

# CARES Technical Approval Report TA1-B 5100



Issue 1



## **HY-TEN** **HT.S Standard Coupler**

Assessment of the  
HY-TEN HT.S Standard  
Coupler Product  
and Quality System  
for Production



TECHNICAL  
APPROVAL  
5100



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# Product

## **HY-TEN HT.S Standard Coupler for reinforcing steel**

### **Product approval held by:**

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## 1 Product Summary

HY-TEN HT.S Standard Couplers in the size range 16mm - 25mm are for the mechanical connection of deformed high yield carbon steel bars for the reinforcement of concrete complying with the requirements of BS4449 Grade B500B.

### 1.1 Scope of Application

HY-TEN Standard HT.S Standard Couplers in the size range 16mm - 25mm have been evaluated for use as follows:

For static BS 8110 and EC2 applications in tension and compression using BS4449 grade B500B in accordance with CARES Appendix TA1-B

### 1.2 Design Considerations

BS 8110 Clause 3.12.8.9 Laps and Joints states "Connections transferring stress may be lapped, welded or joined with mechanical devices. They should be placed, if possible, away from points of high stress and should preferably be staggered". However, BS 8110 Clause 3.12.8.16.2 Bars in tension states "The only acceptable form of full-strength butt joint for a bar in tension comprises a mechanical coupler" satisfying specified slip and tensile strength criteria.



Eurocode 2, Clause 8.7 Laps and mechanical couplers 8.7.1 General (1)P “Forces are transmitted from one bar to another by:

- lapping of bars, with or without bends or hooks;
- welding;
- mechanical devices assuring load transfer in tension-compression or in compression only.”

Clause 8.8 Additional rules for large diameter bars goes on to state that “Splitting forces are higher and dowel action is greater with the use of large diameter bars. Such bars should be anchored with mechanical devices.”

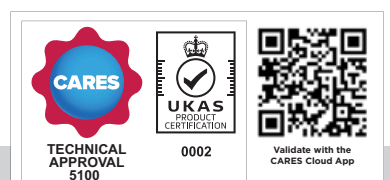
The specified cover for fire resistance and durability should be provided to the coupler sleeve. The couplers as detailed in table 1 have been designed with controlled mechanical properties to be compatible with reinforcing bars complying with reinforcement of the relevant Grade in accordance with BS4449 Grade B500B as detailed in the scope of application section 1.1.

### 1.3 Conclusion

It is the opinion of CARES that HY-TEN HT.S Standard Couplers in the size range 16mm - 25mm are satisfactory for use within the limits stated in paragraph 1.1 when applied and used in accordance with the manufacturer's instructions and the requirements of this certificate.

*Lee Brankley*

L. Brankley  
Chief Executive Officer  
September 2025



## 2 Technical Specification

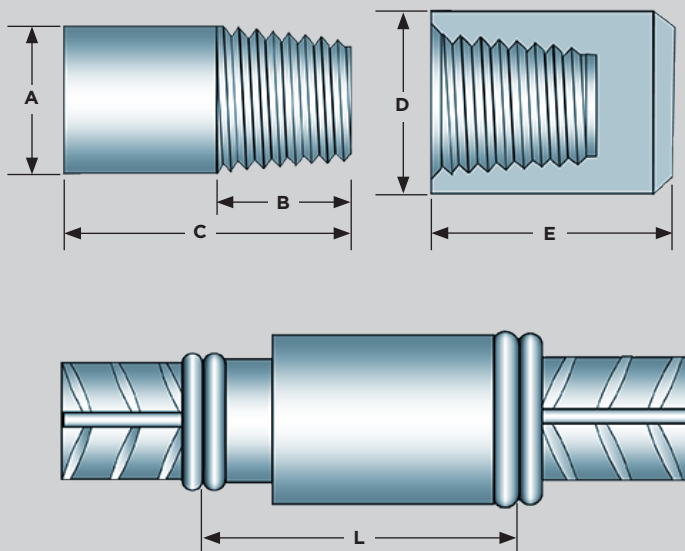
### 2.1 General

The function of HY-TEN HT.S Standard Couplers is to connect deformed steel reinforcing bars complying with BS4449 Grade B500B and thereby create structural continuity of the reinforcing system.

### 2.2 HY-TEN HT.S Standard Coupler

The HY-TEN HT.S Standard Coupler is a system providing a mechanical connection of deformed Grade B500B high yield carbon steel bars for the reinforcement of concrete, complying with the tensile properties of BS4449.

#### HY-TEN HT.S Standard Coupler



Coupler Ref	Bar Dia mm	A mm	B mm	C mm	D mm	E mm	L mm	Tension / Slip B500B	Compression / Slip B500B
HT.S20	16	19	20	43	25	40	60 ± 3	✓	✓
HT.S20	20	19	20	43	25	40	60 ± 3	✓	✓
HT.S25	25	25	25	55	34	50	70 ± 4	✓	✓

Table 1

### 3 Product Performance and Characteristics

#### 3.1 Material Properties

Full destructive tests have been carried out to demonstrate compliance with the performance requirements defined in CARES Appendix TA1-B when used with reinforcing bars to BS4449 Grade B500B for HY-TEN HT.S Standard Couplers.

##### CARES APPENDIX TA1-B strength requirements

- Permanent deformation is less than 0.10mm after loading to  $0.65 Re_{(char)}$  in tension with BS4449 grades B500B reinforcement.
- 99% characteristic tensile strength is greater than 540 MPa with grade B500B reinforcement.



