

3.9 THE BUILDING PROCESS

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1. The first course defines your linear dimensions and one-half of any splicing pattern. The second course will complete your splicing pattern and will lock the blocks together.
2. When working on footings, walls are generally centered; while walls built on slabs are normally orientated to the outside edge.
3. The time and techniques needed to build each course depend on the type of structure, the number and dimensions of the openings. Certain features such as gables and arches will require more time and forethought.
4. Greenblock's 6", 8" 10" and 12" core blocks all have 2 $\frac{5}{8}$ " thick EPS panels on both the inside and outside.
5. Greenblock's 4", core panel blocks have 2" thick EPS panels on both the inside and outside.
6. For consistency and ease of construction, always cut on one of the cut lines located on either side of the block. Cut lines are 1" apart. Therefore when assembling your wall perimeters you should be within $\frac{1}{2}$ " +/- . By always cutting on a "cut line" you will ensure the interlocking nubs have proper alignment and seating. If exact dimensions are required you may cut off of the cut lines. This will usually cause the nubs not to line up, creating a vertical seam one place in that wall for the entire height. You may glue and brace this area as you build and/ or prior to the concrete pour to ensure seam stability.
7. Block offsets or vertical joints (not to be confused with vertical seams) should be staggered a minimum of 2 webs ($\frac{1}{4}$



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block) regardless of the height, length or shape of a wall. Greenblock's left and right corners were designed to set up the necessary ¼ block stagger automatically. In the event there is a joint with less than a 2 web offset, it should be reinforced with glue or strapping (1x3 or 1x4) on both sides to prevent any horizontal movement.

8. Bracing the outside corners is recommended.
9. Be sure to tap each block firmly onto the one below it. Tap firmly enough so there is no space between the two -- but not so hard as to compress the nubs on the one you are installing. You can check your progress after 4 or 5 courses, and again higher in the wall.
10. Being closer to actual block heights will minimize wall compressions and crowning during the concrete pour.



Reminder: When cutting a block, cut on the factory cut marks. Cutting anywhere else on the block will cause a stacked vertical seam. (stacked vertical seams will require strapping or gluing and may increase labor costs and time on the job.)



Reminder: While joints are staggered, webs should line up vertically (except in minimum splice areas) to facilitate requirements for inserting electrical and attachment of interior/ exterior finishes.

