

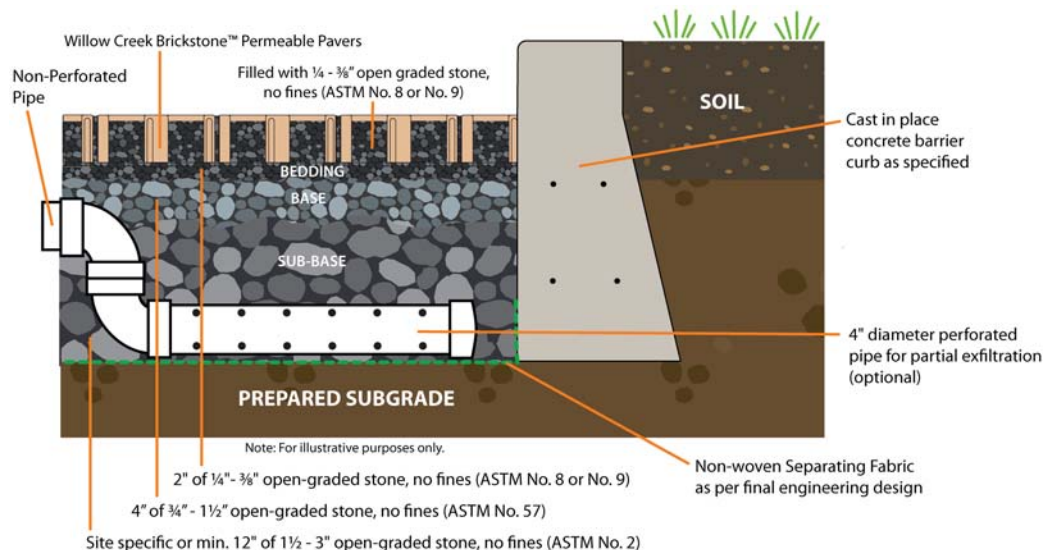
SECTION 32 14 13.19

PERMEABLE INTERLOCKING CONCRETE PAVERS

(1995 Master Format Section 02795)

Note: This guide specification is intended for use in the U.S. It describes construction of permeable interlocking concrete pavers on a permeable, open-graded crushed stone bedding layer (typically No. 8 stone). This layer is placed over an open graded-base (typically No. 57 stone) and subbase (typically No. 2 stone) consisting of a larger crushed stone. The pavers and bedding layer are placed over an open-graded crushed stone base with exfiltration to the soil subgrade. In low infiltration soils or installations with impermeable liners, some or all drainage is directed to an outlet via perforated drain pipes in the subbase. While this guide specification does not cover excavation, liners and drain pipes, notes are provided on these aspects.

The text below must be edited to suit specific project requirements. It should be reviewed by a qualified civil or geotechnical engineer, or landscape architect familiar with the site conditions. Edit this specification term as necessary to identify the design professional in the General Conditions of the Contract.



PART 1 GENERAL

1.01 SUMMARY

A. Section Includes

1. Permeable interlocking concrete pavers.
2. Crushed stone bedding material.
3. Open-graded subbase aggregate.
4. Open-graded base aggregate.
5. Bedding and joint/opening filler materials.
6. Edge restraints.
7. [Geotextiles].

B. Related Sections

1. Section []: Curbs.
2. Section []: [Stabilized] aggregate base.
3. Section []: [PVC] Drainage pipes.
4. Section []: Impermeable liner.
5. Section []: Edge restraints.
6. Section []: Drainage pipes and appurtenances.
7. Section []: Earthworks/excavation/soil compaction.

