



## DECLARATION OF PERFORMANCE



**DoP: 0137**

for Rebar connection with fischer injection system FIS EM Plus (Mortar for post-installed rebar connections) – EN

1. Unique identification code of the product-type: **DoP: 0137**
2. Intended use/es: **Post-installed connection of reinforcing bars (rebars, EN 1992-1-1) by anchoring or overlap connection joint in normal weight concrete, see appendix, especially Annexes B 1 to B 10**
3. Manufacturer: **fischerwerke GmbH & Co. KG, Otto-Hahn-Straße 15, 79211 Denzlingen, Germany**
4. Authorised representative: --
5. System/s of AVCP: **1**
6. European Assessment Document: **ETAG 001; 2013-04**  
European Technical Assessment: **ETA-17/1056; 2017-12-13**  
Technical Assessment Body: **DIBt**  
Notified body/ies: **1343 – MPA Darmstadt**

7. Declared performance/s:

**Mechanical resistance and stability (BWR 1), Safety in use (BWR 4)**

- **Design values of the ultimate bond resistance: See appendix, especially Annex C 1**

**Safety in case of fire (BWR 2)**

- **Reaction to fire: Rebar connections satisfy requirements for Class A 1**
- **Resistance to fire: NPD**

8. Appropriate Technical Documentation and/or Specific Technical Documentation: ---

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

Signed for and on behalf of the manufacturer by:

Andreas Bucher, Dipl.-Ing.

Wolfgang Hengesbach, Dipl.-Ing., Dipl.-Wirtsch.-Ing.

Tumlingen, 2017-12-21

- This DoP has been prepared in different languages. In case there is a dispute on the interpretation the english version shall always prevail.
- The Appendix includes voluntary and complementary information in English language exceeding the (language-neutrally specified) legal requirements.

**Specific Part**

**1 Technical description of the product**

The subject of this European Technical Assessment is the post-installed connection, by anchoring or overlap connection joint, of reinforcing bars (rebars) in existing structures made of normal weight concrete, using the injection mortar fischer FIS EM Plus in accordance with the regulations for reinforced concrete construction.

Reinforcing bars made of steel with a diameter  $\phi$  from 8 to 40 mm or the fischer rebar anchor FRA sizes M12, M16, M20 and M24 and injection mortar FIS EM Plus are used for rebar connections. The steel element is placed into a drilled hole filled with injection mortar and is anchored via the bond between embedded element, injection mortar and concrete.

The product description is given in Annex A.

**2 Specification of the intended use in accordance with the applicable European Assessment Document**

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

The verifications and assessment methods on which this European Technical Assessment is based lead to the assumption of a working life of the rebar connection of at least 50 years. The indications given on the working life cannot be interpreted as a guarantee given by the producer, but are to be regarded only as a means for choosing the right products in relation to the expected economically reasonable working life of the works.

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

**3.1 Mechanical resistance and stability (BWR 1)**

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

**3.2 Safety in case of fire (BWR 2)**

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

**3.3 Hygiene, health and the environment (BWR 3)**

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

**3.4 Safety in use (BWR 4)**

The essential characteristics regarding Safety in use are included under the Basic Works Requirement Mechanical resistance and stability.

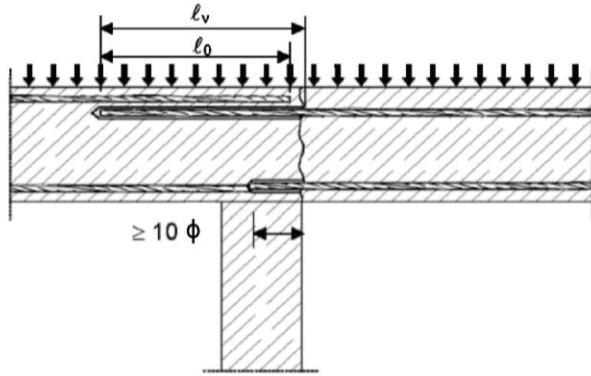
**4 Assessment and verification of constancy of performance (AVCP) system applied, with reference to its legal base**

In accordance with guideline for European technical approval ETAG 001, April 2013 used as European Assessment Document (EAD) according to Article 66 Paragraph 3 of Regulation (EU) No 305/2011 the applicable European legal act is: [96/582/EC].

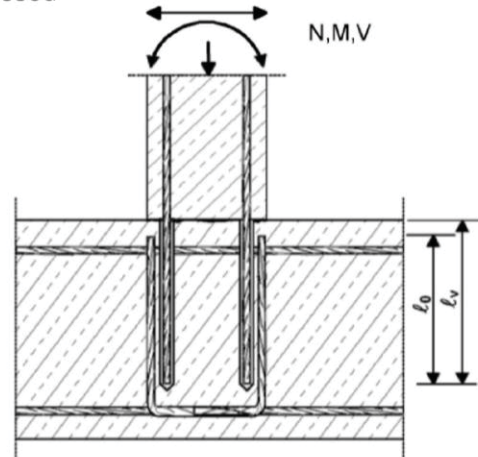
The system to be applied is: 1

**Installation anchor**

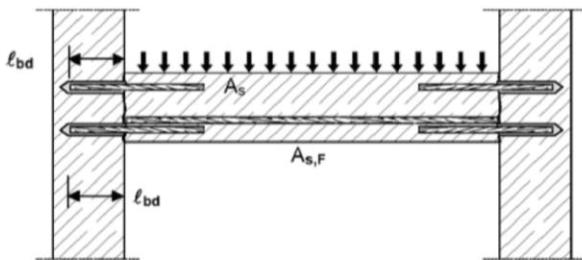
**Figure A1:**  
Overlap joint with existing reinforcement for rebar connections of slabs and beams



