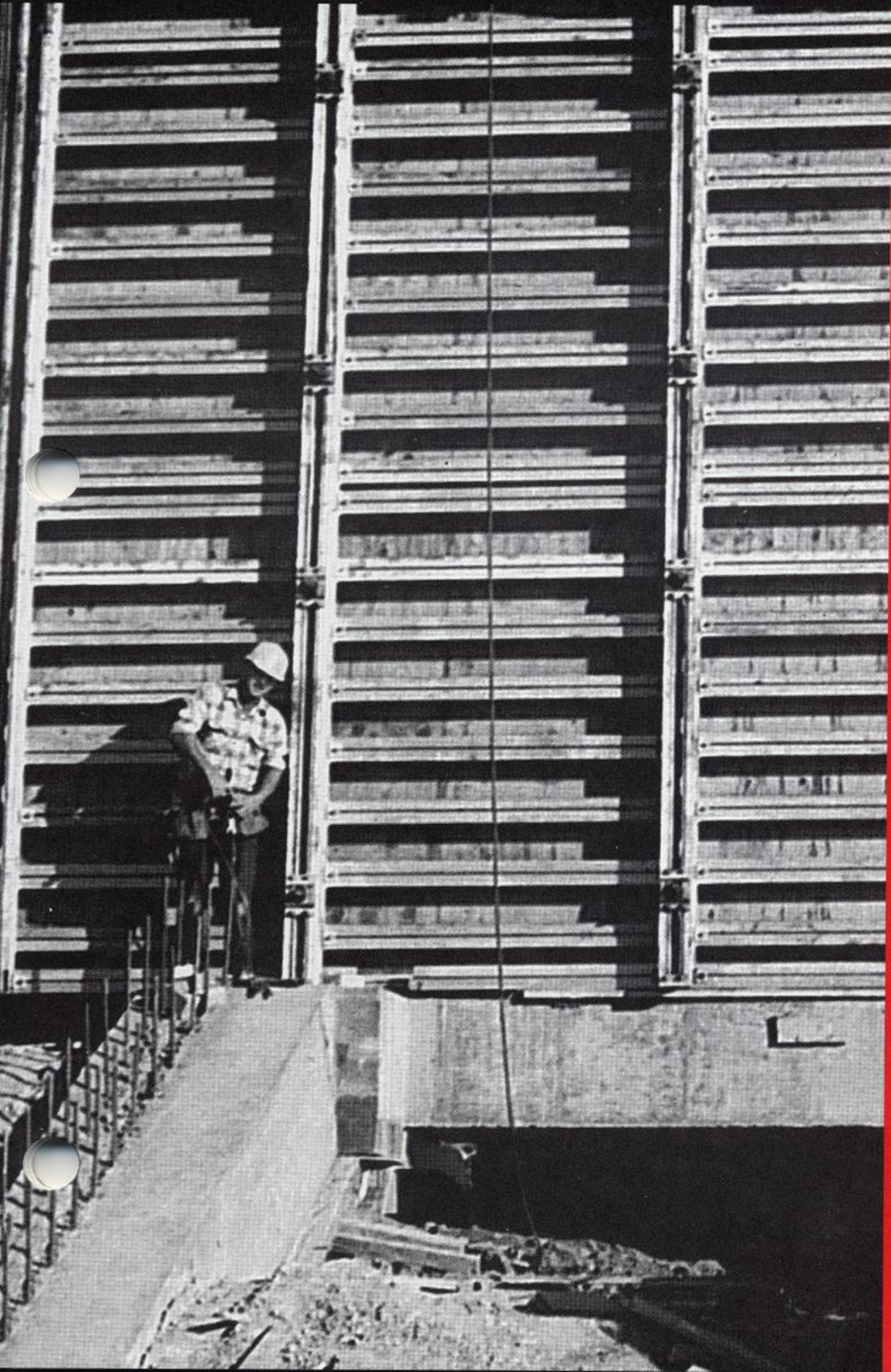




# WACO'S GUIDE TO **FORMING**



**WACO**<sup>®</sup>

Scaffolding & Equipment

Rentals • Sales • Erection



■ ■ ■

# WACO'S GUIDE TO FORMING

■ ■ ■

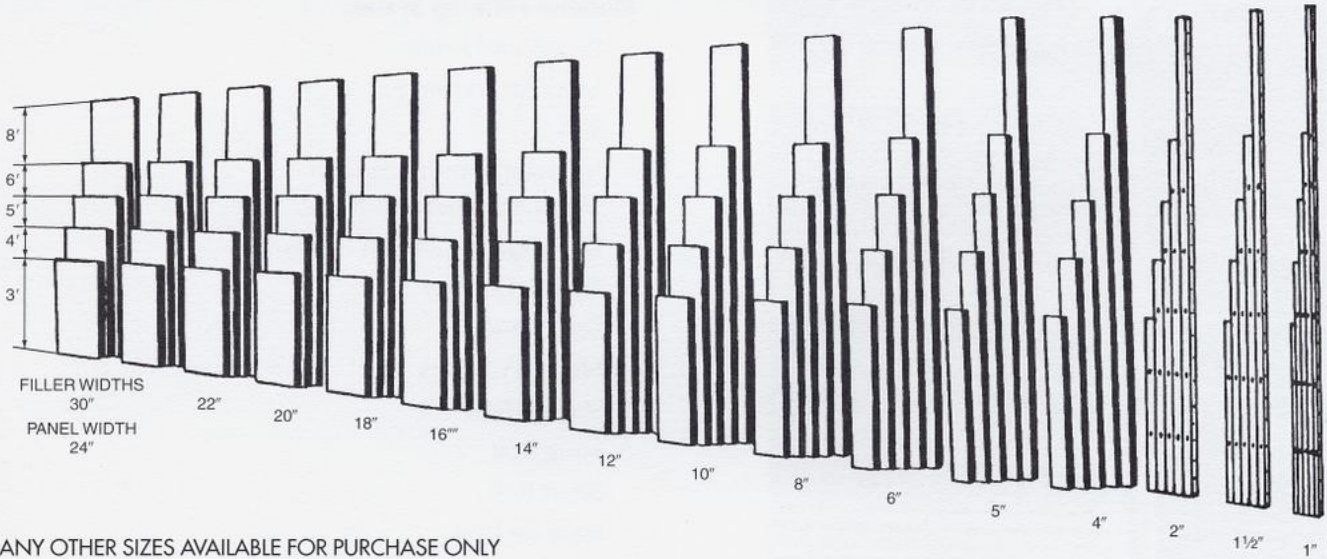
## **Modular Forming System**

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# MODULAR FORMING SYSTEM

## Panels and Fillers

There are 80 sizes available for fast erection of virtually any layout by combining panel and filler sizes and erecting vertically or horizontally. This eliminates the sawing, drilling, measuring and nailing common with job-built forming. Quick and easy handling, no tops, bottoms, lefts or rights, makes for improved labor productivity.

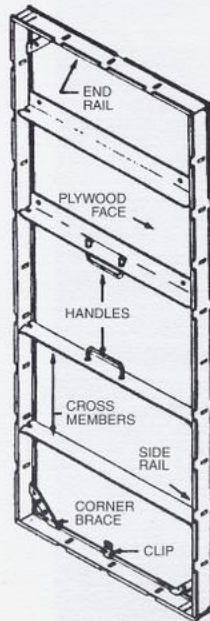


MANY OTHER SIZES AVAILABLE FOR PURCHASE ONLY

## Modular Forming

Steel-Ply owners commonly report 200-300 reuses from panels and fillers before re-ply is required

- 1/2" HDO Plywood is edge and surface sealed to prevent costly delamination and prolong form life.
- Durable high carbon steel frames reinforced for rigidity and strength surround and protect the plywood.
- No measuring or drilling for ties — dado slots 12" on center and 6" from each end for tie insertion.
- Complete system is performance tested and load rated at 1000 psf for maximum concrete placing productivity.



1" & 1 1/2"  
STEEL FILLERS



2"  
STEEL FILLERS

# MODULAR FORMING SYSTEM

## Ties

A form tie would seem to be a product that is easily fashioned by most any job shop. Yet each form tie is required to contain tremendous concrete pressure. Just one bad tie, whether weakened by substandard raw material or a fractured weld, can result in a costly or dangerous situation.

