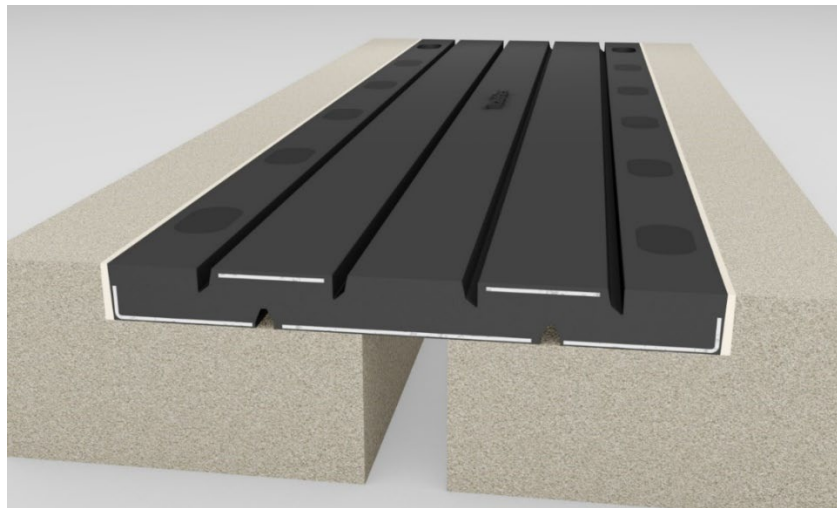


Installation Procedure

Last Updated: March 2025



Wabo[®] TransFlex Joint System

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®TransFlex Panel
- Supplied Hardware and Epoxy
- Sikaflex® NP 1
- WaboCrete 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)
- Backer Rod (supplied by others)

Pre-Installation Notes

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®TransFlex.
- Prepare blockouts to proper dimensions and grades per the shop drawings.
- The joint opening must 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
200A	1/2" X 6 1/2"	5 1/4"	1 1/4"	40
250	5/8" X 8"	6 1/2"	1 1/2"	65
400	3/4" X 10"	8 1/4"	1 3/4"	85
650	7/8" X 10"	8"	2"	100
900	7/8" X 10"	7 3/4"	2 1/4"	100
1300	1 1/8" X 12"	9 1/4"	2 3/4"	150

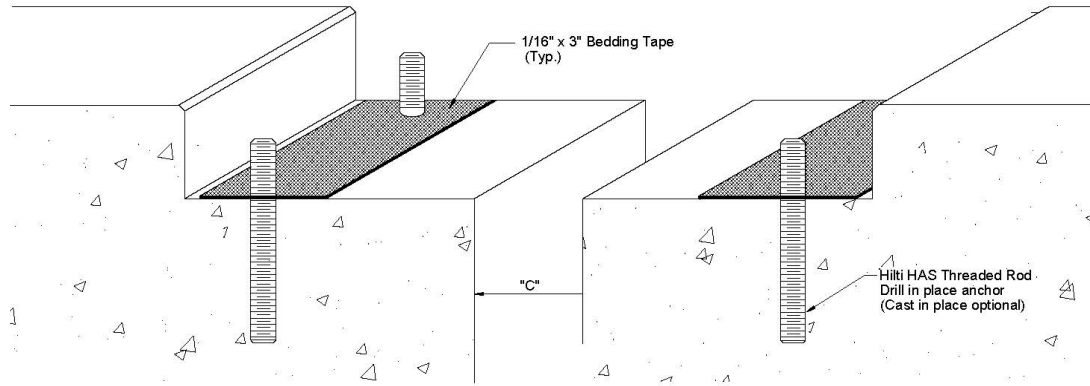


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BLOCKOUT DATA



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	in	mm						
200A	10.375	264	12.375	314	7.625	194	9.625	239	1.375	35	1.563	40	1.250	32
250	13.250	337	15.750	400	9.750	248	12.250	311	1.750	44	1.813	46	1.500	38
400	21.875	556	25.875	657	17.625	448	21.625	549	2.125	54	2.125	54	1.750	44
650	26.125	664	32.375	822	21.000	533	27.500	699	2.438	62	3.000	76	2.000	51
900	31.500	800	40.500	1029	26.500	673	35.500	965	2.500	64	3.750	95	2.250	57
1300	41.625	1057	54.625	1387	36.000	914	49.000	1435	2.813	71	5.000	127	2.750	70



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Installation

1. When using fabricated curb sections, start at the curb.
2. Apply bedding tape as shown on the shop drawings.
3. Set fabricated panel on top of bedding tape.
4. Using bolt holes in panel as guide, drill holes to required depth for anchors.
5. Clean out holes following Hilti guidelines.
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® NP 1 Sealant to the tongue or groove ends of the fabricated curb.
9. Abut panels securely together at all tongue-and -groove connections.
10. Continue this procedure (Steps 2 thru 9) with the standard sections until reaching the field-cut panel.
11. 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.
12. Approximately one hour after initial placement, tighten all nuts shall be to required torque as indicated on shop drawings.
13. After all sections have been installed according to the above directions, fill the bolt cavity with WaboCrete II (Part A & B). Mix part A & B for 30 seconds, once mixed there is a 10 minute working time
14. Seal void between Wabo®TransFlex sections and vertical face of blockout using backer rod and Sikaflex® NP 1 sealant.



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Field Service Assistance

- 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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