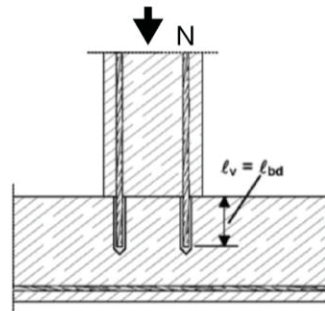
**Figure A2:**  
Overlap joint with existing reinforcement at a foundation of a column or wall where the rebars are stressed



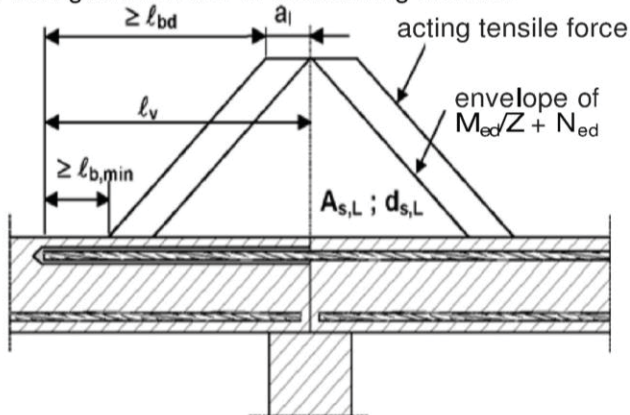
**Figure A3:**  
End anchoring of slabs of beams (e.g. designed as simply supported)



**Figure A4:**  
Rebar connection for stressed primarily in compression



**Figure A5:**  
Anchoring of reinforcement to cover the enveloped line of acting tensile force in the bending member



Note to **Figure A1** to **A5**:

In the Figures no traverse reinforcement is plotted, the traverse reinforcement shall comply with EN 1992-1-1: 2004+AC:2010.

Preparing of joints according to **Annex B 2**

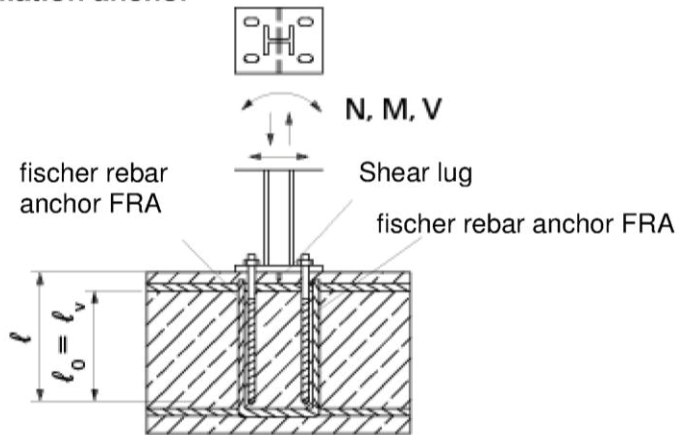
**Rebar connection with fischer Injection mortar FIS EM Plus**

**Annex A 1**

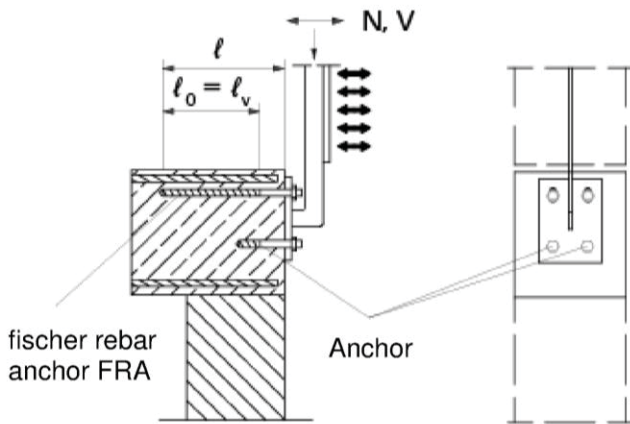
**Product description**

Installed condition and examples of use for rebars

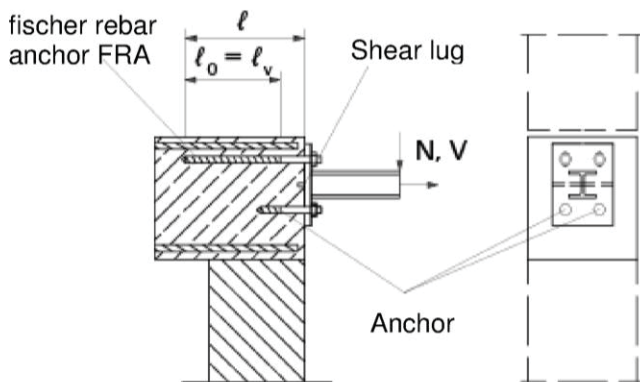
**Installation anchor**



**Figure A6:** Lap to a foundation of a column under bending.



**Figure A7:** Lap of the anchoring of guardrail posts. In the anchor plate, the drill holes for the fischer rebar anchors FRA have to be designed as elongated holes with axial direction to the shear force.



**Figure A8:** Lap of the anchoring of cantilevered building components. In the anchor plate, the drill holes for the fischer rebar anchors FRA have to be designed as elongated holes with axial direction to the shear load.

