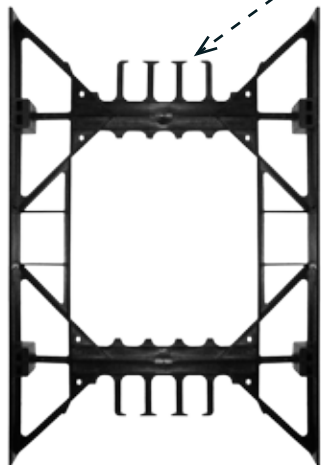
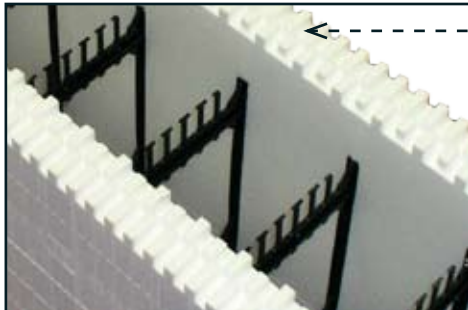


# BUILD BLOCK INSULATING CONCRETE FORMS


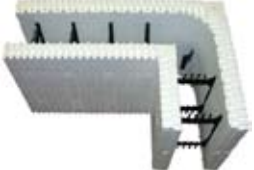

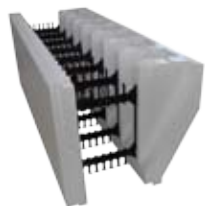
## 1.1 BuildBlock Features

Constructing with BuildBlock will not only save you many hours during the building process but will be an enjoyable experience. The many features built into the BuildBlock forms are the reasons for the efficiency and ease of use.




- ◆ **Completely reversible** (no top or bottom, left or right)
- ◆ **Interlocking connections** have more surface area to hold blocks together without the use of adhesive foam in most cases
- ◆ **Longer web fingers** for securing two pieces of rebar in each row of fingers, helping to eliminate void problems
- ◆ **Molded-in high-density plastic webs** (also referred to as "ties"); Sheetrock and finishes are screwed into the 1½" wide web flange.
- ◆ **Heavy-duty attachment points** (over 450 lbs. screw pull-out strength) built into the face of every web; used to attach vertical bracing during construction, exterior/interior finishes, and cabinetry
- ◆ **Longer corners** than the industry standard require less corner bracing. This feature results in quicker installations and walls that are more plumb and straight.
- ◆ **Patented corner web** provides **corner attach points** for securing sheet rock, siding, and other finishes. The corner holds the vertical rebar up to 5/8" diameter; PVC schedule 40 (3/4" diameter) pipe can be placed down the corner hole located in the outside foam for additional support and to attach finishes to as well.
- ◆ Block designed with **1" repeating pattern and cut lines**, giving you a factory edge with each cut while wasting very little material. In comparison, competing blocks have 2, 4, 6, or 12 inch repeat patterns thus increasing their waste substantially.
- ◆ **Horizontal cut lines every 2" vertically**, eliminating the use of a level when installing window and door bucks
- ◆ **Built-in tape measure** across the block face; saves you the trouble of pulling out a tape measure every time you need to cut a block
- ◆ **Highly visible web markings** make sheet rock and finish attachment easy.

## 1.2 Product Specification Overview

		4" Products	6" Products	8" Products
<b>Straight</b> 	<b>SPECIFICATIONS</b>	<b>4" STRAIGHT*</b>	<b>6" STRAIGHT</b>	<b>8" STRAIGHT</b>
	LENGTH	48"	48"	48"
	WIDTH	9" (4" Core)	11" (6" Core)	13" (8" Core)
	HEIGHT	16"	16"	16"
	RETURN	NA	NA	NA
	CONCRETE VOLUME	.065844 cu. yd.	.098765 cu. yd.	.131687 cu. yd.
	SURFACE AREA	5.33 sq. ft.	5.33 sq. ft.	5.33 sq. ft.
	EPS DIMENSION	2½" each panel	2½" each panel	2½" each panel
	QTY PER BUNDLE	12	12	12
	PRODUCT ID	BB-400	BB-600	BB-800
<b>90° Corner</b> 	<b>SPECIFICATIONS</b>	<b>4" 90° CORNER</b>	<b>6" 90° CORNER</b>	<b>8" 90° CORNER</b>
	LENGTH	31" (ext.) / 22" (int.)	33" (ext.) / 22" (int.)	35" (ext.) / 22" (int.)
	WIDTH	9" (4" Core)	11" (6" Core)	13" (8" Core)
	HEIGHT	16"	16"	16"
	RETURN	19" (ext.) / 10" (int.)	21" (ext.) / 10" (int.)	23" (ext.) / 10" (int.)
	CONCRETE VOLUME	.054574 cu. yd.	.086528 cu. yd.	.121517 cu. yd.
	SURFACE AREA	5.56 sq. ft.	6.00 sq. ft.	6.44 sq. ft.
	EPS DIMENSION	2½" each panel	2½" each panel	2½" each panel
	QTY PER BUNDLE	12	12	12
	PRODUCT ID	BB-490	BB-690	BB-890
<b>45° Corner</b> 	<b>SPECIFICATIONS</b>	<b>4" 45° CORNER</b>	<b>6" 45° CORNER</b>	<b>8" 45° CORNER</b>
	LENGTH	28" (ext.) / 24.272" (int.)	28" (ext.) / 23.444" (int.)	28" (ext.) / 22.615" (int.)
	WIDTH	9" (4" Core)	11" (6" Core)	13" (8" Core)
	HEIGHT	16"	16"	16"
	RETURN	16" (ext.) / 12.272" (int.)	16" (ext.) / 11.444" (int.)	16" (ext.) / 10.615" (int.)
	CONCRETE VOLUME	.054985 cu. yd.	.080841 cu. yd.	.105425 cu. yd.
	SURFACE AREA	4.89 sq. ft.	4.89 sq. ft.	4.89 sq. ft.
	EPS DIMENSION	2½" each panel	2½" each panel	2½" each panel
	QTY PER BUNDLE	12	12	12
	PRODUCT ID	BB-445	BB-645	BB-845
<b>Brickledge</b> 	<b>SPECIFICATIONS</b>		<b>6" BRICKLEDGE</b>	<b>8" BRICKLEDGE</b>
	LENGTH		48"	48"
	BOTTOM WIDTH		11" (6" Core)	13" (8" Core)
	TOP WIDTH		16"	18"
	HEIGHT		16"	16"
	RETURN		NA	NA
	CONCRETE VOLUME		Entire block: 0.134148 Corbels only: 0.035556	Entire block: 0.167074 Corbels only: 0.035556
	SURFACE AREA		5.33 sq. ft.	5.33 sq. ft.
	EPS DIMENSION		2½" inside panel; 1" min. outside panel	2½" inside panel; 1" min. outside panel
	QTY PER BUNDLE		6	6
PRODUCT ID		BB-6BL	BB-8BL	