PART 1 GENERAL (Continued)

1.02 REFERENCES

- A. American Society for Testing and Materials (ASTM)
 - 1. C 67, Standard Test Methods for Sampling and Testing Concrete Masonry Units and Related Units.
 - 2. C 131, Standard Test Method for Resistance to Degradation of Small-Size Coarse Aggregate by Abrasion and Impact in the Los Angeles Machine.
 - 3. C 136, Method for Sieve Analysis for Fine and Coarse Aggregate.
 - 4. C 140, Test Methods for Sampling and Testing Brick and Structural Clay Tile, Section 8 – Freezing and Thawing.
 - 5. D 448, Standard Classification for Sizes of Aggregate for Road and Bridge Construction.
 - 6. C 936, Standard Specification for Solid Interlocking Concrete Pavers.
 - 7. C 979, Specification for Pigments for Integrally Colored Concrete.
 - 8. D 698, Test Methods for Moisture Density Relations of Soil and Soil Aggregate Mixtures Using a 5.5-lb (2.49 kg) Rammer and 12 in. (305 mm) drop.
 - 9. D 1557, Test Methods for Moisture Density Relations of Soil and Soil Aggregate Mixtures Using a 10-lb (4.54 kg) Rammer and 18 in. (457 mm) drop.
 - 10. D 1883, Test Method for California Bearing Ratio of Laboratory-Compacted Soils.
 - 11. D 4254, Standard Test Methods for Minimum Index Density and Unit Weight of Soils and Calculation of Relative Density.
- B. Interlocking Concrete Pavement Institute (ICPI)
 - 1. Permeable Interlocking Concrete Pavement manual.
 - 2. Permeable Design Pro software for hydrologic and structural design.

1.03 SUBMITTALS

- A. In accordance with Conditions of the Contract and Division 1 Submittal Procedures Section.
- B. Manufacturer's drawing and details: Indicate perimeter conditions, junction with other materials, expansion and control joints, paver [layout,] [patterns,] [color arrangement,] installation [and setting] details. Indicate layout, pattern, and relationship of paving joints to fixtures and project formed details.
- C. Minimum 3 lb (2 kg) samples of subbase, base and bedding materials.
- D. Sieve analysis of aggregates for base and bedding materials per ASTM C 136.
- E. Project specific or producer/manufacturer source test results for void ratio and bulk density of the base and sub-base aggregates.
- F. Soils report indicating density test reports, classification, and infiltration rate measured on-site under compacted conditions, and suitability for the intended project.
- G. Erosion and sediment control plan.
- H. [Stormwater management (quality and quantity) calculations; structural analysis for vehicular applications].
- I. Permeable concrete pavers:
 - 1. Manufacturer's product catalog sheets with specifications.
 - 2. [Four] representative full-size samples of each paver type, thickness, color, and finish. Submit samples indicating the range of color expected in the finished installation.
 - 3. Accepted samples become the standard of acceptance for the work of this Section.
 - 4. Laboratory test reports certifying compliance of the concrete pavers with ASTM C 936.
 - 5. Manufacturer's material safety data sheets for the safe handling of the specified materials and products.
 - 6. Manufacturer's written quality control procedures including representative samples of production record keeping that ensure conformance of paving products to the project specifications.
- H. Paver Installation Subcontractor:
 - 1. The Subcontractor shall have suitably experienced personnel and a management capability sufficient to execute the work shown on the contract drawings and specified herein.
 - 2. Job references from projects of a similar size and complexity. Provide Owner/Client/General Contractor names, postal address, phone, fax, and email address.
 - 3. Contractor shall conform to all local and state licensing and bonding requirements.

PART 1 GENERAL (Continued)

1.04 QUALITY ASSURANCE

- A. Paver Installation Subcontractor Qualifications:
 - 1. Utilize an installer having successfully completed concrete paver installation similar in design, material, and extent indicated on this project.
- B. Regulatory Requirements and Approvals: [Specify applicable licensing, bonding or other requirements of regulatory agencies].
- C. Mock-Ups:
 - 1. Install a 10 ft x 10 ft (3 m x 3 m) paver area.
 - 2. Use this area to determine surcharge of the bedding sand layer, joint sizes, lines, laying pattern(s), color(s) and texture of the job.
 - 3. This area will be used as the standard by which the work will be judged.
 - 4. Subject to acceptance by owner, mock-up may be retained as part of finished work.
 - 5. If mock-up is not retained, remove and properly dispose of mock-up.

