Hilti HIT-RE 500 V3 mortar with HIS-(R)N sleeve

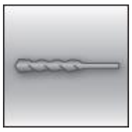
Injection mortar system		Benefits
	Hilti HIT-RE V3 500 330 ml, 500 ml and 1400 ml foil pack	- **SAFEset** technology: Hilti hollow drill bit for hammer drilling and roughening tool for diamond drilling - suitable for cracked/non-cracked concrete C 20/25 to C 50/60 - high loading capacity - suitable for dry and water saturated concrete - under water application - high corrosion resistance - long working time at elevated temperatures - odourless epoxy
	Static mixer	
	HIS-(R)N sleeve	

Base material


Concrete (uncracked)

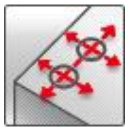

Concrete (cracked)

Installation conditions

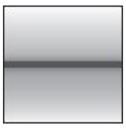

Hammer drilled holes


Diamond drilled holes

SAFEset
Hilti SAFEset technology


Small edge distance and spacing

Load conditions


Static/ quasi-static


Seismic, ETA-C1


Fire resistance

Other information


European Technical Assessment


CE conformity


PROFIS Anchor design Software

A4
316
Corrosion resistance

Approvals / certificates

Description	Authority / Laboratory	No. / date of issue
European Technical Assessment	CSBT	ETA-16/0143 / 2016-07-28

a) All data given in this section according to ETA-16/0143, issue 2016-07-28.

Seismic resistance (for a single anchor)

All data in this section applies to:
- Correct setting (See setting instruction with hammer drilling)
- No edge distance and spacing influence
- *Steel* failure
- Screw strength class 8.8
- Minimum base material thickness
- Concrete C 20/25, $f_{ck,cube}$ = 25 N/mm²
- Temperature range I (min. base material temperature -40°C, max. long/short term base material temperature: +24°C/40°C)
- Installation temperature range +5°C to +40°C
- α_{gap} = 1,0 (using Seismic/Filling set)

Effective anchorage depth for seismic C1

Anchor size			M8	M10	M12	M16	M20
Eff. Anchorage depth	h_{ef}	[mm]	90	110	125	170	205

Characteristic resistance in case of seismic performance category C1

Anchor size			M8	M10	M12	M16	M20
Tensile $N_{Rk,seis}$	HIS-(R)N	[kN]	*25,0*	35,3	42,8	67,8	89,8
Shear $V_{Rk,seis}$	HIS-(R)N	[kN]	*9,0*	*16,0*	*27,0*	*44,0*	*41,0*

Design resistance in case of seismic performance category C1

Anchor size			M8	M10	M12	M16	M20
Tensile $N_{Rd,seis}$	HIS-(R)N	[kN]	16,7	23,5	28,5	45,2	59,9
Shear $V_{Rd,seis}$	HIS-(R)N	[kN]	7,2	12,8	19,2	35,2	32,8

Static resistance (for a single anchor)

All data in this section applies to:
- Correct setting (See setting instruction with hammer drilling)
- No edge distance and spacing influence
- *Steel* failure
- Screw strength class 8.8
- Minimum base material thickness
- Concrete C 20/25, $f_{ck,cube}$ = 25 N/mm²
- Temperature range I (min. base material temperature -40°C, max. long/short term base material temperature: +24°C/40°C)
- Installation temperature range +5°C to +40°C

Effective anchorage depth for static

Anchor size			M8	M10	M12	M16	M20
Eff. Anchorage depth	h_{ef}	[mm]	90	110	125	170	205

Characteristic resistance in case of static performance

Anchor size			M8	M10	M12	M16	M20
Non cracked concrete							
Tensile N_{Rk}	HIS-(R)N	[kN]	*25,0*	*46,0*	*67,0*	111,9	*116,0*
Shear V_{Rk}	HIS-(R)N	[kN]	*13,0*	*23,0*	*34,0*	*63,0*	*58,0*
Cracked concrete							
Tensile N_{Rk}	HIS-(R)N	[kN]	*25,0*	41,5	50,3	79,8	105,7
Shear V_{Rk}	HIS-(R)N	[kN]	*13,0*	*23,0*	*34,0*	*63,0*	*58,0*

