

English Version

Design and use of inserts for lifting and handling of precast concrete elements

Conception et utilisation d'inserts pour le levage et la manutention du béton préfabriqué - Éléments

Bemessung und Anwendung von Transportankern für Betonfertigteile - Elemente

This Technical Report was approved by CEN on 27 July 2015. It has been drawn up by the Technical Committee CEN/TC 229.

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Contents	Page
European foreword.....	4
1 Scope	5
1.1 General.....	5
1.2 Types of inserts for lifting and handling.....	5
1.3 Minimum dimensions.....	5
2 Normative references	5
3 Terms and definitions and symbols	6
3.1 Definitions.....	6
3.2 Symbols.....	8
3.2.1 Action and resistance.....	8
3.2.2 Concrete and steel.....	8
3.2.3 Inserts.....	9
4 Basis of design	9
4.1 General.....	9
4.2 Required verifications.....	9
4.3 Design Principles.....	9
4.3.1 Limit state design.....	9
4.3.2 Ultimate limit state.....	9
4.3.3 Admissible load design.....	10
4.4 Verification.....	11
4.4.1 General.....	11
4.4.2 Partial factor method (Ultimate limit state).....	11
5 Actions on inserts	12
5.1 General.....	12
5.2 Effect of lifting procedures on load directions.....	13
5.3 Actions from adhesion and form friction.....	14
5.4 Dynamic actions.....	15
5.5 Combined actions.....	16
6 Design of lifting inserts and anchorage in concrete by calculation	16
6.1 General conditions.....	16
6.2 Types of inserts covered.....	17
6.2.1 Inserts independently placed on the market.....	17
6.2.2 Inserts made by the precaster.....	19
6.3 General design.....	19
6.3.1 Failure modes.....	19
6.3.2 Design procedures.....	20
6.3.3 Unreinforced concrete.....	20
6.3.4 Reinforced concrete.....	22
6.4 Lifting inserts.....	24
6.4.1 General design.....	24
6.4.2 Lifting loops of smooth bars.....	24
6.4.3 Lifting loops of strands.....	26
6.4.4 Lifting loops of steel wire ropes.....	26
6.5 Lifting of walls and linear elements.....	27

6.5.1	General	27
6.5.2	Minimum thickness of wall or element	28
6.5.3	Anchorage reinforcement.....	28
6.6	Lifting of slabs and pipes.....	30
6.6.1	Minimum edge distances	30
6.6.2	Anchorage reinforcement.....	30
7	Design of lifting inserts and anchorage in concrete by testing	31
7.1	General conditions	31
7.2	Specification of specimens	32
7.2.1	Areas of application	32
7.2.2	Design of test specimen	32
7.2.3	Age of concrete specimen at testing.....	34
7.2.4	Specification of inserts.....	34
7.3	Loading conditions.....	34
7.3.1	Load and support conditions.....	34
7.3.2	Loading history	35
7.3.3	Measurements	35
7.4	Test programs.....	35
7.4.1	General	35
7.4.2	Tests to verify prior knowledge	36
7.4.3	Tests utilizing no prior knowledge — Determination of properties for one insert used for specific applications.....	36
7.5	Assessment of the test results.....	36
7.6	Test report	36
7.6.1	General information	36
7.6.2	Test members	37
7.6.3	Installation of the insert.....	37
7.6.4	Measured values	37
7.6.5	Evaluation report.....	38
8	Lifting and handling instructions	38
Annex A (informative)	Information to be given by the insert supplier	39
A.1	Information on the content of an operational manual.....	39
Annex B (informative)	Use of Supplier's recommendations.....	42
Bibliography	43

European foreword

This document (CEN/TR 15728:2016) has been prepared by Technical Committee CEN/TC 229 "Precast concrete products", the secretariat of which is held by AFNOR.

This document supersedes CEN/TR 15728:2008.

To ensure the performance of the precast concrete products, lifting and handling should be taken into account in the design of the product.

Inserts are used for lifting and handling of precast elements. They should meet an appropriate degree of reliability. They should sustain all actions and influences likely to occur during execution and use.

This Technical Report deals with lifting inserts cast into precast concrete elements. The intent of this document is to give information to precast product designers.

The failure of inserts for lifting and handling could cause risk to human life and/or lead to considerable economic consequences. Therefore inserts for lifting and handling should be selected and installed properly by skilled personnel according to the lifting and handling instructions.

