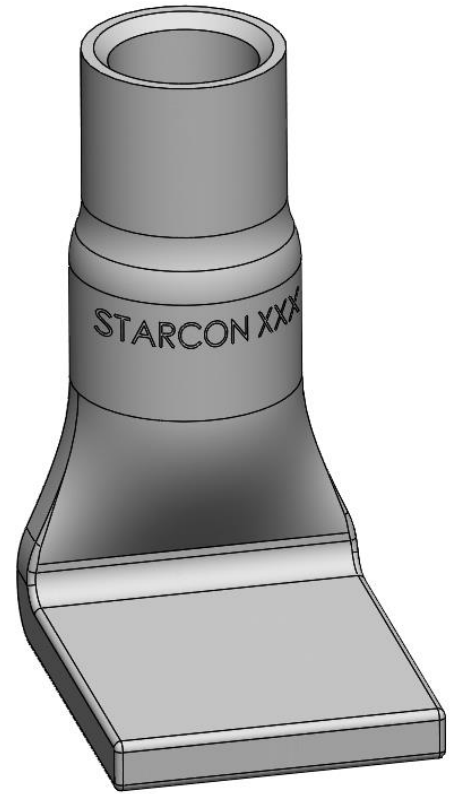
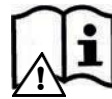


STARCON



STARCON



Fixing Socket bent End M8 to M16

Fixing insert systems for concrete elements.

User and design manual

1 Nomenclature

Symbol	Description	Unit
$^{\circ}C$	Temperature Celsius	$^{\circ}C$
B	Minimum plate thickness of a tile/slap/deck	mm
COG	Center of gravity	$[-]$
D	Diameter of the Insert for fastening	mm
N	Axial load	N
V	Shear load	N
L	Length of the Insert for fastening	mm
h	Height of the angled bend	mm
C_1, C_2, C_3, C_4	Edge distances	mm
S	Load group symbol (STARCON)	—
S_z	Distance between Transport anchors	mm

Table 1 Nomenclature

Starcon Precast Concrete Design & Fixing insert Manual

1	Nomenclature	1
2	Identification.....	2
3	Introduction Starcon Fixing Socket bent End M8 to M16.....	3
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2 Identification

Table 2 provides insight into the revision number of this document. It facilitates tracking changes and ensuring version control for accurate referencing and updates.

Version	Responsible	Creator	Date	Comment
A	CERTEX Denmark	JLJ	18-02-2025	New documentation

Table 2 Revision table

3 Introduction Starcon Fixing Socket bent End M8 to M16

Read this instruction manual before using the spherical anchor. Incorrect use can cause injury or danger!

Safety is paramount when using lifting devices and equipment.

Only trained individuals should operate them as per national law.

Familiarize yourself with the instruction manual before using the Starcon lifting system to ensure safe operation.

Adhering to these guidelines reduces the risk of accidents.

Consult relevant national regulations as they may supersede these instructions.

All individuals involved with the equipment must read and understand this manual.

Always keep the manual with the product. Contact information is provided on the last page.

Contact Certex for assistance or clarification.



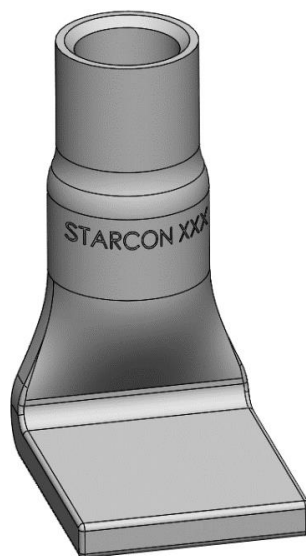
General concept of the use Insert for fastening with angle:

The Starcon Fixing insert system consists of two key components: Starcon Insert for fastening with angle and Starcon Connection holding plate shown on Figure 1.

