

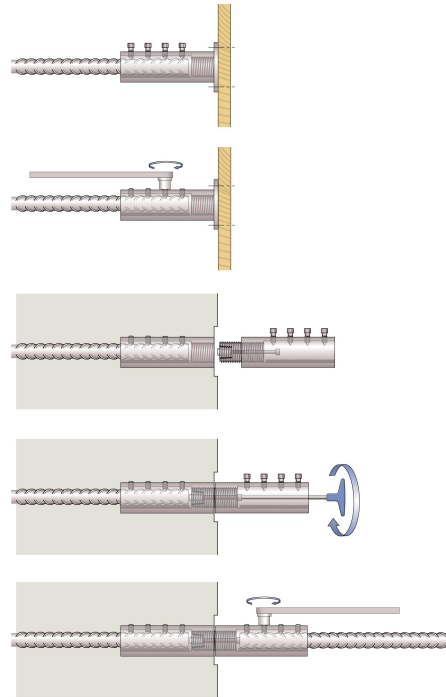
# Ancon MBT Continuity Coupler Installation Guide

## Sizes 20mm to 40mm

**Ancon MBT Couplers must be correctly installed to ensure that the full working capacity can be achieved. The coupler should be complete with the correct number of bolts and the two serrated strip saddles in place inside the coupler. For correct installation, all the bolts must be tightened until the heads shear off.**

The Continuity Coupler male component will be delivered with the threaded stud already in place and the locknuts located on the threaded stud. If the female component is to be left in situ for an extended period, the threads must be greased to prevent corrosion.

- 1 Fix the nail plate to the formwork and fully screw the female component onto the plate. Insert the bar into the coupler, ensuring that it does not encroach into the threaded section.
- 2 Finger tighten the lockshear bolts in a random alternating pattern, then fully tighten using a ratchet wrench, electric or pneumatic power tool, until the heads shear off. Cast the concrete.
- 3 Remove the formwork and unscrew the nail plate. The cone within the male threaded stud must be checked to ensure that it has not expanded the stud. The cone should move freely. The male component can now be fully screwed into the fixed female component. The male coupler can now be rotated up to a full turn to allow the lockshear bolts to be located in an accessible position for tightening.
- 4 The two sections are now locked together by expanding the cone in the centre of the coupler with the tool supplied.
- 5 The continuation bar is placed into the male coupler and the bolts finger tightened. Fully tighten the lock shear bolts in a random alternating pattern, then fully tighten using a ratchet wrench, electric or a pneumatic power tool, until the heads shear off.
6. Do not use impact power tools to tighten the bolts.



Ref.	No./Bolt Thread	Socket Head	Nominal Bolt Shear Torque		Handle Length* (mm)
			(Nm)	(lbf ft)	
ET20	8/M12	1/2"	108	80	600
ET25	8/M16	5/8"	275	203	900
ET32	10/M16	5/8"	360	265	1500**
ET40	14/M20	3/4"	525	385	1800**

The use of scaffold poles is not recommended as an extension to hand wrenches; this can result in increased stresses, leading to thread strip during installation.

\* The minimum length of handle to limit the force required to shear the bolts to 250N. This is approximately equivalent to lifting 25kg or 56 lbs.

\*\* Although these can be tightened using a ratchet wrench, Ancon recommend the use of an electric or pneumatic wrench designed to deliver a steady tightening force to the bolts. **Do not use impact power tools.**

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<b>Batch No</b>	<b>MBT Coupler Installation Guide (Sizes 20mm to 40mm)</b>		
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