Ancon®
MBT Mechanically-Bolted Couplers
for the Construction Industry
Under the Leviat brand, we have united the expertise, skills and resources of Ancon and its sister companies to create a world leader in fixing, connecting and anchoring technology.

The products you know and trust will remain an integral part of Leviat’s comprehensive brand and product portfolio. As Leviat, we can offer you an extended range of specialist products and services, greater technical expertise, a larger and more agile supply chain and better, faster innovation.

By bringing together CRH’s construction accessories family as one global organisation, we are better equipped to meet the needs of our customers, and the demands of construction projects, of any scale, anywhere in the world.

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Our product brands include:

- Ancon
- HALFEN
- HELIFIX
- ISEDIO
- PLAKA


60 locations
30+ locations
3000 people worldwide

Leviat.com
Lapped joints are not always an appropriate means of connecting reinforcing bars. The use of laps can be time consuming in terms of design and installation and can lead to greater congestion within the concrete because of the increased amount of rebar used.

Ancon couplers can simplify the design and construction of reinforced concrete and reduce the amount of reinforcement required.

Lapped joints are dependent upon the concrete for load transfer. For this reason any degradation in the integrity of the concrete could significantly affect the performance of the joint. The strength of a mechanical splice is independent of the concrete in which it is located and will retain its strength despite loss of cover as a result of impact damage or seismic event.

Our range of Ancon reinforcing bar couplers is the most comprehensive available and includes tapered threaded, parallel threaded, mechanically bolted and grouted couplers. Couplers for stainless steel and cryogenic-grade rebars complete the range.

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<td>9</td>
</tr>
</tbody>
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Reinforcing Bar Couplers

MBT
The Ancon MBT range of couplers provides a cost-effective method of joining reinforcing bars, particularly when the fixed bar is already in place and there is insufficient space for a hydraulic swaging press.

MBT Couplers are easy to install and achieve failure loads higher than 115% of the characteristic yield strength of grade 500 reinforcing bar. Neither bar end preparation to form threads, nor bar rotation are required. MBT couplers can also be used to join imperial, plain round or deformed reinforcing bars.

The bar ends are supported within the coupler by two serrated saddles, and as the lockshear bolts are tightened, the conical ends embed themselves into the bar. As this happens the serrated saddles bite into both the bar and the shell of the coupler. The lockshear bolts of couplers up to and including the ET20 can be tightened using a ratchet wrench. For larger couplers a nut runner is recommended.

In all cases heavy duty sockets should be used. When the pre-determined tightening torque for the bolts is reached, the heads shear off leaving the top of the installed bolt slightly proud of the coupler. This provides an instant visual check of correct installation.

Note: Impact tools must not be used to tighten lockshear bolts.

MBT ET Series
The MBT ET series of couplers is used to connect reinforcing bars of the same size.

Testing & Approvals
Full destructive tests are carried out on selected couplers from our stocks. MBT couplers are designed and manufactured in accordance with BS EN ISO 9001. The most common size of ET series couplers are approved to UK CARES TA1-A & TA1-B 5083 and in accordance with the Manual of Contract Documents for Highways Works, Volume 1 Specification for Highways Works, Series 1700 Structural Concrete (Amended March 2020) including the bar sizes featured in the table below.

Sizes ET10, 12, 14, 16, 20, 25 and 28 have been tested and approved by the DIBt and are covered by Approval No Z-1.5-10. Further national approvals include BMVT Approval No. -327.120/0018-I/ST2/2006, RISE Approval No.0541-95 which covers the ET Series and Continuity C Series, and AFCAB Approval No. M20/023 which covers specific bar diameter sizes in the ET series of couplers, as shown in the table below.

The full range of MBT Couplers is certified by GOST for the Russian Federation. In addition the coupler has been tested to show compliance with the following international design codes:- BS EN 1992-1-1: 2004 (Eurocode 2), BS5400, BS8110, BS8597: 2015, ACI 318 and DIN 1045 German code.

Note: Not all coupler types and sizes are relevant to the national approvals shown. For details of coupler types and sizes relevant to each national approval please refer to the relevant approval document, which is available on request.

Installation MBT ET Series

Place the coupler over the end of the bar to half the coupler length +/- 8mm and finger tighten the lockshear bolts onto the bar. Check the alignment and make any necessary adjustments.