Design resistance in case of static performance

Anchor size			M8	M10	M12	M16	M20
Non cracked concrete							
Tensile N_{Rd}	HIS-(R)N	[kN]	16,7	30,7	44,7	74,6	77,3
Shear V_{Rd}	HIS-(R)N	[kN]	10,4	18,4	27,2	50,4	46,4
Cracked concrete							
Tensile N_{Rd}	HIS-(R)N	[kN]	16,7	27,7	33,5	53,2	70,4
Shear V_{Rd}	HIS-(R)N	[kN]	10,4	18,4	27,2	50,4	46,4

Materials

Mechanical properties

Anchor size			M8	M10	M12	M16	M20
Nominal tensile strength f_{uk}	HIS-N	[N/mm²]	490	490	460	460	460
	Screw 8.8		800	800	800	800	800
	HIS-RN		700	700	700	700	700
	Screw A4-70		700	700	700	700	700
Yield strength f_{yk}	HIS-N	[N/mm²]	410	410	375	375	375
	Screw 8.8		640	640	640	640	640
	HIS-RN		350	350	350	350	350
	Screw A4-70		450	450	450	450	450
Stressed cross-section A_s	HIS-(R)N	[mm²]	51,5	108,0	169,1	256,1	237,6
	Screw		36,6	58	84,3	157	245
Moment of resistance W	HIS-(R)N	[mm³]	145	430	840	1595	1543
	Screw		31,2	62,3	109	277	541

Material quality

Part	Material
internally threaded sleeves a) HIS-N	C-steel 1.0718, steel galvanized ≥ 5µm
internally threaded sleeves b) HIS-RN	stainless steel 1.4401 and 1.4571

a) related fastening screw: strength class 8.8, A5 > 8% Ductile
steel galvanized ≥ 5µm

b) related fastening screw: strength class 70, A5 > 8% Ductile
stainless steel 1.4401; 1.4404; 1.4578; 1.4571; 1.4439; 1.4362

Service temperature range

Hilti HIT-RE 500 V3 injection mortar may be applied in the temperature ranges given below. An elevated base material temperature may lead to a reduction of the design bond resistance.

Temperature range	Base material temperature	Maximum long term base material temperature	Maximum short term base material temperature
Temperature range I	-40 °C to +40 °C	+24 °C	+40 °C
Temperature range II	-43 °C to +70 °C	+43 °C	+70 °C

Max short term base material temperature
Short-term elevated base material temperatures are those that occur over brief intervals, e.g. as a result of diurnal cycling.

Max long term base material temperature
Long-term elevated base material temperatures are roughly constant over significant periods of time.

Setting

Installation equipment

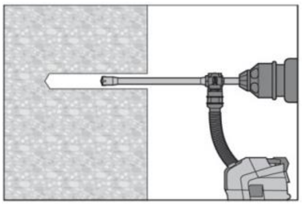
Anchor size	M8	M10	M12	M16	M20
Rotary hammer	TE 2 – TE 16		TE 40 – TE 70		
Other tools	compressed air gun or blow out pump, set of cleaning brushes, dispenser				

a) For anchors in diamond drilled holes load values for combined pull-out and concrete cone resistance have to be reduced (see section “Setting instruction”)

Setting instructions

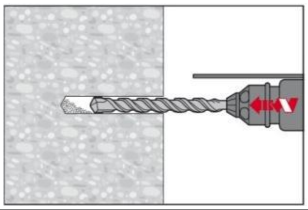
Bore hole drilling

a) Hilti hollow drill bit For dry and wet concrete only



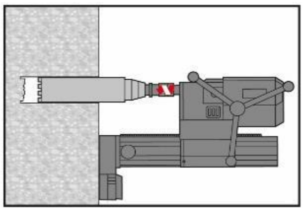
Drill hole to the required embedment depth with an appropriately sized Hilti TE-CD or TE-YD hollow drill bit with Hilti vacuum attachment. This drilling system removes the dust and cleans the bore hole during drilling when used in accordance with the user’s manual.
After drilling is complete, proceed to the “injection preparation” step in the instructions for use.

b) Hammer drilling Dry or wet concrete and installation in flooded holes (no sea water)

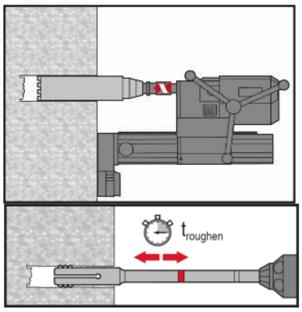


Drill Hole to the required embedment depth with a hammer drill set in rotation-hammer mode using an appropriately sized carbide drill bit.

c) Diamond coring For dry and wet concrete only



Diamond coring is permissible when diamond core drilling machine and the corresponding core bit are used.



