-1 Class 8.8	Nominal strength as governed by steel strength (for a single anchor)	<i>N_{sa}</i>	kN (lb)	29.3 (6,582)	46.4 (10,428)	67.4 (15,157)	125.6 (28,229)	196 (44,051)	282.4 (63,470)	367.2 (82,528)	448.8 (100,868)
		<i>V_{sa}</i>	kN (lb)	17.6 (3,949)	23.0 (5,216)	40.5 (9,094)	75.4 (16,937)	117.6 (26,431)	169.4 (38,082)	220.3 (49,517)	269.3 (60,521)
	Reduction factor for seismic shear	$\alpha_{V,seis}$	-	0.78							
	Strength reduction factor for tension ²	ϕ	-	0.65							
	Strength reduction factor for shear ²	ϕ	-	0.60							
ISO 3506-1, A4 stainless steel ³	Nominal strength as governed by steel strength (for a single anchor)	<i>N_{sa}</i>	kN (lb)	25.6 (5,760)	40.6 (9,125)	59 (13,263)	109.9 (24,700)	171.5 (38,545)	247.1 (55,536)	229.5 (51,580)	280.5 (63,043)
		<i>V_{sa}</i>	kN (lb)	15.4 (3,456)	20.3 (4,564)	35.4 (7,958)	65.9 (14,820)	102.9 (23,127)	148.3 (33,322)	137.7 (30,948)	168.3 (37,826)
	Reduction factor for seismic shear	$\alpha_{V,seis}$	-	0.78							
	Strength reduction factor for tension ²	ϕ	-	0.65							
	Strength reduction factor for shear ²	ϕ	-	0.60							

¹Values provided for common rod material types based on specified strengths and calculated in accordance with ACI 318-19 Eq. 17.6.1.2 and Eq. 17.7.1.2b or ACI 318-14 Eq. 17.4.1.2 and Eq. 17.5.1.2b, as applicable. Nuts and washers must comply with requirements for the rod.

²The tabulated value of ϕ applies when the load combinations of Section 1605.1 of the 2024 and 2021 IBC or Section 1605.2 of the 2018 and 2015 IBC, or ACI 318-19 and ACI 318-14 5.3, as applicable, as set forth in ACI 318-19 17.5.3 or ACI 318-14 17.3.3, as applicable, are used.

³A4-70 Stainless steel (M8-M24); A4-50 Stainless steel (M27-M30).

TABLE 13—CONCRETE BREAKOUT DESIGN INFORMATION FOR METRIC THREADED ROD IN HOLES DRILLED WITH ALL DRILLING METHODS¹

DESIGN INFORMATION	Symbol	Units	Nominal Rod Diameter (mm)							
			M8	M10	M12	M16	M20	M24	M27	M30
Effectiveness factor for cracked concrete	<i>k_{c,cr}</i>	SI (in-lb)	7 (17)							
Effectiveness factor for uncracked concrete	<i>k_{c,uncr}</i>	SI (in-lb)	10 (24)							
Min. anchor spacing	<i>s_{min}</i>	mm (in.)	40 (1 ⁵ / ₈)	50 (2)	60 (2 ³ / ₈)	75 (3)	95 (3 ³ / ₄)	115 (4 ¹ / ₂)	125 (5)	140 (5 ¹ / ₂)
Min. edge distance	<i>c_{min}</i>	mm (in.)	35 (1 ³ / ₈)	40 (1 ⁵ / ₈)	45 (1 ³ / ₄)	50 (2)	60 (2 ³ / ₈)	65 (2 ¹ / ₂)	75 (3)	80 (3 ¹ / ₈)
			See Section 4.1.9 of this report for smaller edge distance with 0.45 <i>T_{max}</i>							
Min. member thickness	<i>h_{min}</i>	mm (in.)	$h_{ef} + 30$ ($h_{ef} + 1\frac{1}{4}$)				$h_{ef} + 2d_o^3$			
Critical edge distance - splitting (for uncracked concrete) ²	<i>c_{ac}</i>	-	See Section 4.1.10 of this report.							
Strength reduction factor for tension, concrete failure modes, Condition B ²	ϕ	-	0.65							
Strength reduction factor for shear, concrete failure modes, Condition B ²	ϕ	-	0.70							

¹Additional setting information is described in Figure 6, installation instructions.

²The strength reduction factor applies when the load combinations from the IBC or ACI 318 are used and the requirements of ACI 318-19 17.5.3 or ACI 318-14 17.3.3(c), as applicable, for Condition B (supplement reinforcement not present) are met. For installations where complying reinforcement can be verified, the applicable strength reduction factors described in ACI 318-19 17.5.3 or ACI 318-14 17.3.3(c), as applicable, may be used for Condition A (supplement reinforcement present).

³*d_o* = hole diameter.

TABLE 14—BOND STRENGTH DESIGN INFORMATION FOR METRIC THREADED ROD IN HOLES DRILLED WITH A HAMMER DRILL AND CARBIDE BIT (OR CHEMFAST HOLLOW CARBIDE DRILL BIT)¹

DESIGN INFORMATION			Symbol	Units	Nominal Rod Diameter (mm)							
					M8	M10	M12	M16	M20	M24	M27	M30
Minimum embedment			$h_{ef,min}$	mm (in.)	60 (2.4)	60 (2.4)	70 (2.8)	80 (3.1)	90 (3.5)	96 (3.8)	108 (4.3)	120 (4.7)
Maximum embedment			$h_{ef,max}$	mm (in.)	120 (4.7)	200 (7.9)	240 (9.4)	320 (12.6)	400 (15.7)	480 (18.9)	540 (21.3)	600 (23.6)
Temperature range A: 110°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete		$\tau_{k,uncr}$	psi (N/mm ²)	2,515 (17.3)	2,465 (17.0)	2,415 (16.6)	2,315 (16.0)	2,215 (15.3)	2,110 (14.6)	2,035 (14.0)	1,960 (13.5)
	Characteristic bond strength in cracked concrete		$\tau_{k,cr}$	psi (N/mm ²)	1,130 (7.8)	1,165 (8.0)	1,405 (9.7)	1,455 (10.0)	1,520 (10.5)	1,550 (10.7)	1,570 (10.8)	1,570 (10.8)
Temperature range B: 110°F / 153°F ^{2,3}	Characteristic bond strength in uncracked concrete		$\tau_{k,uncr}$	psi (N/mm ²)	2,890 (19.9)	2,835 (19.5)	2,775 (19.1)	2,660 (18.3)	2,545 (17.5)	2,425 (16.7)	2,340 (16.1)	2,255 (15.5)
	Characteristic bond strength in cracked concrete		$\tau_{k,cr}$	psi (N/mm ²)	1,300 (9.0)	1,335 (9.2)	1,615 (11.1)	1,675 (11.5)	1,750 (12.1)	1,780 (12.3)	1,805 (12.4)	1,805 (12.4)
Temperature range C: 122°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete		$\tau_{k,uncr}$	psi (N/mm ²)	2,365 (16.3)	2,315 (16.0)	2,270 (15.6)	2,175 (15.0)	2,080 (14.3)	1,985 (13.7)	1,915 (13.2)	1,840 (12.7)
	Characteristic bond strength in cracked concrete		$\tau_{k,cr}$	psi (N/mm ²)	1,125 (7.7)	1,155 (8.0)	1,380 (9.5)	1,400 (9.6)	1,430 (9.9)	1,455 (10.0)	1,475 (10.2)	1,475 (10.2)
Temperature range D: 140°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete		$\tau_{k,uncr}$	psi (N/mm ²)	1,120 (7.7)	1,100 (7.6)	1,075 (7.4)	1,030 (7.1)	985 (6.8)	940 (6.5)	905 (6.3)	875 (6.0)
	Characteristic bond strength in cracked concrete		$\tau_{k,cr}$	psi (N/mm ²)	645 (4.4)	655 (4.5)	655 (4.5)	665 (4.6)	675 (4.7)	690 (4.8)	700 (4.8)	700 (4.8)
CAC ⁴ cleaning	Dry Concrete	Anchor category	—	-	1							
		Strength reduction factor	ϕ_d	-	0.65							
	Water-saturated Concrete	Anchor category	—	-	1							
		Strength reduction factor	ϕ_{ws}	-	0.65							
	Water-filled holes	Anchor category	—	-	3							
		Strength reduction factor	ϕ_{wf}	-	0.45							
Modification factor for water filled holes		K_{wf}	-	1.0								
HDB ⁴ cleaning	Dry Concrete	Anchor category	—	-	1							
		Strength reduction factor	ϕ_d	-	0.65							
	Water-saturated Concrete	Anchor category	—	-	Not applicable	2						
		Strength reduction factor	ϕ_{ws}	-		0.55						
	Water-filled holes	Anchor category	—	-		3						
		Strength reduction factor	ϕ_{wf}	-		0.45						
Modification factor for water filled holes		K_{wf}	-	0.86		0.91	0.96	1				
Reduction factor for seismic tension			$\alpha_{N,seis}$	-		1		0.99	0.98	0.96	0.94	0.93

¹Bond strength values correspond to concrete compressive strength $f'_c = 2,500$ psi [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1]. For concrete compressive strength, f'_c between 2,500 psi and 8,000 psi, the tabulated characteristic bond strength may be increased by a factor of $(f'_c / 2500)^{0.1}$ [For SI: $(f'_c / 17.2)^{0.1}$]. See Section 4.1.4 of this report.