See next page for Double Taper Top forms.

## 1.2 Product Specification Overview, cont.

 Double Taper Top Straight Form	SPECIFICATIONS	6" STRAIGHT	8" STRAIGHT	
	LENGTH		48"	48"
	WIDTH		11" (6" Core)	13" (8" Core)
	HEIGHT		16"	16"
	RETURN		NA	NA
	CONCRETE VOLUME		.130128 cu. yd. Corbels only: .031363	.16305 cu. yd. Corbels only: .031363
	SURFACE AREA		5.33 sq. ft.	5.33 sq. ft.
	EPS DIMENSION		2½" each panel	2½" each panel
	QTY PER BUNDLE		12	12
	PRODUCT ID		BB-6DT	BB-8DT

## 1.3 Product Technical Details

Expanded Polystyrene density	1½ lbs/cu.ft.
Average thickness of EPS	2½" per panel (5" total)
R-value	R-21 foam value
Effective R-value (concrete, form R-value, air infiltration reduction, and thermal mass)	R-30 to R-52
Actual R-value per inch of EPS Foam	4.2/inch
Thermal Mass (form & concrete)	4" core: 47.5lbs/sq.ft. 6" core: 72lbs/sq.ft. 8" core: 96lbs/sq.ft.
K-Factor	.24/inch
Water absorption	- 3% (ASMC272)
Water vapor	0.56 perms per 2.5"
Sound class	52 with ½" sheet rock on inside
Fire wall	3 Hour Fire Rating on 6" Wall (Loading 5000lb. per lf. throughout test.) (Post test loading 12,000 lbs per lf. with no additional depletion.)
Concrete compressive strength	Recommended 3000 psi
Recommended concrete pouring temperature*	15°F to 120°F (-9°C to 49°C)*

\*Properly handled, specially formulated concrete can be poured at temperatures as low as -15°F (-26°C). Consult your ready mix company. **Important:** At temperatures below freezing, you must cover all exposed concrete with insulating material.

## 1.4 Transportation, Handling, and Storage of BuildBlock Forms

Proper transportation, handling, and storage of BuildBlock Forms are required to prevent damage and deterioration, to ensure the quality of the forms for the end user, and to honor warranty requirements.

### Transportation

BuildBlock forms are packaged by the manufacturer in sturdy bundles using corrugated trays and strapping. “Breaking” bundles and transporting unbundled forms voids the warranty on the unbundled forms. BuildBlock will not ship unbundled forms unless expressly requested by the customer and an additional fee applies to do so. BuildBlock highly recommends transporting bundles of forms in an **enclosed** trailer. Use of an open flat-bed trailer is not recommended and may result in damage which is not covered by the manufacturer’s warranty. If using an open trailer, position forms so that wind travels through the cavities, carefully position strapping to avoid damage to forms, and cover the load with a tarp, if possible. When accepting a shipment of forms, the customer should inspect each bundle. In the unlikely event of an issue, the **customer must note the damage on the Bill of Lading** when signing. Customer should then contact BuildBlock Quality Control immediately to begin the warranty process.

### Handling

The vast majority of form and web damage is a result of mishandling, not manufacturing issues. BuildBlock forms should be handled with care to prevent damage to the EPS material (especially the connection grid) and the plastic webs. If using a forklift be especially careful not to damage webs when lifting bundles. A forklift is typically not required. Bundles can be easily carried by one or two people. A 2x4 or conduit pipe may be placed through bundles and used as handles.

### Storage

Secure interior warehouse storage is ideal. Storing forms outside for extended periods of time may result in damage or deterioration by weather elements, insects (especially in termite infested areas), or rodents. Keep in mind that forms are lightweight and easily blown around by wind. We recommend keeping forms in bundles until ready for use. Be careful to secure bundles if adverse weather is expected. If forms are stored outside for more than a few weeks, they should be covered and protected from UV (ultraviolet) rays. Prolonged exposure to UV rays causes yellowing (oxidation) of the EPS. Though this does not affect the integrity of the forms, you must clean the forms to remove the layer of oxidation prior to bonding anything to the surface (such as waterproofing or exterior finishes). After the forms have been installed and filled with concrete, this can easily be done using a stiff brush or power washer.

