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Standard Specification for Adhered Manufactured Stone Masonry Veneer Units¹

This standard is issued under the fixed designation C1670/C1670M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

INTRODUCTION

The purpose of this standard is to establish the minimum product specifications for adhered manufactured stone masonry veneer units. These units are manufactured using a wet cast concrete mixture and finished to simulate stone, rocks found in nature, and other textures.

1. Scope*

1.1 This specification covers the minimum product requirements for adhered manufactured stone masonry veneer units applied as an adhered veneer to exterior and interior walls and structures suitable to receive units.

1.2 The property requirements of this specification apply at the time of delivery. This standard does not address the physical evaluation of installed units removed from service.

1.3 The units described by this specification are manufactured from a mixture of cement, normal or lightweight aggregates (or a combination of both), water, admixtures, other cementitious materials and other components which are wet-cast into shapes simulating the appearance of natural stone and other textures.

1.4 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.5 The text of this specification references notes and footnotes which provide explanatory material. These notes and footnotes shall not be considered as requirements of the standard.

1.6 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use of units.*

NOTE 1—When particular features are desired such as surface textures or color these features should be specified separately. Suppliers should be consulted as to the availability of units having the desired features.

1.7 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:

[C31/C31M Practice for Making and Curing Concrete Test Specimens in the Field](#)

[C33/C33M Specification for Concrete Aggregates](#)

[C39/C39M Test Method for Compressive Strength of Cylindrical Concrete Specimens](#)

[C140/C140M Test Methods for Sampling and Testing Concrete Masonry Units and Related Units](#)

[C150/C150M Specification for Portland Cement](#)

[C157/C157M Test Method for Length Change of Hardened Hydraulic-Cement Mortar and Concrete](#)

[C207 Specification for Hydrated Lime for Masonry Purposes](#)

[C260/C260M Specification for Air-Entraining Admixtures for Concrete](#)

¹ This test method is under the jurisdiction of ASTM Committee C15 on Manufactured Masonry Units and is the direct responsibility of Subcommittee C15.03 on Concrete Masonry Units and Related Units.

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*A Summary of Changes section appears at the end of this standard

C330/C330M Specification for Lightweight Aggregates for Structural Concrete
C331/C331M Specification for Lightweight Aggregates for Concrete Masonry Units
C482 Test Method for Bond Strength of Ceramic Tile to Portland Cement Paste
C494/C494M Specification for Chemical Admixtures for Concrete
C511 Specification for Mixing Rooms, Moist Cabinets, Moist Rooms, and Water Storage Tanks Used in the Testing of Hydraulic Cements and Concretes
C595/C595M Specification for Blended Hydraulic Cements
C618 Specification for Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use in Concrete
C666/C666M Test Method for Resistance of Concrete to Rapid Freezing and Thawing
C979/C979M Specification for Pigments for Integrally Colored Concrete
C989/C989M Specification for Slag Cement for Use in Concrete and Mortars
C1116/C1116M Specification for Fiber-Reinforced Concrete
C1157/C1157M Performance Specification for Hydraulic Cement
C1232 Terminology for Masonry
C1240 Specification for Silica Fume Used in Cementitious Mixtures

3. Terminology

3.1 Terminology defined in Terminology **C1232** shall apply for this specification.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *adhered manufactured stone masonry veneer unit, n*—a non-load bearing masonry unit that is produced by wet-cast blending of cementitious material, lightweight and other aggregates, pigments and admixtures, designed to be applied with a cementitious mortar to a backing surface.

3.2.2 *unit profile, n*—the combination of units that represent the range of shapes and sizes provided in the specified veneer.

3.2.3 *average thickness, n*—the mean of the depth measurement of the unit as measured from the back side to the face side.

3.2.4 *designated area, n*—the area of a completed wall section that is used to verify compliance.

3.2.5 *saturated density, n*—the water saturated weight of the cured specimen divided by the volume of the specimen.

3.2.6 *wet cast, adj*—manufactured from a measurable slump concrete.