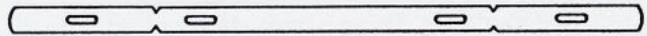
Ties are specially designed for use with the Modular Forming System and are subject to extensive quality control testing. This testing includes raw material performance; length and loop tolerance; tensile strength measurement; coating and packaging inspection. Each tie is a dependable component in the formwork layout.

WACO offers the most complete selection of standard and heavy duty tie designs for the Modular Forming system. These different designs allow for proper tie selection for each forming application.

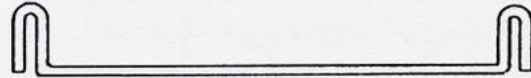
All ties are manufactured under strict quality control and have known load ratings. These load ratings are used to determine the necessary safety factor and all formwork layouts should be designed with the appropriate safety factor in mind.



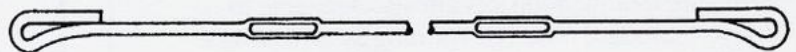
Wire Tie



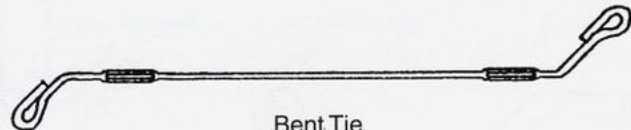
Flat Tie



Base Tie



Gang Form Tie



Bent Tie



Threaded Tie

### Tie Load Limit – Wire and Flat Ties

	Ultimate Load (lb)	Rating According to Factor of Safety	
		1.5 (lb)	2.0 (lb)
Standard duty wire tie	4,500	3,000	2,250
Standard duty threaded tie (1, 2)	4,200	2,800	2,100
Standard duty S-based tie	3,000	2,000	1,500
Heavy duty wire tie	6,000	4,000	3,000
Standard duty flat tie	6,000	4,000	3,000
Heavy duty flat tie	7,000	4,500	3,500
Heavy duty adjustable flat tie	7,000	4,500	3,500
Toggle tie	4,200	2,800	2,100

1. Tie capacity is dependent on adequate anchorage.

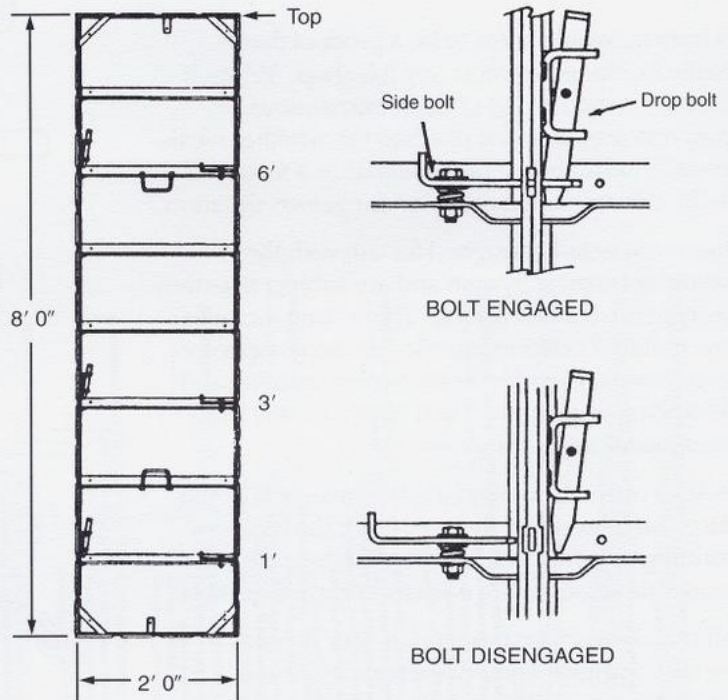
2. When anchored with threaded inserts in 3,500 psi concrete, an ultimate load of 4,000 lb. and a safety factor of 4:1 is recommended.

# MODULAR FORMING SYSTEM

## Modular Forming System With Attached Hardware

Residential and handset jobs are perfect applications for the time-saving Modular Forming System with attached hardware. These panels are supplied with Slide Wedge Bolts and Drop Bolts positioned to customer specifications, typically 1-3-6 foot spacing. With attached hardware, tie positioning becomes simple and hardware loss is eliminated.

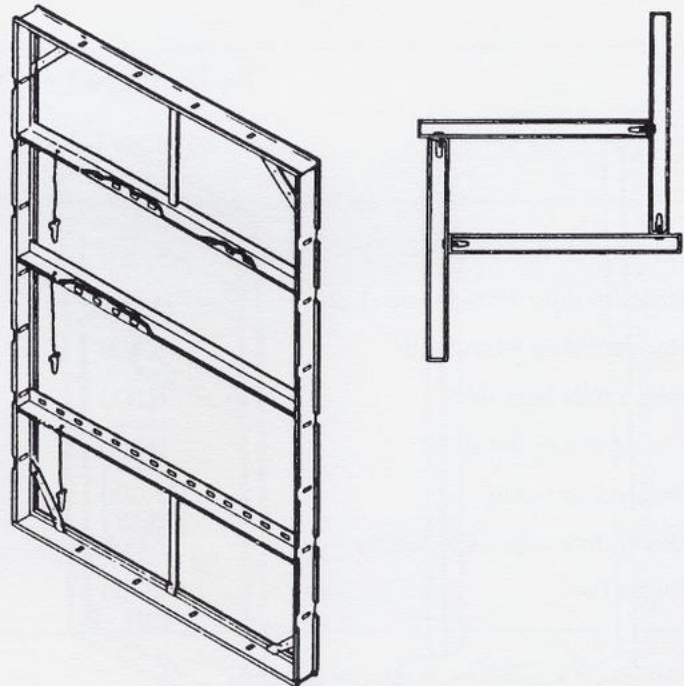
Modular Forming System with attached hardware is fully compatible with all the Modular Forming System components and accessories. Attached hardware modification kits are also available to convert standard Modular Forming System panels and fillers.



## Rectangular Column Forms

The Rectangular Column Form adjusts in 1 inch increments to 30 inches (except for 28" and 29"). These forms can be used independently or with Modular panels or fillers to make up virtually any column dimension.

The Rectangular Column Form requires standard Modular Forming System connecting hardware, which means fast, accurate and easy column forming.

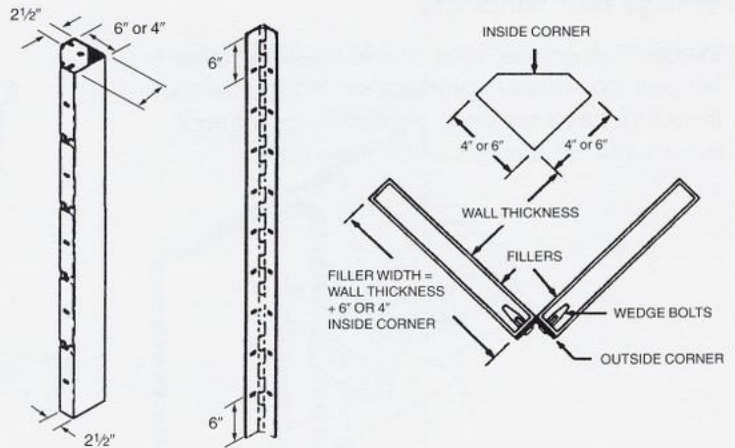


# MODULAR FORMING SYSTEM

## Square Corners

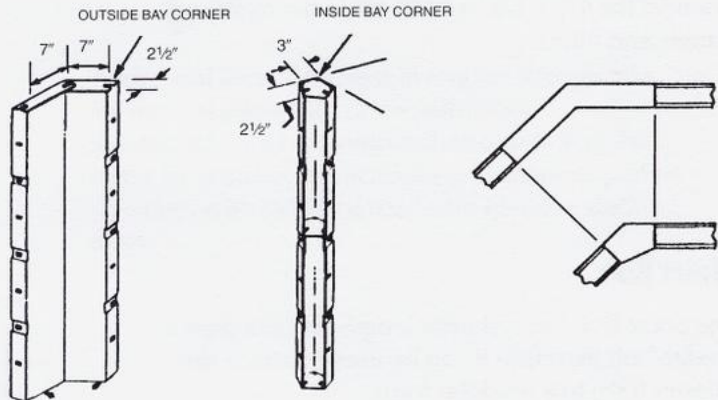
Reusable steel corners, built to precise tolerances, minimize errors by eliminating measuring, sawing and fitting. Both inside and outside Corners are available in five lengths and can be set with either end up or down reducing the time and labor required.