On one half of the coupler, starting from the centre and working outwards, partly tighten the lockshear bolts using either a ratchet wrench or a nut runner as appropriate. Do not use impact tools. Repeat again, this time fully tightening the lockshear bolts until the bolt heads shear off. Repeat the above for the other half of the coupler.

MBT ET Series Dimensions

<table>
<thead>
<tr>
<th>Bar Diameter (mm)</th>
<th>10</th>
<th>12*</th>
<th>14*</th>
<th>16*</th>
<th>18</th>
<th>20*</th>
<th>22</th>
<th>25*</th>
<th>26</th>
<th>28</th>
<th>30</th>
<th>32*</th>
<th>34</th>
<th>36</th>
<th>40*</th>
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<tbody>
<tr>
<td>External Diameter (mm)</td>
<td>d</td>
<td>33</td>
<td>33</td>
<td>42</td>
<td>42</td>
<td>48</td>
<td>48</td>
<td>54</td>
<td>67</td>
<td>71</td>
<td>75</td>
<td>86</td>
<td>81</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Total Length (mm)</td>
<td>l</td>
<td>100</td>
<td>140</td>
<td>160</td>
<td>160</td>
<td>204</td>
<td>204</td>
<td>248</td>
<td>258</td>
<td>312</td>
<td>312</td>
<td>312</td>
<td>420</td>
<td>484</td>
<td>484</td>
</tr>
<tr>
<td>No. of Bolts</td>
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<td>6</td>
<td>6</td>
<td>6</td>
<td>8</td>
<td>8</td>
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<td>10</td>
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<td>12</td>
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<td>14</td>
</tr>
<tr>
<td>Approx Weight (kg)</td>
<td>0.52</td>
<td>0.72</td>
<td>1.25</td>
<td>1.25</td>
<td>2.0</td>
<td>1.96</td>
<td>2.38</td>
<td>3.00</td>
<td>5.91</td>
<td>5.80</td>
<td>6.68</td>
<td>6.50</td>
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<td>15.30</td>
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<tr>
<td>Part No.</td>
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<td>ET12</td>
<td>ET14</td>
<td>ET16*</td>
<td>ET18</td>
<td>ET20</td>
<td>ET22</td>
<td>ET25</td>
<td>ET26</td>
<td>ET28</td>
<td>ET30</td>
<td>ET32</td>
<td>ET34</td>
<td>ET36</td>
<td>ET40</td>
</tr>
</tbody>
</table>

Note: Dimensions are nominal values and subject to change from time to time. Other sizes available on request. * AFCAB certification applies to this bar diameter size.

Part No. ET10 ET12 ET14 ET16* ET18 ET20 ET22 ET25 ET26 ET28 ET30 ET32 ET34 ET36 ET40
MBT Transition Series
The Ancon MBT Transition series of couplers provides an effective solution for connecting bars of different diameters.

Transition couplers have all of the benefits of the ET series and are designed to achieve failure loads higher than 115% of the characteristic yield strength of the smaller grade 500 reinforcing bar.

They can be installed without any preparation to the bar ends and without any need to rotate bars.

The coupler can be rotated to allow access to the bolts for tightening with either a ratchet wrench or a nut runner. In all cases heavy duty sockets should be used. Transition couplers are non-standard and are made to order.

Note: Impact tools should not be used to tighten lockshear bolts.

**MBT Transition Series Dimensions**

<table>
<thead>
<tr>
<th>Bar Diameter (mm)</th>
<th>16/12</th>
<th>16/14</th>
<th>20/12</th>
<th>20/16</th>
<th>25/16</th>
<th>25/20</th>
<th>28/20</th>
<th>28/22</th>
<th>28/25</th>
<th>32/20</th>
<th>32/25</th>
<th>32/28</th>
<th>40/32</th>
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<tbody>
<tr>
<td>External Diameter (mm)</td>
<td>d</td>
<td></td>
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<td></td>
<td></td>
</tr>
<tr>
<td>Total Length (mm)</td>
<td>l</td>
<td></td>
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<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Individual Lengths</td>
<td>a,b</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Socket Size A/F (ins)</td>
<td>a,b</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>No. of Bolts</td>
<td>a,b</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
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<td></td>
</tr>
<tr>
<td>Approx Weight (kg)</td>
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<td></td>
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<td></td>
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<td></td>
</tr>
</tbody>
</table>

Note: Dimensions are nominal values and subject to change from time to time.

