

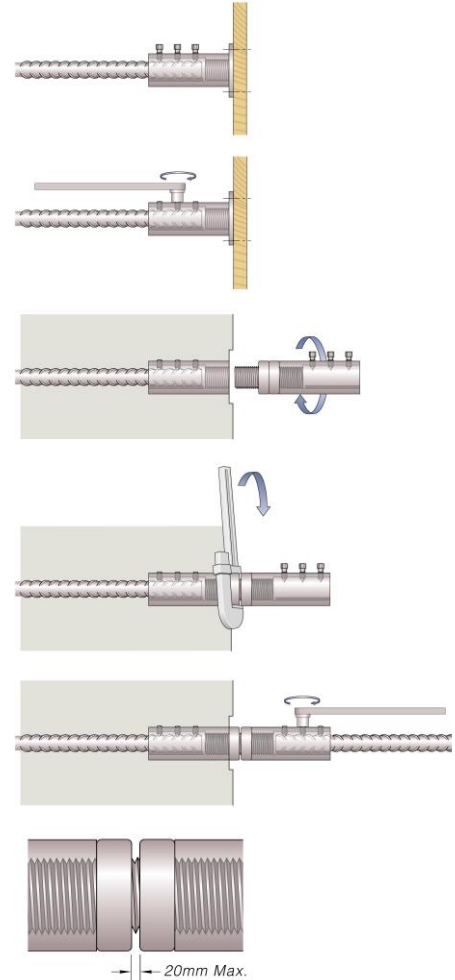
Ancon MBT Continuity Coupler Installation Guide

Sizes 12mm 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 insitu 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. Finger tighten the lockshear bolts.
- 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 complete with two locknuts, can now be fully screwed into the fixed female component. The male coupler can be rotated up to a full turn to allow the lockshear 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.
- 6 Do not use impact power tools to tighten the bolts.



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

Ref.	No./Bolt Thread	Socket Head	Nominal Bolt Shear Torque		Handle Length* (mm)
			(Nm)	(lbf ft)	
C12	6/M10	1/2"	55	40	300
C16	6/M12	1/2"	108	80	600
C20	8/M12	1/2"	108	80	600
C25	8/M16	5/8"	275	150	900
C32	10/M16	5/8"	360	265	1500**
C40	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 recommends 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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