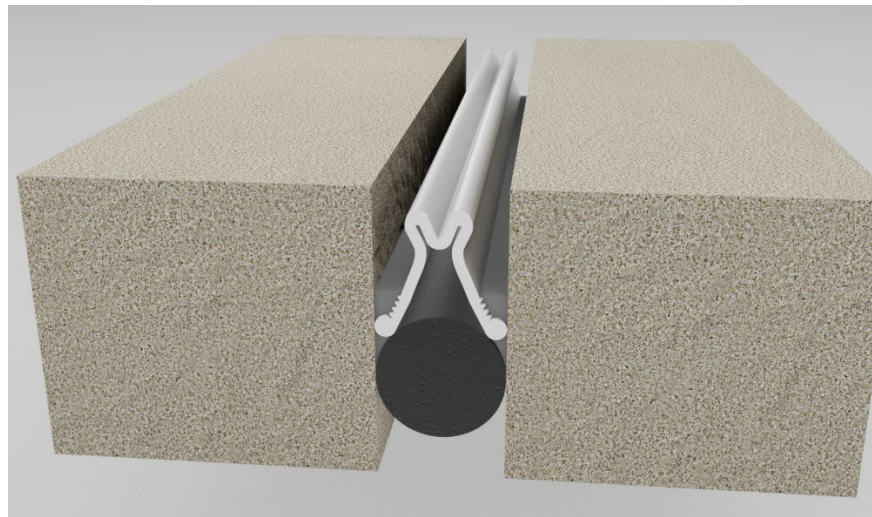


# Installation Procedure

Last Updated: January 2025



## Wabo<sup>®</sup>SPS- CALTRANS- Bonded Joint Seal

### Preformed Silicone Joint Seal System

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.

# Recommended Equipment

Watson Bowman Acme recommends the following equipment and tools for ease of installation Sandblasting equipment to remove laitance in new concrete, and debris or other contaminants for joint replacement in blackout area.

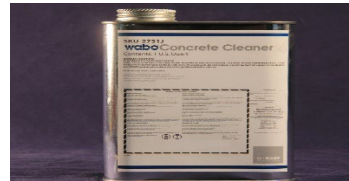
- Pancake compressor should be set to a maximum of 70 psi
- Denatured alcohol to clean seal profile
- White cotton rags to use with denatured alcohol
- Albion AT1500X Pneumatic Caulking Gun (for dual 50.72 oz cartridges)
- Small trowels (3 inch wide) or putty knives for tooling adhesive
- Foam backer rod or blue board to stabilize seal profile during installation
- Non serrated blade for cutting seal
- Solvent brush
- PP Primer (WBA Part # 2717) for splices
- Aron Alpha 241 (WBA Part 2716)



PP Primer



Aron Alpha 241



Denatured alcohol



Wabo®SiliconeSeal



Extended tip for WaboSPS



Albion AT1500X Pneumatic Caulking Gun (for dual 50.72 oz cartridges) (additional cost)



Pancake Compressor (not supplied by WBA)



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# General

The work shall consist of furnishing and installing a Wabo®SPS Joint System in accordance with the details shown on the plans, and the requirements of the specifications. Placement of the Wabo®SPS joint system shall consist of proper surface preparation, material and application of materials. Substitution of alternate materials may affect product performance and are prohibited. Recommended application temperature is 40°F (5°C) and rising.

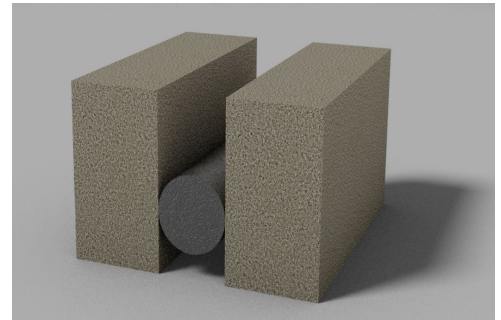
## Pre-Installation

- 1 Preformed Silicone Preparation:** Unroll seal and with a clean rag wipe the serrated sidewall and rounded seal lugs with denatured alcohol (supplied by others) to ensure a clean surface for bonding. Cut to the proper length



## Installation

- 1 Seal Positioning:** Inspect joints for proper depth as detailed in the plans. A closed-cell, expanded polyethylene foam backer rod is recommended for seal depth positioning. The backer rod stabilizes the seal and acts as a seat to prevent the preformed silicone seal from migrating below the recommended joint depth during installation.



