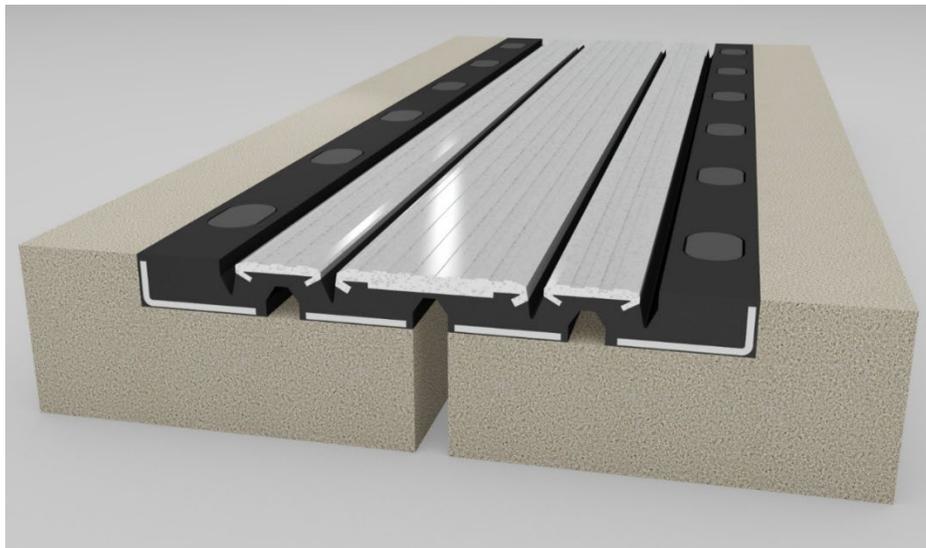


Installation Procedure

Last Updated: March 2025



Wabo® Flex SR

Molded Rubber Segmental Expansion Joint System for Bridge & Highway Applications

The following installation procedure is very important and must be fully understood prior to beginning any work. To ensure proper installation and performance of expansion joint system the following actions must be completed by the installing contractor. Failure to do so will affect product warranty.

- 1) Carefully read and understand installation procedure. Contact WBA's Technical Service Department at (800) 677-4922 for product assistance.
- 2) Inspect all shipments and materials for missing or damaged components and hardware. Contact Customer Service at (800) 677-4922 with WBA's order number and invoice for prompt assistance.
- 3) Inspect substrate or adjacent construction for acceptance before beginning work. Report unacceptable construction to the project manager for scheduled repair work.
- 4) Review WBA shop drawings for project specific detailed information if Engineering services were purchased at time of order.

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Health & Safety

During the installation of any Watson Bowman Acme product, appropriate personal protective items should be worn at all times, including but not limited to the following:

- Proper work clothing
- Safety glasses
- Safety boots
- Gloves
- Hard hat



Local rules and regulations regarding safe work environments and health should be followed.

Standard Components

The following components are required for the installation of this product:

- Wabo®Flex Panel
- Supplied Hardware and Epoxy
- Sikaflex® NP 1WaboCrete II Part A & B only
- Bedding Tape

Recommended Equipment

This product requires the following additional equipment for an easy and successful installation:

- Equipment for lifting panels
- Torque wrench (thin wall with deep well) to tighten anchors.
- Prybar to move or position panel.
- Hammer drill to install anchors.
- Panel Close-down device available (contact sales representative)
- Hydraulic rams or scissor jacks to aid in joining panels
- Backer Rod (supplied by others)

Pre-Installation Notes



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Field Preparation

- The joint interface must be clean, sound, and durable (free of dirt, coatings, rust, grease, oil, and other contaminants).
- Newly placed concrete must be cured a minimum of 14 days.
- Any spalling or cracking concrete must be removed to sound concrete and repaired prior to installation of Wabo®Flex.
- Prepare blockouts to proper dimensions and grades per the shop drawings. The joint opening should be blown clean using compressed air (>90psi).
- The bottom surface of the blockout shall be parallel with the plane of the roadway (true and flat). All air voids 1/4" and larger shall be filled in with an approved grout.
- The anchor spacing, corresponding to the dimensions spanning the open joint (Refer to Blockout Data Dimension "B") , must be verified and adjusted for temperature prior to the installation of the anchors.

Anchor Placement

- **Chemical Anchors** follow Hilti procedures for hole size and embedment depth. If using factory transitions be sure to start at the gutter line.
- **Cast-in-place Anchors** are to be installed into the formwork starting at the gutter-line and proceeding toward the "field-cut piece." Care is to be taken to ensure that the anchors are set at right angles to the bottom of the blockout. Also refer shop drawings.
- For installation questions or concerns, contact WBA field service.