Corners are wedge-bolt connected to panels and fillers, eliminating the need for nailing or blocking. Unskilled labor quickly learns to handle corners efficiently.



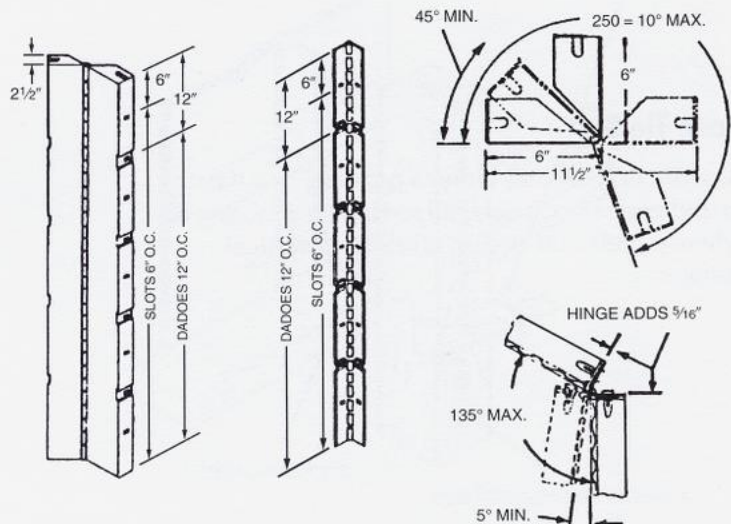
## Bay Corners

Standard 135 degree inside and outside bay corners simplify forming. Attach to Modular Forming panels and fillers with wedge bolts for quick and easy assembly. Inside and outside Bay Corners are available in five standard lengths.



## Hinged Corners

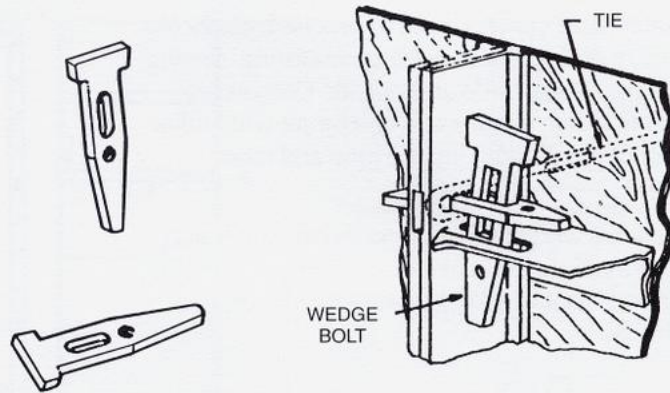
In most wall applications, inside Hinged Corners are used opposite outside Hinged Corners to achieve the desired angle. The inside Hinged Corner may be used to form inside corners down to 45 degrees. The outside Hinged Corner will form outside corners from 135 down to 5 degrees. Filler sizes need to make up dimension will vary depending on the angle being formed.



# MODULAR FORMING SYSTEM

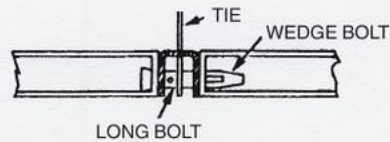
## Wedge Bolt Simplicity

Wedge Bolt connections enable unskilled labor to become consistently productive. No special tool required, just a hammer. Wedge Bolts connect panels and capture ties at the same time.



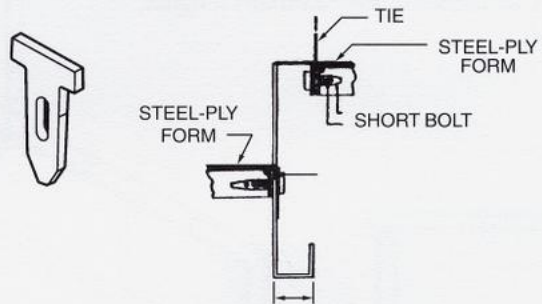
## Long Bolt

The Long Bolt similar to the wedge bolt is used to connect the 1", 1 1/2" and 2" steel filler to adjust panels and fillers.



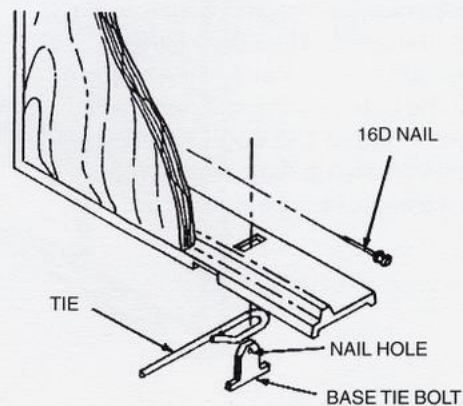
## Short Bolt

The Short Bolt has a shorter length and slot than a wedge bolt therefore it can be used to attach the pilaster form to a modular form.



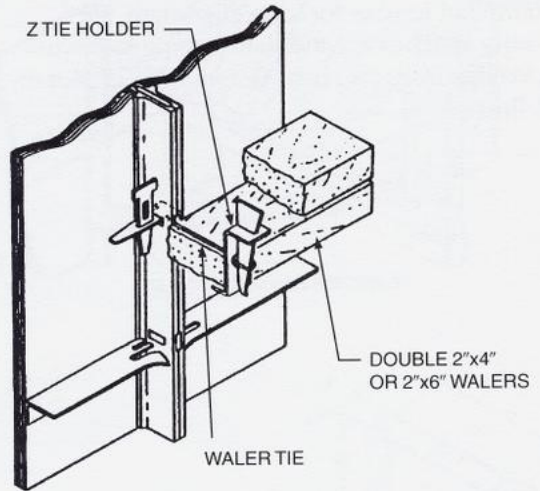
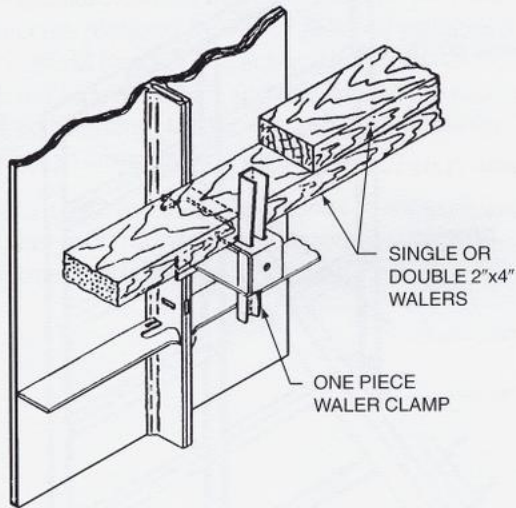
## Base Tie Bolt

Base Tie Bolt secures either a panel tie or a flat tie to an end rail or a side rail resting on a footing or where panels butt against an existing vertical surface.



# MODULAR FORMING SYSTEM

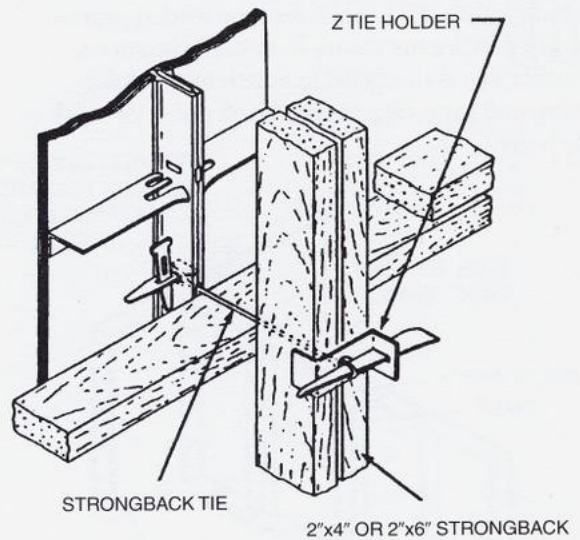
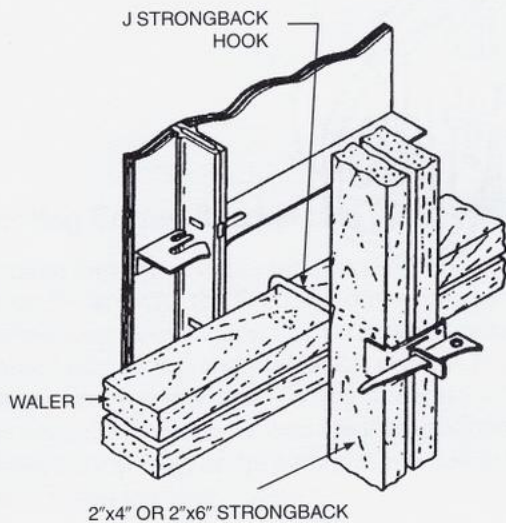
## Waler Attachment Methods



Standard 2x4 or 2x6 lumber can be used as walers for the Modular Forming System. Using specially designed hardware, the walers are quickly fastened to bring formwork into alignment. Only one row of walers is required per tier of forms for handset applications (8 foot maximum spacing).