**Installation**

**MBT Transition Series**

1. Place the coupler over the end of the bar to the appropriate depth +/- 6mm and finger tighten the lockshear bolts onto the bar. Check the alignment and make any necessary adjustments.

2. Place the other bar end into the coupler until it pushes up against the first bar and finger tighten the remaining lockshear bolts. Check alignment and make any adjustments.

3. On one half of the coupler, starting from the centre and working outwards, partly tighten the lockshear bolts using either a ratchet wrench or a nut runner as appropriate. Do not use impact tools. Repeat again, this time fully tightening the lockshear bolts until the bolt heads shear off. Repeat the above for the other half of the coupler.

**Electric Wrench**

Ancon Electric Wrenches are available for purchase or hire. The smooth continuous action of the wrench prevents the early shearing of the lockshear bolts and damage to threads. The wrench is supplied with specially hardened heavy duty sockets. For details please contact us.
Reinforcing Bar Couplers

MBT Continuity C Series
The Ancon MBT Continuity coupler allows reinforcement to be extended at construction joints without the need to drill or otherwise substantially deface the formwork.

The female part of the C series coupler is fixed to the formwork with the aid of a nail plate.

After removal of the formwork, the nail plate protects the internally threaded end of the coupler. It is advisable to loosen the nail plate to break the bond with the concrete whilst it is still ‘green’. When the nail plate is removed, the male section can be screwed into the existing section of the coupler.

Installation

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. Finger tighten the lockshear bolts. Check alignment and make any adjustments.

2. Starting from the nail plate end and working outwards, partly tighten the lockshear bolts using either a ratchet wrench or a nut runner as appropriate. Do not use impact tools. Repeat again, this time fully tightening the lockshear bolts until the bolt heads shear off. Cast in concrete.

3. Remove the formwork and unscrew the nail plate. The male component can now be fully screwed into the fixed female component. The male component can be rotated up to a full turn to allow the bolts to be located in an accessible position for tightening.

4. Run the locknut along the threaded male stud to abut the female component. Fully tighten the locknut against the female section using a wrench.

5. Place the continuation bar into the male component and finger tighten the bolts. Check alignment and make any adjustments. Starting from the centre and working outwards, partly tighten the lockshear bolts using either a ratchet wrench or a nut runner as appropriate. Do not use impact tools. Repeat again, this time fully tightening the lockshear bolts until the bolt heads shear off. Fully tighten the locknut.

Note: When the coupler is fully assembled the visible threaded stud between the two locknuts must not exceed 20mm.

Note: 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.

<table>
<thead>
<tr>
<th>Bar Diameter (mm)</th>
<th>1Z</th>
<th>16</th>
<th>2U</th>
<th>2Z</th>
<th>32</th>
<th>40</th>
</tr>
</thead>
<tbody>
<tr>
<td>External Diameter (mm)</td>
<td>33</td>
<td>42</td>
<td>48</td>
<td>54</td>
<td>71</td>
<td>81</td>
</tr>
<tr>
<td>Maximum Length (mm)</td>
<td>250</td>
<td>280</td>
<td>349</td>
<td>414</td>
<td>490</td>
<td>675</td>
</tr>
<tr>
<td>Female Component Length (mm)</td>
<td>100</td>
<td>115</td>
<td>147</td>
<td>177</td>
<td>214</td>
<td>300</td>
</tr>
<tr>
<td>Threaded Section (mm)</td>
<td>30</td>
<td>35</td>
<td>39</td>
<td>43</td>
<td>53</td>
<td>53</td>
</tr>
<tr>
<td>Socket Size A/F (ins)</td>
<td>1”</td>
<td>1”</td>
<td>1”</td>
<td>1”</td>
<td>1”</td>
<td>1”</td>
</tr>
<tr>
<td>No. of Bolts</td>
<td>6</td>
<td>6</td>
<td>8</td>
<td>8</td>
<td>10</td>
<td>14</td>
</tr>
<tr>
<td>Nail Plate Diameter x Thickness</td>
<td>75 x 5</td>
<td>75 x 5</td>
<td>75 x 5</td>
<td>100 x 5</td>
<td>100 x 5</td>
<td>127 x 5</td>
</tr>
<tr>
<td>Approx Weight (kg)</td>
<td>1.40</td>
<td>2.20</td>
<td>3.70</td>
<td>5.15</td>
<td>11.5</td>
<td>18.8</td>
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<tr>
<td>Part No.</td>
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<td>C16</td>
<td>C20</td>
<td>C25</td>
<td>C32</td>
<td>C40</td>
</tr>
</tbody>
</table>

Note: Dimensions are nominal values and subject to change from time to time.
Repair and Remedial Work
The Ancon MBT range of couplers is ideal for applications involving the replacement of corroded or damaged reinforcement as bar ends require no preparation or rotation.