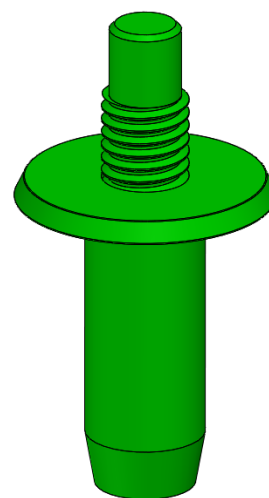
To ensure proper placement of the fixing socket unit in the finished concrete product, the head of the Starcon insert for fastening with angle is assembled into a corresponding Starcon connection holding plate before pouring. Once the concrete reaches a strength of at least 15 MPa, connection holding plate can be removed. At the installation site, connecting and securing precast concrete components may only commence when the concrete has reached a strength of at least 25 MPa. Contact CERTEX Danmark for lower strength values.

The Starcon fixing socket and systems use the guidelines EN 1090 and CEN/TS 1992-4:2009. This ensures the highest level of safety when using our products.

Material:	Steel.
Surface treatment:	Electro galvanized (Corrosion class: C3, ISO 12944). Stainless steel AISI316 (Corrosion class: C5, ISO 12944).



Starcon Fixing Socket bent End



Connection holding plate

Figure 1 Starcon Fixing system.

4 Safety instructions before use



- Starcon Insert for fastening must only be installed on a Starcon connection holding plate of the same rating.
- Starcon Insert for fastening with angle that are exposed to corrosion, or damaged must not be used.
- Starcon Insert for fastening with angle is not to be used for lifting or transporting precast concrete units.
- The Starcon fixing and handling system must not be used to fix more than the specified load.
- The Starcon fixing system must only be used by skilled, trained employees.
- The concrete safety factor assumes a factory production control complying with EN13369. If these requirements are not fulfilled, a safety factor of $\gamma = 2,5$ shall be used.
- All relevant concrete failure modes shall be verified by the pre casting manufacturer of the concrete elements; the different failure modes and verification methods are specified in EN13155 (Annex H).

5 Advantages of the Starcon system.

The Starcon system offers Starcon insert for fastening with angle. The system comprises fixing sockets pre-set in the concrete, along with other connecting elements and accessories.

The Starcon system is available in groups M8 to M16. It is typically embedded in the concrete element during the prefabrication stage. When connection is needed, we will screw or bolt into the fixing socket. The applied force is transmitted evenly into the concrete through the fixing socket.

5.1 Note

The information in this manual is for guidance only, and the use of the manual does not in any way exempt the manufacturer from ensuring that the chosen fixing system is suitable for the intended purpose. The information and data listed in this manual only refer to original Starcon products supplied by *CERTEX DANMARK A/S*.

6 Using the Starcon system

The Starcon system comprises a wide range of anchors in a group from M8 to M16 per fixing socket with various lengths. The principle for using the system is the same for the entire range. The Starcon system consists of the following two main components:

6.1 Starcon Insert for fastening with angle

The Starcon Insert for fastening with angle is a steel embedded member with a specially designed foot for secure anchoring in hardened concrete. The Starcon Insert for fastening with angle is a cylindrical, internally threaded unit, connects to other components using screws or bolts. Starcon inserts for fastening with angle are clearly labelled with dimensions (e.g. 0.5S) and are available in a variety of lengths. They undergo specimen testing for defects and dimensional deviation.

6.2 Starcon Connection holding plate

The connection holding plate, typically made of cylindrical plastic components with a threaded end, must be carefully attached to the anchor head and positioned correctly before being securely fastened to the formwork. After the concrete cures and hardens, the connection holding plate is removed, exposing the anchor head seated in a trapezoidal depression. Since the connection holding plate is typically stripped and unscrewed during removal, it's not normally reusable.

7 Safety factors for fixing insert systems

For the calculations of the fixing system, the following safety factors shown Table 3 have been applied to ensure its reliability and safety.

Failure safety factors	
Concrete pull out failure	$SF_{concrete} = 2,5$

Table 3 Failure safety factors

8 General information

This section provides essential details on the Starcon insert for fastening with angle systems, offering clarity and guidance for safe and efficient usage.