²Characteristic bond strengths are for sustained loads including dead and live loads. For load combinations consisting of short-term loads only such as wind, bond strengths may be increased by 10 percent for temperature range A and B, by 16 percent for temperature range C, and by 144 percent for temperature range D.

³Short term elevated concrete temperatures are those that occur over brief intervals, e.g. as result of diurnal cycling. Long term concrete temperatures are roughly constant over significant periods of time.

Temperature range A: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 110°F (43°C);

Temperature range B: Maximum short term temperature = 153°F (67°C), maximum long term temperature = 110°F (43°C);

Temperature range C: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 122°F (50°C);

Temperature range D: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 140°F (60°C).

⁴CAC: compressed air cleaning see [Figure 6](#); HDB: cleaning during drilling action with hollow drill bit system

TABLE 15—BOND STRENGTH DESIGN INFORMATION FOR METRIC THREADED ROD IN HOLES DRILLED WITH A CORE DRILL AND DIAMOND CORE BIT ¹

DESIGN INFORMATION		Symbol	Units	Nominal Rod Diameter (mm)								
				M8	M10	M12	M16	M20	M24	M27	M30	
Minimum embedment		$h_{ef,min}$	mm (in.)	60 (2.4)	60 (2.4)	70 (2.8)	80 (3.1)	90 (3.5)	96 (3.8)	108 (4.3)	120 (4.7)	
Maximum embedment		$h_{ef,max}$	mm (in.)	120 (4.7)	200 (7.9)	240 (9.4)	320 (12.6)	400 (15.7)	480 (18.9)	540 (21.3)	600 (23.6)	
Temperature range C: 122°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete		$\tau_{k,uncr}$	psi (N/mm ²)	1,635 (11.3)	1,545 (10.6)	1,475 (10.2)	1,370 (9.4)	1,295 (8.9)	1,235 (8.5)	1,200 (8.3)	1,170 (8.1)
	SPCAC ⁴ cleaning	Dry Concrete	Anchor category	–	–	1						
Strength reduction factor			ϕ_d	–	0.65							
Water-saturated Concrete		Anchor category	–	–	1			2				
		Strength reduction factor	ϕ_{ws}	–	0.65			0.55				
Water-filled holes		Anchor category	–	–	3							
		Strength reduction factor	ϕ_{wf}	–	0.45							
	Modification factor for water filled holes	K_{wf}	–	1.0		0.99	0.96	0.94	0.92	0.91		

¹Bond strength values correspond to concrete compressive strength $f'_c = 2,500$ psi [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1]. For concrete compressive strength, f'_c between 2,500 psi and 8,000 psi, the tabulated characteristic bond strength may be increased by a factor of $(f'_c / 2500)^{0.2}$ [For SI: $(f'_c / 17.2)^{0.2}$]. See Section 4.1.4 of this report.

²Characteristic bond strengths are for sustained loads including dead and live loads. For load combinations consisting of short-term loads only such as wind, bond strengths may be increased by 4 percent for temperature range C.

³Short term elevated concrete temperatures are those that occur over brief intervals, e.g. as result of diurnal cycling. Long term concrete temperatures are roughly constant over significant periods of time.

Temperature range C: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 122°F (50°C).

⁴SPCAC: see [Figure 6](#)

TABLE 16—STEEL DESIGN INFORMATION FOR METRIC REINFORCING BARS ¹

DESIGN INFORMATION		Symbol	Units	Nominal Bar Size								
				Ø 8	Ø 10	Ø 12	Ø 14	Ø 16	Ø 20	Ø 25	Ø 28	Ø 32
Reinforcing bar O.D.		d	mm (in.)	8 (0.315)	10 (0.394)	12 (0.472)	14 (0.551)	16 (0.630)	20 (0.787)	25 (0.984)	28 (1.102)	32 (1.260)
Reinforcing bar effective cross-sectional area		A_{se}	mm ² (in. ²)	50 (0.078)	78.5 (0.121)	113.1 (0.175)	153.9 (0.239)	201.1 (0.312)	314.2 (0.487)	490.9 (0.761)	615.8 (0.954)	804.2 (1.247)
DIN 488 BSt 500	Nominal strength as governed by steel strength (for a single anchor)	N_{sa}	kN (lb)	27.5 (6,182)	43.2 (9,739)	62.2 (14,024)	84.7 (19,088)	110.6 (24,932)	172.8 (38,956)	270.0 (60,868)	338.7 (76,353)	442.3 (99,727)
		V_{sa}	kN (lb)	16.5 (3,709)	25.9 (5,843)	37.3 (8,414)	50.8 (11,453)	66.4 (14,959)	103.7 (23,373)	162.0 (36,521)	203.2 (45,812)	265.4 (59,836)
	Reduction factor for seismic shear	$\alpha_{V,seis}$	–	0.75								
	Strength reduction factor for tension ²	ϕ	–	0.65								
	Strength reduction factor for shear ²	ϕ	–	0.60								

¹Values provided for common bar material types based on specified strengths and calculated in accordance with ACI 318-19 Eq. 17.6.1.2 and Eq. 17.7.1.2b or ACI 318-14 Eq. 17.4.1.2 and Eq. 17.5.1.2b, as applicable.

²The tabulated value of ϕ applies when the load combinations of Section 1605.1 of the 2024 and 2021 IBC or Section 1605.2 of the 2018 and 2015 IBC, or ACI 318-19 and ACI 318-14 5.3, as applicable, as set forth in ACI 318-19 17.5.3 or ACI 318-14 17.3.3, as applicable, are used.

**TABLE 17—CONCRETE BREAKOUT DESIGN INFORMATION FOR METRIC REINFORCING BARS
IN HOLES DRILLED WITH ALL DRILLING METHODS¹**

DESIGN INFORMATION	Symbol	Units	Nominal Bar Size								
			ø 8	ø 10	ø 12	ø 14	ø 16	ø 20	ø 25	ø 28	ø 32
Effectiveness factor for cracked concrete	$k_{c,cr}$	SI (in-lb)	7 (17)								
Effectiveness factor for uncracked concrete	$k_{c,uncr}$	SI (in-lb)	10 (24)								
Min. anchor spacing	s_{min}	mm (in.)	40 (1 ⁵ / ₈)	50 (2)	60 (2 ³ / ₈)	70 (2 ³ / ₄)	75 (3)	95 (3 ³ / ₄)	120 (4 ⁵ / ₈)	130 (5 ¹ / ₄)	150 (5 ⁷ / ₈)
Min. edge spacing ⁴	c_{min}	mm (in.)	35 (1 ³ / ₈)	40 (1 ⁵ / ₈)	45 (1 ³ / ₄)	50 (2)	50 (2)	60 (2 ³ / ₈)	70 (2 ³ / ₄)	75 (3)	85 (3 ¹ / ₈)
Min. member thickness	h_{min}	mm (in.)	$h_{ef} + 30$ ($h_{ef} + 1\frac{1}{4}$)				$h_{ef} + 2d_o^3$				
Critical edge spacing – splitting (for uncracked concrete) ²	c_{ac}	-	See Section 4.1.10 of this report.								
Strength reduction factor for tension, concrete failure modes, Condition B ²	ϕ	-	0.65								
Strength reduction factor for shear, concrete failure modes, Condition B ²	ϕ	-	0.70								

¹Additional setting information is described in [Figure 6](#), installation instructions.

²The strength reduction factor applies when the load combinations from the IBC or ACI 318 are used and the requirements of ACI 318-19 17.5.3 or ACI 318-14 17.3.3(c), as applicable, for Condition B (supplement reinforcement not present) are met. For installations where complying reinforcement can be verified, the applicable strength reduction factors described in ACI 318-19 17.5.3 or ACI 318-14 17.3.3(c), as applicable, may be used for Condition A (supplement reinforcement present).

³ d_o = hole diameter.

⁴The edge distances, c_{min} less than the values given in the table may be reduced subject to the anchor spacing, s_{min} in accordance with Section 4.1.9.

