



Headed Reinforcement Corporation

### HRC 500 SERIES INSTALLATION PROCEDURE (Caltrans)

This procedure is for the installation of assembled HRC 500/510 couplers and steel reinforcing bars.

The male and female components are screwed together hand-tight without the need to rotate the bar themselves. See Figure 1 on attached. The assembly must then be tightened using the torque values as defined in Table 1, except for hoops that require no minimum torque. Since the two coupler parts are free to rotate around bar axis, it may be necessary to hold one coupler part stationary with a pipe wrench while torque is being applied to the corresponding component. Visual inspection must be performed according to Figure 2. Full threads must not be visible. The male collar and female sleeve must not touch or bottom out.

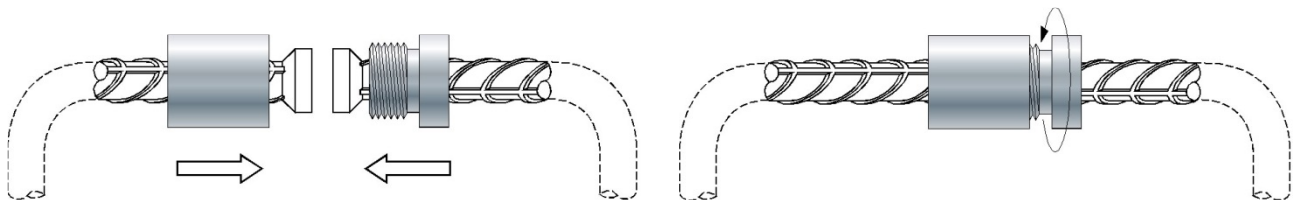


Figure 1 – 500/510 Series Couplers

Lubricate threads with grease or WD-40 if necessary

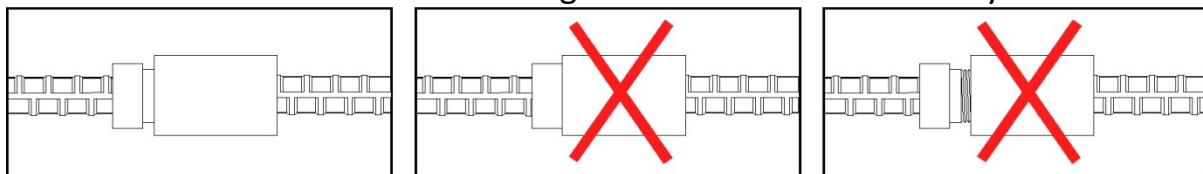


Figure 2 – 500/510 Visual Inspection

Table 1 – Dimensions of HRC 500/510 Couplers

Bar size	#4	#5	#6	#7	#8	#9	#10	#11	#14
A-Coupler OD [in]	1.375	1.500	1.625	1.875	2.125	2.375	2.625	2.875	3.500
B-Typical Length [in]	2.00	2.13	2.38	2.88	3.13	3.50	3.75	4.25	5.13
Torque [lbf-ft]*	100	100	150	200	250	250	300	350	400

For SI: 1 inch = 25.4 mm, 1 sq.in. = 645 mm<sup>2</sup>, 1 foot = 305mm

\* Torque not required for hoops. Hand tightening is sufficient.