Diamond coring is permissible when suitable diamond core drilling machines and the corresponding core bits are used.

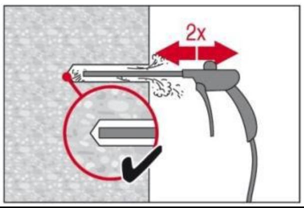
Before roughening the borehole needs to be dry. Check usability of the roughening tool with the wear gauge RTG.
Roughen the borehole over the whole length to the required hef.

Bore hole cleaning

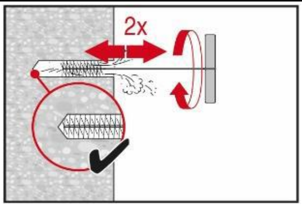
Just before setting an anchor, the bore hole must be free of dust and debris.

a) Compressed air cleaning CAC

For bore hole diameters $d_0 \leq$ 20mm and bore hole depth $h_0 \leq$ 20d or $h_0 \leq$ 250 mm (d = diameter of element)



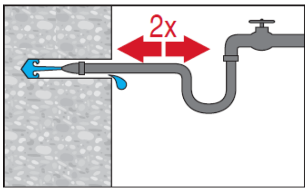
The Hilti manual pump may be used for blowing out bore holes up to diameters $d_0 \leq$ 20 mm and embedment depths up to $h_{ef} \leq$ 10d.
Blow out at least 4 times from the back of the bore hole until return air stream is free of noticeable dust



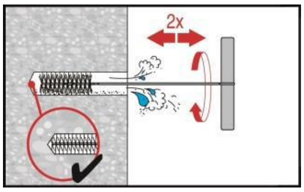
Brush 4 times with the specified brush size (brush diameter ≥ bore hole) by inserting the steel brush Hilti HIT-RB to the back of the hole (if needed with extension) in a twisting motion and removing it.
The brush must produce natural resistance as it enters the bore hole - if not the brush is too small and must be replaced with the proper brush diameter.

b) Cleaning of hammer drilled holes and diamond cored holes

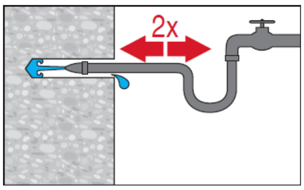
For all bore hole diameters d_0 and all bore hole depth h_0



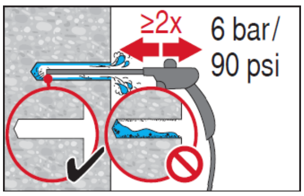
Flush 2 times the hole by inserting a water hose (water-line pressure) to the back of the hole until water runs clear.



Brush 2 times with the specified brush size by inserting the steel brush Hilti HIT-RB to the back of the hole (if needed with extension) in a twisting motion and removing it.
The brush must produce natural resistance as it enters the bore hole - if not the brush is too small and must be replaced with the proper brush diameter.

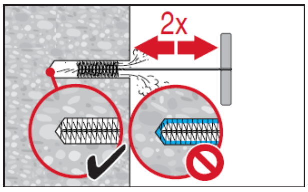


Flush again 2 times the hole by inserting a water hose (water-line pressure) to the back of the hole until water runs clear.

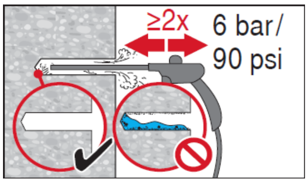


Blow 2 times from the back of the hole (if needed with nozzle extension) over the hole length with oil-free compressed air (min. 6 bar at 6 m³/h) until return air stream is free of noticeable dust and water.

Bore hole diameter ≥ 32 mm the compressor must supply a minimum air flow of 140 m³/hour.



