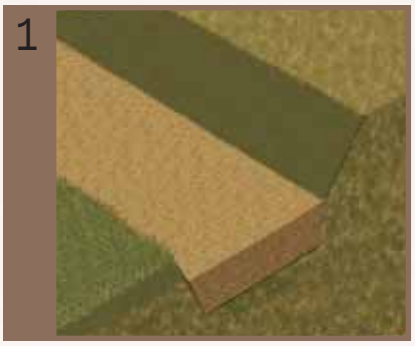
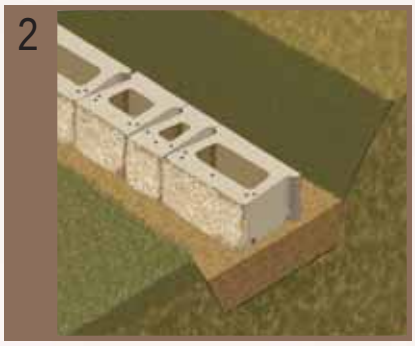
Installation Steps

Prepare the Base Leveling Pad



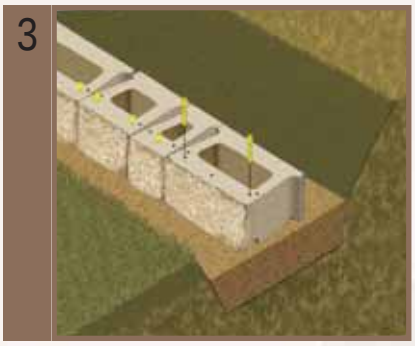
Remove all surface vegetation and debris. Do not use this material as backfill. After selecting the location and length of the wall, excavate the base trench to the designed width and depth. Start the leveling pad at the lowest elevation along wall alignment. Prepare the leveling pad base with 8 inches (200mm) of well-compacted granular fill (gravel, road base, or 1/2-inch to 3/4-inch (10 - 20mm) crushed stone). At required elevation changes in the leveling pad, step up in 8-inch (200mm) increments. Compact to 95% Standard Proctor or greater. Do not use PEA GRAVEL or SAND for leveling pad.

Install the Base Course



In a random arrangement, place the first course of Keystone Century Wall units end to end (with front corners touching) on the prepared base. The surface of the unit with the long groove (receiving channel) near the front face of the unit should be placed down and the open pin holes should face up, as shown. Make sure each unit is level - side to side and front to back. Leveling the first course is critical for accurate and acceptable results. For alignment of straight walls, use a string line positioned along the unit pin holes for accuracy. Minimum embedment of base course is 8 inches (200mm) below grade. Typical embedment is H/20 (Height/20).

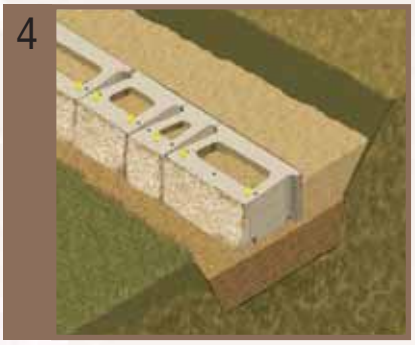
Insert the Fiberglass Pins



Place the shouldered fiberglass pins into the appropriate holes to achieve the desired setback position of the Keystone Century Wall units. Place pins in the front most hole(s) for near vertical alignment. Place pins in the rear most holes for an 8.8° setback per course.

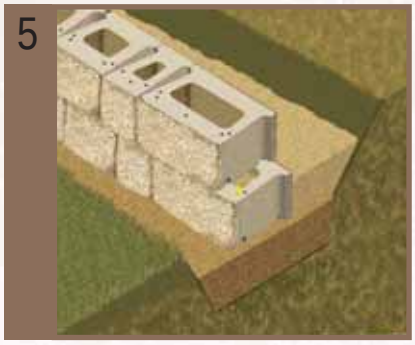
NOTE: The large unit has an “optional” pin hole for use in making sure small units above do not slip between pins.

Install Drainage Fill, & Backfill



Once the pins have been installed, provide 1/2-inch 3/4-inch (10-20mm) crushed stone drainage fill behind the units to a minimum distance behind the tail of 1 foot (300mm). Fill all open spaces between units and open cavities/cores with the same drainage material. Proceed to place backfill soil in maximum 8-inch (200mm) layers and compact to 95% Standard Proctor with the appropriate compaction equipment. Note: Do not run heavy (ride-on) compaction equipment within 3 feet (1m) of back of wall. Do not use PEA GRAVEL or SAND for drainage fill.

Install Additional Courses



Place the next course of Keystone Century Wall units over the fiberglass pins, fitting the pins into the long receiving channel recess in the units above. Push/pull the Century Wall units toward the face of the wall until the channel makes full contact with the pins. Each course should be built in a random arrangement with the only rule of thumb being to avoid vertical joint alignment. (i.e. stack bonding)

Capping the Wall

Clean off the last course of Keystone Century Wall in preparation for the cap or coping to finalize the wall. With units dry and clean, use Keystone Kapseal construction adhesive or the equivalent for a mechanical bond. Install the Keystone Century Wall capping unit, architectural precast concrete, or cut stone as a coping element. Cap may be flush or overhanging as required by aesthetics and design.

General Notes

- Verify unit type, size, weight availability by region. Unit depth (face to tail) may vary up to 1 inch ± (25mm) due to texture variations.
- Remove any excess concrete slag from pin holes and receiving channel as required to assemble wall. During manufacturing, some concrete crumbs may deposit in these areas and should be removed to permit pins to be placed in the appropriate holes and receiving channels.
- Cut or split units as required (with a mason saw, hydraulic break or chisel and hammer) wherever units need to be altered to allow construction to be finalized.
- When cutting concrete units, always wear safety goggles, gloves, and filter mask per manufacturer’s recommendations.