MBT ET Couplers
When two MBT ET type couplers are used, the replacement bar is cut approximately 5mm shorter than the original length to allow clearance for insertion between the sound ends of the in-situ bars. MBT ET couplers are pushed fully over both ends of the replacement bar and temporarily held in position. The replacement bar is then correctly positioned and the couplers moved to a previously marked position on the existing bars indicating half the length of the coupler. The lockshear bolts are tightened to complete the installation. The above application is suitable where the bar being replaced is at least 2 x MBT ET coupler length (see page 22) + 100mm.

MBT Continuity C Series Gap Closer
A smaller section of bar can be removed and replaced by an MBT Continuity C Series coupler. The central threaded stud can be modified to suit the gap. The table provides the minimum bar length (dimension A) and minimum concrete pocket length (dimension B) to be cut away to facilitate this solution.

Installation
Bar replacement using MBT Continuity C Series Gap Closer

1. Orientate so threaded sections face inwards and pass the two halves of the continuity coupler over the opposing bar ends to leave the gap visible.
2. Insert appropriately sized stud in the gap and rotate each half of the coupler so the stud locates fully in each internal thread.
3. Tighten locknuts against the couplers. Shear bolt heads to complete installation by starting from the centre and working outwards and partly tightening the lockshear bolts using either a ratchet wrench or a nut runner as appropriate. Do not use impact tools. Repeat again, this time fully tightening the lockshear bolts.

MBT Continuity C Series Gap Closer
<table>
<thead>
<tr>
<th>Bar Diameter (mm)</th>
<th>A</th>
<th>B</th>
</tr>
</thead>
<tbody>
<tr>
<td>12</td>
<td>100</td>
<td>300</td>
</tr>
<tr>
<td>16</td>
<td>115</td>
<td>345</td>
</tr>
<tr>
<td>20</td>
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<td>441</td>
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<td>25</td>
<td>177</td>
<td>531</td>
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<td>32</td>
<td>214</td>
<td>642</td>
</tr>
<tr>
<td>40</td>
<td>300</td>
<td>900</td>
</tr>
</tbody>
</table>
**MBT Headed Anchors**

Ancon MBT Headed Anchors are designed to provide dead end embedment for bars in concrete. This helps to reduce congestion and simplify the placement of rebars by removing the need for hooked ends.

The anchor comprises half an MBT coupler with a plate welded to one end which carries the full tension load of the bar when it is bearing against the concrete. Plates can be supplied with or without a hole, allowing bars to either end in or pass through the coupler. The MBT Headed Anchor also has the added advantage of requiring no special bar end preparation.

<table>
<thead>
<tr>
<th>Bar Diameter (mm)</th>
<th>10</th>
<th>12</th>
<th>14</th>
<th>16</th>
<th>18</th>
<th>20</th>
<th>22</th>
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<th>28</th>
<th>30</th>
<th>32</th>
<th>34</th>
<th>36</th>
<th>40</th>
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</thead>
<tbody>
<tr>
<td><strong>External Diameter (mm)</strong></td>
<td>d</td>
<td>d</td>
<td>d</td>
<td>d</td>
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<td>d</td>
<td>d</td>
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<tr>
<td><strong>Coupler Length (mm)</strong></td>
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<td>l</td>
<td>l</td>
<td>l</td>
<td>l</td>
<td>l</td>
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<td>l</td>
<td>l</td>
<td>l</td>
<td>l</td>
<td>l</td>
</tr>
<tr>
<td><strong>Total Length (mm)</strong></td>
<td>l_o</td>
<td>l_o</td>
<td>l_o</td>
<td>l_o</td>
<td>l_o</td>
<td>l_o</td>
<td>l_o</td>
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<td>l_o</td>
<td>l_o</td>
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</tr>
<tr>
<td><strong>Plate Thickness (mm)</strong></td>
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<td>t</td>
<td>t</td>
<td>t</td>
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<td>t</td>
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<td>t</td>
</tr>
<tr>
<td><strong>Plate w x h (mm)</strong></td>
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<td>p</td>
<td>p</td>
<td>p</td>
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<td>p</td>
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<tr>
<td><strong>Socket Size A/F (ins)</strong></td>
<td></td>
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</tr>
<tr>
<td><strong>No of Bolts</strong></td>
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<td>3</td>
<td>3</td>
<td>3</td>
<td>3</td>
<td>3</td>
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<td>3</td>
<td>3</td>
<td>3</td>
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<td>3</td>
</tr>
<tr>
<td><strong>Approx Weight (kg)</strong></td>
<td>0.64</td>
<td>0.74</td>
<td>1.01</td>
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<td>1.58</td>
<td>1.58</td>
<td>2.29</td>
<td>3.81</td>
<td>4.14</td>
<td>5.08</td>
<td>5.72</td>
<td>5.17</td>
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</tr>
<tr>
<td><strong>Part No.</strong></td>
<td>ETHA10 ETHA12 ETHA14 ETHA16 ETHA18 ETHA20 ETHA22 ETHA25 ETHA26 ETHA28 ETHA30 ETHA32 ETHA34 ETHA36 ETHA40</td>
<td></td>
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</tr>
<tr>
<td><strong>Part No.</strong> (Hole in plate)</td>
<td>ETHA10H ETHA12H ETHA14H ETHA16H ETHA18H ETHA20H ETHA22H ETHA25H ETHA26H ETHA28H ETHA30H ETHA32H ETHA34H ETHA36H ETHA40H</td>
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</tr>
</tbody>
</table>