The required transverse reinforcement acc. to EN 1992-1-1:2004+AC:2010 is not shown in the figures. **The fischer rebar anchor FRA may be only used for axial tensile force.** The tensile force must be transferred by lap to the existing reinforcement of the building. The transfer of the shear force has to be ensured by suitable measure, e.g. by means of shear force or anchors with European Technical Approval/Assessment (ETA)

**Rebar connection with fischer Injection mortar FIS EM Plus**

**Product description**

Installed condition and examples of use for fischer rebar anchor FRA

**Annex A 2**

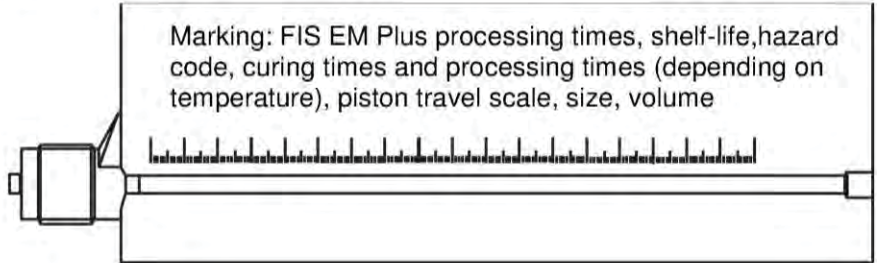


**Injection cartridge fischer FIS EM Plus**

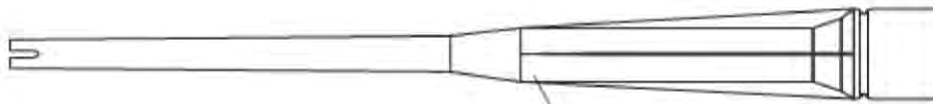
Sizes: 390 ml; 585 ml; 1100 ml, 1500 ml



Sealing cap

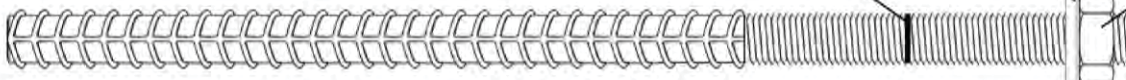


Marking: FIS EM Plus processing times, shelf-life, hazard code, curing times and processing times (depending on temperature), piston travel scale, size, volume



Static mixer FIS MR Plus or FIS UMR

**fischer rebar anchor FRA M12, M16, M20, M24**



marking setting depth

washer

hexagon nut

**Reinforcing bar (rebar)**

φ8, φ10, φ12, φ14, φ16, φ20, φ22, φ24, φ25, φ26, φ28, φ30, φ32, φ34, φ36, φ40



marking setting depth

**Rebar connection with fischer Injection mortar FIS EM Plus**

**Product description**

Injection mortar; reinforcing bar, rebar anchor FRA

**Annex A 3**

**Figure A9: Properties of reinforcing bars (rebar)**



- The minimum value of related rip area  $f_{R,min}$  according to EN 1992-1-1:2004+AC:2010
- The maximum outer rebar diameter over the ribs shall be:
  - The nominal diameter of the rip  $\phi + 2 * h$  ( $h \leq 0,07 * \phi$ )
  - ( $\phi$ : Nominal diameter of the bar; h: rip height of the bar)

**Table A1: Materials of rebars**

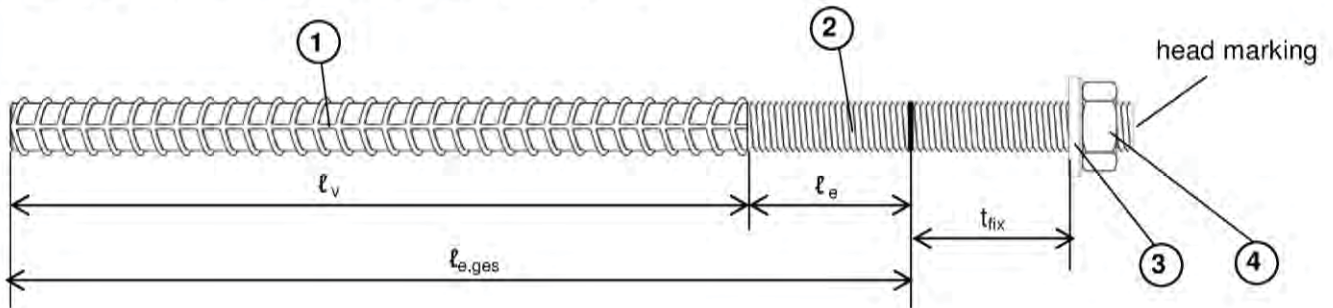
Designation	Reinforcing bar (rebar)
Reinforcing bar EN 1992-1-1:2004+AC:2010, Annex C	Bars and de-coiled rods class B or C with $f_{yk}$ and k according to NDP or NCL of EN 1992-1-1/NA:2013 $f_{uk} = f_{tk} = k \cdot f_{yk}$

**Rebar connection with fischer Injection mortar FIS EM Plus**


**Product description**  
Properties and materials of rebars

**Annex A 4**

**Figure A10: Properties of fischer rebar anchors FRA**



Head marking e.g.:  FRA (for stainless steel)

 FRA C (for high corrosion-resistant steel)

**Table A2: Installation parameters for fischer rebar anchors FRA**

Threaded diameter			M12	M16	M20	M24
Nominal bar size	$\phi$	[mm]	12	16	20	25
Width across flat	SW	[mm]	19	24	30	36
Nominal drill bit diameter	$d_0$	[mm]	14 <sup>2)</sup>	16	20	25
Depth of drill hole ( $h_0 = l_{ges}$ )	$l_{e,ges}$	[mm]	$l_v + l_e$			
Effective anchorage depth	$l_v$	[mm]	acc. to static calculation			
Distance concrete surface to welded joint	$l_e$	[mm]	100			
Diameter of clearance hole in the fixture <sup>1)</sup>	Pre-positioned $\leq d_f$	[mm]	14	18	22	26
	Push through $\leq d_f$	[mm]	18	22	26	32
Minimum thickness of concrete member	$h_{min}$	[mm]	$h_0+30$ $\geq 100$	$h_0 + 2d_0$		
Maximum torque moment	$T_{inst,max}$	[Nm]	50	100	150	150