8.1 Marking on the Insert for fastening with angle

Each insert for fastening with angle is clearly labeled with its load capacity, thread size, and manufacturer's identification, ensuring easy and secure identification of the systems, even post-installation show on Figure 2.



Figure 2 Marking on the cylinder of the insert for fastening.

8.2 Guidelines for the Insert for fastening with angle selection

When selecting insert for fastening with angle, it's essential to consider various factors to ensure safety and effectiveness. The tables provided contain crucial information such as maximum load capacities, edge distances, and installation values for different inserts for fastening with angle types.

Key points to consider:

- The number of inserts for fastening.
- How the insert for fastening is arranged.
- The load-bearing capacity of the insert for fastening with angle.
- Compressive strength of concrete.
- Concrete quality.
- Environmental impact on the use.
- Dynamic factor.

8.3 Guidelines for installation

For the Starcon insert for fastening with angle systems to be appropriately installed, it is imperative to ensure compliance with specific technical criteria and prerequisites:

- Adherence to load capacity specifications of the anchor.
- Maintaining appropriate edge spacing.
- Ensuring the concrete grade is suitable.
- Verifying alignment with the load direction.
- Additional reinforcement requirements.

8.4 Guideline for load capacity

Load capacity of a fixing socket relies on several factors:

- The length of the insert for fastening with angle.
- The spacing between the insert for fastening and the edges, both axially and along the edge.
- The direction of the applied load.
- The arrangement of reinforcement within the concrete structure.

9 Design method

This section provides essential information for the correct and safe selection and use of the insert for fastening with angle. To ensure the construction's durability and safety, it is crucial to carefully follow the manufacturer's technical specifications and guidelines during design and construction. Additionally, the casting process is discussed, including the transfer of load to the concrete using the angle bend, and the importance of correctly placing formwork and anchors during casting to avoid errors and risks. Warnings are given regarding the correct size of formwork and the risk of errors with incorrect sizes, which can lead to potentially dangerous situations.

9.1 Load Transfer with Anchor Casting

Load transfer to the concrete is made easier by the socket foot, which means it can handle heavy loads even with short socket shown on Figure 3. However, with very thin elements, these concentrated loads can cause lateral spalling because of the strong pulling forces. The concrete must withstand a minimum resistance of 2.5 units before experiencing structural failure.

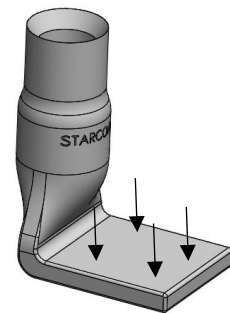


Figure 3 Load transfer.

9.1.1 Correct placement of connection holding plate and insert for fastening during casting.

Caution: If the connection holding plate is too small, it won't be compatible with the fixing equipment later. Conversely, if the recess block is too large, attaching the fixing equipment correctly will be impossible, increasing the risk of the fixing equipment slipping out. This could lead to premature fixing insert failure and the subsequent collapse of the construction element. Always ensure the connection holding plate size matches the identified appropriate size. Figure 4 illustrates the correct placement of the connection holding plate in wet concrete to ensure optimal anchorage strength for the insert for fastening.