Anchor Data Table

SYSTEM	ANCHOR SIZE	EMBED DEPTH	EXPOSED HEIGHT	TORQUE FT-LBS
SR 2A	1/2" X 6 1/2"	5 1/4"	1 1/4"	40
SR 2.5	5/8" X 8"	6 1/2"	1 1/2"	65
SR 4A	3/4" X 10"	8 1/4"	1 3/4"	85
SR 6.5	7/8" X 10"	8"	2"	100
SR 9	7/8" X 10"	7 3/4"	2 1/4"	100
SR 13	1 1/8" X 12"	9 1/4"	2 3/4"	150

BLOCKOUT DATA

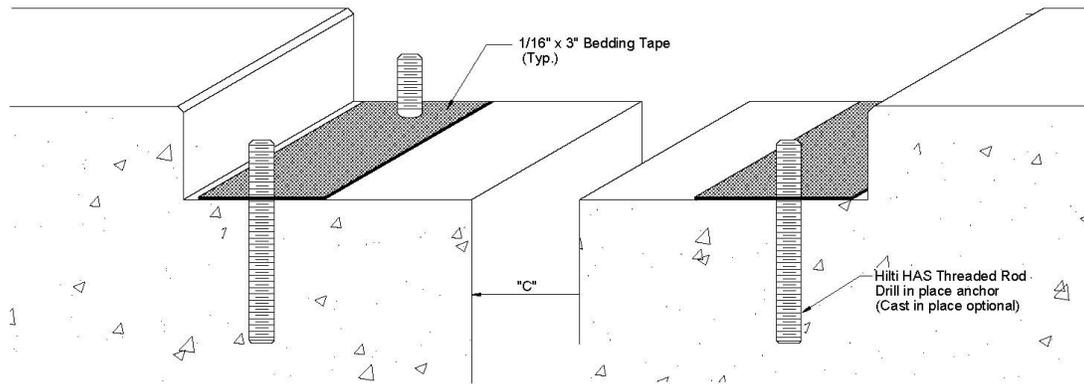


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Blockout Data Table

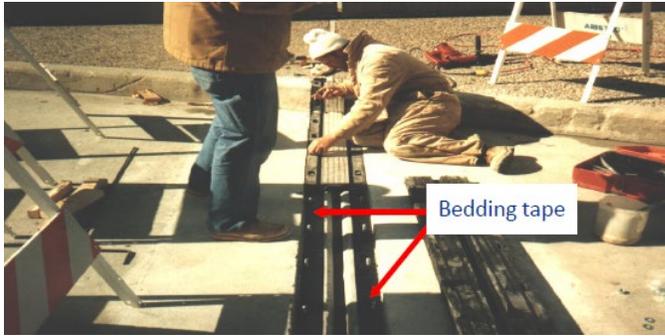
Model Number	"A"				"B"				"D"		"E"		"F"	
	Min		Max		Min		Max							
	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm		
SR 2A	10.125	257	12.125	308	7.375	187	9.375	239	1.375	35	1.813	46	1.250	32
SR 2.5A	13.000	330	15.500	394	9.750	248	12.250	311	1.625	41	2.063	52	1.500	38
SR 4A	21.500	546	25.500	648	17.625	448	21.625	549	1.938	49	2.375	60	1.750	44
SR 6.5A	25.250	641	31.750	806	21.000	533	27.500	699	2.125	54	3.250	83	2.000	51
SR 9	33.375	848	42.375	1076	29.000	737	38.000	965	2.188	56	4.000	102	2.250	57
SR 13	49.000	1245	62.000	1575	43.500	1105	56.500	1435	2.750	70	5.250	133	2.750	70

Installation

1. When using fabricated curb sections, start at the curb.



2. Apply the bedding tape as shown on the shop drawings.



3. Set fabricated panel on top of bedding sealant.



4. Using bolt holes in panel as guide, drill holes to required depth for anchors.



5. Clean out holes following Hilti guidelines on product packaging.
6. Install Anchors using supplied epoxy. Allow to cure referring to Hilti guidelines.

7. After epoxy cures, bolt down panel to deck to the specified torque indicated on the Shop Drawings or Anchor Data Table.



8. Apply Sikaflex®-NP1 to the groove ends of the fabricated curb and bolt in place. Then connect next panel securely together at all tongue-and-groove connections. SikaflexNP1 should squeeze from topside connection to ensure engagement. Continue this procedure (Steps 2 thru 9) with the standard sections until reaching the field-cut panel.
9. After field measuring, cut the panel to the required length. When butting two cut ends at a field splice apply 3 layers of bedding tape to the cut ends.



10. Approximately one hour after initial placement, all nuts or bolts shall be tightened to required torque.
11. After all sections have been installed according to the above directions, fill the bolt cavity with (image #5)
12. WaboCrete II (Part A & B). Mix part A & B for 30 seconds, once mixed there is a 10 minute working time (image # 7 can be used or a new image needed)
13. Seal void between Wabo®Flex sections and vertical face of blockout using backer rod and Sikaflex NP1.

Field Service Assistance



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- Please contact Watson Bowman Acme for Field Service Assistance to address project specific recommendations, proper installation procedures of our products.

Follow us on social media for industry news, new product announcements & more:



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