1.05 DELIVERY, STORAGE, AND HANDLING

- A. General: Comply with Division 1 Product Requirement Section.
- B. Comply with manufacturer's ordering instructions and lead-time requirements to avoid construction delays.
- C. Delivery: Deliver materials in manufacturer's original, unopened, undamaged container packaging with identification tags intact.
 - 1. Coordinate delivery and paving schedule to minimize interference with normal use of buildings adjacent to paving.
 - 2. Deliver concrete pavers to the site in steel banded, plastic banded, or plastic wrapped cubes capable of transfer by forklift or clamp lift.
 - 3. Unload pavers at job site in such a manner that no damage occurs to the product or existing construction
- D. Storage and Protection: Store materials in protected area such that they are kept free from mud, dirt, and other foreign materials.

1.06 ENVIRONMENTAL REQUIREMENTS

- A. Do not install sand or pavers during heavy rain or snowfall.
- B. Do not install sand or pavers over frozen base materials.
- C. Do not install frozen bedding materials.

1.07 MAINTENANCE

- A. Extra materials: Provide [Specify area] [Specify percentage] additional material for use by owner for maintenance and repair.
- B. Pavers shall be from the same production run as installed materials.

PART 2 PRODUCTS

Note: Some projects may include permeable and solid interlocking concrete pavements. Specify each product as required.

2.01 PERMEABLE INTERLOCKING CONCRETE PAVERS

A. Manufacturer (ICPI Member): **Willow Creek Concrete Products, Inc.**
12626 County Road 150
Kimball, MN 55353
Phone (888) 398-9631 Fax (320) 398-5416
WillowCreekPavingStones.com

B. Permeable Interlocking Concrete Paver Units:

1. Paver Type: Brickstone Permeable Concrete Paver

| Product Name | Dimensions | Thickness | Colors Available |
|----------------------------|--|-------------------|------------------|
| Brickstone Permeable Paver | 3.95 in (100mm) x 7.90 in (200mm) | 3.125 in. (80 mm) | To be determined |
| a. | Material Standard: Comply with material standards set forth in ASTM C 936. | | |
| b. | Color [and finish]: [Specify color.] [Specify finish]. | | |
| c. | Color Pigment Material Standard: Comply with ASTM C 979. | | |

Note: Concrete pavers may have spacer bars on each unit. Spacer bars are recommended for mechanically installed pavers. Manually installed pavers may be installed with or without spacer bars. Verify with manufacturers that overall dimensions do not include spacer bars.

Note: Minimum 80 mm (3 1/8 in.) thick units are recommended for permeable pavement applications.

d. Size: 3.95 inches x 7.90 inches x 3.125 inches thick.

Note: When 3 1/8 in. (80 mm) thick pavers are specified, their compressive strength test results per ASTM C 140 should be adjusted by multiplying by 1.18 to equate the results to that from 2 3/8 in. (60 mm) thick pavers.

- e. Average Compressive Strength (ASTM C 140): 8000 psi (55 MPa) with no individual unit under 7200 psi (50 MPa).
- f. Average Water Absorption (ASTM C 140): 5% with no unit greater than 7%.
- g. Freeze/Thaw Resistance (ASTM C 67): Resistant to 50 freeze/thaw cycles with no greater than 1% loss of material. Freeze-thaw testing requirements shall be waived for applications not exposed to freezing conditions.