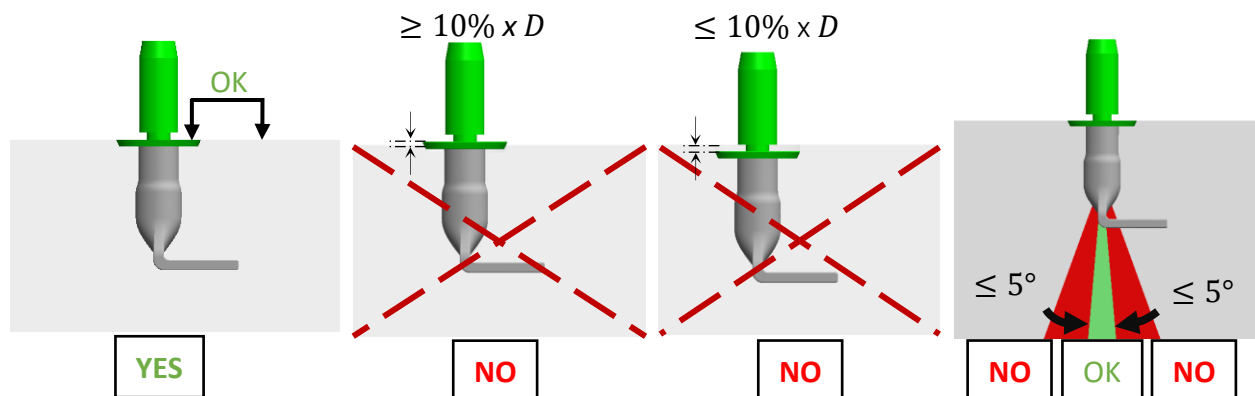


Figure 4 Correct placement of connection holding plate.

9.2 Concrete part dimensions

Figure 5 shows a measurement sketch for the concrete part. The minimum edge distances required for the anchor to ensure adequate load distribution and to prevent edge failures.

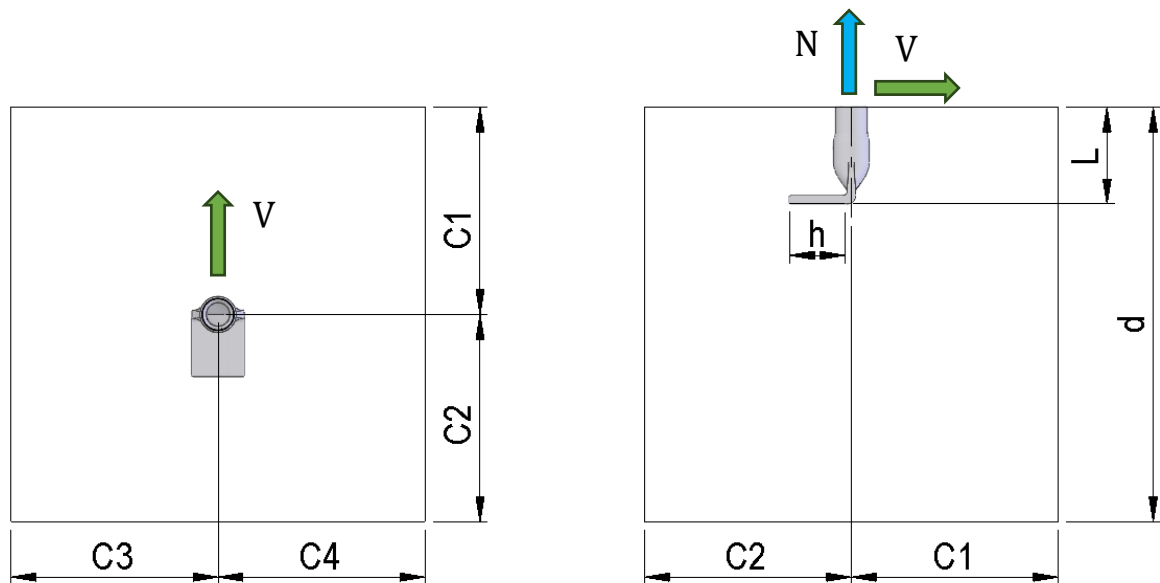


Figure 5 Concrete part.

Table 4 shows the dimensions of the various types of concrete part.

Type	Length <i>L</i> mm	Height <i>h</i> mm	Min. edge distance <i>C</i> ₁ , <i>C</i> ₂ , <i>C</i> ₃ , <i>C</i> ₄ mm	Min. depth of concrete <i>d</i> mm
M8	30	20	60	90
M10	35	21	70	105
M12	45	25	90	135
M16	60	30	120	180
	100	35	140	210

*C*₁ : Edge distance to the point of shear load application on the free edge.