TABLE 18—BOND STRENGTH DESIGN INFORMATION METRIC REINFORCING BARS IN HOLES DRILLED WITH A HAMMER DRILL AND CARBIDE BIT (OR CHEMOFAST HOLLOW CARBIDE DRILL BIT)¹

DESIGN INFORMATION		Symbol	Units	Nominal Bar Size										
				Ø 8	Ø 10	Ø 12	Ø 14	Ø 16	Ø 20	Ø 25	Ø 28	Ø 32		
Minimum embedment		$h_{ef,min}$	mm. (in.)	60 (2.4)	60 (2.4)	70 (2.8)	75 (3.0)	80 (3.1)	90 (3.5)	100 (3.9)	112 (4.4)	128 (5.0)		
Maximum embedment		$h_{ef,max}$	mm (in.)	120 (4.7)	200 (7.9)	240 (9.4)	280 (11.0)	320 (12.6)	400 (15.7)	500 (19.7)	560 (22.0)	640 (25.2)		
Temperature range A: 110°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete	$\tau_{k,uncr}$	psi (N/mm ²)	2,070 (14.3)	2,055 (14.2)	2,040 (14.1)	2,025 (14.0)	2,010 (13.9)	1,985 (13.7)	1,945 (13.4)	1,925 (13.3)	1,895 (13.1)		
	Characteristic bond strength in cracked concrete	$\tau_{k,cr}$	psi (N/mm ²)	1,345 (9.3)	1,345 (9.3)	1,740 (12.0)	1,735 (12.0)	1,725 (11.9)	1,690 (11.7)	1,650 (11.4)	1,620 (11.2)	1,605 (11.1)		
Temperature range B: 110°F / 153°F ^{2,3}	Characteristic bond strength in uncracked concrete	$\tau_{k,uncr}$	psi (N/mm ²)	2,380 (16.4)	2,365 (16.3)	2,345 (16.2)	2,330 (16.1)	2,315 (15.9)	2,280 (15.7)	2,235 (15.4)	2,210 (15.2)	2,180 (15.0)		
	Characteristic bond strength in cracked concrete	$\tau_{k,cr}$	psi (N/mm ²)	1,550 (10.7)	1,550 (10.7)	2,000 (13.8)	1,995 (13.7)	1,985 (13.7)	1,945 (13.4)	1,900 (13.1)	1,865 (12.8)	1,845 (12.7)		
Temperature range C: 122°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete	$\tau_{k,uncr}$	psi (N/mm ²)	1,945 (13.4)	1,930 (13.3)	1,920 (13.2)	1,905 (13.1)	1,890 (13.0)	1,865 (12.8)	1,830 (12.6)	1,810 (12.5)	1,780 (12.3)		
	Characteristic bond strength in cracked concrete	$\tau_{k,cr}$	psi (N/mm ²)	1,340 (9.2)	1,340 (9.2)	1,635 (11.3)	1,630 (11.2)	1,620 (11.2)	1,590 (10.9)	1,550 (10.7)	1,525 (10.5)	1,505 (10.4)		
Temperature range D: 140°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete	$\tau_{k,uncr}$	psi (N/mm ²)	920 (6.4)	915 (6.3)	910 ⁵ (6.3)	905 ⁵ (6.2)	895 (6.2)	885 (6.1)	865 (6.0)	855 (5.9)	845 (5.8)		
	Characteristic bond strength in cracked concrete	$\tau_{k,cr}$	psi (N/mm ²)	790 (5.5)	780 (5.4)	775 (5.3)	770 (5.3)	770 (5.3)	755 (5.2)	735 (5.1)	720 (5.0)	715 (4.9)		
CAC ⁴ cleaning	Dry Concrete	Anchor category	-	-	1									
		Strength reduction factor	ϕ_a	-	0.65									
	Water-saturated Concrete	Anchor category	-	-	1									
		Strength reduction factor	ϕ_{ws}	-	0.65									
	Water-filled holes	Anchor category	-	-	3									
		Strength reduction factor	ϕ_{wf}	-	0.45									
Modification factor for water filled holes		K_{wf}	-	1.0										
HDB ⁴ cleaning	Dry Concrete	Anchor category	-	-	1									
		Strength reduction factor	ϕ_a	-	0.65									
	Water-saturated Concrete	Anchor category	-	-	2									
		Strength reduction factor	ϕ_{ws}	-	0.55									
	Water-filled holes	Anchor category	-	-	3									
		Strength reduction factor	ϕ_{wf}	-	0.45									
		Modification factor for water filled holes	K_{wf}	-	0.86			0.91		0.96		1		
					0.99		0.98		0.96		0.94		0.93	
Reduction factor for seismic tension		$\alpha_{N,seis}$	-	1			0.99		0.98		0.96		0.94	0.93

¹Bond strength values correspond to concrete compressive strength $f'_c = 2,500$ psi [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1]. For concrete compressive strength, f'_c between 2,500 psi and 8,000 psi, the tabulated characteristic bond strength may be increased by a factor of $(f'_c / 2500)^{0.1}$ [For SI: $(f'_c / 17.2)^{0.1}$]. See Section 4.1.4 of this report.

²Characteristic bond strengths are for sustained loads including dead and live loads. For load combinations consisting of short-term loads only such as wind, bond strengths may be increased by 10 percent for temperature range A and B, by 16 percent for temperature range C, and by 144 percent for temperature range D.

³Short term elevated concrete temperatures are those that occur over brief intervals, e.g. as result of diurnal cycling. Long term concrete temperatures are roughly constant over significant periods of time.

Temperature range A: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 110°F (43°C);

Temperature range B: Maximum short term temperature = 153°F (67°C), maximum long term temperature = 110°F (43°C);

Temperature range C: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 122°F (50°C);

Temperature range D: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 140°F (60°C).

⁴CAC: compressed air cleaning see Figure 6; HDB: cleaning during drilling action with hollow drill bit system.

⁵Not applicable for installation with HDB cleaning in water-filled holes for short term loads only.

TABLE 19—BOND STRENGTH DESIGN INFORMATION METRIC REINFORCING BARS IN HOLES DRILLED WITH A CORE DRILL AND DIAMOND CORE BIT¹

DESIGN INFORMATION			Symbol	Units	Nominal Bar Size								
					ø 8	ø 10	ø 12	ø 14	ø 16	ø 20	ø 25	ø 28	ø 32
Minimum embedment			$h_{ef,min}$	mm. (in.)	60 (2.4)	60 (2.4)	70 (2.8)	75 (3.0)	80 (3.1)	90 (3.5)	100 (3.9)	112 (4.4)	128 (5.0)
Maximum embedment			$h_{ef,max}$	mm (in.)	120 (4.7)	200 (7.9)	240 (9.4)	280 (11.0)	320 (12.6)	400 (15.7)	500 (19.7)	560 (22.0)	640 (25.2)
Temperature range C: 122°F / 176°F ^{2,3}	Characteristic bond strength in uncracked concrete		$\tau_{k,uncr}$	psi (N/mm ²)	1,670 (11.5)	1,605 (11.1)	1,560 (10.7)	1,520 (10.5)	1,483 (10.2)	1,430 (9.8)	1,375 (9.5)	1,350 (9.3)	1,320 (9.1)
	SPCAC ⁴ cleaning	Dry Concrete	Anchor category	—	-	1							
Strength reduction factor			ϕ_d	-	0.65								
Water-saturated Concrete		Anchor category	—	-	2								
		Strength reduction factor	ϕ_{ws}	-	0.55								
Water-filled holes		Anchor category	—	-	3								
		Strength reduction factor	ϕ_{wf}	-	0.45								
	Modification factor for water filled holes	K_{wf}	-	0.90									

¹Bond strength values correspond to concrete compressive strength $f'_c = 2,500$ psi [minimum of 24 MPa is required under ADIBC Appendix L, Section 5.1.1]. For concrete compressive strength, f'_c between 2,500 psi and 8,000 psi, the tabulated characteristic bond strength may be increased by a factor of $(f'_c / 2500)^{0.2}$ [For SI: $(f'_c / 17.2)^{0.2}$]. See Section 4.1.4 of this report.

²Characteristic bond strengths are for sustained loads including dead and live loads. For load combinations consisting of short-term loads only such as wind, bond strengths may be increased by 4 percent for temperature range C.

³Short term elevated concrete temperatures are those that occur over brief intervals, e.g. as result of diurnal cycling. Long term concrete temperatures are roughly constant over significant periods of time.

Temperature range C: Maximum short term temperature = 176°F (80°C), maximum long term temperature = 122°F (50°C).