<sup>1)</sup> For bigger clearance holes in the fixture see chapter 1.1 of the TR 029

<sup>2)</sup> Both drill bit diameters can be used

**Table A3: Materials of fischer rebar anchors FRA**

Part	Description	Materials	
		FRA	FRA C
1	Reinforcing bar	B500B acc. to DIN 488-1:2009	
2	Round bar with partial or full thread	Stainless steel acc. to EN 10088-1:2014	High corrosion-resistant steel acc. to EN 10088-1:2014
3	Washer	Stainless steel acc. to EN 10088-1:2014	High corrosion-resistant steel acc. to EN 10088-1:2014
4	Hexagon nut	Stainless steel acc. to EN 10088-1:2014 Strength class 80; acc. to EN ISO 3506:2009	High corrosion-resistant steel acc. to EN 10088-1:2014 Strength class 80; acc. to EN ISO 3506:2009

**Rebar connection with fischer Injection mortar FIS EM Plus**

**Product description**  
Properties and materials of fischer rebar anchors FRA

**Annex A 5**



**Specifications of intended use**

**Anchorage subject to:**

Static and quasi-static loads

**Base materials:**

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

Note: In case of a carbonated surface of the existing concrete structure the carbonated layer shall be removed in the area of the post-installed rebar connection with a diameter of  $\phi + 60$  mm prior to the installation of the new rebar

The depth of concrete to be removed shall correspond to at least the minimum concrete cover in accordance with EN 1992-1-1:2004+AC:2010.

The foregoing may be neglected if building components are new and not carbonated and if building components are in dry conditions

**Temperature Range:**

- - 40°C to +80°C (max. short term temperature +80°C and max long term temperature +50°C)

**Use conditions (Environmental conditions) for fischer rebar anchors FRA:**

- Structures subject to dry internal conditions (fischer rebar anchors FRA and FRA C)
- Structures subject to external atmospheric exposure (including industrial and marine environment) and to permanently damp internal condition, if no particular aggressive conditions exist (fischer rebar anchors FRA and FRA C)
- Structures subject to external atmospheric exposure and to permanently damp internal condition, if other particular aggressive conditions exist (fischer rebar anchors FRA C)

Note: Particular aggressive conditions are e.g. permanent, alternating immersion in seawater or the splash zone of seawater, chloride atmosphere of indoor swimming pools or atmosphere with extreme chemical pollution (e.g. in desulphurization plants or road tunnels where de-icing materials are used)

**Design:**

- Anchorages are designed under the responsibility of an engineer experienced in anchorages and concrete work
- Verifiable calculation notes and drawings are prepared taking account of the forces to be transmitted Design according to EN 1992-1-1:2004+AC:2010 and Annex B 2 and B 3
- The actual position of the reinforcement in the existing structure shall be determined on the basis of the construction documentation and taken into account when designing

**Installation:**

- Dry or wet concrete
- It must not be installed in flooded holes
- Overhead installation allowed
- Hole drilling by hammer drill, compressed air drill or diamond drill mode
- The installation of post-installed rebar respectively fischer rebar anchor FRA shall be done only by suitable trained installer and under Supervision on site; the conditions under which an installer may be considered as suitable trained and the conditions for Supervision on site are up to the Member States in which the installation is done
- Check the position of the existing rebars (if the position of existing rebars is not known, it shall be determined using a rebar detector suitable for this purpose as well as on the basis of the construction documentation and then marked on the building component for the overlap joint)

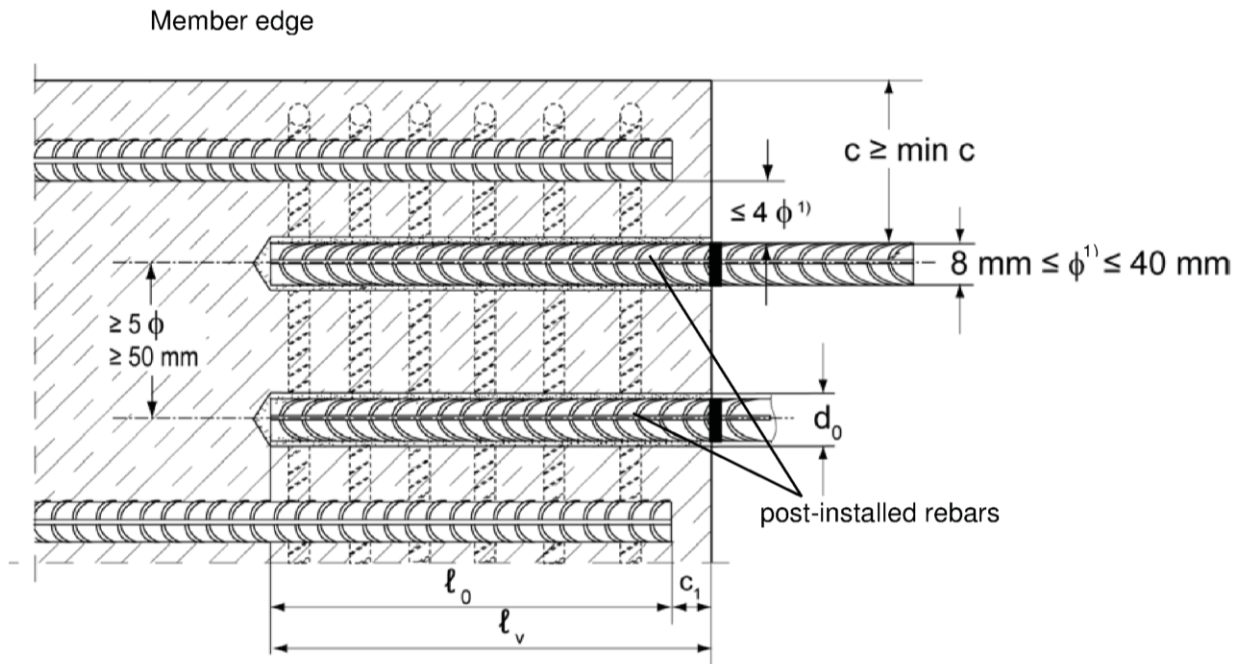
**Rebar connection with fischer Injection mortar FIS EM Plus**