*C*₂ : Edge distance in the direction opposite to the applied load.

*C*₃, *C*₄: Distances from the edge that are perpendicular to the direction of the shear load.

Min. spacing of 2x *C*₃ must be maintained between two or more sockets

Ensure that the Insert for fastening with angle is oriented with the angle bend parallel to the direction of the shear force as illustrated here.

Table 4 Dimension of the Concrete part

10 Starcon Insert for fastening with angle load data

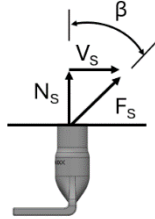
Table 5 provides information to assist in determining appropriate fixing sockets under conditions with varying axial and shear load design on the fixing sockets, conducted in unreinforced C20/25 concrete. The static calculation of the Insert for fastening performed according to CEN TS 1992-4:2009 - Design of fastenings for use in concrete.

The following boundary conditions are utilized for the calculation:

- **1 anchor** symmetrically positioned to the center of gravity.
- **Dynamic factor** (site handling) $\Gamma_{dyn} = 1.3$

Type	Length <i>L</i> mm	Height <i>h</i> mm	Design load [Ton]	
			Axial <i>N_{RD}</i>	Shear <i>V_{RD}</i>
M8	30	20	0,2	0,2
M10	35	21	0,27	0,25
M12	45	25	0,42	0,36
M16	60	30	0,69	0,56
	100	35	0,71	0,92

Interaction – axial load and shear load at the same time: (Utilization axial direction) + (Utilization in shearing) ≤ 120%
 $N_{SD} / N_{RD} + V_{SD} / V_{RD} \leq 1,2$



At $\beta = 45^\circ$
 $F_s = \sqrt{2} \cdot N_s$
 $V_s = N_s$

Disclaimer: The table serves solely as a guideline. For accurate guidance and calculations, please contact www.Certex.dk.

Table 5 Insert for fastening with angle load data.

11 General safety information when using the Starcon system.

General safety information when using the Starcon system.



- Ensure that the marking on the Starcon lifting unit always points in the direction of pull during lifting.
- The lifting machine must be approved to lift at least the maximum applied load + the weight of the Starcon lifting and handling system + any hoisting accessories.
- Lifting movements must be smooth; no sudden or abrupt changes in direction with the lifting machine should be made during a lifting operation, as this can lead to pendulum movements of the load, causing crushing hazards or dropping of the load.
- Where there is a risk of crushing between the load and objects, building parts, machinery, etc., the operator must not be in the danger zone.
- The operator's work area must be flat and free of obstacles that could pose a tripping hazard.
- When depositing the load, the operator must ensure this accepts on a flat and stable surface.
- Only when the load has been deposited and secured the Starcon lifting unit is completely unloaded may it be released and lifted free.
- Before each lift, ensure that both the Starcon lifting unit and the Starcon lifting anchor embedded in the concrete product are free from dirt that could reduce grip.
- Never insert arms or feet under a concrete product.
- Concrete products must never be dragged, only lifted.
- No modifications to the Starcon lifting and handling system may be made without written permission from the manufacturer.
- The operator must always ensure that the connection between the lifting machine and/or any hoisting accessories and the Starcon lifting unit is correct and secured against unintentional detachment.
- The operator must always ensure that the connection between the Starcon lifting unit and the Starcon lifting anchor is correct and secured against unintentional detachment.
- Keep a safe distance and never walk under a suspended load.
- Use gloves, safety shoes and other PPE when handling.
- Never use a Starcon lifting and handling system that has visible defects such as wear, deformations, rust damage, etc.
- Most anchors are designed to be easily handled during installation without the need for lifting equipment. However, some anchors may weigh more and should be handled using lifting equipment. Please refer to the order list for the accurate weight of each product.

11.1 Personal Protection

Always use gloves, a safety helmet, and safety shoes as a minimum requirement when operating the equipment. Keep hands and other body parts away from the lifting stand, lifting accessories, and the load during use.