⁴SPCAC: see [Figure 6](#)

TABLE 20—DEVELOPMENT LENGTH FOR U.S. CUSTOMARY UNIT REINFORCING BARS IN HOLES DRILLED WITH A HAMMER DRILL AND CARBIDE BIT (OR CHEMOFAST HOLLOW CARBIDE DRILL BIT) OR A CORE DRILL AND DIAMOND CORE BIT ^{1, 2, 4, 5, 6}

DESIGN INFORMATION	Symbol	Criteria Section of Reference Standard	Units	Bar size							
				#3	#4	#5	#6	#7	#8	#9	#10
Nominal reinforcing bar diameter	d_b	ASTM A615/A706	in. (mm)	0.375 (9.5)	0.500 (12.7)	0.625 (15.9)	0.750 (19.1)	0.875 (22.2)	1.000 (25.4)	1.125 (28.6)	1.250 (31.8)
Nominal bar area	A_b	ASTM A615/A706	in ² (mm ²)	0.11 (71.3)	0.20 (126.7)	0.31 (197.9)	0.44 (285.0)	0.60 (387.9)	0.79 (506.7)	1.00 (644.7)	1.27 (817.3)
Development length for $f_y = 60$ ksi and $f'_c = 2,500$ psi (normal weight concrete) ³	l_d	ACI 318-19 25.4.2.4 or ACI 318-14 25.4.2.3	in. (mm)	12.0 (304.8)	14.4 (365.8)	18.0 (457.2)	21.6 (548.6)	31.5 (800.1)	36.0 (914.4)	40.5 (1028.7)	45.0 (1143)
Development length for $f_y = 60$ ksi and $f'_c = 4,000$ psi (normal weight concrete) ³	l_d	ACI 318-19 25.4.2.4 or ACI 318-14 25.4.2.3	in. (mm)	12.0 (304.8)	12.0 (304.8)	14.2 (361.4)	17.1 (433.7)	24.9 (632.5)	28.5 (722.9)	32.0 (812.8)	35.6 (904.2)

For SI: 1 inch ≡ 25.4 mm, 1 lbf = 4.448 N, 1 psi = 0.006897 MPa.

For pound-inch units: 1 mm = 0.03937 inches, 1 N = 0.2248 lbf, 1 MPa = 145.0 psi

¹ Development lengths valid for static, wind, and earthquake loads (SDC A and B).

² Development lengths in SDC C through F must comply with ACI 318-19 and ACI 318-14 Chapter 18 and section 4.2.4 of this report.

³ f_y and f'_c used in this table are for example purposes only. For sand-lightweight concrete, increase development length by 33%, unless the provisions of ACI 318-19 25.4.2.5 or ACI 318-14 25.4.2.4 are met to permit $\lambda > 0.75$.

$$4 \left(\frac{C_b + K_{tr}}{d_b} \right) = 2.5, \psi_t = 1.0, \psi_e = 1.0, \psi_s = 0.8 \text{ for } d_b \leq \#6, 1.0 \text{ for } d_b > \#6.$$

⁵ Minimum f'_c of 24 MPa is required under ADIBC Appendix L, Section 5.1.1

⁶ Calculations may be performed for other steel grades per ACI 318-14 and ACI 318-19 Chapter 25.

TABLE 21—DEVELOPMENT LENGTH FOR EU METRIC REINFORCING BARS IN HOLES DRILLED WITH A HAMMER DRILL AND CARBIDE BIT (OR CHEMOFAST HOLLOW CARBIDE DRILL BIT) OR A CORE DRILL AND DIAMOND CORE BIT ^{1, 2, 4, 5, 6}

DESIGN INFORMATION	Symbol	Criteria Section of Reference Standard	Units	Bar size						
				8	10	12	16	20	25	32
Nominal reinforcing bar diameter	d_b	BS 4449: 2005	mm (in.)	8 (0.315)	10 (0.394)	12 (0.472)	16 (0.630)	20 (0.787)	25 (0.984)	32 (1.260)
Nominal bar area	A_b	BS 4449: 2005	mm ² (in ²)	50.3 (0.08)	78.5 (0.12)	113.1 (0.18)	201.1 (0.31)	314.2 (0.49)	490.9 (0.76)	804.2 (1.25)
Development length for $f_y = 72.5$ ksi and $f'_c = 2,500$ psi (normal weight concrete) ³	l_d	ACI 318-19 25.4.2.4 or ACI 318-14 25.4.2.3	mm (in.)	305 (12.0)	348 (13.7)	417 (16.4)	556 (21.9)	871 (34.3)	1087 (42.8)	1392 (54.8)
Development length for $f_y = 72.5$ ksi and $f'_c = 4,000$ psi (normal weight concrete) ³	l_d	ACI 318-19 25.4.2.4 or ACI 318-14 25.4.2.3	mm (in.)	305 (12.0)	305 (12.0)	330 (13.0)	439 (17.3)	688 (27.1)	859 (33.8)	1100 (43.3)

For SI: 1 inch ≡ 25.4 mm, 1 lbf = 4.448 N, 1 psi = 0.006897 MPa.

For pound-inch units: 1 mm = 0.03937 inches, 1 N = 0.2248 lbf, 1 MPa = 145.0 psi

¹ Development lengths valid for static, wind, and earthquake loads (SDC A and B).

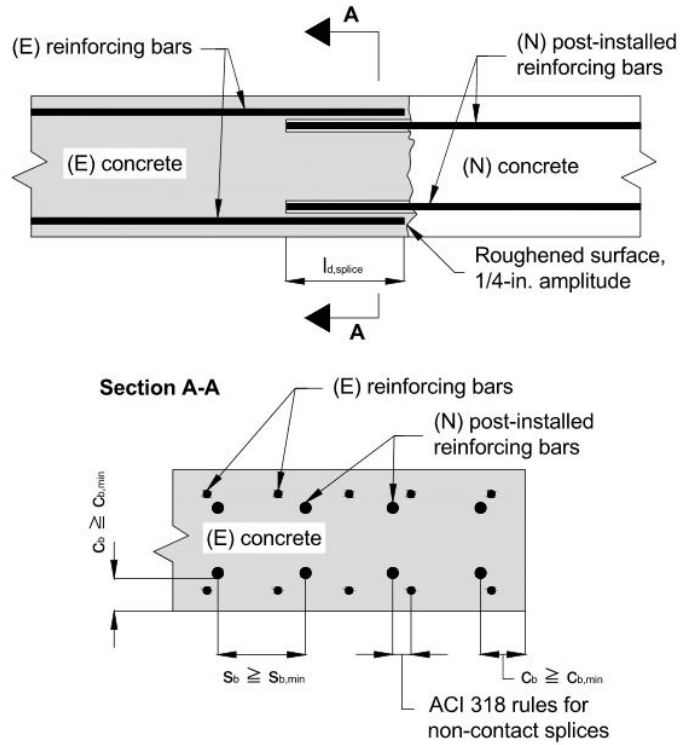
² Development lengths in SDC C through F must comply with ACI 318-19 and ACI 318-14 Chapter 18 and section 4.2.4 of this report.

³ f_y and f'_c used in this table are for example purposes only. For sand-lightweight concrete, increase development length by 33%, unless the provisions of ACI 318-19 25.4.2.5 or ACI 318-14 25.4.2.4 are met to permit $\lambda > 0.75$.

$$4 \left(\frac{C_b + K_{tr}}{d_b} \right) = 2.5, \psi_t = 1.0, \psi_e = 1.0, \psi_s = 0.8 \text{ for } d_b < 20\text{mm}, 1.0 \text{ for } d_b \geq 20\text{mm}.$$

⁵ Minimum f'_c of 24 MPa is required under ADIBC Appendix L, Section 5.1.1

⁶ Calculations may be performed for other steel grades per ACI 318-14 and ACI 318-19 Chapter 25.



