

Adhesive Anchoring Installation Instructions

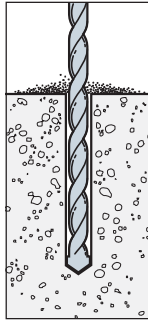


NOTE: Always check expiration date on product label. Do not use expired product.

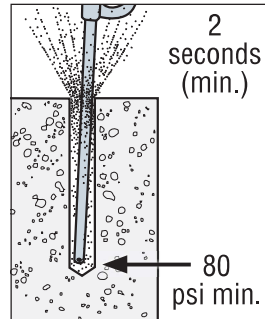


WARNING: When drilling and cleaning hole, use eye and lung protection. When installing adhesive, use eye and skin protection.

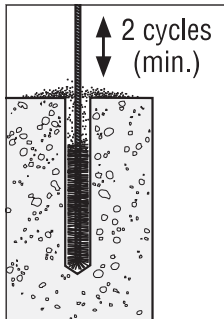
1A Hole Preparation — Horizontal, Vertical and Overhead Applications (SET-3G™ for anchor installation)

**1. Drill.**

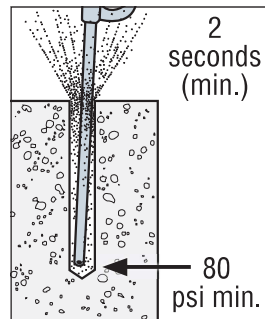
Drill hole to specified diameter and depth.

**2. Blow.**

Remove dust from hole with oil-free compressed air for a minimum of two seconds. Compressed air nozzle must reach the bottom of the hole.

**3. Brush.**

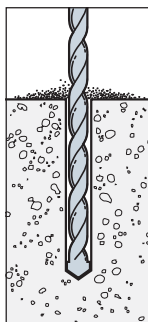
Clean with a steel wire brush for a minimum of two cycles. Brush should provide resistance to insertion. If no resistance is felt, the brush is worn and must be replaced.

**4. Blow.**

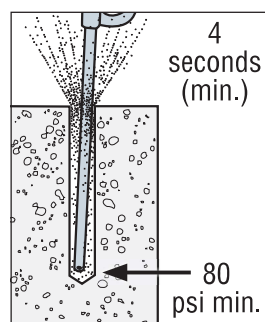
Remove dust from hole with oil-free compressed air for a minimum of two seconds. Compressed air nozzle must reach the bottom of the hole.

Visit strongtie.com for proper brush part number.

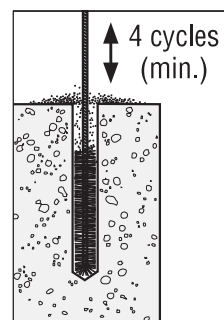
Hole Preparation — Horizontal, Vertical and Overhead Applications (SET-XP®, AT-XP®, ET-HP®) and (SET-3G only for post-installed rebar connections)

**1. Drill.**

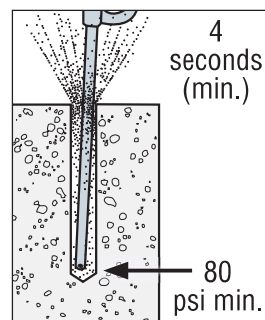
Drill hole to specified diameter and depth.

**2. Blow.**

Remove dust from hole with oil-free compressed air for a minimum of four seconds. Compressed air nozzle must reach the bottom of the hole.

**3. Brush.**

Clean with a nylon brush for a minimum of four cycles. Brush should provide resistance to insertion. If no resistance is felt, the brush is worn and must be replaced.

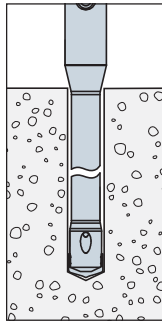
**4. Blow.**

Remove dust from hole with oil-free compressed air for a minimum of four seconds. Compressed air nozzle must reach the bottom of the hole.

Visit strongtie.com for proper brush part number.