11.2 Preparation of the product before use

11.2.1 Transport and Storage

Anchors should be transported and stored safely to prevent risks to personnel and nearby objects.

11.2.2 Unpacking

Remove the pallet and packaging protecting the anchors.

Cut the safety straps. The person unpacking should wear gloves, safety shoes, and safety glasses when cutting the straps.

11.2.3 Safe Disposal of Packaging Materials

All packaging used by Certex Denmark can be reused. Pallets and all wooden packaging can be reused or recycled.

All plastic, cardboard, and paper materials should be sent to the local recycling center.

If there are no local recycling facilities, the packaging should be returned to Certex Denmark for disposal at the customer's expense.

11.2.4 Preparatory Work Before Installation

After unpacking, visually inspect the anchors for any damage.

11.2.5 Installation and Assembly

The anchors are delivered ready for use.

11.2.6 Storage and Protection Between Periods of Normal Use

Inspect the anchors before each use and lift. Never use anchors or lifting accessories with visible defects such as wear, deformations, corrosion damage, etc.

Always store the lifting bar indoors, in a dry and ventilated area.

11.2.7 Provision of Information (Users, Operators, Service Experts)

All operators or individuals within the danger zone must receive information on operating the anchors and must be trained by the supervisor, familiarizing themselves with the product and its use before lifting operations commence.

Operators must be trained in the use of the Starcon lifting bar and all its functions and positioned to have a clear view of the entire lifting operation.

11.2.8 Placement of Instruction

All user manuals should always be stored together with the Starcon lifting bar.

12 Maintenance and inspection

- All maintenance must be performed when the Starcon lifting unit is unloaded.
- The Starcon lifting unit should be inspected and maintained to ensure parts remains in proper condition during use.
- After each use, the Starcon lifting unit should be cleaned and inspected for any faults or deficiencies.
- If any faults are found, they must be rectified, or the Starcon lifting parts should be discarded.
- The Starcon lifting parts should always be stored in a dry and well-ventilated area.
- Any damaged, corroded, or worn-out Starcon lifting parts must be immediately taken out of service and marked not be used again.
- Equipment from Starcon should undergo at least one annual inspection by a qualified skilled person to inspect lifting equipment and cranes.

12.1 Maintenance Schedule



- Only original spare parts may be used, and they must be replaced by a trained individual.
- The annual inspection must be carried out by a skilled person who has received the necessary training and certification for lifting equipment.
- All services must be documented, and the data must be stored.
- If there are any visual defects or if the labeling is not present on the lifting stand, the lifting stand must be marked as "out of service".

- B** Before use
- A** After use
- M** Monthly, or a maximum of 200 hours of usage.
- Y** Annually, or after a maximum of 2400 hours of use.

Inspection	B	A	M	Y
Perform a visual inspection to check for signs of overload, deformation, damage, wear, and corrosion.	X	X	X	X
The equipment must undergo inspection.			X	
Ensure that the equipment is clear and legibly labeled.	X			X
Inspection should be carried out by a qualified individual with a report prepared.				X

Table 6 Maintenance schedule

13 Disposal / Recycling

This section describes the end of use for the product.

- End of use / Disposal The lifting points shall be sorted / scrapped as general steel scrap.
- The Starcon lifting and handling system should be sorted and disposed of according to appropriate material categories, including metal, plastic, etc.
- Certex can assist you with disposal if required.

14 Product data of Starcon Fixing Socket bent End

Figure 6 shows a measurement sketch for the Starcon Fixing Socket bent End with labels for the respective dimensions.