INSTALLATION PARAMETERS FOR POST-INSTALLED REINFORCING BARS

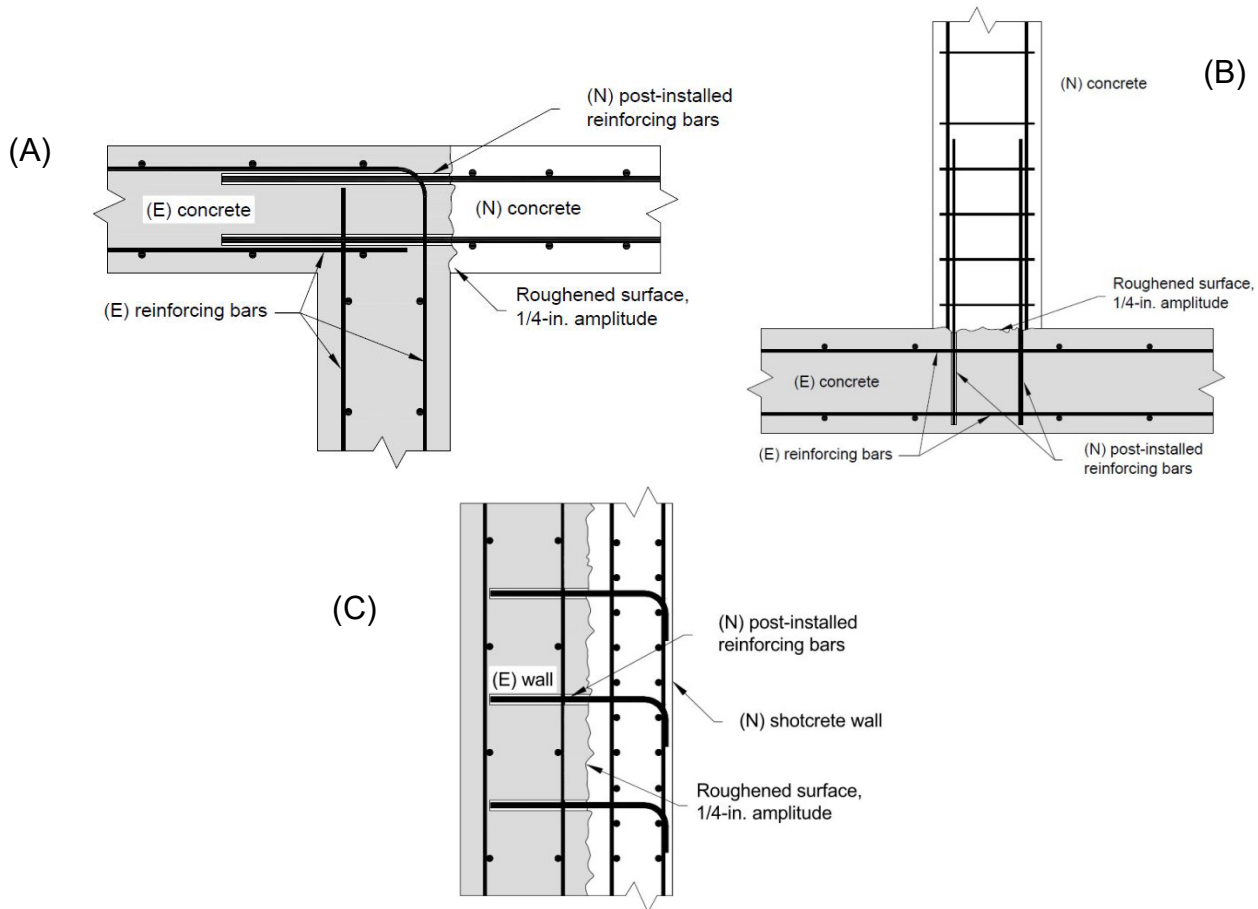
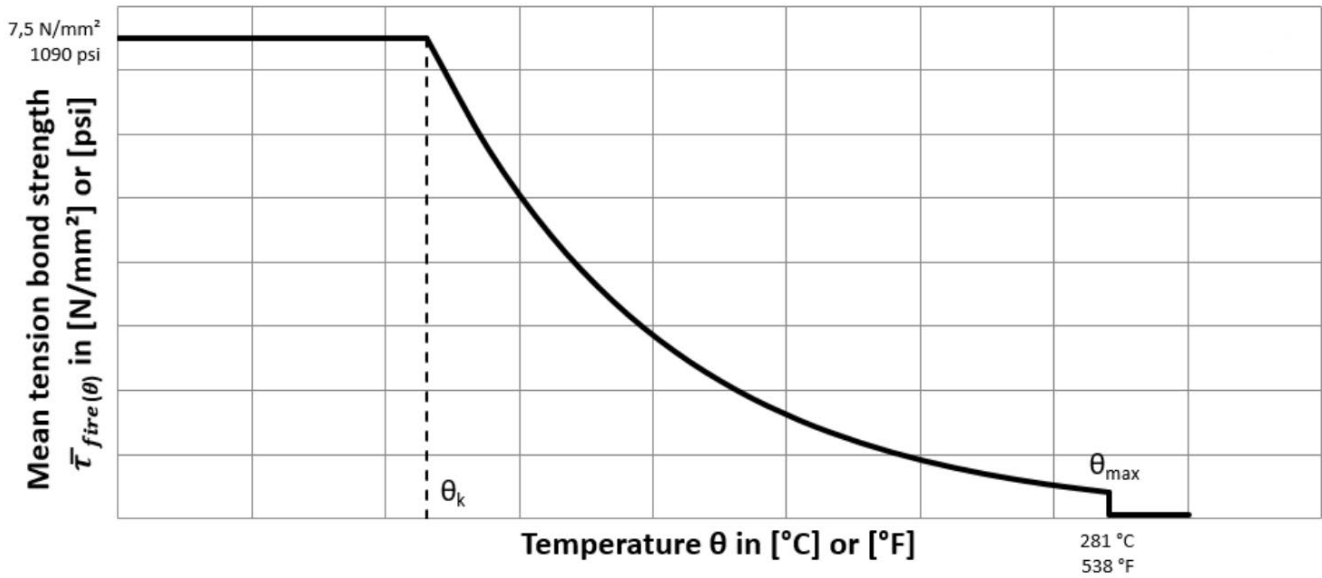


FIGURE 4—APPLICATION EXAMPLES FOR POST-INSTALLED REINFORCING BARS:
 (A) TENSION LAP SPLICE WITH EXISTING FLEXURAL REINFORCEMENT; (B) TENSION DEVELOPMENT OF COLUMN DOWELS;
 (C) DEVELOPMENT OF SHEAR DOWELS FOR NEWLY THICKENED SHEAR WALL



The mean tension bond strength $\bar{\tau}_{fire}(\theta)$ under fire conditions shall be determined in accordance with the following equations:

For hammer drill and carbide bit (or Chemofast hollow carbide bit)^{1,2}:

$$\bar{\tau}_{fire}(\theta) = 9216320 \cdot \theta^{-1.921} \leq 1090 \text{ [psi] with } \theta \text{ in } ^{\circ}F$$

$$\bar{\tau}_{fire}(\theta) = 4266 \cdot \theta^{-1.656} \leq 7.5 \text{ [N/mm}^2\text{] with } \theta \text{ in } ^{\circ}C$$

$$\theta_k = 111^{\circ}F \text{ (46}^{\circ}C)$$

For diamond core bit^{1,3}:

$$\bar{\tau}_{fire}(\theta) = 7700963 \cdot \theta^{-1.921} \leq 1090 \text{ [psi] with } \theta \text{ in } ^{\circ}F$$

$$\bar{\tau}_{fire}(\theta) = 3564 \cdot \theta^{-1.656} \leq 7.5 \text{ [N/mm}^2\text{] with } \theta \text{ in } ^{\circ}C$$

$$\theta_k = 101^{\circ}F \text{ (41}^{\circ}C)$$

¹ With $\theta_{max} = 281^{\circ}C$ ($538^{\circ}F$). For temperatures larger than θ_{max} the bond strength $\bar{\tau}_{fire}(\theta) = 0$. See section 4.2.5 of this report.

² Bond strengths under fire are for short-term loads such as wind, for sustained loads including dead and live, and for seismic loads.

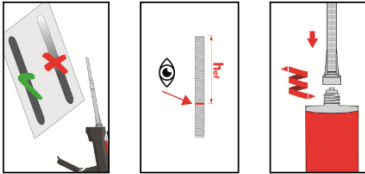
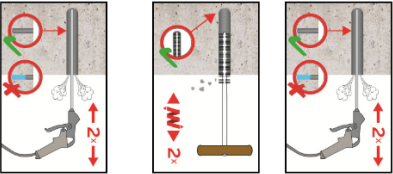
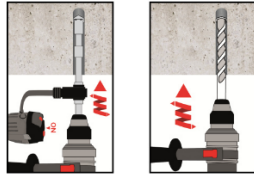
³ Bond strengths under fire are for short-term loads such as wind, for sustained loads including dead and live, but not for seismic loads. For application under seismic conditions, bond strengths must be decreased by 11 percent.