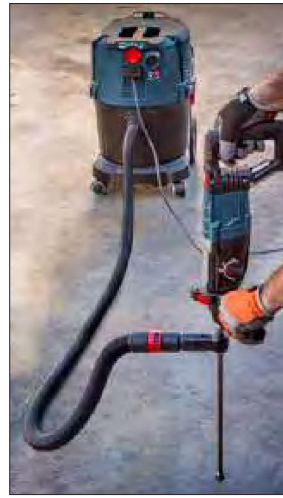
Adhesive Anchoring Installation Instructions

1B Hole Preparation Vacuum Drill Bit System* — Horizontal, Vertical and Overhead Applications



1. Drill.

Drill hole to specified diameter and depth using the accepted vacuum drill bit system.*

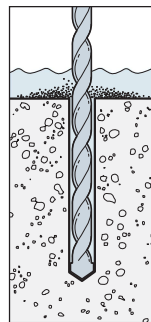


Approved for installation with multiple vacuum drill bit systems.*

*Note: Visit strongtie.com for tested and accepted hollow carbide drill bit and vacuum dust extraction systems.

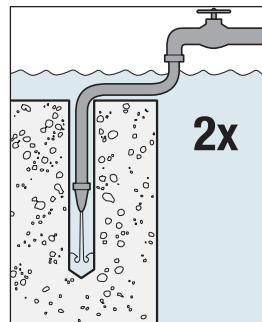
Adhesive Anchors

1C Hole Preparation — Submerged Applications (SET-3G™ only)



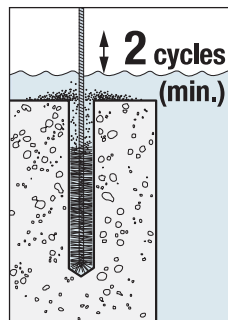
1. Drill.

Drill hole to specified diameter and depth.



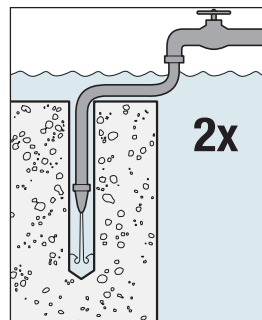
2. Flush.

Remove slurry from hole by flushing hole twice with water until water runs clear.



3. Brush.

Clean with a steel wire brush for a minimum of two cycles. Brush should provide resistance to insertion. If no resistance is felt, the brush is worn and must be replaced.



4. Flush.

Remove slurry from hole by flushing hole twice with water until water runs clear.

Visit strongtie.com for proper brush part number.

Adhesive Anchoring Installation Instructions

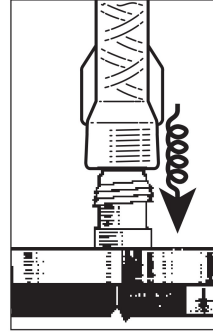
2 Cartridge Preparation

1. Check.

Check expiration date on product label. Product is usable until end of printed expiration month. **Do not use expired product.**

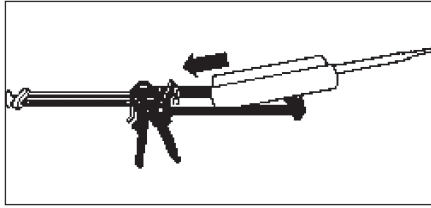
2. Open.

Open cartridge per package instructions.



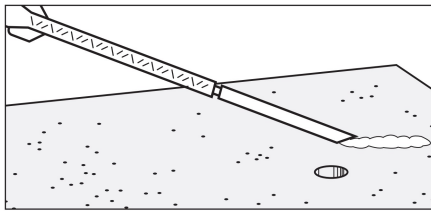
3. Attach.

Attach proper Simpson Strong-Tie® nozzle and extension to cartridge. Do not modify nozzle.



4. Insert.

Insert cartridge into dispensing tool.



5. Dispense.

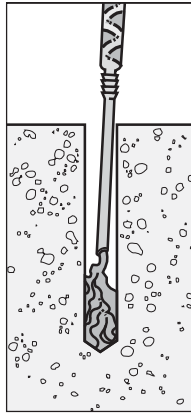
Dispense adhesive to the side until properly mixed (uniform color).

