

SAFETY FIRST! In all cases, follow jobsite safety plans, and consider your own personal safety. Make sure you are wearing PPE, and are securely positioned so that you will not slip or fall during installation.

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). The assembly must then be hand-tightened to a snug fit. Lubricate threads and use wrenches if necessary. 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

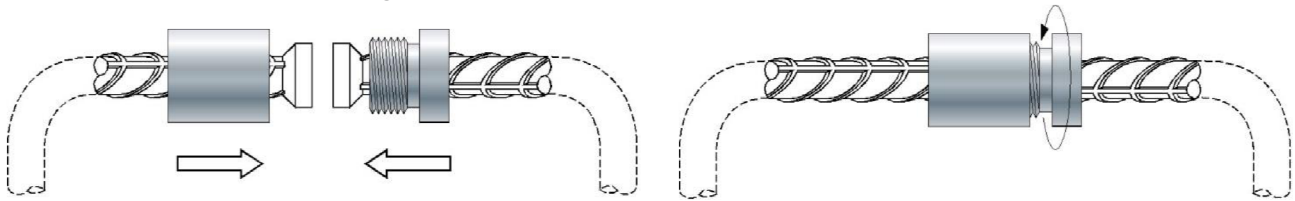
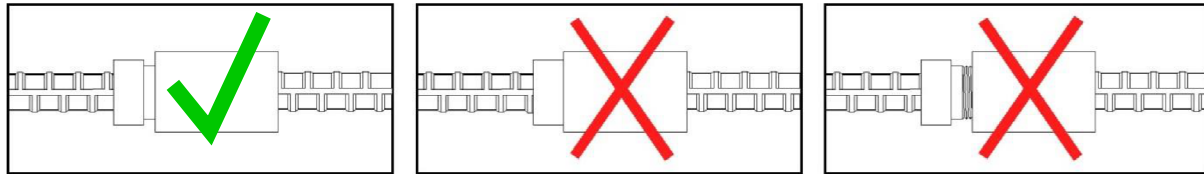


Figure 2 – 500/510 Visual Inspection



Lubricate threads with grease or WD 40 if necessary.

If the upset heads are not formed correctly, threads will be visible, or the coupler components will touch or bottom out before the bars are tightened.

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]	2.000	2.130	2.380	2.880	3.130	3.500	3.750	4.250	5.130
Tolerance (+/-) [in]	0.100	0.200	0.300	0.300	0.150	0.200	0.250	0.200	0.400

For SI: 1 inch = 25.4 mm, 1 sq.in. = 645 mm², 1 foot = 305mm

Hand-Tight will develop full thread tensile capacity, but pipe wrenches may be required to fully tighten and eliminate movement within the coupler.

CALIFORNIA PROP. 65 WARNING



WARNING
 CANCER AND REPRODUCTIVE HARM
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