

nVent LENTON Connect S2 and B12 Series

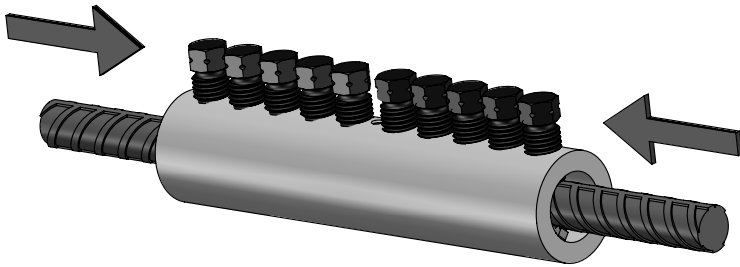


Figure 1 - Assembly

Step 1: Read all instructions and procedures before commencing splicing. Ensure the nVent LENTON Connect coupler is sized properly for the bars being spliced and per project plans.

Step 2: Ensure the rebar is free of any excessive dirt, concrete slurry, rust, etc. which may affect product performance. Ensure maximum rebar lip does not exceed limits set in Table 2. Excessive shear lip interferes with rebar installation.

Step 3: Insert rebar into nVent LENTON Connect coupler until contact is made with the center stop pin as shown in Figure 3. Rebar must be flush against center stop pin.

Step 4: Pre-torque each bolt to the corresponding value in Table 1. Start with the bolts in the middle, and work in sequence to the outside as shown in Figure 2. During installation ensure the rebar is in contact with both of the serrated rails. The serrated rails need to remain in the manufactured positions during installation. The serrated rails are held in place by a positional weld. Cracking of the positional weld during assembly is acceptable.

Step 5: Perform a secondary tightening in the same order until the bolt heads shear.

Repeat Steps 1 through 5 for other side of the coupler.

If a bolt head does not shear, the installer should verify that the appropriate torque was met (see Table 1). If a minimum cover must be maintained, the bolt head can be cut off after the proper torque has been applied.

If a bolt strips during installation, evidenced by a loss of resistance to the applied torque, stop the installation immediately. Remove the un-sheared, damaged bolt. Contact nVent for Technical Support.

See equipment specifications on Page 2.

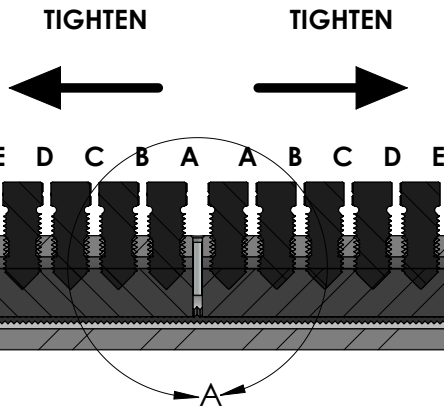


Figure 2 - Assembly Cross Section
Tightening Sequence A,B,C,D,etc.

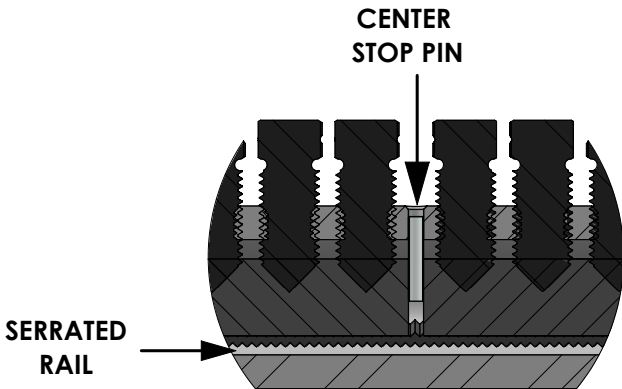


Figure 3 - Detail A
Solid contact between bar and stop pin as shown.

WARNING:

1. nVent products shall be installed and used only as indicated in nVent product instruction sheets and training materials. Instruction sheets are available at www.nVent.com and from your nVent customer service representative.
2. nVent products must never be used for a purpose other than the purpose for which they were designed or in a manner that exceeds specified load ratings.
3. All instructions must be completely followed to ensure proper and safe installation and performance.
4. Improper installation, misuse, misapplication or other failure to completely follow nVent's instructions and warnings may cause product malfunction, property damage, serious bodily injury and/or death, and void your warranty.

The customer is responsible for:

- a. Conformance to all governing codes.
- b. The integrity of structures to which the products are attached, including their capability of safely accepting the loads imposed, as evaluated by a qualified engineer.
- c. Using appropriate industry standard hardware as noted above.

SAFETY INSTRUCTIONS:

All governing codes and regulations and those required by the job site must be observed. Always use appropriate safety equipment such as eye protection, hard hat, and gloves as appropriate to the application.

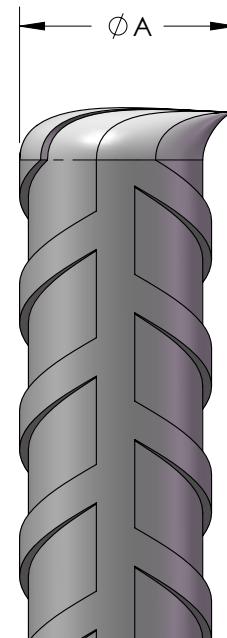
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Table 1. Bolt Torque Values

Rebar Designation			S2 Coupler	B12 Coupler	Socket Size		Average Pre-Torque		Average Torque to Shear Bolts	
In-lb	Metric	Canada			in	(mm)	ft-lb	(N-m)	ft-lb	(N-m)
#4/#5	12/16	10M/15M	LC16S2D	LC16B12D	1/2	(13)	55	(75)	85	(115)
#6	20	20m	LC20S2D	LC20B12D	1/2	(13)	55	(75)	85	(115)
#7	22	-	LC22S2D	LC22B12D	1/2	(13)	55	(75)	85	(115)
#8	25	25M	LC25S2D	LC25B12D	5/8	(16)	130	(185)	190	(260)
#9	28	30M	LC28S2D	LC28B12D	3/4	(19)	300	(400)	440	(600)
#10	32	-	LC32S2D	LC32B12D	3/4	(19)	300	(400)	440	(600)
#11	36	35M	LC36S2D	LC36B12D	3/4	(19)	300	(400)	440	(600)

Table 2 - Maximum Shear Lip

Rebar Size	Maximum Rebar Shear Lip Diameter (A)	
	in	mm
12 or 16 (#4,#5)	0.73	19
20 (#6)	0.89	23
22 (#7)	0.99	25
25 (#8)	1.16	29
28 (#9)	1.26	32
32 (#10)	1.46	37
36 (#11)	1.50	38



Equipment Specifications

To reach the specified torques in Table 1, a 1" square drive pneumatic impact wrench and air compressor are required for coupler sizes 25 and larger. The air compressor should have a minimum of 185CFM at an operating air pressure of 100 psi. This required air flow is to be delivered to the driver through a 3/4" to 1" air hose. An impact wrench must have a minimum torque capacity of 250 ft-lb for coupler sizes 16-22, 500 ft-lbs for coupler size 25, and 1000 ft-lbs for coupler sizes 28 and greater. Other tools such as electric impact wrenches, nut-runners or hand wrenches may be used as long as the appropriate torque is attained and validated.

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