FIGURE 5— BOND STRENGTH VS TEMPERATURE FOR POST INSTALLED REINFORCING BAR APPLICATIONS SUBJECT TO ELEVATED TEMPERATURE / FIRE IN HOLES DRILLED WITH HAMMER DRILL AND CARBIDE BIT (OR CHEMOFAST HOLLOW CARBIDE DRILL BIT) OR DIAMOND CORE BIT

CHEMFAST®

EP 1000 - Instruction

1. Setting instructions for solid base material with Hammer drilling or Chemofast hollow drill bit system - ESR-4246

Preparing	Hole cleaning	Drilling
 <p>3 Check adhesive expiration date on cartridge label. Do not use expired product. Review Safety Data Sheet (SDS) before use. For the permitted range of the base material and cartridge temperature see Table 2. Attach a supplied mixing nozzle to the cartridge. Do not modify the mixer in any way and make sure the mixing element is inside the nozzle. Load the cartridge into the correct dispensing tool.</p> <p>4 <i>Note: Always use a new mixing nozzle with new cartridges of adhesive and also for all work interruptions exceeding the published out (verpackt) time of the adhesive.</i></p> <p>5 Prior to inserting the anchor rod or rebar into the filled drilled hole, the position of the embedment depth has to be marked on the anchor. Verify anchor element is straight and free of surface damage.</p> <p>Adhesive must be properly mixed to achieve published properties. Prior to dispensing adhesive into the drilled hole, separately dispose at least three full strokes of adhesive through the mixing nozzle until the adhesive is a consistent grey or red color. Review and note the published working and cure times (see Table 2) prior to injection of the mixed adhesive into the cleaned anchor hole.</p>	 <p>2a Finally blow the hole clean again with compressed air (min. 6 bar / 90 psi) a minimum of two times, until return air stream is free of noticeable dust. If the back of the drilled hole is not reached an extension shall be used.</p> <p>2b Determine brush diameter (see Table 3) for the drilled hole. Brush the hole with the selected wire brush a minimum of two times (2x). A brush extension (supplied by Chemofast Anchoring GmbH) must be used for drill hole depth > 6" (150mm). The wire brush diameter must be checked periodically during use ($D_{brush} > D_{min}$, see Table 3a or 3b). The brush should resist insertion into the drilled hole - if not the brush is too small and must be replaced with the proper brush diameter. If the back of the drilled hole is not reached a brush extension shall be used.</p>	 <p>1 Precaution: Wear suitable eye and skin protection. Avoid inhalation of dusts during drilling and/or removal (see dust extraction equipment by Chemofast to minimize dust emissions). Drill a hole into the base material with a hammer drill tool to the size and embedment required by the selected steel hardware element (see Table 4). The tolerances of the carbide drill bit must meet the requirements of ANSI Standard B7.12.15. For bore holes drilled with the Chemofast hollow drill bit system (consisting of Heller Duster Expert drill bits and a Class M vacuum with air flow 150m³/h resp. 427/s resp. 90cfm) the vacuum must be only no further cleaning is required → go to Step 3, otherwise to Step 2a for MAC or CAC hole cleaning instructions.</p> <p>In case of standing water in the drilled hole, all the water has to be removed from the hole (e.g. vacuum, compressed air, etc.) prior to cleaning.</p>
<p>CAC: Cleaning for all bore hole diameter in uncracked and cracked concrete</p>		

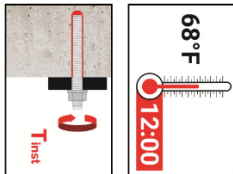
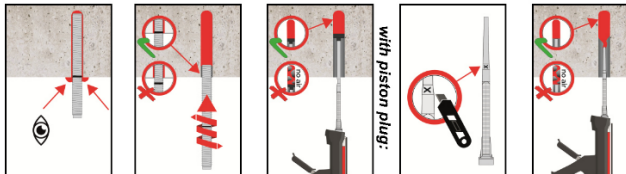
Curing and fixture	Installation																								
 <p>9 Allow the adhesive anchor to cure to the specified full curing time prior to applying any load (see Table 2). Do not disturb, torque or load the anchor until it is fully cured.</p> <p>10 After full curing of the adhesive anchor, a fixture can be installed to the anchor and tightened up to the maximum torque (shown in Table 4) by using a calibrated torque wrench.</p> <p>Take care not to exceed the maximum torque for the selected anchor.</p>	 <p>6 Fill the cleaned hole approximately two-thirds full with mixed adhesive starting from the bottom or back of the anchor hole. Slowly withdraw the mixing nozzle as the hole fills to avoid creating air pockets or voids. If the bottom or back of the anchor hole is not reached with the mixing nozzle only an extension tube supplied by Chemofast Anchoring GmbH (Cat# 16009 or Cat# 16004) must be used with the mixing nozzle. In case of using the extension tube VL 6/1.8 (Cat# 16004), cut the tip of the mixer nozzle at position "X".</p> <p>Piston plugs (see Table 3a or 3b) must be used with and attached to mixing nozzle and extension tube for:</p> <ul style="list-style-type: none"> overhead installations and installations between horizontal and overhead all installations with drill hole depth $d_2 > 10"$ (250mm) <p>with anchor rod 5/8" to 1-1/4" (V16 to M30) diameter and rebar sizes #5 to #10 (Ø14 to Ø32).</p> <p>Insert piston plug to the back of the drilled hole and inject as described in the method above. During installation the piston plug will be naturally extruded from the drilled hole by the adhesive pressure. Attention! Do not install anchors overhead or upward inclined without installation hardware supplied by Chemofast and also receiving proper training and/or certification. Contact Chemofast for details prior to use.</p> <p>7 The anchor should be free of dirt, grease, oil or other foreign material. Push clean threaded rod or reinforcing bar into the anchor hole while turning slightly to ensure positive distribution of the adhesive until the embedment depth is reached. Observe the gel (working) time.</p> <p>8 Be sure that the anchor is fully seated at the bottom of the hole and that some adhesive has flowed from the hole and all around the top of the anchor. If there is not enough adhesive in the hole, the installation must be repeated. For overhead applications and applications between horizontal and overhead the anchor must be secured from moving/falling during the cure time (e.g. wedges). Minor adjustments to the anchor may be performed during the gel time but the anchor shall not be moved after placement and during cure.</p>																								
<p>2. Gel (working) times and curing times</p> <table border="1"> <thead> <tr> <th>Temperature of base material</th> <th>Gel (working) time</th> <th>Full curing time</th> </tr> </thead> <tbody> <tr> <td>41°F (+5°C) to 49°F (+9°C)</td> <td>80 min</td> <td>48 h</td> </tr> <tr> <td>50°F (+10°C) to 58°F (+14°C)</td> <td>60 min</td> <td>28 h</td> </tr> <tr> <td>59°F (+15°C) to 67°F (+19°C)</td> <td>40 min</td> <td>18 h</td> </tr> <tr> <td>68°F (+20°C) to 75°F (+24°C)</td> <td>30 min</td> <td>12 h</td> </tr> <tr> <td>77°F (+25°C) to 93°F (+34°C)</td> <td>12 min</td> <td>9 h</td> </tr> <tr> <td>95°F (+35°C) to 102°F (+39°C)</td> <td>8 min</td> <td>6 h</td> </tr> <tr> <td>104°F (+40°C)</td> <td>8 min</td> <td>4 h</td> </tr> </tbody> </table> <p>Cartridge temperature must be between 41°F (+5°C) and 104°F (+40°C)</p>	Temperature of base material	Gel (working) time	Full curing time	41°F (+5°C) to 49°F (+9°C)	80 min	48 h	50°F (+10°C) to 58°F (+14°C)	60 min	28 h	59°F (+15°C) to 67°F (+19°C)	40 min	18 h	68°F (+20°C) to 75°F (+24°C)	30 min	12 h	77°F (+25°C) to 93°F (+34°C)	12 min	9 h	95°F (+35°C) to 102°F (+39°C)	8 min	6 h	104°F (+40°C)	8 min	4 h	
Temperature of base material	Gel (working) time	Full curing time																							
41°F (+5°C) to 49°F (+9°C)	80 min	48 h																							
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104°F (+40°C)	8 min	4 h																							

FIGURE 6—INSTALLATION INSTRUCTIONS

CHEMOFAST® EP 1000 - Instruction

1. Setting instructions for solid base material with Diamond drilling - ESR-4246

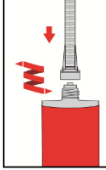
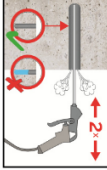
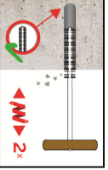
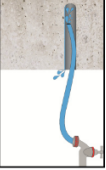
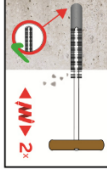
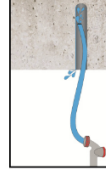
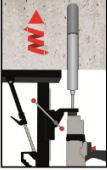
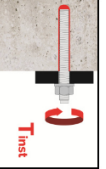