Minimum groove depth placement is as follows:

Model number	Groove (installation) depth
Wabo®SPS-225	2.625" (67 mm)
Wabo®SPS-400	3.75" (95 mm)
Wabo®SPS-500	4.75" (121 mm)

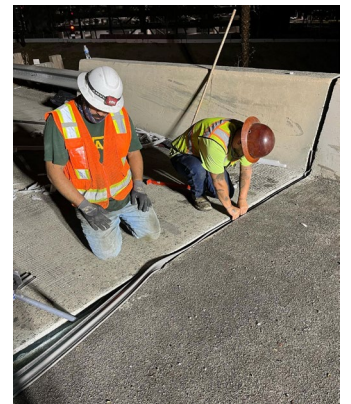
The size of the backer rod should be approximately 20-25% greater than the joint opening to be sealed. For larger openings, foam board or "hot-dogging" the backer rod (increasing a standard backer rod by cutting it partially open and inserting a smaller foam rod) can be used.

Set pressure on air compressor to 70 psi after attaching trigger and follow the operating instructions that come with the device.

Note: Extension tip may be cut shorter. Tip must remain a minimum of 2.5" in length from the base of the tip.

Place a bead of Wabo®SiliconeSeal on each side of the backer rod where the seal will be sitting.

Fold seal and insert into the joint opening. Ensure contact with joint interfaces and the adhesive.



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**2**

**Silicone Bead Placement:** . Apply a continuous 3/8" to 1/2" bead of Wabo®SiliconeSeal to both sides of the joint interface. Apply adhesive directly on each side of backer rod.

**3**

Tool the Wabo®SiliconeSeal on both sides to ensure the adhesive makes full contact with the seal and substrate. The Wabo®SPS joint system will be ready to accept traffic within one hour after installation

## Seal Splicing

**1**

Cut preformed silicone seal material with a non-serrated blade creating a fresh cut on both sides. A miter box is recommended to maintain a straight and accurate cut. A lubricant could be used to cut such as denatured alcohol.

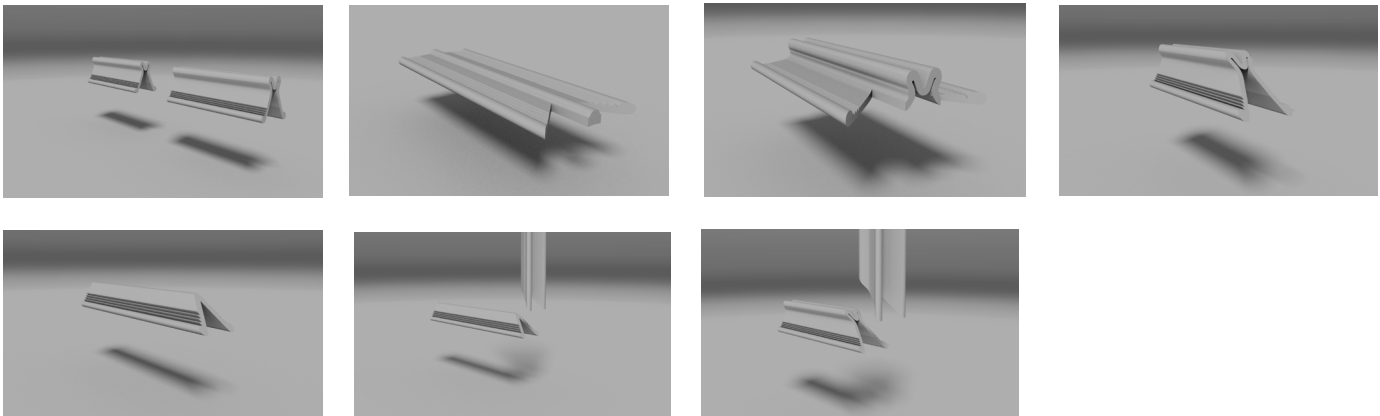
Measure seal to ¼" past face of curb and mark with a pen. From mark add appropriate angle (typically 45) with seal folded in half. Then lay seal flat and cut with razor stopping at center fold and remove triangle leaving center run long.

**2**

Fold seal in half and very carefully continue angle through center this will prevent a gap in center when putting two pieces together. Repeat on opposing side.

Both ends of the preformed silicone seal shall be cleaned using a solvent brush and PP Primer (WBA Part # 2717) to cut the surface. Apply the Aron Alpha 241F (part #2716) to the cut surface of the preformed silicone seal one half at a time and compress pieces together, holding in place for 30 seconds under firm pressure.

After the glue has properly cured, tool Wabo®SiliconeSeal over the spliced area to ensure water tightness. It is recommended to let spliced section rest untouched for approximately 3 minutes prior to flexing in the joint opening, ensuring full cure of the splice adhesive.



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