**Intended use**  
Specifications

**Annex B 1**

**Figure B1: General construction rules for post-installed rebars**

- Only tension forces in the axis of the rebar may be transmitted
- The transfer of shear forces between new concrete and existing structure shall be designed additionally according to EN 1992-1-1:2004+AC:2010
- The joints for concreting must be roughened to at least such an extent that aggregate protrude



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

- c concrete cover of post-installed rebar
- $c_1$  concrete cover at end-face of existing rebar
- min c minimum concrete cover according to Table B1 and to EN 1992-1-1:2004+AC:2010, Section 4.4.1.2
- $\phi$  diameter of post-installed rebar
- $\ell_0$  lap length, according to EN 1992-1-1:2004+AC:2010, Section 8.7.3
- $\ell_v$  effective embedment depth,  $\geq \ell_0 + c_1$
- $d_0$  nominal drill bit diameter, see Annex B 5

**Rebar connection with fischer Injection mortar FIS EM Plus**

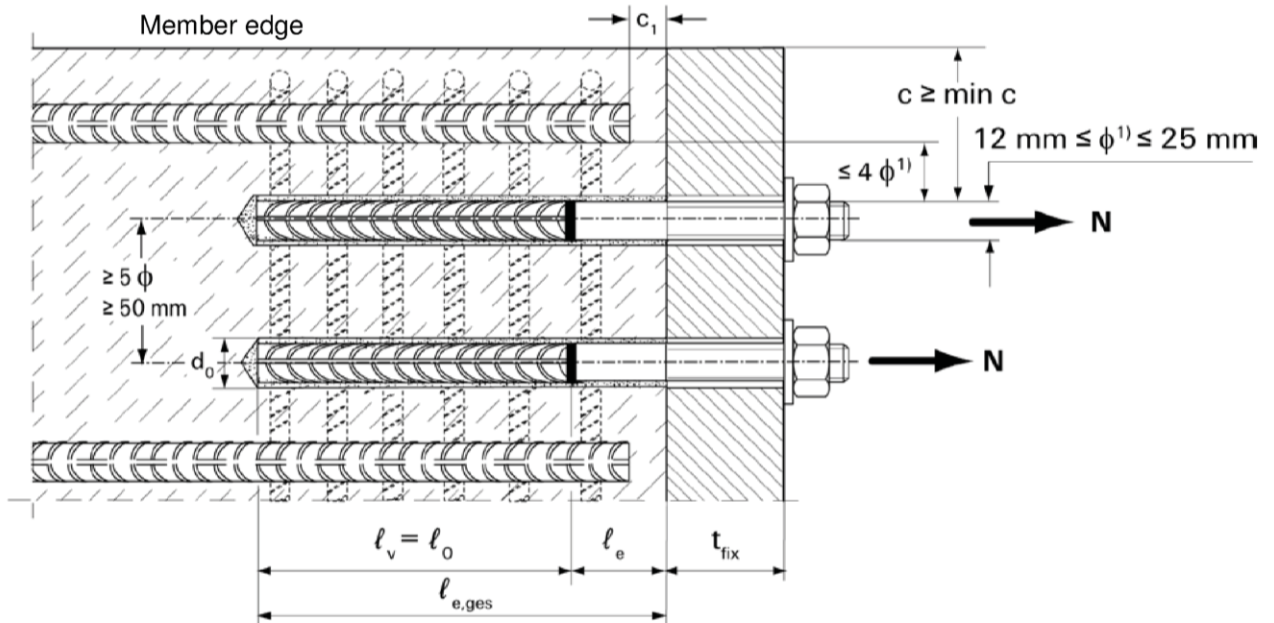
**Annex B 2**

**Intended use**

General construction rules for post-installed rebars

**Figure B2: General construction rules for post-installed rebar anchors FRA**

- Only tension forces in the axis of the FRA may be transmitted
- The tension force must be transferred via an overlap joint to the reinforcement in the building part.
- The transmission of the shear load shall be ensured by appropriate additional measures, e.g. by shear lugs or by anchors with an European Technical Assessment (ETA).
- In the anchor plate, the holes for the tension anchor shall be executed as elongated holes with the axis in the direction of the shear force.



<sup>1)</sup> If the clear distance between lapped bars exceeds  $4\phi$  then the lap length shall be increased by the difference between the clear bar distance and  $4\phi$

- c concrete cover of post-installed FRA
- $c_1$  concrete cover at end-face of existing rebar
- min c minimum concrete cover according to Table B1 and to EN 1992-1-1:2004+AC:2010, Section 4.4.1.2
- $\phi$  nominal diameter of the bar
- $\ell_0$  lap length, according to EN 1992-1-1:2004+AC:2010, Section 8.7.3
- $\ell_{e,ges}$  overall embedment depth,  $\geq \ell_v + \ell_e$
- $d_0$  nominal drill bit diameter, see Annex B 5
- $\ell_e$  length of the bonded in threaded part
- $t_{fix}$  thickness of the fixture
- $\ell_v$  effective embedment depth

