

*Recommended*  
**Fabrication Practices for  
Epoxy-Coated Reinforcing Bars**

- Storage**
  - ✓ Store bundles on suitable materials, such as timber cribbing.
  - ✓ Space timber cribbing to minimize sagging.
  - ✓ Use nylon strapping or other non-abrasive material.
  - ✓ If outdoor storage is to exceed 30 days, cover coated bars with suitable material and minimize condensation.
- Shearing & Bending**
  - ✓ Contact points on shearing and bending equipment to be a suitable material.
  - ✓ Inspect bars after bending and repair any cracks with patching material.
- Patching Material**
  - ✓ Use 2-part patching material, approved by the coating manufacturer.
  - ✓ Follow manufacturer instructions.
- Handling & Loading**
  - ✓ Use spreader bar or strong back with multiple pick-up points to minimize sags.
  - ✓ For lifting, use nylon or padded slings; not bare chains or cables.
  - ✓ For shipping, secure the load with nylon or padded strapping.

For additional information, see Appendix F of CRSI's Epoxy Coating Plant Certification Manual, ASTM D 3963/D 3963M and Annex X1 of ASTM A 775/A 775M.



Concrete Reinforcing Steel Institute  
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## Job-Site Repair of Damaged Epoxy Coating



### Step 1

*Remove rust and contaminants from the damaged area to be patched with a wire brush.*



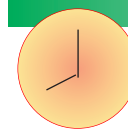
### Step 2

*Mix the patching material according to the manufacturer's instructions. Use patching material prior to end of pot life.*



### Step 3

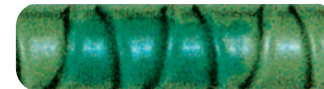
*Apply the patching material to the repaired area. Follow the patch material manufacturer's instructions.*



### Step 4

*Allow the repaired area sufficient curing time, as specified by the manufacturer's instructions, before placing concrete.*

**PROPERLY REPAIRED**



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