BarSplice PRODUCTS INC.
4900 Webster Street • Dayton, OH 45414 • Ph: (937) 275-8700

Prior to following the instructions below, verify that this document is the latest version in use. The latest version can be found at www.barsplice.com.

INSTALLATION INSTRUCTIONS FOR FIELD ASSEMBLY OF TAPER THREADED GRIP-TWIST® DoughNUT TDS / TDX

FABRICATOR IS RESPONSIBLE FOR PROVIDING THESE INSTRUCTIONS TO THE PLACER AND/OR CONTRACTOR.

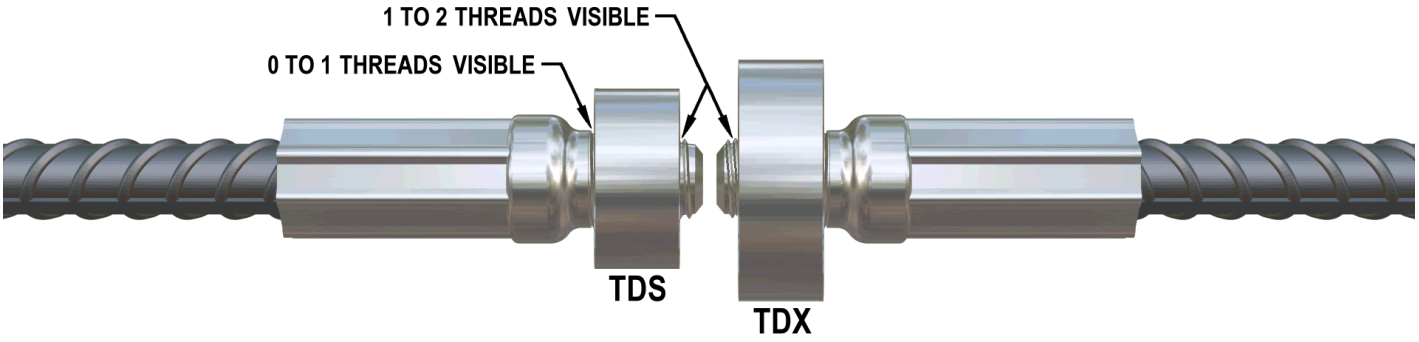
If the fabricator has pre-assembled the heads to the couplers, these instructions do not apply except for their inspection in step 4.

Taper Threaded Grip-Twist® Male couplers are shipped with color-coded plastic caps to protect the threads. These should be kept in place until time of assembly. If missing, obtain the correct caps from the manufacturer. If thread damage is discovered, it must be corrected before assembly to avoid premature binding. Minor thread damage can be fixed using a thread file, or a thread cleaning tool. DO NOT TRY TO ASSEMBLE DAMAGED THREADS. All DoughNUT headed devices and Male couplers are marked with the intended rebar size. Take care to install the correct size head on the corresponding size Male coupler. DO NOT USE WITH REBAR THAT IS LARGER OR SMALLER THAN THE INTENDED BAR SIZE. STORE DOUGHNUT HEADED DEVICES AND MALE COUPLERS IN A CLEAN, DRY PLACE UNTIL READY TO INSTALL.

1) Remove the protective cap from the TTGT Male coupler and check both external (Male) and internal (DoughNUT) threads for cleanliness. Clean off any debris and/or foreign matter. **DO NOT USE CORROSIVE ACIDS**. Any thread damage must be corrected as noted above prior to installation.

2) Locate the DoughNUT headed device over the Male coupler thread and rotate clockwise by hand. If you feel the threads starting to prematurely bind, **DO NOT FORCE THEM**. Continue to rotate (approximately 4 – 5 rotations) until FULLY ENGAGED and SNUG on the Male coupler. See **FIGURE 1** for assembled connection.

FIGURE 1: ASSEMBLED CONNECTION



NOTE: If the DoughNUT threads do not properly engage the Male coupler threads during assembly, stop immediately. Disassemble the connection to determine the problem. Possible causes of mis-assembly may be mis-matched thread sizes, contaminated threads (i.e. concrete, dirt, etc.) or damaged threads. Re-assemble only after the problem has been identified and corrected.

3) A chain wrench or pipe wrench can be used to snug and tighten the DoughNUT headed device onto the Male coupler as needed. Always consider your own **personal safety**. Make sure you are securely positioned and that you will not slip or fall during installation. Use only good quality wrenches that will not round-out.

4) After assembly, inspect for complete swaging of the Male coupler and proper thread engagement of the DoughNUT. For taper threads, some variation in the number of exposed threads is natural due to the thread tolerance and run-out. In general, it is typical to see 0 to 1 complete thread(s) on the bearing face side after full assembly, per **FIGURE 1**. If needed, fully assembled taper threads can be double-checked using a chain wrench or pipe wrench as described above, to ensure the head is snug. **IT IS NOT NECESSARY TO USE A TORQUE WRENCH OR APPLY A HIGH TORQUE VALUE.**

Please direct all assembly questions to BarSplice Products, Inc.