Additional tiers of forms will require strongbacks for vertical alignment of the formwork. Strongbacks are only required on one side of the forms for handset applications and attach to panels or walers with standard hardware to make stacking easy.

## Strongback Attachment Methods

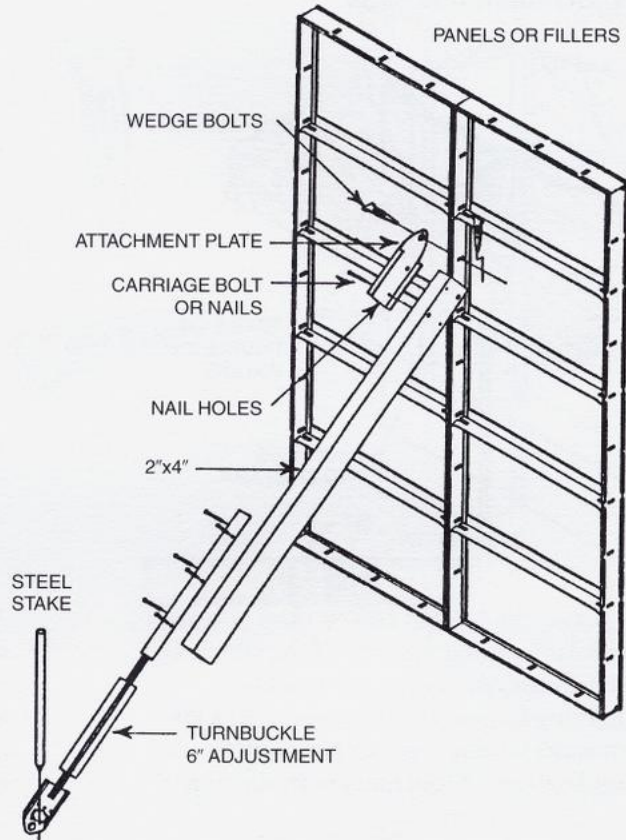




# MODULAR FORMING SYSTEM

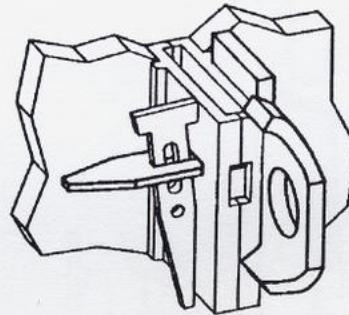
## Aligning

Attachment plates and turnbuckles are used with standard 2x4 lumber for form alignment. The assembly attaches to Modular Forming formwork with Wedge Bolts and provides up to 6" of plumb-ing adjustment.



## Safety Eye

Climbing formwork is not a recommended procedure, but may be necessary in certain situations. The Safety Eye is designed to attach to Modular Forming and provide a secure hook point for work safety belts.

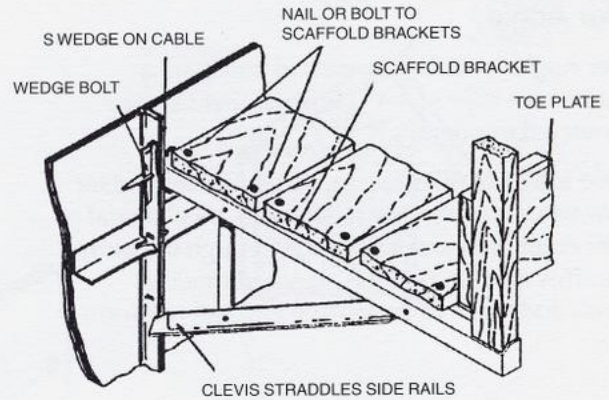


# MODULAR FORMING SYSTEM

## Scaffold Bracket

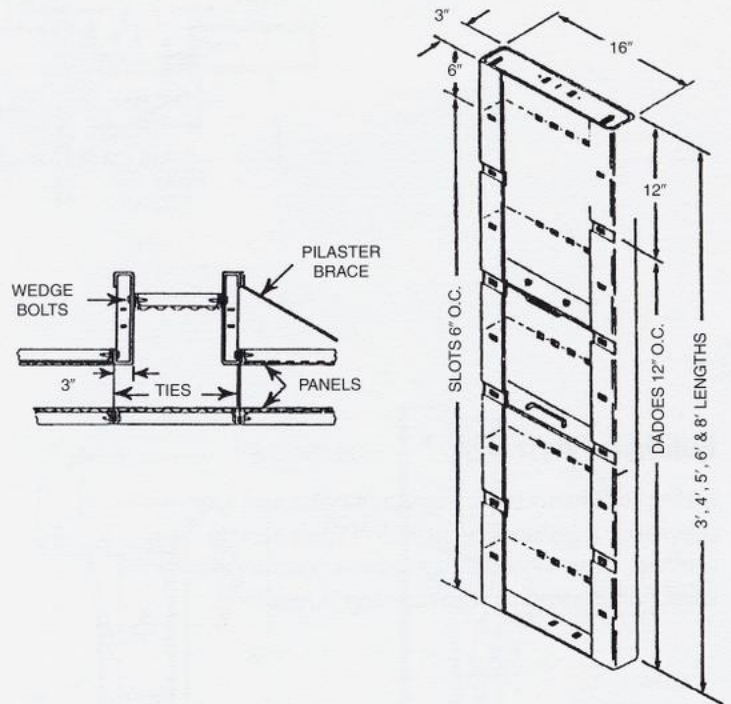
The Modular Scaffold Bracket assembly provides a safe access platform for above grade applications. The Scaffold Bracket is quickly attached to formwork with a wedge bolt and the attached S-Wedge. Scaffold planking, toe boards and guard rails (by contractor) complete the work platform.

Note: Do not use Scaffold Bracket to support concrete soffit forms or for temporary storage of equipment and material.



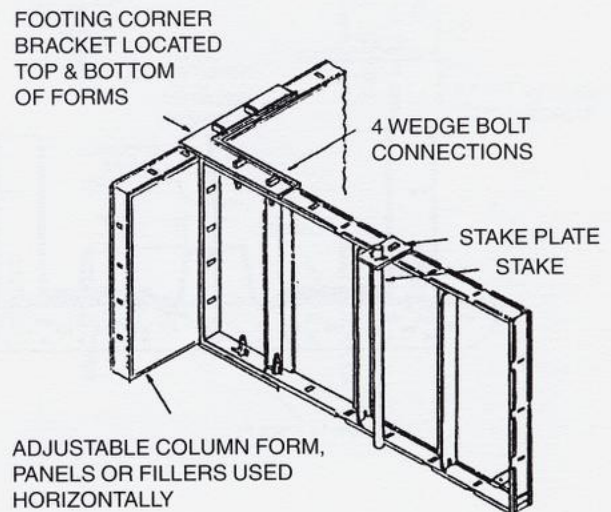
## Pilaster Forms

Pilasters of less than 12 inches are formed quickly and easily using the Modular Forming System and Pilaster Forms. The Pilaster Form eliminates the need for using inside and outside corners with specific filler sizes. Pilaster Forms can be used to form concrete pilasters from 1 to 12 inches deep in 1 inch increments.



## Footing Corner Bracket and Stake Plate

Footing forming with the modular Forming System is made easy with the Footing Corner Bracket and Stake Plate. Two Footing Corner Brackets at each corner, one on top and one on the bottom, hold the panels firmly and at virtually any dimension (2" increments). The Stake Plates are then positioned along the top edge of the panels as needed to hold Steel Stakes in place.