Adhesive Anchoring Installation Instructions

3A Filling the Hole — Vertical Anchorage

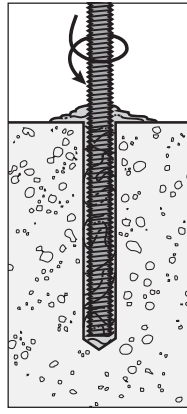
Prepare the hole per “Hole Preparation” instructions on product label.

Dry and Damp Holes:



1. Fill.

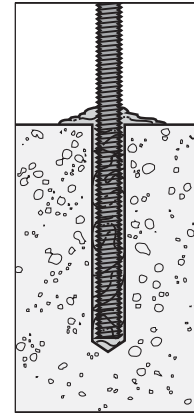
Fill hole $\frac{1}{2}$ to $\frac{2}{3}$ full, starting from bottom of hole to prevent air pockets. Withdraw nozzle as hole fills up.



2. Insert.

Insert clean, oil-free anchor, (marked with the required embedment depth), turning slowly until the anchor contacts the bottom of the hole.

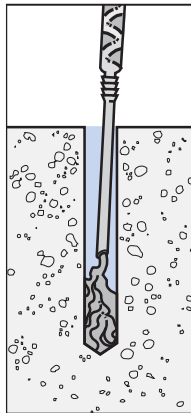
Threaded rod or rebar



3. Do not disturb.

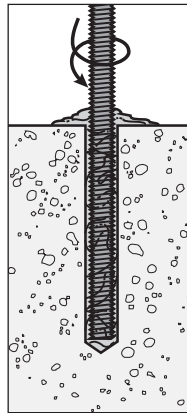
Do not disturb load or torque anchor until fully cured.

Water-Filled Holes:



1. Fill.

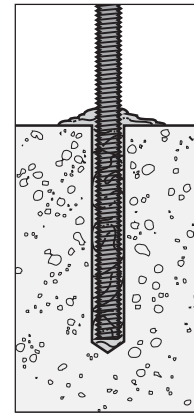
Fill hole completely full, starting from bottom of hole to prevent water pockets. Withdraw nozzle as hole fills up.



2. Insert.

Insert clean, oil-free anchor, (marked with the required embedment depth), turning slowly until the anchor contacts the bottom of the hole.

Threaded rod or rebar



3. Do not disturb.

Do not disturb load or torque anchor until fully cured.

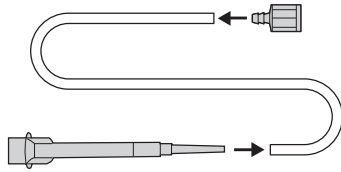
Note: Nozzle extensions may be needed for deep holes.

Adhesive Anchoring Installation Instructions

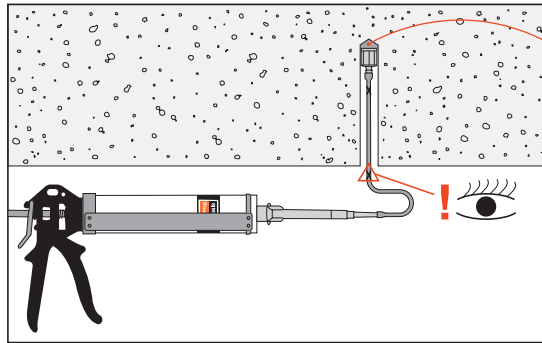
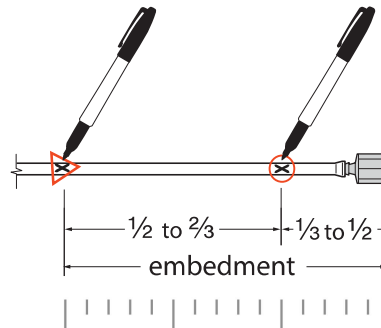
Adhesive Anchors

3B Filling the Hole — Horizontal and Overhead Anchorage

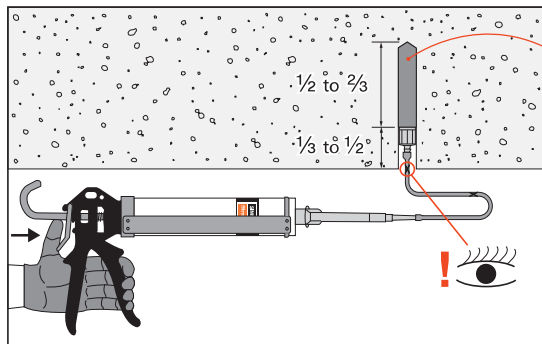
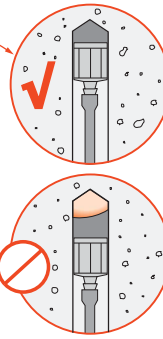
Prepare the hole per “Hole Preparation” instructions on product label.