**Rebar connection with fischer Injection mortar FIS EM Plus**

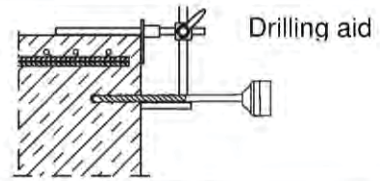
**Intended use**

General construction rules for post-installed rebar anchors FRA

**Annex B 3**



**Table B1:**  
**Minimum concrete cover  $c$ <sup>1)</sup> depending of the drilling method and the drilling tolerance**



Drilling method	Nominal diameter of the bar $\phi$ [mm]	Minimum concrete cover min c	
		Without drilling aid [mm]	With drilling aid [mm]
Hammer drilling	$\leq 20$	30 mm + 0,06 $l_v$	30 mm + 0,02 $l_v \geq 2 \phi$
	$\geq 22$	40 mm + 0,06 $l_v$	40 mm + 0,02 $l_v \geq 2 \phi$
Pneumatic drilling	$\leq 20$	50 mm + 0,08 $l_v$	50 mm + 0,02 $l_v$
	$\geq 22$	60 mm + 0,08 $l_v$	60 mm + 0,02 $l_v$
Diamond drilling	$\leq 20$	30 mm + 0,06 $l_v$	30 mm + 0,02 $l_v \geq 2 \phi$
	$\geq 22$	40 mm + 0,06 $l_v$	40 mm + 0,02 $l_v \geq 2 \phi$

<sup>1)</sup> See Annex B2, Figure B1 and Annex B3, Figure B2

Note: The minimum concrete cover as specified in EN 1992-1-1:2004+AC:2010 must be observed

**Table B2:**  
**Dispensers and cartridge sizes corresponding to maximum embedment depth  $l_{v,max}$**

Rebar /FRA	Manual dispenser	Accu and pneumatic dispenser (small)	Pneumatic dispenser (large)	
	Cartridge size 390 ml, 585 ml	Cartridge size 390 ml, 585 ml	Cartridge size 1500 ml	
$\phi$ [mm]	$l_{v,max} / l_{e,ges,max}$ [mm]	$l_{v,max} / l_{e,ges,max}$ [mm]	$l_{v,max} / l_{e,ges,max}$ [mm]	
8	1000	1000	1800	
10		1200		
12 / FRA 12				1500
14				
16 / FRA 16	700	1300	2000	
20 / FRA 20		1000		
22 / 24 / 25 / FRA 24	700			700
26 / 28				
30 / 32 / 34	-----	500	2000	
36				
40				

**Table B3: Working times  $t_{work}$  and curing times  $t_{cure}$**

Temperature in the anchorage base [°C]	Max. working time <sup>2)</sup> $t_{work}$ [minutes]	Minimum curing time <sup>3)</sup> $t_{cure}$ [hours]
	<b>FIS EM Plus</b>	<b>FIS EM Plus</b>
+5 to +9 <sup>1)</sup>	120	40
>+10 to +19	30	18
>+20 to +29	14	10
>+30 to +40	7	5

<sup>1)</sup> For installation temperature lower than 10°C the mortar FIS EM Plus must be tempered to 20°C

<sup>2)</sup> Maximum time from the beginning of injection to rebar setting and positioning

<sup>3)</sup> For wet concrete the curing time must be doubled

**Rebar connection with fischer Injection mortar FIS EM Plus**

**Intended use**

Minimum concrete cover/ Maximum embedment depth per dispenser and cartridge size/ Working times and curing times

**Annex B 4**



**Table B4:**  
**Installation tools for drilling and cleaning the bore hole and injection of the mortar**

Rebar / FRA $\phi$ [mm]	Drilling and cleaning						Injection			
	Nominal drill bit diameter $d_0$ [mm]		Diameter of cutting edge $d_{cut}$ [mm]		Steel brush diameter $d_b$ [mm]		Cleaning nozzle [mm]	Extension tube [mm]	Injection adapter [colour]	
8	10 <sup>1)</sup>	12 <sup>1)</sup>	$\leq 10,50$	$\leq 12,50$	11,0	12,5	11	9	-	nature
10	12 <sup>1)</sup>	14 <sup>1)</sup>	$\leq 12,50$	$\leq 14,50$	12,5	15			nature	blue
12/ FRA 12	14 <sup>1)</sup>	16 <sup>1)</sup>	$\leq 14,50$	$\leq 16,50$	15	17	15		blue	red
14	18		$\leq 18,50$		19		19	9 or 15	yellow	
16/ FRA 16	20		$\leq 20,55$		21,5				green	
20/ FRA 20	25		$\leq 25,55$		26,5				black	
22, 24	30		$\leq 30,55$		32		grey			
25/ FRA 24	30		$\leq 30,55$		32		28		grey	
26 / 28	35		$\leq 35,70$		37				brown	
30 / 32 / 34	40		$\leq 40,70$		42		38		red	
36	45		$\leq 45,70$		47				yellow	
40	55		$\leq 55,70$		58				nature	

<sup>1)</sup> Both drill bit diameters can be used

**Rebar connection with fischer Injection mortar FIS EM Plus**

**Intended use**

Installation tools for drilling and cleaning the bore hole and injection installation of the mortar

**Annex B 5**

**Safety regulations**

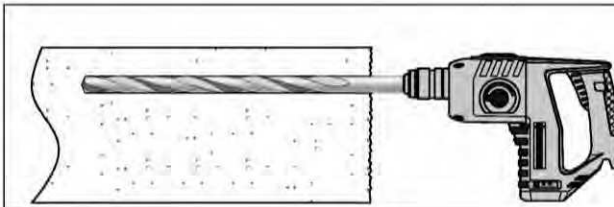


Review the Material Safety Data Sheet (SDS) before use for proper and safe handling!