*Note: Minimum compressive strength of concrete 25N/mm². Dimensions are nominal values and subject to change from time to time.*
Other Leviat Products

Reinforcement Continuity Systems
Reinforcement Continuity Systems are an increasingly popular means of maintaining continuity of reinforcement at construction joints in concrete. Our re-bend systems consist of pre-bent bars housed within a steel casing. Once installed, the bars are straightened ready for lapping with slab reinforcement. A range of headed anchors and starter bars is also available, which once cast in concrete will accept threaded continuation bars. They easily accommodate long lap lengths such as those prevalent in EC2, and eliminate the need for on-site bar straightening. Headed anchors are particularly useful when it comes to minimising rebar congestion in the wall.

Shear Load Connectors
Shear Load Connectors are used to transfer shear across expansion joints and contraction joints in concrete. They are more effective at transferring loads and allowing movement to take place than standard dowels. The range features rectangular box section sleeves to allow lateral movements in addition to longitudinal movements. A range of lockable dowels is available for temporary movement joints in post-tensioned concrete.

Channel and Bolt Fixings
Leviat offers a wide range of channels and bolts in order to fix items such as fabricated steel masonry supports and restraints to structural frames. Cast-in channels and expansion bolts are used for fixing to the edges of concrete floors and beams.

Punching Shear Reinforcement
Punching shear reinforcement systems are used within a slab to provide additional reinforcement and prevent punching shear around columns. The systems generally consists of double-headed studs welded to flat rails, and are designed to suit the load conditions and slab depth at each column location using free-to-download calculation software.

Structural Thermal Breaks
Structural thermal breaks minimise heat loss while maintaining structural integrity: for example at balcony locations in externally insulated and cavity insulated buildings, or at slab-to-wall connections in internally insulated buildings. As a critical structural component they transfer moment, shear, tension and compression forces. Standard solutions are available for concrete-to-concrete, steel-to-concrete and steel-to-steel interfaces.

HM Grout Sleeve Couplers
Ancon HM Grout Sleeves have been designed to cater for the rebar tolerances / bar alignment issues associated with joining precast concrete elements together.

The range comprises two standard coupler types: full-grout sleeves and half-grout sleeves. In the first, bars are simply inserted to meet at the nominal centre point of the sleeve. In the latter, one end features an internal thread to accept a pre-threaded bar while the other is open to accommodate a non-threaded continuation bar. The standard internal thread suits Ancon Bartec Plus parallel-threaded rebars. Other thread profiles are available.

These sleeves are manufactured from high strength ductile iron and used with our high performance, shrinkage-compensated cementitious grout.

Tests show compliance with the rebar coupler performance specifications in BS 8597 and ISO 15835.