**Step 1**

- Attach the piston plug to one end of the flexible tubing (PPFT25).
- Cut tubing to the length needed for the application, mark tubing as noted below and attach other end of tubing to the mixing nozzle.
- If using a pneumatic dispensing tool, regulate air pressure to 80–100 psi.

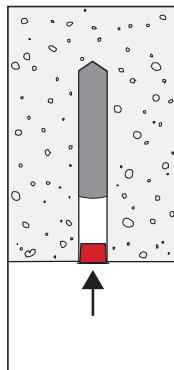
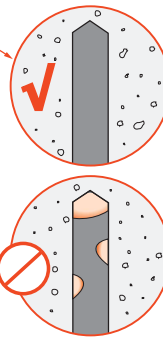
**Step 2**

- Insert the piston plug to the back of the drilled hole and dispense adhesive.

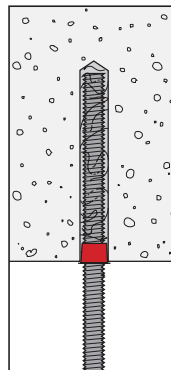
**Step 3**

- Fill the hole $\frac{1}{2}$ to $\frac{2}{3}$ full.

Note: As adhesive is dispensed into the drilled hole, the piston plug will slowly displace out of the hole due to back pressure, preventing air gaps.

**Step 4**

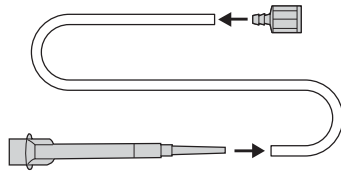
- Install the appropriate Simpson Strong-Tie® adhesive retaining cap.

**Step 5**

- Place either threaded rod or rebar through the adhesive retaining cap and into adhesive filled hole.
- Turn rod/rebar (marked with the required embedment depth) slowly until the insert bottoms out.
- Do not disturb load or torque anchor until fully cured. For overhead installations, the anchor must be secured from movement during the cure time (e.g., wedges or other restraint methods).

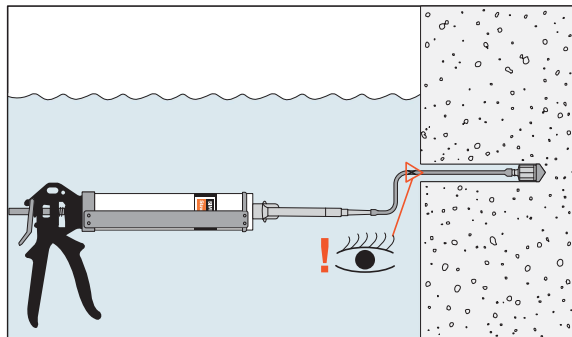
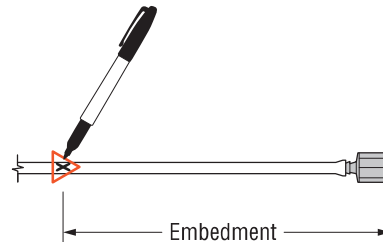
Adhesive Anchoring Installation Instructions

- 3C Filling the Hole** — Submerged Anchorage (SET-3G™ only)
Prepare the hole per “Hole Preparation” instructions on product label.