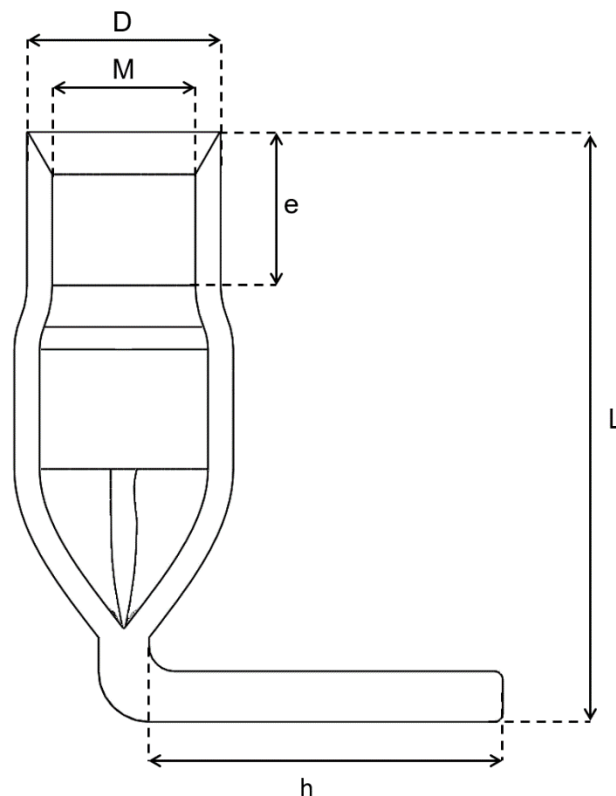


Figure 6 Insert for fastening with angle sketch.

14.1 Technical data

Table 7 shows the dimensions of the various types of Starcon Fixing Socket bent End.

Type	Socket dia. D mm	Length L mm	Thread M mm	Thead length e mm	Height h mm
M8	11	30	8	8	20
M10	13	35	10	10	21
M12	16	45	12	12	25
M16	22	60	16	15	30
	22	100	16	15	30

Table 7 Starcon Fixing Socket bent End dimension.

15 Product data of connection holding plate for insert for fastening

Figure 7 shows a measurement sketch for the Connection holding plate.

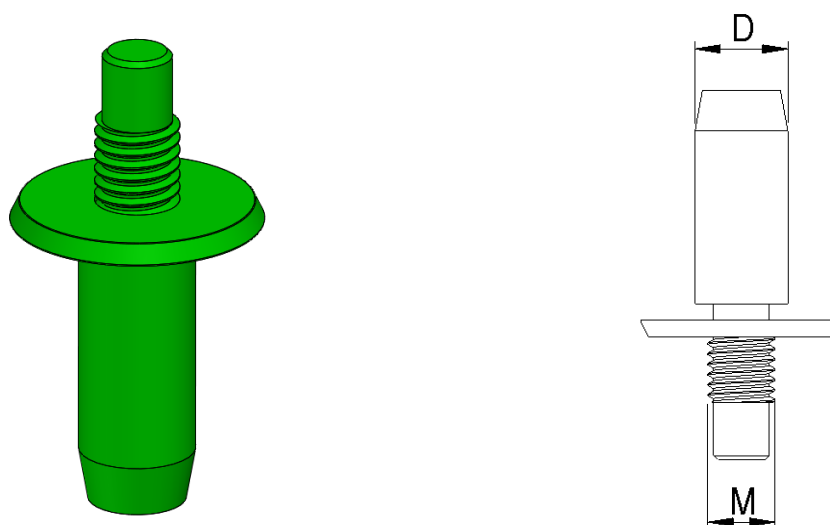


Figure 7 Connection holding plate for insert for fastening.

15.1 Technical data

Table 8 shows the dimensions of the various types of the connection holding plate used for casting of the insert for fastening.

Connection holding plate Starcon Group	D mm	Color
M8	11	Green
M10	11	Yellow
M12	11	Red
M16	17	Black
M20	17	White

Table 8 Dimension of connection holding plate for insert for fastening.

Our industries, products & services

At CERTEX Denmark, we are a secure and reliable total supplier and partner within fixing equipment. Below is an overview of the industries we service, our product range, and the services we offer."



"

**Based on many years of experience
& know-how within lifting, load
tests & engineering, CERTEX
Denmark is your reliable partner &
supplier of steel wire, lifting
applications & related services."**