Contact us for full technical details or download the product brochure online.
Innovative engineered products and construction solutions that allow the industry to build safer, stronger and faster.
Worldwide contacts for Leviat:

Australia
Leviat
98 Kurrajong Avenue,
Mount Druitt Sydney, NSW 2770
Tel: +61 - 2 8808 3100
Email: info.au@leviat.com

Austria
Leviat
Leonard-Bernstein-Str. 10
Saturn Tower, 1220 Wien
Tel: +43 - 1 - 259 8770
Email: info.at@leviat.com

Belgium
Leviat
Industrielaan 2
1740 Ternat
Tel: +32 - 2 - 582 29 45
Email: info.be@leviat.com

China
Leviat
Room 601 Tower D, Vantone Centre
No. A6 Chao Yang Men Wai Street
Chaoyang District
Beijing · P.R. China 100020
Tel: +86 - 10 5907 3200
Email: info.cn@leviat.com

Czech Republic
Leviat
Business Center Šafránkova
Šafránkova 1238/1
155 00 Praha 5
Tel: +420 - 311 - 690 060
Email: info.cz@leviat.com

Finland
Leviat
Vädersgatan 5
412 50 Göteborg / Sweden
Tel: +358 (0)10 6338781
Email: info.fi@leviat.com

France
Leviat
6, Rue de Cabanis
FR 31240 L’Union
Toulouse
Tel: +33 - 5 - 34 25 54 82
Email: info.fr@leviat.com

Germany
Leviat
Liebigstrasse 14
40764 Langenfeld
Tel: +49 - 2173 - 970 - 0
Email: info.de@leviat.com

India
Leviat
309, 3rd Floor, Orion Business Park
Ghodbunder Road, Kapurbawdi,
Thane West, Thane,
Maharashtra 400607
Tel: +91 - 22 2589 2032
Email: info.in@leviat.com

Italy
Leviat
Via F.lli Bronzetti 28
24124 Bergamo
Tel: +39 - 035 - 0760711
Email: info.it@leviat.com

Malaysia
Leviat
28 Jalan Anggerik Mokara 31/59
Kota Kemuning, 40460 Shah Alam
Selangor
Tel: +603 - 5122 4182
Email: info.my@leviat.com

Netherlands
Leviat
Oostermaat 3
7623 CS Borne
Tel: +31 - 74 - 267 14 49
Email: info.nl@leviat.com

New Zealand
Leviat
2/19 Nuttall Drive, Hillsborough,
Christchurch 8022
Tel: +64 - 3 376 5205
Email: info.nz@leviat.com

Norway
Leviat
Vestre Svanholmen 5
4313 Sandnes
Tel: +47 - 51 82 34 00
Email: info.no@leviat.com

Philippines
Leviat
2933 Regus, Joy Nostalg,
ADB Avenue
Ortigas Center
Pasig City
Tel: +63 - 2 7957 6381
Email: info.ph@leviat.com

Poland
Leviat
UL. Obornicka 287
60-691 Poznań
Tel: +48 - 61 - 622 14 14
Email: info.pl@leviat.com

Singapore
Leviat
14 Benoi Crescent
Singapore 629977
Tel: +65 - 6266 6802
Email: info.sg@leviat.com

Spain
Leviat
Polígono Industrial Santa Ana
c/ Ignacio Zuloaga, 20
28822 Rivas-Vaciamadrid
Tel: +34 - 91 632 18 40
Email: info.es@leviat.com

Sweden
Leviat
Vädursgatan 5
412 50 Göteborg
Tel: +46 - 31 - 98 58 00
Email: info.se@leviat.com

Switzerland
Leviat
Grenzstrasse 24
3250 Lyss
Tel: +41 - 31 750 3030
Email: info.ch@leviat.com

United Arab Emirates
Leviat
RA08 TB02, PO Box 17225
JAFZA, Jebel Ali, Dubai
Tel: +971 (0)4 883 4246
Email: info.ae@leviat.com

United Kingdom
Leviat
President Way, President Park,
Sheffield, S4 7UR
Tel: +44 - 114 275 5224
Email: info.uk@leviat.com

United States of America
Leviat
6467 S Falkenburg Rd.
Riverview, FL 33578
Tel: (800) 423-9140
Email: info.us@leviat.us

For countries not listed
Email: info@leviat.com

Leviat.com

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For more information on these products, contact:

Leviat
President Way
President Park
Sheffield, S4 7UR
United Kingdom
Tel: +44 (0) 114 275 5224
Fax: +44 (0) 114 276 8543
Email: info.ancon.uk@leviat.com

For sales enquiries:
Email: reinforcement.uk@leviat.com

www.ancon.co.uk
www.leviat.com