2.02 PRODUCT SUBSTITUTIONS

A. Substitutions: No substitutions permitted.

2.03 CRUSHED STONE FILLER, BEDDING, BASE AND SUBBASE

- A. Crushed stone with 90% fractured faces, LA Abrasion < 40 per ASTM C 131, minimum CBR of 80% per ASTM D 1883.
- B. Do not use rounded river gravel for base or bedding materials.
- C. All stone materials shall be washed with less than 1% passing the No. 200 sieve.
- D. Joint/opening filler, bedding, base and subbase: conforming to ASTM D 448 gradation as shown in Tables 1, 2 and 3 below:

PART 2 PRODUCTS (Continued)

Table 1

Grading Requirements for ASTM No. 8 Bedding and Joint/Opening Filler

| Sieve Size | Percent Passing |
|------------------|-----------------|
| ½" (12.5 mm) | 100 |
| ⅜" (9.5 mm) | 85 to 100 |
| No. 4 (4.75 mm) | 10 to 30 |
| No. 8 (2.36 mm) | 0 to 10 |
| No. 16 (1.16 mm) | 0 to 5 |

Table 2

Grading Requirements for ASTM No. 57 Base

| Sieve Size | Percent Passing |
|------------------|-----------------|
| 1½ in. (37.5 mm) | 100 |
| 1 in. (25 mm) | 95 to 100 |
| ½ in. (12.5 mm) | 25 to 60 |
| No. 4 (4.75 mm) | 0 to 10 |
| No. 8 (2.36 mm) | 0 to 5 |

Table 3

Grading Requirement for ASTM No. 2 Subbase

| Sieve Size | Percent Passing |
|------------------|-----------------|
| 3 in. (75 mm) | 100 |
| 2½ in. (63 mm) | 90 to 100 |
| 2 in. (50 mm) | 35 to 70 |
| 1½ in. (37.5 mm) | 0 to 15 |
| ¾ in. (19 mm) | 0 to 5 |

- E. Gradation criteria for the bedding and base:

Note: D_x is the particle size at which x percent of the particles are finer. For example, D_{15} is the particle size of the aggregate for which 15% of the particles are smaller and 85% are larger.

1. D_{15} base stone / D_{50} bedding stone < 5.
2. D_{50} base stone / D_{50} bedding stone > 2.

2.04 ACCESSORIES

- A. Provide accessory materials as follows:

Note: Curbs will typically be cast-in-place concrete or precast set in concrete haunches. Concrete curbs may be specified in another Section. Do not use plastic edging with steel spikes to restrain the paving units when vehicular traffic is present.

1. Edge Restraints
 - a. Manufacturer: [Specify manufacturer.].
 - b. Material: [Pre-cast concrete] [Cut stone] [Concrete].
 - c. Material Standard: [Specify material standard.].

Note: See ICPI publication, Permeable Interlocking Concrete Pavements for guidance on geotextile selection. Geotextile use is optional.

2. Geotextile Fabric:
 - a. Material Type and Description: Willow Creek Paving Stones Underlayment Fabric
 - b. Material Standard: Exceeds ICPI minimum standard
 - c. Supplier: Willow Creek Concrete Products

PART 3 EXECUTION

3.01 ACCEPTABLE INSTALLERS

- A. [Specify acceptable paver installation subcontractors.]

3.02 EXAMINATION

Note: The elevations and surface tolerance of the soil sub-grade determine the final surface elevations of concrete pavers. The paver installation contractor cannot correct deficiencies in the excavation and grading of the soil sub-grade with additional bedding materials. Therefore, the surface elevations of the soil sub-grade should be checked and accepted by the General Contractor or designated party, with written certification presented to the paver installation subcontractor prior to starting work.

A. Acceptance of Site Verification of Conditions:

1. General Contractor shall inspect, accept and certify in writing to the paver installation subcontractor that site conditions meet specifications for the following items prior to installation of interlocking concrete pavers.

Note: Compaction of the soil sub-grade should be determined by the project engineer. If the soil sub-grade requires compaction, compact to a minimum of 95% standard Proctor density per ASTM C 698 for pedestrian areas and residential driveways, and a minimum of 95% modified Proctor per ASTM D 1557 for vehicular areas. Compacted soil density and moisture should be checked in the field with a nuclear density gauge or other test methods for compliance to specifications. Stabilization of the soil and/or base material may be necessary with weak or continually saturated soils, or when subject to high wheel loads. Compaction will reduce the permeability of soils. If soil compaction is necessary, reduced infiltration may require drain pipes within the open-graded sub base to conform to local storm drainage requirements.