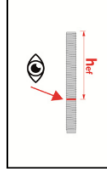

Preparing	Hole cleaning	Drilling
 <p>3 Check adhesive expiration date on cartridge label. Do not use expired product. Review Safety Data Sheet (SDS) before use. For the permitted range of the base material and cartridge temperature see Table 2. Attach a supplied mixing nozzle to the cartridge. Do not modify the mixer in any way and make sure the mixing element is inside the nozzle. Load the cartridge into the correct dispensing tool.</p> <p>Note: Always use a new mixing nozzle with new cartridges of adhesive and also for all work interruptions exceeding the published set (wackzeit) time of the adhesive.</p>	 <p>21 Starting from the bottom or back of the anchor hole, blow the hole clean with compressed air (min. 6 bar / 90 psi) a minimum of two times, until return air stream is free of noticeable dust. If the back of the drilled hole is not reached an extension shall be used.</p>  <p>22 Determine brush diameter (see Table 3) for the drilled hole. Brush the hole with the selected wire brush a minimum of two times (2x). A brush extension (supplied by Chemofast Anchoring GmbH) must be used for drill hole depth > 6" (150mm). The wire brush diameter must be checked periodically during use. (D_{brush} > D_{min}, see Table 3a or 3b). The brush should resist insertion into the drilled hole. If the brush is too small and must be replaced with the proper brush diameter. If the back of the drilled hole is not reached a brush extension shall be used.</p>  <p>23 Finally, starting from the bottom or back of the bore hole, rinse/flush the hole clean until clean water comes out. If the back of the drilled hole is not reached an extension shall be used.</p>  <p>24 Determine brush diameter (see Table 3) for the drilled hole. Brush the hole with the selected wire brush a minimum of two times (2x). A brush extension (supplied by Chemofast Anchoring GmbH) must be used for drill hole depth > 6" (150mm). The wire brush diameter must be checked periodically during use. (D_{brush} > D_{min}, see Table 3a or 3b). The brush should resist insertion into the drilled hole. If the brush is too small and must be replaced with the proper brush diameter. If the back of the drilled hole is not reached a brush extension shall be used.</p>  <p>25 Starting from the bottom or back of the bore hole, rinse/flush the hole clean until clean water comes out. If the back of the drilled hole is not reached an extension shall be used.</p> <p>SFCAC: Cleaning for all bore hole diameter in uncracked concrete</p>	 <p>1 Precaution: Wear suitable eye and skin protection. Avoid inhalation of dusts during drilling and/or removal (see dust extraction equipment by Chemofast to minimize dust emissions). Drill a hole into the base material with a diamond drill tool to the size and embedment required by the selected steel hardware element (see Table 2).</p> <p>In case of standing water in the drilled hole, all the water has to be removed from the hole (e.g. vacuum, compressed air, etc.) prior to cleaning.</p>
 <p>8 After full curing of the adhesive anchor, a fixture can be installed to the anchor and tightened up to the maximum torque (shown in Table 4) by using a calibrated torque wrench.</p> <p>Take care not to exceed the maximum torque for the selected anchor.</p>	 <p>6 Fill the cleaned hole approximately two-thirds full with mixed adhesive starting from the bottom or back of the anchor hole. Slowly withdraw the mixing nozzle as the hole fills to avoid creating air pockets or voids. If the bottom or back of the anchor hole is not reached with the mixing nozzle only an extension tube supplied by Chemofast Anchoring GmbH (Cat# 16009 or Cat# 16004) must be used with the mixing nozzle. In case of using the extension tube V.16/1.8 (Cat# 16004), cut the tip of the mixer nozzle at position "X".</p> <p>Piston plugs (see Table 3a or 3b) must be used with and attached to mixing nozzle and extension tube for:</p> <ul style="list-style-type: none"> - overhead installations and installations between horizontal and overhead - all installations with drill hole depth $d_0 > 10"$ (250mm) - with anchor rod 5/8" to 1-1/4" (V16 to M30) diameter and rebar sizes #5 to #10 (Ø14 to Ø32) <p>Insert piston plug to the back of the drilled hole and inject as described in the method above. During installation the piston plug will be naturally extruded from the drilled hole by the adhesive pressure. Attention! Do not install anchors overhead or upwardly inclined without installation hardware supplied by Chemofast and also receiving proper training and/or certification. Contact Chemofast for details prior to use.</p>  <p>7 The anchor should be free of dirt, grease, oil or other foreign material. Push clean threaded rod or reinforcing bar into the anchor hole while turning slightly to ensure positive distribution of the adhesive until the embedment depth is reached. Observe the gel (working) time.</p>  <p>9 Allow the adhesive anchor to cure to the specified full curing time prior to applying any load (see Table 2). Do not disturb, torque or load the anchor until it is fully cured.</p>	 <p>4 Prior to inserting the anchor rod or rebar into the filled drilled hole, the position of the embedment depth has to be marked on the anchor. Verify anchor element is straight and free of surface damage.</p>  <p>5 Adhesive must be properly mixed to achieve published properties. Prior to dispensing adhesive into the drilled hole, separately dispense at least three full strokes of adhesive through the mixing nozzle until the adhesive is a consistent gray or red color. Review and note the published working and cure times (see Table 2) prior to injection of the mixed adhesive into the cleaned anchor hole.</p>

FIGURE 6—INSTALLATION INSTRUCTIONS (Continued)



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[Rev. cl]

Injection tools	Cartridge system	Extra mixing nozzles	Piston Plug	Compressed air nozzle (min. 90 psi)	Extension tube (min. 10/0.75)	Extension with wood handle	Cartridge	Injection tools	Extension tube
14 to 20 fl. oz. dispenser Cat. #30222 - Manual tool Cat. #30224 - Pneumatic tool	EP1000 14.8 fl. oz. (440ml) EP1000 20 fl. oz. (585ml)	EP 1000 mixing nozzle Cat. #40154			Cat. #16009 Extension tube VL16/11.8	Cat. #16132 Brush extension Cat. #16131	14 to 20 fl. oz. Manual tool Pneumatic tool	≤ #5 ≤ 16 ≤ #5 ≤ 16	≤ 27-1/2 [inch] ≤ 700 [mm] ≤ 51-1/2 [inch] ≤ 1300 [mm]
47 fl. oz. dispensers Cat. #30221 - Pneumatic tool	EP 1000 47 fl. oz. (1400ml)		Cat. # Table 3a or 3b)	If the bore hole ground is not reached an extension shall be used.	Cat. #16004 Extension tube		14 to 20 fl. oz. Pneumatic tool	≤ #8 ≤ #5 ≤ 39-1/2 [inch] ≤ 1000 [mm]	≤ 75 [inch] ≤ 1920 [mm] V. 116/1.8 (Cat. #16004)

5. EP 1000 adhesive anchor system and accessories

6. Post-installed rebar $h_{ar} \geq 20d$

Parameter	Nominal threaded rod (fractional)										Nominal threaded rod (metric)										Reinforcing bar (fractional)										Reinforcing bar (metric)									
	in.					ft.					mm					mm					in.					ft.					mm					mm				
d_s = Nominal anchor rod diameter	3/8"	1/2"	5/8"	3/4"	7/8"	1"	1-1/4"	V8	M10	M12	M16	M20	V24	M27	M30	#3	#4	#5	#6	#7	#8	#9	#10	Ø8	Ø10	Ø12	Ø14	Ø16	Ø20	Ø25	Ø28	Ø32								
d_b (d _{br}) = Nominal ANSI drill bit size	7/16	9/16	11/16	7/8	1	1-1/8	1-3/8	10	12	14	18	22	28	30	35	1/2	5/8	3/4	7/8	1	1-1/8	1-1/2	1-1/2	12	14	16	18	20	25	28	35	40								
T_{max} = Maximum torque	15 ²⁾	30	44	66	96	147	221	10	20	40	80	120	170	250	300	15 ²⁾	30	44	66	96	147	185	221	10	20	40	45	80	90	120	175	250	300							
T_{min} = Minimum embedment	2-3/8	2-3/4	3-1/8	3-1/2	3-1/2	4	5	60	70	80	80	90	96	108	120	2-3/8	2-3/4	3-1/8	3-1/2	3-1/2	4	4-1/2	5	60	60	70	75	80	90	100	112	128								
$f_{dr,max}$ = Maximum embedment	7-1/2	10	12-1/2	15	17-1/2	20	25	160	200	240	320	400	480	540	600	7-1/2	10	12-1/2	15	17-1/2	20	22-1/2	25	160	200	240	280	320	400	500	560	640								
S_{min} = Min. spacing	1-7/8	2-1/2	3	3-5/8	4-1/4	4-3/4	5-7/8	40	50	60	80	100	120	135	150	1-7/8	2-1/2	3	3-5/8	4-1/4	4-3/4	5-1/4	5-7/8	40	50	60	70	80	100	125	140	160								
C_{min} = Min. edge distance (100% T_{max})	1-5/8	1-3/4	2	2-3/8	2-1/2	2-3/4	3-1/4	35	40	45	55	60	70	75	80	1-5/8	1-3/4	2	2-3/8	2-1/2	2-3/4	3	3-1/4	35	40	45	50	55	60	70	75	85								
C_{min} = Min. edge distance (45% T_{max})	-	-	-	-	-	-	-	40	45	45	55	60	70	75	80	-	-	-	-	-	-	-	-	40	45	45	50	55	60	70	75	85								
f_{br} = Minimum member thickness	-	-	-	-	-	-	-	$h_{ar} + 1-1/4$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	-	-	-	-	-	-	-	-	$h_{ar} + 30$	$h_{ar} + 30$	$h_{ar} + 30$	$h_{ar} + 30$	$h_{ar} + 30$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$								
Parameter valid for post-installed rebar	-	-	-	-	-	-	-	$h_{ar} + 1-1/4$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	-	-	-	-	-	-	-	-	$h_{ar} + 30$	$h_{ar} + 30$	$h_{ar} + 30$	$h_{ar} + 30$	$h_{ar} + 30$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$	$h_{ar} + 2d_s$								
$f_{dr,min}$ = Minimum embedment	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	2-3/8	2-3/4	3-1/8	3-1/2	3-1/2	4	4-1/2	5	60	60	70	75	80	90	100	112	128								
$f_{dr,max}$ = Maximum embedment (PIR)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	22-1/2	30	37-1/2	45	52-1/2	60	67-1/2	75	480	600	720	840	960	1200	1500	1680	1920								
¹⁾ S_{min} = 5x d_s																																								
²⁾ for ASTM A36 and F1554 Grade 36, T_{max} = 11 ft.-lb.																																								