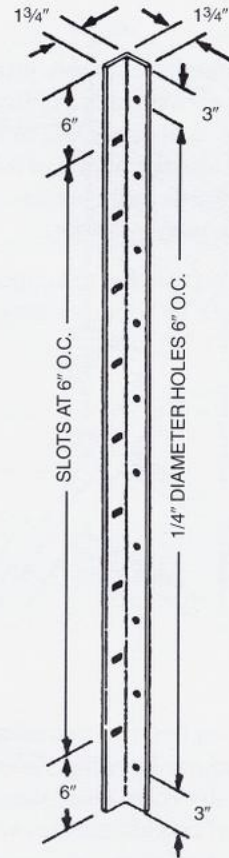
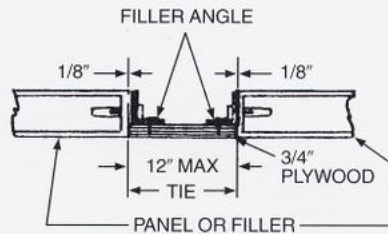


# MODULAR FORMING SYSTEM

## Filler Angle

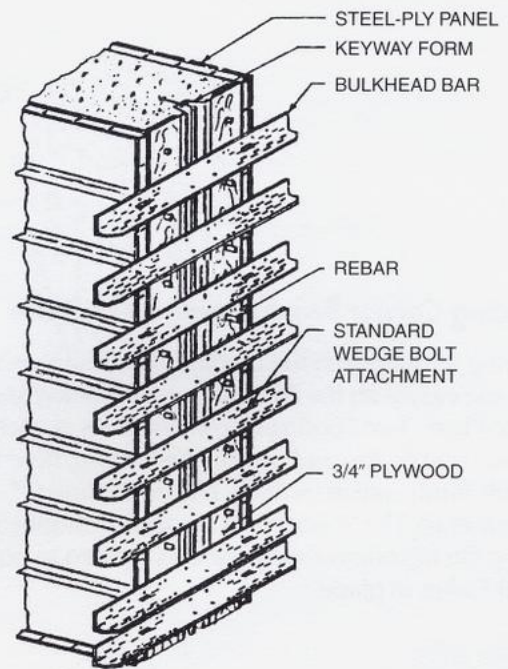
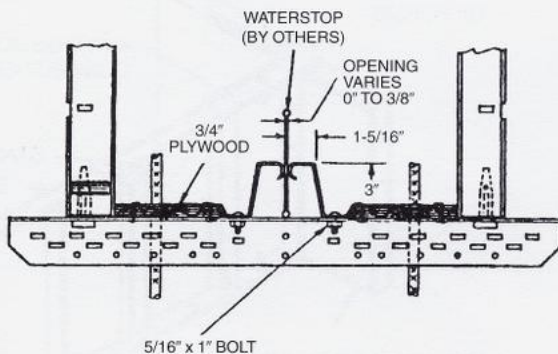
Filler Angles provide a means to construct a custom size filler of 3/4" plywood that can be connected to siderails.

These job-built filler pieces are recommended for areas where reinforcing steel, pipes, mechanical or other equipment must protrude through the form face. This method protects standard modular panels and fillers from damage and extends form life.



## Bulkhead Assembly

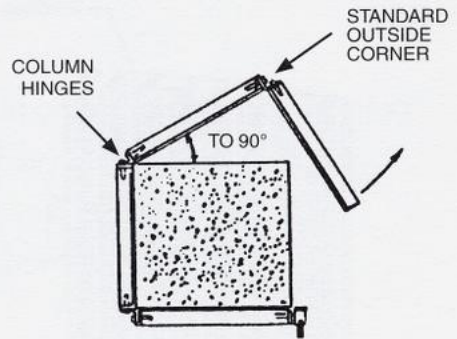
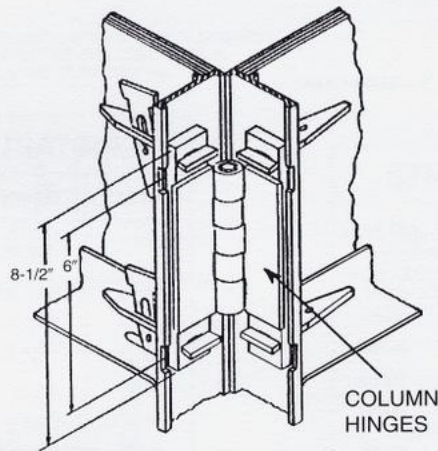
Using Bulkhead Bars, Keyway Forms and 3/4" plywood, a secure construction joint can be formed. This assembly can also accommodate steel penetrations and waterstop if required.



# MODULAR FORMING SYSTEM

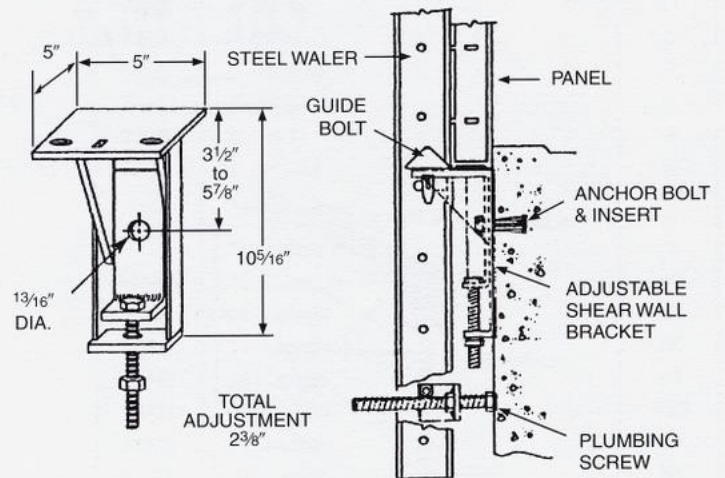
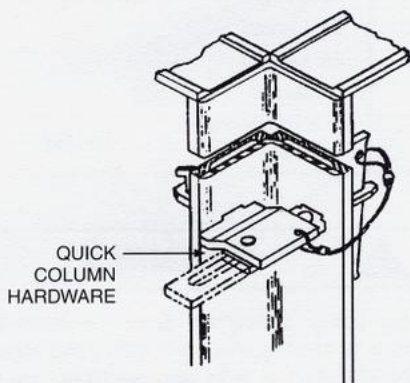
## Column Hardware

Column Hinges are used to hinge forms during setting and stripping. Quick Column Hardware, used opposite the Column Hinges, allows the forms to be opened with hardware still in place. Used together, this column hardware speeds column production and increases labor productivity.



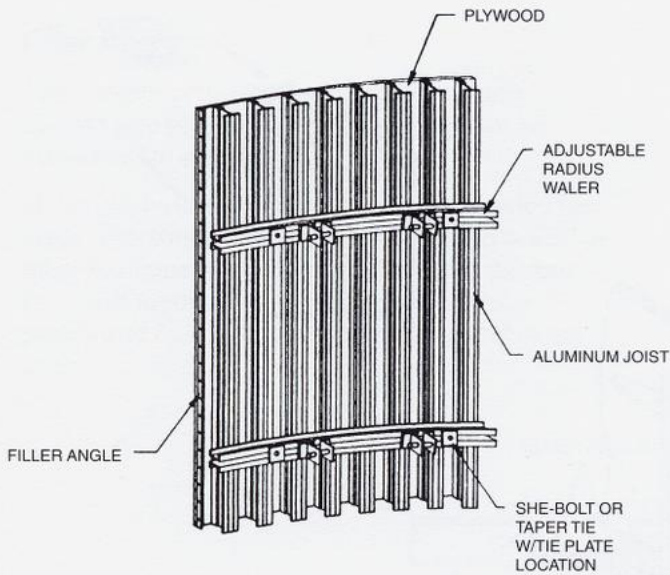
## Adjustable Shear Wall Bracket

The Adjustable Shear Wall Bracket, when used with the appropriate anchor, will support modular formwork in multiple lift applications. The bracket allows for 2 3/8" vertical adjustment for formwork positioning.

