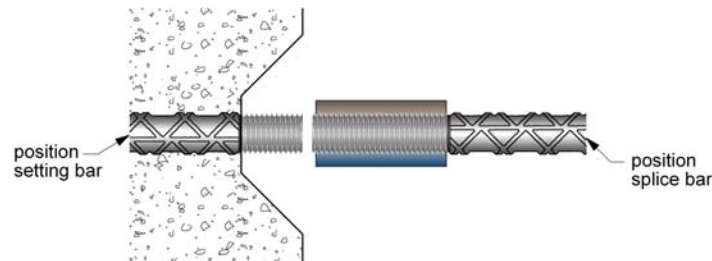


## INSTALLATION INSTRUCTIONS FOR FIELD ASSEMBLY OF BPI® BARSPLICER POSITION COUPLERS ON GRADE 60 THREADED REBARS [U.S. METRIC GRADE 420]

External rebar threads are protected by plastic caps which should be kept in place until the time of assembly. If missing, **obtain the correct caps** from the manufacturer or supplier. If you see minor external **thread damage**, try using a thread file to correct the problem. For other thread damage, it may be necessary to use a thread die tool. **DO NOT TRY TO ASSEMBLE DAMAGED THREADS.** You may cause *premature binding*. **DO NOT USE THIS COUPLER IN CONJUNCTION WITH A REBAR WHICH IS LARGER OR SMALLER THAN THE INTENDED BAR SIZE. DO NOT USE WITH ANYTHING OTHER THAN UNIFIED NATIONAL COURSE (UNC) THREADS. STORE COUPLERS IN A CLEAN, DRY PLACE UNTIL READY TO INSTALL.**

- 1 Because of the nature of the position assembly, the threaded rebar should be placed first. Place a cap on the thread and use a block out in order to make sure the rebar thread is protected from the concrete before pouring concrete around or near the thread. **DO NOT PLACE REINFORCING BAR IF THE THREADS ARE DAMAGED AND CANNOT BE REPAIRED.**
- 2 When joining the threaded rebar and Barsplicer position coupler, remove the protective cap and then line up both sides as straight as possible as shown in the pre-assembled condition below. Also be sure to have the rebar ends as close to each other as possible, with no more than 1/8" gap, in order to maximize the engagement of the rebar threads once fully assembled.

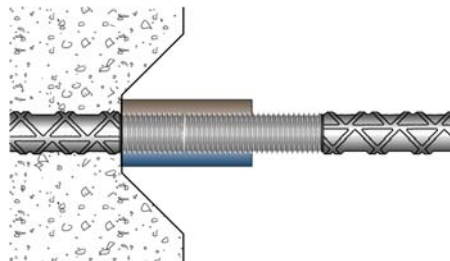
### PRE-ASSEMBLED CONNECTION



Just before assembly, check both internal and external threads for cleanliness. Clean off any foreign matter. **DO NOT USE CORROSIVE ACIDS.** Any thread damage must be corrected as noted above before installation.

- 3 After the initial thread location, rotate the position coupler clockwise onto the rebar thread making sure that the threaded ends remain aligned. **NOTE: If the threaded end of the rebar is bent, DO NOT ALIGN THE REBARS. ALIGN THE THREADS SO THAT THE THREADS SCREW TOGETHER.** Continue to rotate the coupler by hand. If you feel the threads starting to prematurely bind, **DO NOT FORCE THEM. Shake the free end of the rebar while turning. ASSEMBLE UNTIL THE SHORTER LENGTH THREAD IS FULLY ENGAGED IN THE POSITION COUPLER AND THE LONGER LENGTH REBAR THREAD IS ENGAGED APPROXIMATELY HALF OF ITS OVERALL THREAD LENGTH (as shown in the assembled condition below).**

### ASSEMBLED CONNECTION



If the threaded rebar end does not properly engage into the Barsplicer coupler during assembly, stop immediately. Disassemble the connection to determine the problem. Possible causes of mis-assembly may be either mis-matched thread sizes, or threads are contaminated with (ex.) concrete, dirt, or threads have been damaged. Reassemble only after the problem has been identified and corrected.

- 4 To be assured that the position setting bar threads have been fully engaged into the Barsplicer Position coupler, use a pipe wrench or chain wrench to snug and tighten the setting bar threads (Note: Splice bar threads will remain loose within coupler). **DO NOT WIRE TIE BARS UNTIL AFTER FULL ASSEMBLY.** In all cases, consider your own **personal safety**. Make sure you are securely positioned and that you will not slip or fall during installation. Use only good quality wrenches that will not round-out.
- 5 Inspect the splice for proper thread engagement. For Barsplicer threads, some variation in the number of exposed threads is natural due to thread tolerance build-up and thread run-out. In general, it is usual to see 0 to 1 threads on the position setting bar after full assembly (Note: Position splice bar should have approximately half of its overall thread length visible after proper assembly). **IT IS NOT NECESSARY TO USE A TORQUE WRENCH DURING ASSEMBLY OR APPLY A HIGH TORQUE VALUE.**
- 6 In the case of epoxy coated couplers and rebar, touch-up any damaged areas and exposed threads with an epoxy repair kit. Seal off the rebar at the point of entry of the rebar into the coupler using epoxy repair material.