Identification of the product

HPM Anchor Bolts are available in standard models (16, 20, 24, 30, and 39) analogous to the M-thread diameter of the bolt. The model of anchor bolt can be identified by the name in the label on the product and the color of the product.

Forming a bolt group

Bolts are collected into bolt groups using the PPL Installation Template. The installation template enables bolt groups to be centralized on the horizontal plane in exactly the right place and easily adjusted to the correct casting level.

HPM Anchor Bolt color identification.

<table>
<thead>
<tr>
<th>Anchor Bolt</th>
<th>Thread diameter [mm]</th>
<th>Color code</th>
<th>Installation Template</th>
</tr>
</thead>
<tbody>
<tr>
<td>HPM 16</td>
<td>16</td>
<td>Yellow</td>
<td>PPL 16</td>
</tr>
<tr>
<td>HPM 20</td>
<td>20</td>
<td>Blue</td>
<td>PPL 20</td>
</tr>
<tr>
<td>HPM 24</td>
<td>24</td>
<td>Gray</td>
<td>PPL 24</td>
</tr>
<tr>
<td>HPM 30</td>
<td>30</td>
<td>Green</td>
<td>PPL 30</td>
</tr>
<tr>
<td>HPM 39</td>
<td>39</td>
<td>Orange</td>
<td>PPL 39</td>
</tr>
</tbody>
</table>

The PPL Installation Template is a steel plate. Anchor Bolts are fixed through the holes on the template with nuts and washers. The PPL installation plate has alignment marks for accurate positioning of the anchor bolt group. Anchor bolts also have center marks on the top of each bolt for alternative positioning methods. To prevent displacement during the concreting process, the template should be fixed securely to the supporting base by its fixing recesses at the sides. Concrete can be poured easily through the hole in the middle of the template. After casting, the installation template is detached and can be reused.
Ordering PPL Installation Templates

When PPL Installation Templates are ordered the thread diameter of bolts, the number of bolts and the center-to-center dimensions must be specified.

Examples of installation plates:
1. **PPL39-4 360x360**: 4 pieces M39 bolts in square form.
2. **PPL39-4 500x400**: 4 pieces M39 bolts in rectangular form.
3. **PPL30-6 280x(190+190)**: 6 pieces M30 bolts rectangular form.
4. **PPL30-8 (190+190)x(190+190)**: 8 pieces M30 bolts in the form of a square.
5. **PPL30-3 300x300**: 3 pieces M30 bolts in the form of rectangular triangles.
6. **PPL24-8 D400**: 8 pieces M24 bolts in the form of circles with diameter of 400 mm.

PPL Installation Templates can also be manufactured according to drawings that present the location of the bolts and thread diameters.
Bolt installation and installation tolerances

The bolts are installed to the height level according to dimension $h_b$ given in table below. The height level is measured from the surface of concrete, and the level tolerance is ±20 mm. Each anchor bolt includes a marking of the anchorage depth.

Installation tolerances and the anchor bolt’s protrusion from the concrete.

<table>
<thead>
<tr>
<th>Anchor Bolt</th>
<th>HPM 16</th>
<th>HPM 20</th>
<th>HPM 24</th>
<th>HPM 30</th>
<th>HPM 39</th>
</tr>
</thead>
<tbody>
<tr>
<td>Thickness of grouting $t_{\text{grout}}$ [mm]</td>
<td>50</td>
<td>50</td>
<td>50</td>
<td>50</td>
<td>60</td>
</tr>
<tr>
<td>Protrusion of the bolt $h_b$ [mm]</td>
<td>105</td>
<td>115</td>
<td>130</td>
<td>150</td>
<td>180</td>
</tr>
<tr>
<td>Installation tolerance for the bolt [mm]</td>
<td>±3</td>
<td>±3</td>
<td>±3</td>
<td>±3</td>
<td>±3</td>
</tr>
</tbody>
</table>

Bending the bolts

HPM Anchor Bolts are made of B500B ribbed reinforcement steel. Bending must be done in accordance with EN 1992-1-1. See Annex E of this manual with application examples.

Welding the bolts

Welding of the bolts should be avoided, although all materials used in HPM Anchor Bolts are weldable (except the nuts). Requirements and instructions of standard EN 17660-1: Welding of reinforcing steel, Part 1: load bearing welding joints shall be taken into account when welding rebars.
**Existing buildings**

Where placing anchor bolts adjacent to walls or other obstructions, construction sequences should be considered. It is necessary to check that the erector will have enough access to tighten the nuts. If special setting is required, please contact Peikko Technical Support.

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**Erection of the attachment**

Before erecting the attachment, the upper nuts and washers are removed from the anchor bolts. The lower leveling nuts and washers are adjusted to the correct level. The attachment is erected directly on the pre-leveled washers and nuts. An alternative method is to place shims between anchor bolts and adjust them to the proper level. The lower leveling nuts must be leveled at least 5 mm under the top level of shims to ensure that the attachment will rest first on the shims.
Securing the connection

The upper nuts and washers are screwed onto the bolts and the attachment is aligned in the vertical position using leveling nuts. It is practical to use two theodolites from different directions to ensure verticality. The nuts are tightened at least to the minimum torque given in the table below. Adequate torque can be achieved typically by 10−15 impacts of a slogging ring wrench (DIN 7444) or open-ended slogging wrench (DIN 133) and a 1.5 kg sledgehammer.

Recommended minimum $T_{min}$ and maximum $T_{max}$ torque values of nuts.

<table>
<thead>
<tr>
<th>Anchor Bolt</th>
<th>$T_{min}$ [Nm]</th>
<th>$T_{max}$ [Nm]</th>
<th>Size of the slogging wrench</th>
</tr>
</thead>
<tbody>
<tr>
<td>HPM 16</td>
<td>120</td>
<td>170</td>
<td>24 mm</td>
</tr>
<tr>
<td>HPM 20</td>
<td>150</td>
<td>330</td>
<td>30 mm</td>
</tr>
<tr>
<td>HPM 24</td>
<td>200</td>
<td>570</td>
<td>36 mm</td>
</tr>
<tr>
<td>HPM 30</td>
<td>250</td>
<td>1150</td>
<td>46 mm</td>
</tr>
<tr>
<td>HPM 39</td>
<td>350</td>
<td>2640</td>
<td>60 mm</td>
</tr>
</tbody>
</table>

Grouting the joint

Before loading the attachment with any other structures the joint must be grouted following the grout supplier’s instructions. The grouting must be non-shrinking and have a strength according to the plans. To avoid air being trapped in the joint, it is recommended that grout be poured from one side only. Grouting formwork is made so that adequate concrete cover for anchor bolts is achieved.
Instructions for controlling bolt installation

**Before casting:**
- Ensure that the right PPL Installation Template is being used (axial distances, thread size)
- Verify the location of the bolt group
- Ensure that the reinforcement required by the bolts has been installed
- Ensure that the bolts are at the correct level
- Ensure that the installation plate and bolt group are not rotated
- Ensure that the bolt group is fixed in such a way that no movement can occur during casting

**After casting:**
- Ensure that the location of the bolt group is within the allowance for tolerance. Greater variations must be reported to the structural designer
- Protect the thread until the erection of the attachment (tape, plastic tube, etc.)

Instructions for controlling attachment installation

The joints must be made according to the installation plan drafted by the structural designer. If needed, Peikko’s technical support can provide advice.

**Check the following:**
- The installation order
- Supports and bracing during installation
- Instructions for tightening the nuts
- Instructions for joint casting