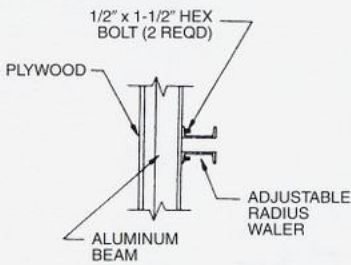


# STEEL ADJUSTABLE RADIUS WALER

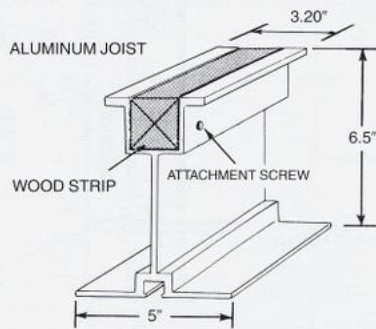
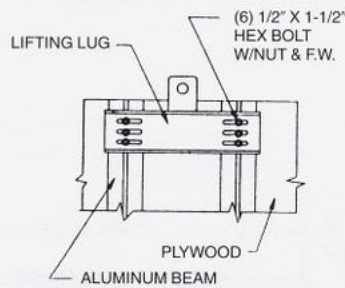
- Radius Adjusts from 30 ft. to 100 ft.
- Manufactured to Any Length
- Heavy Load Capacity
- Fewer Ties
- Saves Labor



## BEAM ATTACHMENT DETAIL



## LIFTING LUG DETAIL



Note: Place form plywood with its grain running at 90° to the joists, and stagger plywood sheets

## ADJUSTABLE RADIUS WALERS SYSTEM

Part No.	Description	Weight
<b>Walers made to size</b>		
8466	6'6" Adjustable Radius Waler (IS)	125 lbs.
8476	7'6" Adjustable Radius Waler (IS)	149
8479	7'9" Adjustable Radius Waler(OS)	150
8455	Adjustable RAD Wall Assembly Plate	5
8456	Lifting Lug	4
955	1/2 x 1 1/2 Alum. Beam HD Bolt Assembly	0-16
<b>Filler Angles</b>		
7826	8' (Pink)	11
7626	6' (Yellow)	8
7526	5' (Green)	7
7426	4' (Blue)	4
7326	3' (Red)	4
7209	2' (White)	4
<b>Aluminum Beams (6 1/2") (Joist)</b>		
	Per Linear Foot	4
106AB	10'6" Length	42
12AB	12' Length	48
14AB	14' Length	56
16AB	16' Length	64
18AB	18' Length	72
21AB	21' Length	84
24AB	24' Length	96
"A"	A-Clamps	.1
IS = Inside OS = Outside		

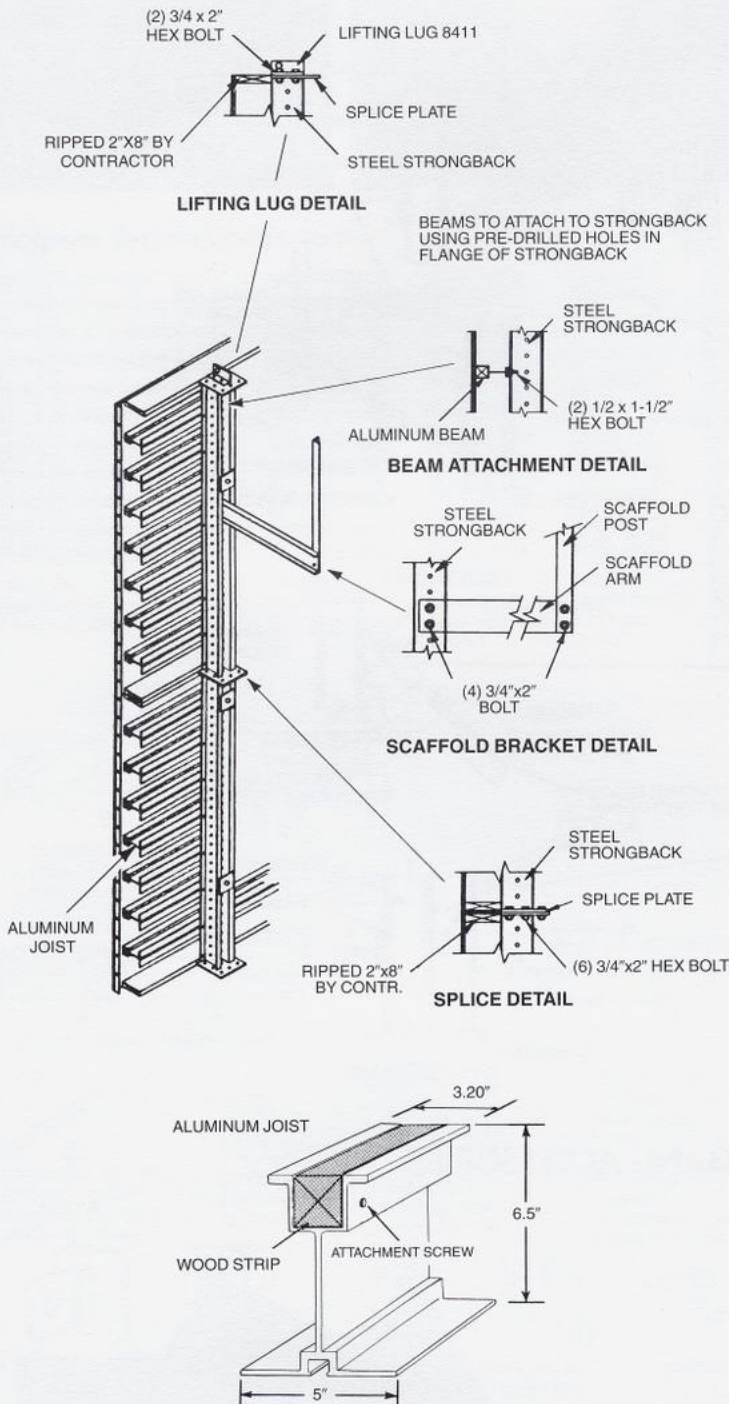
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Scaffolding & Equipment

**⚠ WARNING ⚠**

Before using, putting up or taking down scaffolding, forming, or shoring check with your boss, supplier, or call 1-800-321-3150 as to its safe use. There are many ways you can be hurt or killed using scaffolding, forming, or shoring. Use all equipment in accordance with safety design requirements and standards.

**SAFETY MUST COME FIRST!**

# STEEL WALL GANG & STEEL SUPERFORM STRONGBACKS



- Add or Remove Vertical Section
- Heavy Load Capacity
- Fewer Ties
- Labor Saver

## STEEL SUPERFORM STRONGBACK

Part No.	Description	Weight
8401	1' x 6" Superform Strongback	28 lbs.
8402	2' x 6" Superform Strongback	52
8404	4' x 6" Superform Strongback	84
8406	6' x 6" Superform Strongback	121
8408	8' x 6" Superform Strongback	152
8410	1/2 x 1 1/2 Alum. Beam HD Bolt Assembly	33
8411	Superform Scaffold Bracket	4
950	Superform Lifting Lug	.46
954	3/4" x 2" Bolt Assy. (Superform)	.24
Filler Angles		
7826	8' (Pink)	11
7626	6' (Yellow)	8
7526	5' (Green)	7
7426	4' (Blue)	5
7326	3' (Red)	4
7209	2' (White)	4
Aluminum Beams (6 1/2") (Joist)		
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Note: Place form plywood with its grain running at 90° to the joists, and stagger plywood sheets