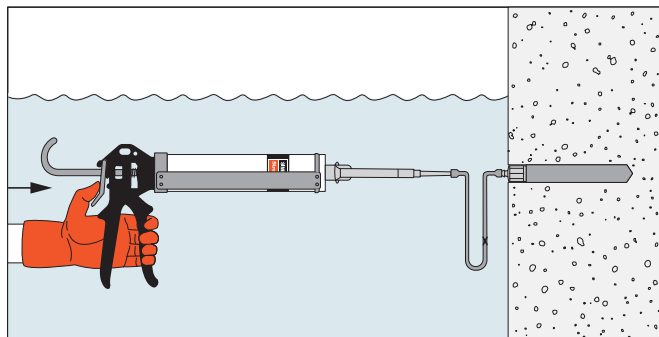
Step 1

- Attach the piston plug to one end of the flexible tubing (PPFT25).
- Cut tubing to the length needed for the application, mark tubing as noted below and attach other end of tubing to the mixing nozzle.
- If using a pneumatic dispensing tool, regulate air pressure to 80–100 psi.



Step 2

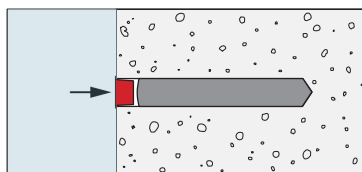
- Insert the piston plug to the back of the drilled hole and dispense adhesive.



Step 3

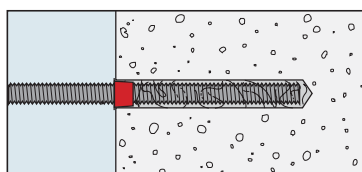
- Fill the hole completely full.

Note: As adhesive is dispensed into the drilled hole, the piston plug will slowly displace out of the hole due to back pressure, preventing air gaps.



Step 4

- Install the appropriate Simpson Strong-Tie adhesive retaining cap.



Step 5

- Place either threaded rod or rebar through the adhesive retaining cap and into adhesive filled hole.
- Turn rod/rebar (marked with the required embedment depth) slowly until the insert bottoms out.
- Do not disturb load or torque anchor until fully cured.

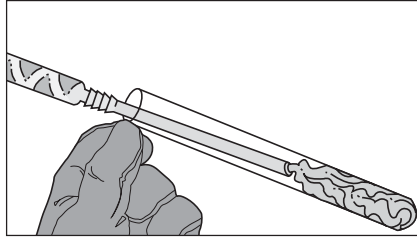
Adhesive Anchoring Installation Instructions

Adhesive Anchors

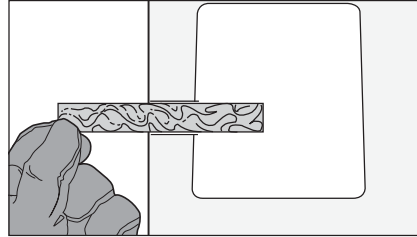
FOR HOLLOW BASE MATERIALS

3D Filling the Hole —

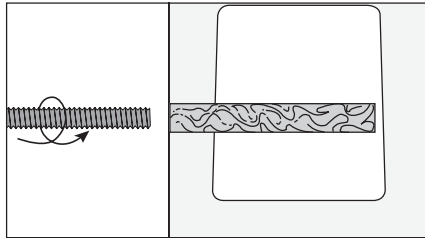
When Anchoring with Screens: For SET-3G™, SET-XP® and AT-XP® Adhesives
Prepare the hole per instructions on “Hole Preparation.”

**1. Fill.**

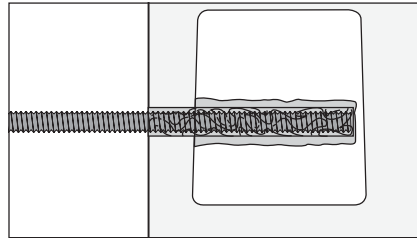
Fill screen completely. Fill from the bottom of the screen and withdraw the nozzle as the screen fills to prevent air pockets. (Close integral cap after filling.)

**2. Insert.**

Insert adhesive-filled screen into hole.

**3. Insert.**

Insert clean, oil-free anchor, turning slowly until the anchor contacts the bottom of the screen.

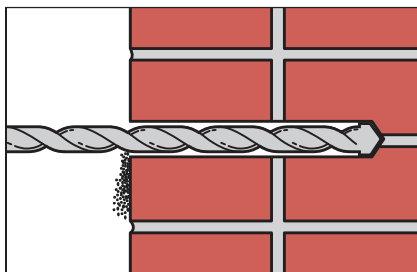
**4. Do not disturb.**

Do not disturb anchor until fully cured.
(See cure schedule for specific adhesive.)