- a. Verify that sub-grade preparation, compacted density and elevations conform to specified requirements.
 - b. Provide written density test results for soil sub-grade to the Owner, General Contractor and paver installation subcontractor.
 - c. Verify location, type, and elevations of edge restraints, [concrete collars around] utility structures, and drainage pipes and inlets.
2. Do not proceed with installation of bedding and interlocking concrete pavers until sub-grade soil conditions are corrected by the General Contractor or designated subcontractor.

3.03 PREPARATION

- A. Verify that the soil sub-grade is free from standing water.
- B. Stockpile joint/opening filler, base and subbase materials such that they are free from standing water, uniformly graded, free of any organic material or sediment, debris, and ready for placement.
- C. Edge Restraint Preparation:
 1. Install edge restraints per the drawings [at the indicated elevations].

PART 3 EXECUTION (Continued)

3.04 INSTALLATION

Note: The minimum slope of the soil sub-grade should be 0.5%. Actual slope of soil sub-grade will depend on the drainage design. All drainpipes, observation wells, overflow pipes, and impermeable liner (if applicable) should be in place per the drawings prior to or during placement of the subbase and base, depending on their location. Care must be taken not to damage drainpipes during compaction and paving. No mud or sediment can be left on the base or bedding aggregates. If they are contaminated, they must be removed and replaced with clean materials.

- A. General
 - 1. Any excess thickness of soil applied over the excavated soil sub-grade to trap sediment from adjacent construction activities shall be removed before application of the [geotextile] and subbase materials.
 - 2. Keep area where pavement is to be constructed free from sediment during entire job. [Geotextiles] Base and bedding materials contaminated with sediment shall be removed and replaced with clean materials.
 - 3. Do not damage drainpipes, overflow pipes, observation wells, or any inlets and other drainage appurtenances during installation. Report any damage immediately to the project engineer.
- B. Geotextiles
 - 1. Place on bottom and sides of soil sub-grade. Secure in place to prevent wrinkling from vehicle tires and tracks.
 - 2. Overlap a minimum of 0.6 m (24 in.) in the direction of drainage.
- C. Open-graded sub-base and base
 - 1. Moisten, spread and compact the No. 2 subbase in 100 to 150 mm (4 to 6 in.) lifts [without wrinkling or folding the geotextile. Place subbase to protect geotextile from wrinkling under equipment tires and tracks].
 - 2. For each lift, make at least two passes in the vibratory mode then at least two in the static mode with a minimum 10 t (10 T) vibratory roller until there is no visible movement of the No. 2 stone. Do not crush aggregate with the roller.
 - 3. The surface tolerance of the compacted No. 2 subbase shall be ± 20 mm ($\pm \frac{3}{4}$ in.) over a 3 m (10 ft.) straightedge.
 - 4. Moisten, spread and compact No. 57 base in one 4 in. (100mm) thick lift. On this layer, make at least two passes in the vibratory mode then at least two in the static mode with a minimum 10 t (10 T) vibratory roller until there is no visible movement of the No. 2 stone. Do not crush aggregate with the roller.

Note: At the option of the designer, this supplemental test method listed below can be used to establish a consistent methodology for in-situ density data collection of open-graded aggregate base layer (typically ASTM No. 57 stone). This test method can assist contractors in reaching adequate job site compaction and offer an additional level of confidence for the project owner and designer. This test method is appropriate for pavement subject to consistent vehicular traffic such as parking lots and roads. It is not needed for pedestrian areas and residential driveways.