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Scaffolding & Equipment



### WARNING



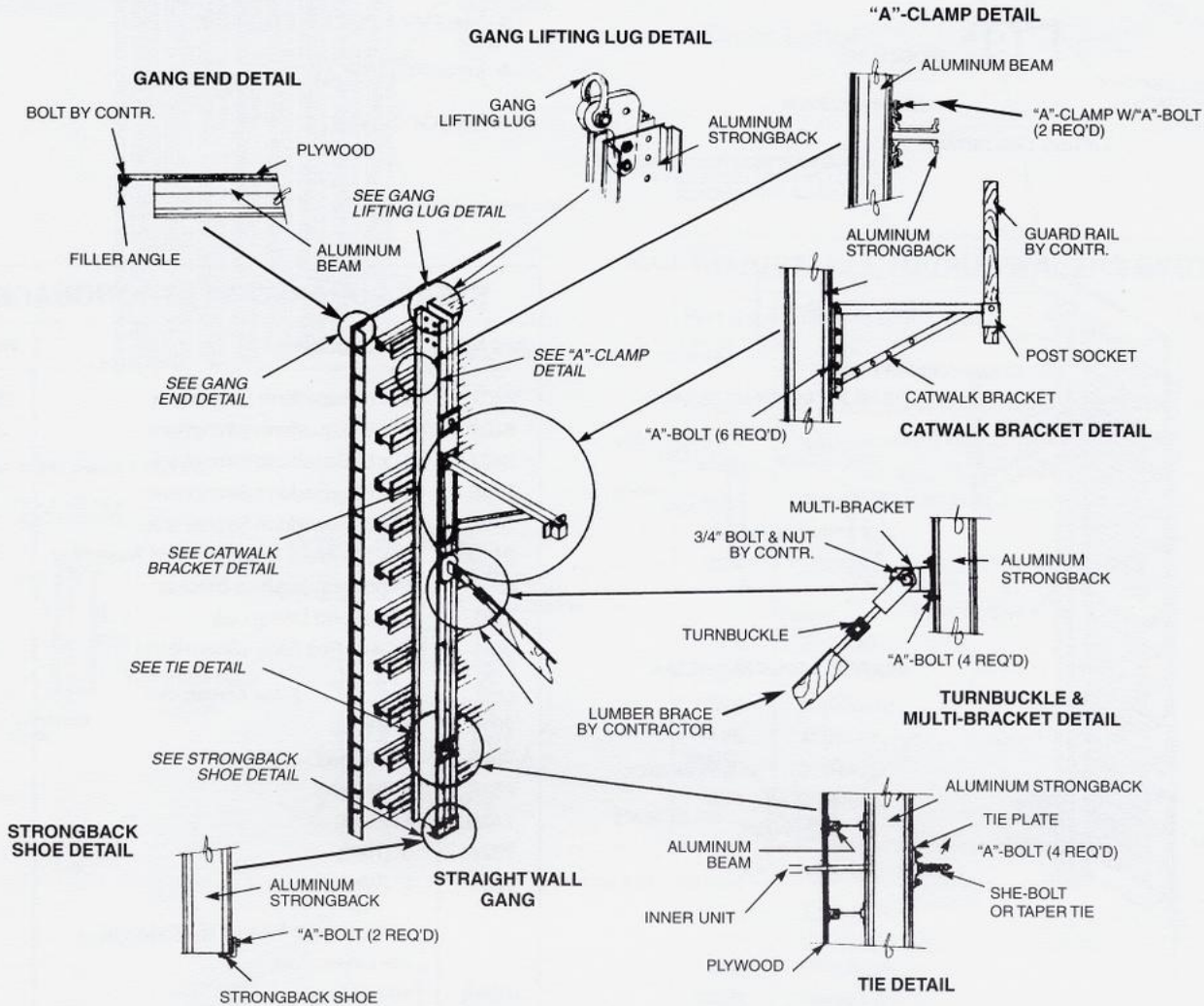
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# ALUMINUM GANG FORM SYSTEMS

- Lightweight
- Heavy Load Capacity
- Labor Saving
- Rent Components
- Fewer Ties than Conventional Forms
- Custom Design & Layout

## STRAIGHT WALL GANG



## CIRCULAR WALL GANG ACCESSORIES

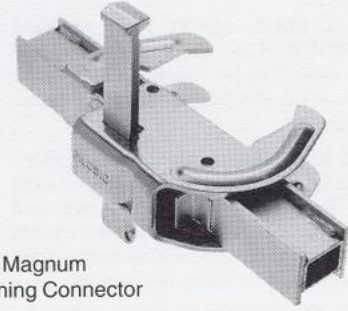
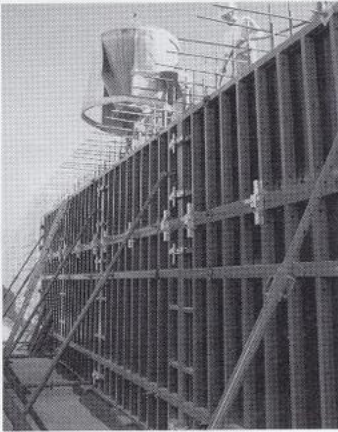


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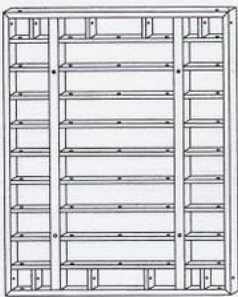
**SAFETY MUST COME FIRST!**

# MAGNUM LARGE PANEL FORMING SYSTEM



The Magnum Aligning Connector

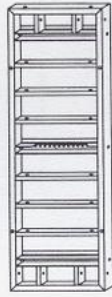
## Magnum System Components



21533241  
240x300 Panel  
7'10½" x 9'10⅛"



21533120  
120x300 Panel  
3'11¼" x 9'10⅛"



21533101  
Adjustable Panel  
3'3⅜" x  
9'10⅛"



21533090  
90x300 Panel  
2'11⅞" x  
9'10⅛"



21533060  
60x300 Panel  
1'11⅝" x  
9'10⅛"



A 21533356 (30+30)x300 Inner corner panel, (11¾"+11¾") x 9'10⅛"



B 21533360 (30+30)x300 Inner corner panel with hinge



C 21533370 (30+30)x300 Outer corner panel with hinge



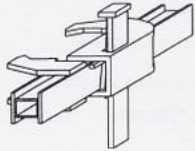
D 21534040 40x300 Infill panel, 1'3¾" x 9'10⅛"



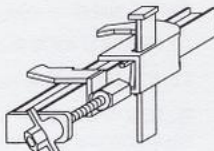
E 21534000 5x300 Infill bar, 1'3½" x 9'10⅛"



F 21534010 10x300 Infill bar, 3'15⅛" x 9'10⅛"

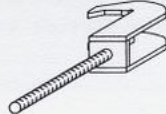


21535010  
Magnum Aligning  
Connector

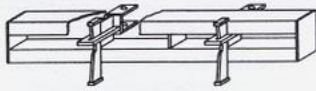


21535020  
Magnum Adjustable  
Aligning Connector

21535040  
Connecting Device  
for outer corners



21591005  
Working Bracket



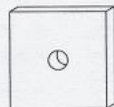
21535030 Magnum Aligning Device



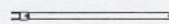
S34 Tie-Rod, 29/32" Ø  
21585037 1'2¾" L  
21585075 2'5'17/32" L  
21585100 3'3⅜" L



21585900  
S34 Wing nut  
for Tie-Rod



21585930  
Tie-Rod Plate  
4¾" x 4¾" x 5/8"



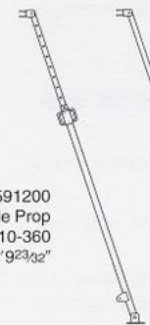
21591210  
Fixed Prop Arm  
3'7⅝"



21591205  
Adjustable Prop Arm  
3'7⅝" to 4'11'1/16"



21537100  
Crane hook



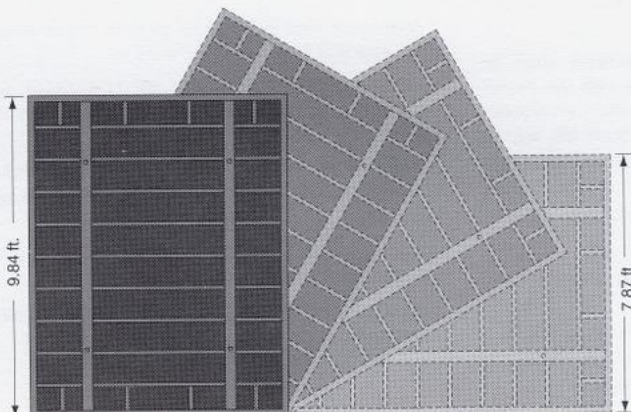
21591200  
Adjustable Prop  
210-360  
6'10'1/16" - 11'9'23/32"



21591201  
Adjustable Prop  
300-460  
9'10⅛" - 15'1'3/32"



21591300  
Adjustable Prop  
530-700  
17'4'21/32" - 22'11'19/32"



Magnum panels are designed with just 2 ties in height, one every 19.3 sq. ft. of surface, to reduce the number of pieces and thereby shorten erection and dismantling time. The formwork can create any casting height, in 18 increments, using just 5 basic system element.

Just one operation connects and aligns panels.

◀ A large surface base panel (8.6 sq. yards erected) can be set for either horizontal or vertical use.



## GENERAL GUIDELINES

**POST THESE SCAFFOLDING SAFETY GUIDELINES** in a conspicuous place and be sure that all persons who erect, dismantle or use scaffolding are aware of them.

**FOLLOW ALL STATE, LOCAL AND FEDERAL CODES, ORDINANCES AND REGULATIONS** pertaining to scaffolding because they may be more restrictive. For example, height or width requirements may vary.

**SURVEY THE JOB SITE** — A survey shall be made of the job site for hazards, such as untamped earth fills, ditches, debris, high tension wires, unguarded openings, and other hazardous conditions created by other trades. These conditions shall be corrected or avoided as noted in the following sections.