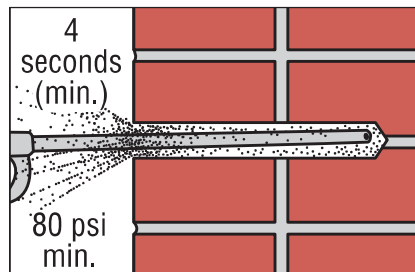
FOR UNREINFORCED BRICK MASONRY

1A Hole Preparation —

For Configurations A (Horizontal) and B (22½° Downward)
Installations with a Carbide-Tipped Drill Bit.

**1. Drill.**

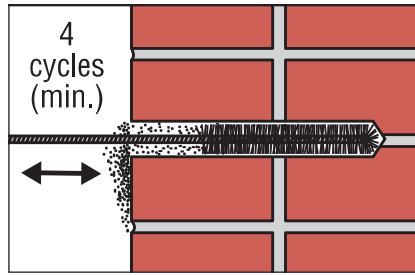
Drill 1"-diameter hole to specified depth with a carbide-tipped drill bit, using rotation only mode. For Configurations A, drill 8" deep. For Configuration B, drill to within 1" of the opposite side of wall (minimum 13" deep).

**2. Blow.**

Remove dust from hole with oil-free compressed air for a minimum of four seconds. Compressed air nozzle **MUST** reach the bottom of the hole.

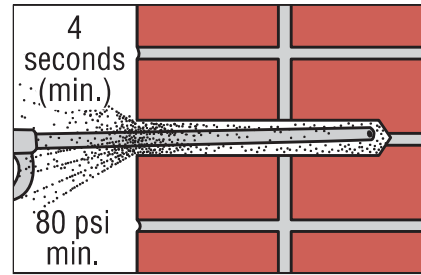
Adhesive Anchoring Installation Instructions

FOR UNREINFORCED BRICK MASONRY (cont.)



3. Brush.

Clean with a nylon brush for a minimum of four cycles. Brush **MUST** reach the bottom of the hole. Brush should provide resistance to insertion. If no resistance is felt, the brush is worn and must be replaced.



4. Blow.

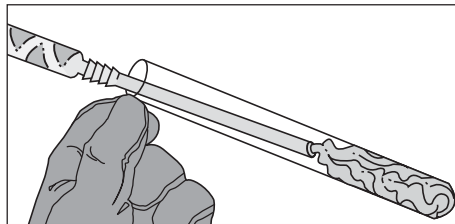
Remove dust from hole with oil-free compressed air for a minimum of four seconds. Compressed air nozzle **MUST** reach the bottom of the hole.

2 Cartridge Preparation

Reference p. 44 for cartridge preparation.

3 Filling the Hole —

For Configurations A (Horizontal) and B (22½° Downward) Installations.



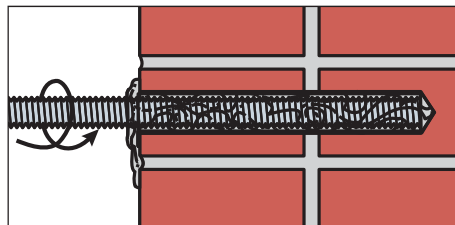
1. Fill.

Fill screen completely. Fill from the bottom of the screen and withdraw the nozzle as the screen fills to prevent air pockets.



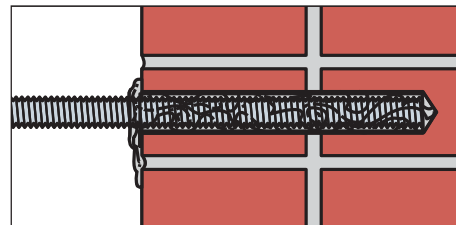
2. Insert.

Insert adhesive filled screen into hole.



3. Insert.

Insert clean, oil-free anchor, turning slowly until the anchor contacts the bottom of the screen.



4. Do not disturb.

Do not disturb anchor until fully cured. (See cure schedule for specific adhesive.)

Note: Steel wire mesh screens may be used for Configurations A and B.