- 5. Use part of the compacted base area as a control strip for density testing by the [Testing Company].
 - a. The [Testing Company] shall supply nuclear moisture/density gauges and ancillary equipment required to conduct density and moisture content measurements for compaction of the No. 57 aggregate drainage layer. Qualified testing laboratory operators/gauges may conduct compaction testing. Each gauge operator shall be trained in the safe operation, transportation and handling of the gauge. The registered owner of the gauge shall have and maintain a valid Radioisotope License for each gauge.
 - b. Each gauge shall have been calibrated within the last 12 months, either by the manufacturer or other qualified agent, against certified density and moisture reference blocks. The density standard count and the moisture standard count shall be within 2 percent and 4 percent respectively, of the most recent calibration values. A certificate of calibration for each gauge shall accompany each gauge.
- 6. Target Moisture
 - a. Determine a target density on the control strip during under the following conditions: (1) after initial placement and compaction of the base aggregate layer (2) when there is a perceptible change in the appearance or gradation of the aggregate, (3) when there is a change in the source of aggregate.

PART 3 EXECUTION (Continued)

3.04 INSTALLATION

- b. Test field density according to ASTM D 2922 *Standard Test Methods for Density of Soil and Soil-Aggregate In-Place by Nuclear Methods (shallow depth)*. Field density tests shall be performed on compacted base materials to determine within acceptable limits of a target density.
7. Control Strip
 - a. The Testing Company shall construct a control strip for the determination of a target density consisting of a single uniform lift as specified in the contract documents, but not more than 4 in. (100mm) thick and covering approximately 600 sq. yards (500 sq. meters) in area. No testing shall be performed within 10 ft (3 m) from any unrestrained outside edge of the work area. The control strip may be incorporated into the project upon acceptance of density measurements by the Testing Company.
 - b. During construction of the control strip, the surface of the aggregate shall be visibly moist and maintained as such throughout construction and compaction.
 - c. After initial placement of the aggregate base material, the compaction equipment shall make two passes over the entire surface of the control strip. Field densities and field moisture contents, using the backscatter/indirect method, shall be determined at five randomly selected locations at least 15 ft (5 m) apart. The dry density and moisture content shall be calculated for each of these locations and the averages shall be used as the initial values. The maximum compacted thickness of the aggregate base layer measured for density shall be 4 in. (100 m).
 - d. The compaction equipment shall then make two additional passes over the entire surface of the control strip. After compaction, three separate, random field density and moisture content determinations shall be made; using the backscatter/indirect method, and a new average dry density and moisture content shall be calculated.
 - e. If the new average dry density exceeds the previous value by more than 1.2 pcf (20 kg/m³) then two additional passes of the equipment shall be carried out as described above. If the new average dry density does not exceed the previous value by more than 1.2 pcf (20 kg/m³), then compaction of the control strip will be considered satisfactory and complete.
 - f. Upon satisfactory completion of the completion of the control strip, an additional seven (7) field density and moisture tests, using the backscatter/indirect method, shall be taken at random locations and the dry density and moisture content values shall be determined. The final dry density and moisture content of the control strip shall be the average of these seven values plus the three most recent values obtained upon completion
 8. Compaction Equipment
 - a. Use a smooth dual or single smooth drum, minimum 10 ton (10 T) vibratory roller or a minimum 13,500 lbf (60kN) centrifugal force, reversible vibratory plate compactor that provides maximum compaction force without crushing the aggregate base.
 9. Test Report
 - a. The test report shall include the following:
 - 1) Project description.
 - 2) Sketch of the test area and test locations.
 - 3) Aggregate type and layer thickness.
 - 4) Aggregate characteristic properties: gradation, void ratio, bulk density.
 - 5) Compaction equipment type and weight.
 - 6) Static or vibratory compaction.
 - 7) Number of passes of the compaction equipment.
 - 8) Test number and location.
 - 9) Individual and average field wet density, moisture content, dry density values determined after each compaction operation in accordance with ASTM D 2922 *Standard Test Methods for Density of Soil and Soil-aggregate In-Place by Nuclear Methods (Shallow Depth)*.
 - 10) Calculation of target density

PART 3 EXECUTION (Continued)

- D. The surface tolerance of the compacted No. 57 base should not deviate more than +/- in. (25mm) over a 10 ft (3 m) straightedge.

Note: As an alternative test method, in-place density of the base aggregate may be checked per ASTM D 4254. Compacted density should be 95% of the laboratory index density established for the base layer.