**INSPECT ALL EQUIPMENT BEFORE USING** — Never use any equipment that is damaged or defective in any way.

**KEEP ALL EQUIPMENT IN GOOD REPAIR** — Avoid using corroded equipment — the strength of corroded equipment is not known.

**INSPECT ERECTED SCAFFOLDS DAILY** — or at the beginning of every shift to be sure that they are maintained in safe condition.

**NEVER USE EQUIPMENT FOR PURPOSES OR IN WAYS FOR WHICH IT WAS NOT INTENDED.**

**REPORT ANY UNSAFE CONDITION. NEVER TAKE CHANCES** — Do not work on scaffolds if your physical condition is such that you feel dizzy or unsteady in any way.

**WORKING UNDER THE INFLUENCE OF ALCOHOL OR ILLEGAL DRUGS IS STRICTLY PROHIBITED.**

**CONSULT YOUR SCAFFOLDING SUPPLIER — NEVER TAKE CHANCES** — Consult manuals and instructions provided by the supplier; scaffolding is his business

## GUIDELINES FOR ERECTION AND USE OF SCAFFOLDS

**A. PROVIDE ADEQUATE SILLS** for scaffold posts and use base plates.

**B. USE ADJUSTING SCREWS** or other approved conditions.

**C. PLUMB AND LEVEL ALL SCAFFOLDS** as the erection proceeds. Do not force braces to fit—level the scaffold until proper fit can be made easily.

**D. BRACING** Each frame or panel shall be braced by horizontal bracing. Cross bracing, diagonal bracing or any combination thereof for securing vertical members together laterally. All brace connections shall be made secure, in accordance with manufacturers' recommendations.

**E. DO NOT CLIMB CROSS BRACES** Use only an access (climbing) ladder, access steps, frame designed to be climbed or equivalent safe access to the scaffold.

**F. TIE RUNNING SCAFFOLD TO WALL** or structure when the height exceeds four (4) times the minimum scaffold base dimension. The first vertical and longitudinal tie shall be placed at this point. Vertical ties shall be repeated at intervals not greater than 26 feet. Longitudinal ties shall be placed at each end and at intervals not greater than 30 feet.

Ties must prevent the scaffold from tipping into or away from the wall or structure.

## SAFETY GUIDELINES

### as recommended by SCAFFOLDING, SHORING & FORMING INSTITUTE

It shall be the responsibility of all employers and employees to read and comply with the following common sense guidelines which are designed to promote safety in the erecting and dismantling of scaffolds. These guidelines do not purport to be all-inclusive nor to supplant or replace other additional safety and precautionary measures to cover usual or unusual conditions. Local, State, or Federal statute or regulations shall supersede these guidelines if there is a conflict and it is the responsibility of each employee to comply.

**G. WHEN SCAFFOLDS ARE TO BE PARTIALLY OR FULLY ENCLOSED**, specific precautions must be taken to assure frequency and adequacy of ties attaching the scaffolding to the building due to increased load conditions resulting from effects of wind and weather. The scaffolding components to which the ties are attached must also be checked for additional loads.

**H. WHEN FREE STANDING SCAFFOLD TOWERS** exceed four times their minimum base dimension vertically, they must be restrained from tipping.

**I. DO NOT ERECT SCAFFOLDS NEAR ELECTRICAL POWER LINES** unless proper precautions are taken. Consult the power service company for advice.

**J. DO NOT USE LADDERS** or makeshift devices on top of scaffolds to increase the height.

**K. DO NOT EXCEED MANUFACTURERS' RECOMMENDED LOAD RATING.**

**L. EQUIP AND MAINTAIN ALL PLATFORMS** with proper guardrails, midrails and toeboards along all open sides and ends of scaffold platforms.

**M. ALL BRACKETS** shall be seated correctly with side brackets parallel to the frames and end brackets at 90 degrees to the frames. Brackets shall not be bent or twisted from normal position. Brackets (except mobile brackets designed to carry materials) are to be used as work platforms only and shall not be used for storage of material or equipment. When brackets are used, the scaffold shall be tied to the structure or otherwise restrained to prevent tipping.

**N. ALL SCAFFOLDING ACCESSORIES** shall be used and installed in accordance with the manufacturers' recommended procedure. Accessories shall not be altered in the field. Scaffolds, frames and their components of various manufacturers shall not be intermixed.

**O. FOR PLANKING, THE FOLLOWING GUIDELINES APPLY:**

1. Use only lumber that is properly inspected and graded as scaffold plank.
2. Planking shall have at least 12" of overlap and extend 6" beyond center of support, or be cleated at both ends to prevent sliding off supports.

3. Fabricated scaffold planks and platforms, unless created or restrained by hooks, shall extend over their end supports not less than 6 inches nor more than 12 inches.

4. Secure plank to scaffold when necessary.

**P. FOR ROLLING SCAFFOLDS THE FOLLOWING ADDITIONAL GUIDELINES APPLY.**

1. **CASTERS WITH PLAIN STEMS** shall be attached to the panel or adjustment screw by pins or other suitable means.

2. **DO NOT EXTEND ADJUSTING SCREWS ON ROLLING SCAFFOLDS MORE THAN 12 INCHES.**

3. **WHEELS OR CASTERS** shall be provided with a locking device and kept locked during erection and dismantling or any time scaffolds are not being moved.

4. **SECURE OR REMOVE ALL MATERIAL AND EQUIPMENT** from platform before moving scaffold.

5. **USE HORIZONTAL DIAGONAL BRACING** near the bottom and at 20 foot intervals measured from the rolling surface.

6. **DO NOT USE** brackets or other platform extensions without consideration of overturning effect.

7. **THE HEIGHT OF A ROLLING SCAFFOLD** excluding its uppermost guardrails, must not exceed four times its smallest base dimension unless it is stabilized by an engineered counterweight system or some other equivalent means.

8. **CLEAT OR SECURE ALL PLANKS.**

9. **DO NOT ATTEMPT TO MOVE A ROLLING SCAFFOLD WITHOUT SUFFICIENT HELP** — watch out for holes in floor and overhead obstructions — stabilize against tipping.

10. **DO NOT RIDE ROLLING SCAFFOLDS.**

11. **JOINTS** shall be restrained from separation

**Q. FOR "PUTLOGS" AND "TRUSSES"** the following additional guidelines apply.

1. **DO NOT CANTILEVER OR EXTEND PUTLOGS/TRUSSES** as side brackets without thorough consideration for loads to be applied.

2. **PUTLOGS/TRUSSES SHOULD BE EXTENDED AT LEAST 6 inches** beyond point of support.

3. **PLACE RECOMMENDED BRACING BETWEEN PUTLOGS/TRUSSES** when the span of putlogs/trusses more than 12 feet.

**R. WHEN DISMANTLING SCAFFOLDING THE FOLLOWING ADDITIONAL GUIDELINES APPLY:**

1. **CHECK TO SEE IF SCAFFOLDING HAS BEEN STRUCTURALLY ALTERED** in any way which would make it unsafe, and if so, reconstruct where necessary before commencing with dismantling procedures.

2. **VISUALLY INSPECT PLANK** prior to dismantling to be sure that they are safe to work on.

3. **COMPONENTS SHOULD BE LOWERED** as soon as dismantled in a safe manner so as to protect personnel below.

4. **DO NOT ACCUMULATE EXCESS COMPONENTS OR EQUIPMENT** on the level being dismantled.

5. **DISMANTLED EQUIPMENT** should be stockpiled in an orderly manner.

**S. FOLLOW ERECTION PROCEDURES AND USE MANUALS.**

# Rentals Sales Erection

## Scaffolding

Standard End Frames  
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Wedgelok™ System  
FasTube®  
Exprescaff®

## Speciality Trade Tools

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Chimney Scaffolds  
Mortar Board Stands  
Sheet Material Dollies  
Speed-Scaff™  
Casters  
Trash Chutes

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Hi-Load® Frames  
Shore "X"® Frames  
Shore "X"® 25 Kip frames  
Aluminum Joists  
WacoMax®

## Forming

Modular Forms  
Magnum Large Panel Forms  
Aluminum Gang Forms  
Heavy Duty Wall Ties  
Wacote® Form Oil  
Concrete Accessories



## WARNING

Before using, putting up or taking down scaffolding or shoring, check with your boss as to its safe use. There are many ways you can be hurt or killed using scaffolding. Use all equipment in accordance with safety design requirements and standards.

**SAFETY MUST COME FIRST!**

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