This Technical Report based on current practices gives recommendations for correct choice and design of lifting inserts according to the lifting capacity of their part embedded in the concrete. It is based on EN 1992-1-1 (Eurocode 2), EN 1993-1-1 (Eurocode 3), CEN/TS 1992-4-1 and on published supplier's data.

Safety levels should be determined nationally. In the Technical Report numerical values for safety factors as used in different CEN member states are given for information and are recommended as basic values that provide an acceptable level of reliability. They have been selected assuming that an appropriate level of workmanship and of quality management (Factory Production Control) applies. They may be applied in the absence of national regulations.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

1 Scope

1.1 General

This Technical Report provides recommendations for the choice and use of cast-in steel lifting inserts, hereafter called 'inserts' for the handling of precast concrete elements. They are intended for use only during transient situations for lifting and handling, and not for the service life of the structure. The choice of insert is made according to the lifting capacity of their part embedded in the concrete, or may be limited by the capacity of the insert itself and the corresponding key declared by the insert manufacturer.

The report covers commonly used applications (walls/beams/columns and solid slabs and pipes). The range of these applications is further limited to prevent other types of failure than concrete breakout failure (cone failure), bond failure, failure of reinforcement or failure in the steel insert.

Due to lack of information this report does not cover double shell walls, floor plates and beams for beam-and-block floor systems.

The safety levels are given for information and are intended for short-term-handling and transient situations.

This Technical Report applies only to precast concrete elements made of normal weight concrete and manufactured in a factory environment and under a factory production control (FPC) system (in accordance with EN 13369:2013, 6.3) covering the insert embedment.

This Technical Report does not cover:

- the design of the lifting inserts independently placed on the market;
- lifting inserts for permanent and repeated use.

This Technical Report is prepared based on the fact that the anchorage in the concrete of parts of the lifting assembly is governed by the Construction Products Regulation. Lifting accessories independently placed on the market are governed by the Machinery Directive.

1.2 Types of inserts for lifting and handling

This Technical Report applies to the embedment of lifting inserts. Devices made by the precaster may consist of smooth bars, prestressing strands, steel plates with anchorage or steel wire ropes. The system devices may be e.g. internal threaded inserts, flat steel inserts and headed inserts.

Lifting loops of ribbed bars are not covered.

1.3 Minimum dimensions

This Technical Report applies in general to inserts with a minimum nominal diameter of 6 mm or the corresponding cross section. In general, the minimum anchorage depth should be $h_{ef} = 40$ mm.

Wire ropes of diameter less than 6 mm are not covered.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 1990:2002, *Eurocode - Basis of structural design*

EN 1992-1-1:2004, *Eurocode 2: Design of concrete structures - Part 1-1: General rules and rules for buildings*

EN 1993-1-1:2005, *Eurocode 3: Design of steel structures - Part 1-1: General rules and rules for buildings*

EN 10025-2, *Hot rolled products of structural steels - Part 2: Technical delivery conditions for non-alloy structural steels*

EN 12385-4, *Steel wire ropes — Safety — Part 4: Stranded ropes for general lifting applications*

EN 13369:2013, *Common rules for precast concrete products*

EN 13414-1, *Steel wire rope slings — Safety — Part 1: Slings for general lifting service*

3 Terms and definitions and symbols

For the purposes of this document, the following terms and definitions and symbols apply.

3.1 Definitions

3.1.1

concrete breakout failure

concrete cone separated from the base material by loading the insert

3.1.2

concrete breakout resistance

resistance corresponding to a concrete cone surrounding the insert or group of inserts separating from the member

3.1.3

edge distance

distance from the edge of the concrete surface to the centre of the nearest insert

3.1.4

anchorage length

for cast-in headed insert bolts and splayed inserts is illustrated in Figure 1

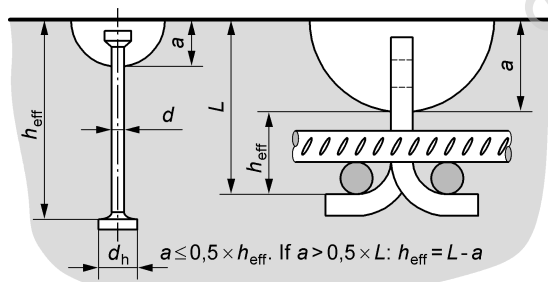


Figure 1 — Examples of anchorage length for different types of inserts

3.1.5

embedment depth

distance from the concrete surface to the farthest point of insert, measured perpendicular to the concrete surface