- E. Bedding Layer
1. Moisten, spread and compact the No. 8 bedding material.
 2. Fill voids left by removed screed rails with No. 8 stone.
 3. The surface tolerance of the screeded No. 8 bedding layer should not deviate more than ± 13 mm ($\pm \frac{1}{2}$ in.) over a 3 m (10 ft.) straightedge.
 4. Do not subject screeded bedding material to any pedestrian or vehicular traffic before paving unit installation begins.
- F. Permeable interlocking concrete pavers and joint/opening fill material
1. Lay the paving units in the pattern(s) and joint widths shown on the drawings. Maintain straight pattern lines.
 2. Fill gaps at the edges of the paved area with cut units. Cut pavers subject to tire traffic shall be no smaller than $\frac{1}{3}$ of a whole unit.
 3. Cut pavers to be placed along the edges with a [double-bladed splitter] or masonry saw.
 4. Fill the openings and joints with No. 8 stone.

Note: Some paver joint widths may be narrow and not accept most of the No. 8 stone. Use joint material that will fill joints such as washed ASTM No. 89 or No. 9 stone.

5. Remove excess aggregate by sweeping pavers clean.
6. Compact and seat the pavers into the bedding material using a low-amplitude, 75-90 Hz plate compactor capable of at least 22 KN (5,000 lbs.) centrifugal compaction force. This will require at least two passes with the plate compactor.
7. Do not compact within 2 m (6 ft) of the unrestrained edges of the paving units.
8. Apply additional aggregate to the openings and joints if needed filling them completely. Remove excess aggregate by sweeping then compact the pavers. This will require at least two passes with the plate compactor.
9. All pavers within 6 ft. (2 m) of the laying face must be left fully compacted at the end of each day.
10. The final surface tolerance of compacted pavers shall not deviate more than +/- $\frac{3}{8}$ th in (10 mm) under a 10 ft (3 m) long straightedge.
11. The surface elevation of pavers shall be 3 to 6 mm ($\frac{1}{8}$ to $\frac{1}{4}$ in.) above adjacent drainage inlets, concrete collars or channels.

3.05 FIELD QUALITY CONTROL

- A. After sweeping the surface clean, check final elevations for conformance to the drawings.
- B. Lippage: No greater than 3 mm ($\frac{1}{8}$ in.) difference in height between adjacent pavers.

Note: The surface of the pavers may be ($\frac{1}{8}$ to $\frac{1}{4}$ in.) 3 to 6 mm above the final elevations after compaction. This helps compensate for possible minor settling normal to pavements.

- C. The surface elevation of pavers shall be 3 to 6 mm ($\frac{1}{8}$ to $\frac{1}{4}$ in.) above adjacent drainage inlets, concrete collars or channels.
- D. Bond lines for paver courses: +/- $\frac{1}{2}$ in. (+/-15 mm) over a 50 ft (15 m) string line.

3.06 PROTECTION

- A. After work in this section is complete, the General Contractor shall be responsible for protecting work from sediment deposition and damage due to subsequent construction activity on the site.
- B. PICP installation contractor shall return to site after 6 months from completion of the work and provide the following as required: fill paver joints with stones, replace broken or cracked pavers, and re-level settled pavers to initial elevations. Any additional work shall be considered part of the original bid price with no additional compensation.

END OF SECTION



Sales Office:

Willow Creek™ Paving Stones

6348 Highway 36, Suite 7

Oakdale, MN 55128

(651) 773-7480

WillowCreekPavingStones.com



Manufacturing Facility:

Willow Creek Concrete Products, Inc.

3701 Park Avenue NW

Faribault MN 55021

(877) 331-3198 (507) 331-3198

WillowCreekConcreteProducts.com



Manufacturing Facility:

Willow Creek Concrete Products, Inc.

12626 County Road 150

Kimball, MN 55353

(888) 398-9631 (320) 398-5415

WillowCreekConcreteProducts.com