## 4 Installation

The HT.S Coupler is always delivered to site connected to the appropriate re-bar. The formation of the joint is achieved by screwing the two sections together, i.e. male and female elements.

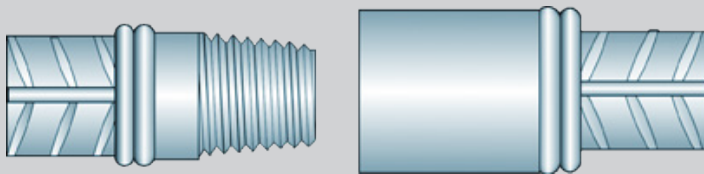
The joint should always be tightened by the use of a wrench, until there is no further movement available between the two sections.



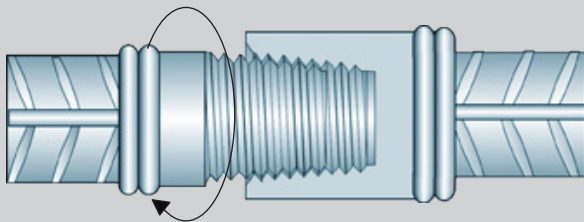
HT.50 Coupler Machine

### 4.1 HT.S Standard Coupler

#### HT.S installation instructions



**1 The two sections of the joint are brought together**



**2 The joint is then screwed together using a wrench**



**3 A wrench length of 900mm is recommended for tightening to ensure the necessary torque is applied, ensuring a tight joint**

## 5 Safety Considerations

The friction welding of the couplers is done at the Hy-Ten factory in Wallingford. The couplers are delivered to the factory, packaged in 20kg boxes. A full risk assessment has been undertaken by HY-TEN for this manufacturing process.

On site, the usual safety precautions should be followed when handling re-bar and the use of gloves and other relevant PPE is always advised.

## 6 Product Testing and Evaluation

HY-TEN HT.S Standard Couplers have been tested to satisfy the requirements of CARES Appendix TA1-B for Couplers with reinforcing bars to BS4449 Grade B500B. The testing comprised the following elements:

- Tensile Strength
- Permanent Deformation
- Compression testing

The products are subject to a programme of periodic testing to ensure that they remain within the performance limits of this technical approval.

## 7 Quality Assurance

HY-TEN HT.S Standard Couplers are produced under an ISO9001 quality management system certified by CARES. The quality management system scheme monitors the production of the couplers and ensures that materials and geometry remain within the limits of this technical approval.



## 8 Building Regulations

### 8.1 The Building Regulations (England and Wales)

#### Structure, Approved Document A

HY-TEN HT.S Standard Couplers, when used in EC2 based designs using the data contained within this technical approval, satisfy the relevant requirements of The Building Regulations (England and Wales), Approved Document A.

#### Materials and Workmanship, Approved Document

This technical approval gives assurance that the HY-TEN HT.S Standard Couplers comply with the material requirements of EC2.

### 8.2 The Building Regulations (Northern Ireland)

#### Materials and Workmanship

This technical approval gives assurance that HY-TEN HT.S Standard Couplers comply with the material requirements of EC2 by virtue of regulation 23, *Deemed to satisfy provisions regarding the fitness of materials and workmanship*.

### 8.3 The Building Standards (Scotland)

#### Fitness of Materials

This technical approval gives assurance that HY-TEN HT.S Standard Couplers comply with the material requirements of EC2 by virtue of *Clause 0.8*.

#### Structure

HY-TEN HT.S Standard Couplers, when used in EC2 based designs using the data contained within this technical approval, satisfy the requirements of *The Building Standards (Scotland) clause 1*.



## 9 References

- BS 4449: 2005: Steel for the reinforcement of concrete - Weldable reinforcing steel - Bar, coil and decoiled product - Specification.
- BS 8110: Part 1: 1997 (Revised 2005): Structural Use of Concrete, Code of Practice for Design and Construction.
- BS EN ISO 9001: Quality management systems - Requirements.
- CARES Appendix TA1-B; Quality and Operations Schedule for the Technical Approval of Couplers for Reinforcing Steel For BS 8110 Applications for Static Tension or Static Compression.
- BS EN 1992-1-1:2004 Eurocode 2 Design of concrete structures - General rules for buildings.



## 10 Conditions

1. The quality of the materials and method of manufacture have been examined by CARES and found to be satisfactory. This Technical Approval will remain valid provided that:
  - a) The product design and specification are unchanged.
  - b) The materials, method of manufacture and location are unchanged.
  - c) The manufacturer complies with CARES regulations for Technical Approvals.
  - d) The manufacturer holds a valid CARES Certificate of Product Assessment.
  - e) The product is installed and used as described in this report.
2. CARES make no representation as to the presence or absence of patent rights subsisting in the product and/or the legal right of HY-TEN to market the product.
3. Any references to standards, codes or legislation are those which are in force at the date of this certificate.
4. Any recommendations relating to the safe use of this product are the minimum standards required when the product is used. These requirements do not purport to satisfy the requirements of the Health and Safety at Work etc Act 1974 or any other relevant safety legislation.
5. CARES does not accept any responsibility for any loss or injury arising as a direct or indirect result of the use of this product.
6. This Technical Approval Report should be read in conjunction with CARES Certificate of Product Assessment No 5100. Confirmation that this technical approval is current can be obtained from CARES.



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