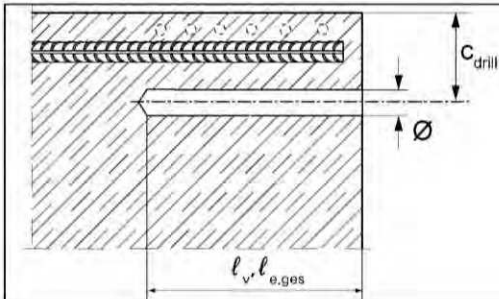
Wear well-fitting protective goggles and protective gloves when working with mortar fischer FIS EM Plus  
important: Observe the instructions for use provided with each cartridge.

**1. Drill hole**

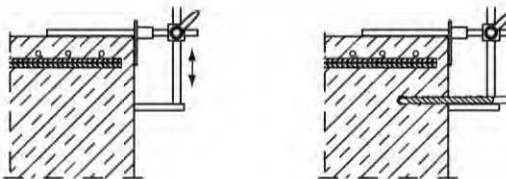
Note: Before drilling, remove carbonized concrete; clean contact areas (see Annex B 1)  
In case of aborted drill hole the drill hole shall be filled with mortar.



Drill hole to the required embedment depth using a hammer-drill with carbide drill bit set in rotation hammer mode, a pneumatic drill or a diamond drill in drilling mode.  
Drill bit sizes see Table B4.



Measure and control concrete cover  $c$   
 $c_{drill} = c + \phi / 2$   
Drill parallel to surface edge and to existing rebar  
Where applicable use fischer drilling aid.



For holes  $l_v > 20$  cm use drilling aid.  
Three different options can be considered:


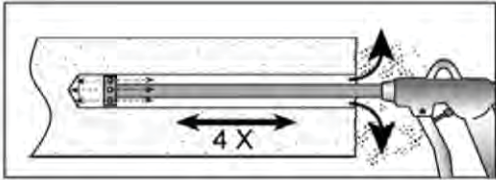

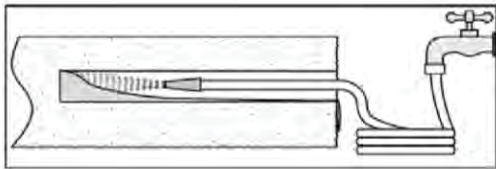
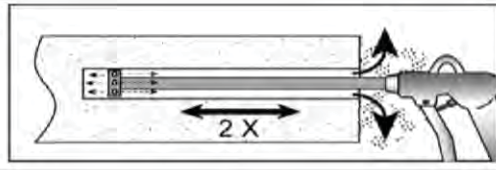
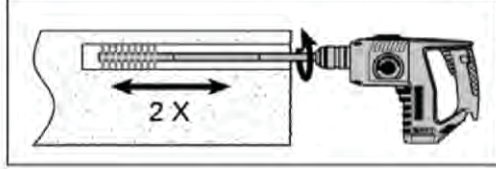
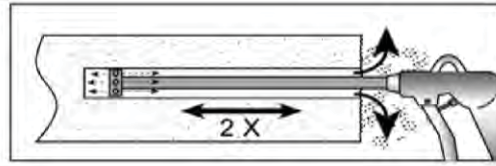
- A) fischer drilling aid
- B) Slat or spirit level
- C) Visual check

**Rebar connection with fischer Injection mortar FIS EM Plus**

**Intended use**  
Installation instruction part 1

**Annex B 6**

## 2. Cleaning the bore hole

<p><b>Hammer- and pneumatic drilling</b></p>	
	<p>Blowing four times from the back of the hole with oil-free compressed air (min. 6 bar) until return air stream is free of noticeable dust.</p>
<p><b>Diamond drilling</b></p>	
<p>Break away the drill core and remove it</p>	
	<p>Flush the bore hole until the water comes clear</p>
	<p>Blowing two times from the back of the hole with oil-free compressed air (min. 6 bar) until return air stream is free of noticeable dust.</p>
	<p>Fix an adequate steel brush with an extension into a drilling machine and brush the bore hole two times</p>
	<p>Blowing two times from the back of the hole with oil-free compressed air (min. 6 bar) until return air stream is free of noticeable dust.</p>



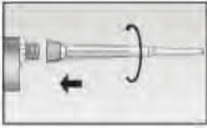


**Rebar connection with fischer Injection mortar FIS EM Plus**

**Intended use**  
Installation instruction part 2

**Annex B 7**





### 3. Rebar preparation and cartridge preparation

	<p>Before use, make asure the rebar or the rebar anchor FRA is dry and free of oil or other residue.          Mark the embedment depth <math>l_v</math> on the rebar (e.g. with tape)          Insert rebar in borehole, to verify hole and setting depth <math>l_v</math> resp. <math>l_{e,ges}</math></p>
<b>Injection system preparation</b>	
	<p>No. 1: Twist off the sealing cap</p>
	<p>No. 2: Twist on the static mixer (the spiral in the static mixer must be clearly visible).</p>
	<p>No. 3: Place the cartridge into a suitable dispenser.</p>
	<p>No. 4: Press approximate 10 cm of material out until the resin is evenly grey in colour. Don't use mortar that is not uniformly grey.</p>

### 4. Inject mortar into borehole

#### 4.1 borehole depth $\leq 250$ mm:

	<p>Inject the mortar from the back of the hole towards the front and slowly withdraw the mixing nozzle step by step after each trigger pull.          Fill holes approximately 2/3 full, or as required to ensure that the annular gap between the rebar and the concrete is completely filled with adhesive over the embedment length.</p>
	<p>After injecting, depressurize the dispenser by pressing the release trigger. This will prevent further mortar discharge from the mixing nozzle.</p>