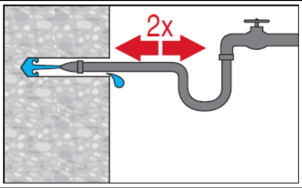
Brush 2 times with the specified brush size by inserting the steel brush Hilti HIT-RB to the back of the hole (if needed with extension) in a twisting motion and removing it.
The brush must produce natural resistance as it enters the bore hole - if not the brush is too small and must be replaced with the proper brush diameter.



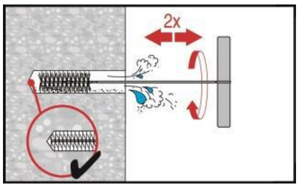
Blow again with compressed air 2 times until return air stream is free of noticeable dust and water.

c) Cleaning of diamond cored holes followed by roughening

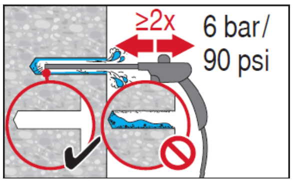
For all drill hole diameters d_0 and all drill hole depths h_0.



Flush 2 times by inserting a water hose (water-line pressure) to the back of the hole until water runs clear.

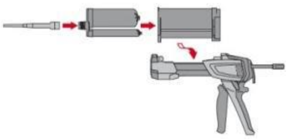


Brush 2 times with the specified brush (see Table B7) by inserting the steel brush Hilti HIT-RB to the back of the hole (if needed with extension) in a twisting motion and removing it. The brush must produce natural resistance as it enters the drill hole (brush Ø ≥ drill hole Ø) - if not the brush is too small and must be replaced with the proper brush diameter.

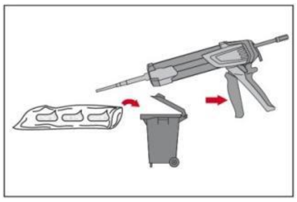


Blow 2 times from the back of the hole (if needed with nozzle extension) over the whole length with oil-free compressed air (min. 6 bar at 6 m^3/h) until return air stream is free of noticeable dust and water. For drill hole diameters ≥ 32 mm the compressor has to supply a minimum air flow of 140 m^3/h.

Injection preparation



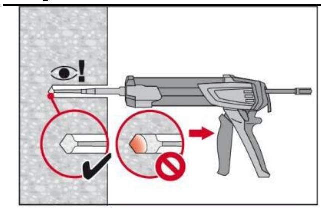
Tightly attach new Hilti mixing nozzle HIT-RE-M to foil pack manifold (snug fit). Do not modify the mixing nozzle. Observe the instruction for use of the dispenser and mortar.
Check foil pack holder for proper function. Do not use damaged foil packs / holders. Insert foil pack into foil pack holder and put holder into HIT-dispenser.



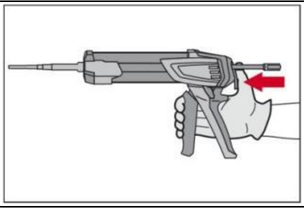
The foil pack opens automatically as dispensing is initiated. Discard initial adhesive. Depending on the size of the foil pack an initial amount of adhesive has to be discarded.
Discard quantities are: 2 strokes for 330 ml foil pack, 3 strokes for 500 ml foil pack, 65 ml for 1400 ml foil pack.

Inject adhesive

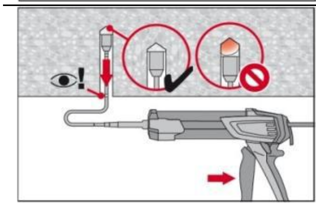
From the back of the drill hole without forming air voids



Inject the adhesive starting at the back of the hole, slowly withdrawing the mixer with each trigger pull.
Fill holes approximately 2/3 full. It is required that the annular gap between the anchor and the concrete is completely filled with adhesive along the embedment length.



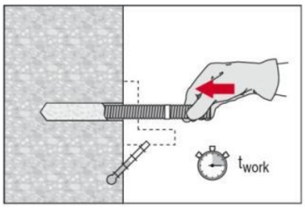
After injection is completed, depressurize the dispenser by pressing the release trigger. This will prevent further adhesive discharge from the mixer.