4. Anchor property / Setting information (fractional and metric sizes)

Threaded Rod	Rebar	Drill bit - Ø	Brush - Ø		min. Brush - Ø	Cat. #	Piston plug (No.)	Cat. #
			in.	mm				
3/8"	-	7/16	13.5	0.458	11.6	16111	[]	
#3	-	1/2	14.3	0.562	13.2	16112	[]	
-	#4	9/16	16.3	0.654	14.8	16114	[]	No plugs required
-	#4	5/8	18.3	0.720	16.5	16116	[]	No plugs required
5/8"	-	11/16	20.0	0.787	18.0	16117	[]	11/16
-	#5	3/4	21.5	0.846	19.5	16118	[]	40341
3/4"	#6	7/8	24.8	0.976	23.0	16121	[]	40343
7/8"	#7	1	28.5	1.122	26.2	16123	[]	40345
1"	#8	1-1/8	31.8	1.252	29.5	16125	[]	40347
1-1/4"	#9	1-3/8	38.2	1.504	35.8	16128	[]	40349
-	#10	1-1/2	41.4	1.630	39.0	16129	[]	40350

Threaded Rod	Rebar	Drill bit - Ø	Brush - Ø		min. Brush - Ø	Cat. #	Piston plug (No.)	Cat. #
			in.	mm				
M8	-	10	11.5	0.45	10.5	16110	[]	
M10	-	12	13.5	0.53	12.5	16111	[]	
M12	10	14	15.5	0.61	14.5	16113	[]	No plugs required
-	12	16	17.5	0.69	16.5	16115	[]	No plugs required
M16	-	18	20	0.79	18.5	16117	[]	18
-	16	20	22	0.87	20.5	16119	[]	40340
M20	-	22	24	0.94	22.5	16122	[]	40342
-	20	25	27	1.06	24.5	16122	[]	40345
M24	-	28	30	1.18	28.5	16124	[]	40346
M27	-	30	31.8	1.25	30.5	16125	[]	40347
M30	-	35	37	1.46	35.5	16127	[]	40349
-	32	40	43.5	1.71	40.5	16130	[]	40351

3a. Parameter cleaning and setting tools (fractional sizes)

3b. Parameter cleaning and setting tools (metric sizes)

FIGURE 6—INSTALLATION INSTRUCTIONS (Continued)

DIVISION: 03 00 00—CONCRETE
Section: 03 16 00—Concrete Anchors

DIVISION: 05 00 00—METALS
Section: 05 05 19—Post-Installed Concrete Anchors

REPORT HOLDER:

CHEMOFAST ANCHORING GmbH

EVALUATION SUBJECT:**CHEMOFAST EP 1000 ADHESIVE ANCHOR AND POST-INSTALLED REINFORCING BAR CONNECTION SYSTEM IN CRACKED AND UNCRACKED CONCRETE****1.0 REPORT PURPOSE AND SCOPE****Purpose:**

The purpose of this evaluation report supplement is to indicate that Chemofast EP1000 Adhesive Anchor and Post-Installed Reinforcing Bar Connection System in Cracked and Uncracked Concrete, described in ICC-ES evaluation report [ESR-4246](#), has also been evaluated for compliance with the codes noted below as adopted by the Los Angeles Department of Building and Safety (LADBS).

Applicable code editions:

- 2023 City of Los Angeles Building Code ([LABC](#))
- 2023 City of Los Angeles Residential Code ([LARC](#))

2.0 CONCLUSIONS

The Chemofast EP1000 Adhesive Anchor and Post-Installed Reinforcing Bar Connection System in Cracked and Uncracked Concrete, described in Sections 2.0 through 7.0 of the evaluation report [ESR-4246](#), complies with the LABC Chapter 19, and the LARC, and is subject to the conditions of use described in this supplement.

3.0 CONDITIONS OF USE

The Chemofast EP1000 Adhesive Anchor and Post-Installed Reinforcing Bar Connection System in Cracked and Uncracked Concrete described in this evaluation report must comply with all of the following conditions:

- All applicable sections in the evaluation report [ESR-4246](#).
- The design, installation, conditions of use and identification of the anchors are in accordance with the 2021 *International Building Code*® (IBC) provisions noted in the evaluation report [ESR-4246](#).
- The design, installation and inspection are in accordance with additional requirements of LABC Chapters 16 and 17, and City of Los Angeles Information Bulletin P/BC 2020-092, as applicable.
- Under the LARC, an engineered design in accordance with LARC Section R301.1.3 must be submitted.
- The design strength values listed in the evaluation report and tables are for the connection of the anchors to the concrete. The connection between the anchors and the connected members shall be checked for capacity (which may govern).
- For use in wall anchorage assemblies to flexible diaphragms, anchors shall be designed per the requirements of City of Los Angeles Information Bulletin P/BC 2023-071.

This supplement expires concurrently with the evaluation report, reissued February 2025.

DIVISION: 03 00 00—CONCRETE

Section: 03 16 00—Concrete Anchors

DIVISION: 05 00 00—METALS

Section: 05 05 19—Post-Installed Concrete Anchors

REPORT HOLDER:

CHEMOFAST ANCHORING GmbH

EVALUATION SUBJECT:

CHEMOFAST EP 1000 ADHESIVE ANCHOR AND POST-INSTALLED REINFORCING BAR CONNECTION SYSTEM IN CRACKED AND UNCRACKED CONCRETE

1.0 REPORT PURPOSE AND EVALUATION SCOPE

Purpose:

The purpose of this evaluation report supplement is to indicate that Chemofast EP1000 Adhesive Anchor and Post-Installed Reinforcing Bar Connection System in Cracked and Uncracked Concrete, described in ICC-ES evaluation report ESR-4246, has also been evaluated for compliance with the codes noted below.

Compliance with the following codes:

- 2023 *Florida Building Code—Building*
- 2023 *Florida Building Code—Residential*

2.0 PURPOSE OF THIS SUPPLEMENT

The Chemofast EP1000 Adhesive Anchor and Post-Installed Reinforcing Bar Connection System in Cracked and Uncracked Concrete, described in Sections 2.0 through 7.0 of the evaluation report ESR-4246, complies with the *Florida Building Code—Building* and the *Florida Building Code—Residential*, as applicable. The design requirements must be determined in accordance with the *Florida Building Code—Building* or the *Florida Building Code—Residential*, as applicable. The installation requirements noted in ICC-ES evaluation report ESR-4246 for the 2021 *International Building Code*® meet the requirements of the *Florida Building Code—Building* or the *Florida Building Code—Residential*, as applicable.

Use of the Chemofast EP1000 Adhesive Anchor and Post-Installed Reinforcing Bar Connection System in Cracked and Uncracked Concrete has also been found to be in compliance with the High-Velocity Hurricane Zone provision of the *Florida Building Code—Building* and the *Florida Building Code—Residential* with the following condition.

- a) For connections subject to uplift, the connection must be designed for no less than 700 pounds (3114 N).

For products falling under Florida Rule 61G20-3, verification that the report holder's quality assurance program is audited by a quality assurance entity approved by the Florida Building Commission for the type of inspections being conducted is the responsibility of an approved validation entity (or the code official when the report holder does not possess an approval by the Commission).

This supplement expires concurrently with the evaluation report, reissued February 2025.