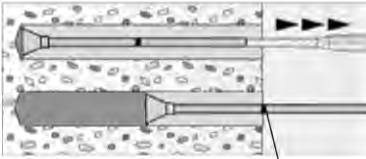

**Rebar connection with fischer Injection mortar FIS EM Plus**

**Intended use**  
 Installation instruction part 3

**Annex B 8**



**4.2 borehole depth > 250 mm:**

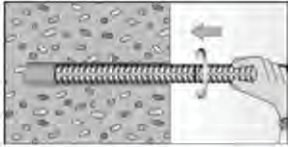
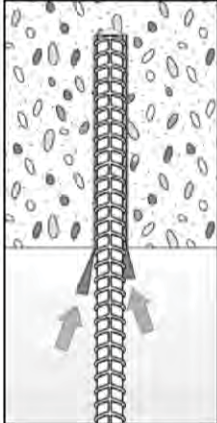
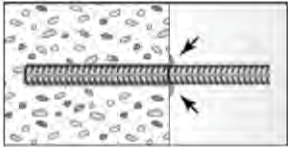

	<p>Assemble mixing nozzle FIS MR Plus or FIS UMR, extension tube and injection adapter (see Table B 4)</p>
 <p>Mortar level mark</p>	<p>Mark the required mortar level <math>l_m</math> and embedment depth <math>l_v</math>, resp. <math>l_{e,ges}</math> with tape or marker on the injection extension tube.</p> <p>a) Estimation:</p> $l_m = \frac{1}{3} * l_v \text{ resp. } l_m = \frac{1}{3} * l_{e,ges}$ <p>b) Precise formula for optimum mortar volume:</p> $l_m = l_v \text{ resp. } l_{e,ges} \left( 1,2 * \frac{d_s^2}{d_0^2} - 0,2 \right) [\text{mm}]$
 <p>Mortar level mark</p>	<p>Insert injection adapter to back of the hole. Begin injection allowing the pressure of the injected adhesive mortar to push the injection adapter towards the front of the hole.</p> <p>Fill holes approximately 2/3 full, or as required to ensure that the annular gap between the rebar and the concrete is completely filled with adhesive over the embedment length.</p> <p>When using an injection adapter continue injection until the mortar level mark <math>l_m</math> becomes visible.</p> <p>Maximum embedment depth see Table B 2</p>
	<p>After injecting, depressurize the dispenser by pressing the release trigger. This will prevent further mortar discharge from the mixing nozzle.</p>

**Rebar connection with fischer Injection mortar FIS EM Plus**

**Annex B 9**

**Intended use**  
Installation instruction part 4

**4.2 Insert rebar**

	<p>For each installation insert the rebar / rebar anchor FRA slowly twisted into the borehole until the embedment mark is at the concrete surface level.</p>
	<p>For overhead installation support the rebar / rebar anchor FRA and secure it from falling till mortar started to harden, e.g. using wedges.</p>
	<p>After installing the rebar or FRA the annular gap must be completely filled with mortar.</p> <p>Proper installation</p> <ul style="list-style-type: none"> <li>• Desired anchoring embedment is reached <math>\ell_v</math>: embedment mark at concrete surface.</li> <li>• Excess mortar flows out of the borehole after the rebar has been fully inserted until the embedment mark.</li> </ul>
	<p>Observe the working time "<math>t_{work}</math>" (see Table B3), which varies according to temperature of base material. Minor adjustments to the rebar / rebar anchor FRA position may be performed during the working time</p> <p>Full load may be applied only after the curing time "<math>t_{cure}</math>" has elapsed (see Table B 3)</p>

**Rebar connection with fischer Injection mortar FIS EM Plus**

**Intended use**  
Installation instruction part 5

**Annex B 10**

**Minimum anchorage length and minimum lap length**

The minimum anchorage length  $\ell_{b,min}$  and the minimum lap length  $\ell_{o,min}$  according to EN 1992-1-1:2004+AC:2010 ( $\ell_{b,min}$  acc. to Eq. 8.6 and Eq. 8.7 and  $\ell_{o,min}$  acc. to Eq. 8.11) shall be multiply by a factor according to Table C1.

**Table C1: Factor related to concrete class and drilling method**

Concrete class	Drilling method	Factor
C12/15 to C50/60	Hammer drilling and pneumatic drilling	1,0
C12/15 to C50/60	Diamond drilling	1,3

**Table C2: Design values of the ultimate bond resistance  $f_{bd}$  in N/mm<sup>2</sup>**

According to EN 1992-1-1: 2004+AC:2010 for good bonds conditions (for all other bond conditions multiply the values by 0,7)

Hammer drill or pneumatic drill									
Rebar / FRA	Bond resistance $f_{bd}$ [N/mm <sup>2</sup> ]								
	Concrete class								
	C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
$\phi$ [mm]									
8 to 25	1,6	2,0	2,3	2,7	3,0	3,4	3,7	4,0	4,3
26 to 40									4,0
Diamond drill									
Rebar / FRA	Bond resistance $f_{bd}$ [N/mm <sup>2</sup> ]								
	Concrete class								
	C12/15	C16/20	C20/25	C25/30	C30/37	C35/45	C40/50	C45/55	C50/60
$\phi$ [mm]									
8 to 12						3,4	3,7	4,0	4,3
14 to 25	1,6	2,0	2,3	2,7	3,0			3,7	
26 to 40						3,0			

**Rebar connection with fischer Injection mortar FIS EM Plus**

**Annex C 1**

**Performances**

Minimum anchorage length and minimum lap length  
Design values of ultimate bond resistance  $f_{bd}$