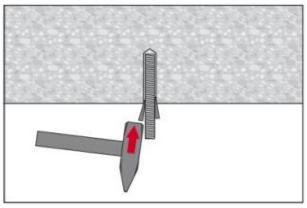
Overhead installation and/or installation with embedment depth h_{ef} > 250mm. For overhead installation the injection is only possible with the aid of extensions and piston plugs. Assemble HIT-RE-M mixer, extension(s) and appropriately sized piston plug HIT-SZ. Insert piston plug to back of the hole and inject adhesive. During injection the piston plug will be naturally extruded out of the bore hole by the adhesive pressure.

Setting the element

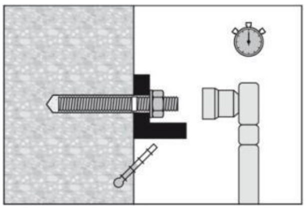
Just before setting an anchor, the drill hole must be free of dust and debris.



Before use, verify that the element is dry and free of oil and other contaminants. Mark and set element to the required embedment depth untill working time t_{work} has elapsed.



For overhead installation use piston plugs and fix embedded parts with e.g. wedges HIT-OHW.



Loading the anchor: after required curing time t_{cure} the anchor can be loaded. The applied installation torque shall not exceed T_{max}.

For detailed information on installation see instruction for use given with the package of the product.

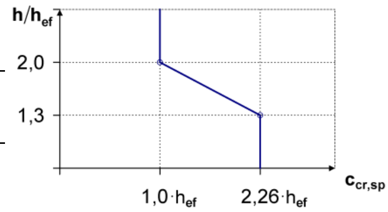
Curing time for general conditions

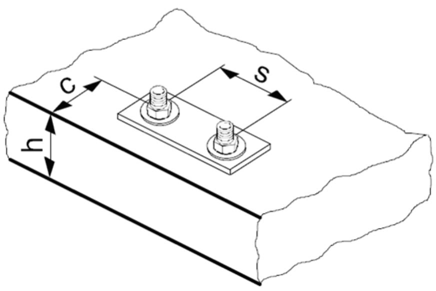
Temperature of the base material T	Minimum curing time t_{cure}
-5 °C to -1 °C	168 h
0 °C to 4 °C	48 h
5 °C to 9 °C	24 h
10 °C to 14 °C	16 h
15 °C to 19 °C	16 h
20 °C to 24 °C	7 h
25 °C to 29 °C	6 h
30 °C to 34 °C	5 h
35 °C to 39 °C	4,5 h
40 °C	4 h

The curing time data are valid for dry base material only. In wet base material the curing times must be doubled.

Setting details

Setting details

Anchor size			M8	M10	M12	M16	M20
Nominal diameter of drill bit	d_0	[mm]	14	18	22	28	32
Diameter of element	d	[mm]	12,5	16,5	20,5	25,4	27,6
Effective anchorage and drill hole depth	h_{ef}	[mm]	90	110	125	170	205
Minimum base material thickness	h_{min}	[mm]	120	150	170	230	270
Diameter of clearance hole in the fixture	d_f	[mm]	9	12	14	18	22
Thread engagement length; min - max	h_s	[mm]	8-20	10-25	12-30	16-40	20-50
Minimum spacing	s_{min}	[mm]	60	70	90	115	130
Minimum edge distance	c_{min}	[mm]	40	45	55	65	90
Critical spacing for splitting failure	$s_{cr,sp}$		$2\ c_{cr,sp}$				
Critical edge distance for splitting failure [a]	$c_{cr,sp}$	[mm]	$1,0 \cdot h_{ef}$ for $h / h_{ef} \geq 2,0$ $4,6\ h_{ef} - 1,8\ h$ for $2,0 > h / h_{ef} > 1,3$ $2,26\ h_{ef}$ for $h / h_{ef} \leq 1,3$				
Critical spacing for concrete cone failure	$s_{cr,N}$		$2\ c_{cr,N}$				
Critical edge distance for concrete cone failure [c]	$c_{cr,N}$		$1,5\ h_{ef}$				
Torque moment [c]	T_{max}	[Nm]	10	20	40	80	150



For spacing (edge distance) smaller than critical spacing (critical edge distance) the design loads have to be reduced.

a) $h_{ef,min} \leq h_{ef} \leq h_{ef,max}$ (h_{ef}: embedment depth)

b) h: base material thickness ($h \geq h_{min}$)

c) The critical edge distance for concrete cone failure depends on the embedment depth h_{ef} and the design bond resistance. The simplified formula given in this table is on the save side.