4. Materials

4.1 Cementitious materials shall conform to the following applicable specifications:

4.1.1 *Portland Cement*—Specification **C150/C150M**.

4.1.2 *Blended Hydraulic Cements*—Specification **C595/C595M**.

4.1.3 *Pozzolans*—Specification **C618**.

4.1.4 *Slag Cement*—Specification **C989/C989M**.

4.1.5 *Hydraulic Cement*—Specification **C1157/C1157M**.

4.1.6 *Silica Fume*—Specification **C1240**.

4.1.7 *Hydrated Lime*—Specification **C207**.

4.2 *Aggregates*—Aggregates shall conform to the following specifications, except for grading requirements:

4.2.1 *Normal Weight Aggregates*—Specification **C33/C33M**.

4.2.2 *Lightweight Aggregates*—Specification **C330/C330M** or **C331/C331M**.

4.3 *Air-Entraining Admixtures*—Specification **C260/C260M**.

4.4 *Concrete Admixtures*—Specification **C494/C494M**.

4.5 *Coloring Pigments*—Specification **C979/C979M**.

4.6 *Reinforcement Fibers*—Specification **C1116/C1116M**.

4.7 *Other Constituents:*

4.7.1 Other constituent materials shall be shown by test of experience or history of performance under equivalent conditions not to be detrimental to the durability of the adhered manufactured stone masonry veneer unit, or adhered manufactured stone masonry veneer construction, or both.

5. Compressive Strength

5.1 From each manufacturing location, obtain representative samples from standard production of each concrete mix used for units in accordance with **5.2**.

5.1.1 ~~Sample and test the concrete mixes used for units no more than twelve months prior to production of units. More frequent testing shall be required if there is any change in the manufacturing process including changes in cementitious~~ Compressive

strength shall be based on testing of mixes using the same manufacturing process, materials or their sources, aggregates or their sources, water-cementitious materials ratio, mix design, manufacturing process or curing. This does not include producing concrete mix design, production methods, and curing methods within 12 months of delivery of the units. Production of units of varying shapes, configurations or sizes of units. size, shape, color, or configuration shall not constitute a manufacturing process change.

NOTE 2—It is common practice to use the same mix design to produce a wide variety of adhered manufactured stone masonry veneer unit shapes, sizes, and configurations. This standard only requires the evaluation of the compressive strength of each mix design, not each unit configuration produced by a common mix design.

5.2 Sample the concrete mix at the manufacturing facility from standard production mix. Form compressive strength and absorption specimens in accordance with Practice **C31/C31M**; except that the time requirements for transportation do not apply when specimens are shipped to the testing laboratory.

5.2.1 For compressive strength testing, prepare five 4-in. diameter by 8 in. [100 mm by 200 mm] cylinders and test in accordance with **5.3**. Do not disturb the curing cylinders for a minimum of 48 hours after casting. De-mold them at an age of seven days.

5.3 Test specimens at an age of 28 days in accordance with Test Method **C39/C39M**.

5.4 The average compressive strength of five specimens shall be a minimum of 2100 psi [15 MPa] with no individual specimen having a measured compressive strength less than 1800 psi [12 MPa].

6. Freeze-Thaw Durability

6.1 From each manufacturing location, obtain representative samples from standard production of each concrete mix used for units in accordance with **6.2**.

6.1.1 ~~Sample and test the concrete mixes used for units no more than twelve months prior to production of units. More frequent testing shall be required if there is any change in the manufacturing process including changes in cementitious~~ Freeze-thaw durability shall be based on testing of mixes using the same manufacturing process, materials or their sources, aggregates or their sources, water-cementitious materials ratio, mix design, manufacturing process or curing. This does not include producing concrete mix design, production methods, and curing methods within 12 months of delivery of the units. Production of units of varying shapes, configurations or sizes of units. size, shape, color, or configuration shall not constitute a manufacturing process change.

6.2 Sample the concrete mix at the manufacturing facility from standard production mix in accordance with Practice **C31/C31M** except that the time requirements for transportation do not apply when specimens are shipped to the testing laboratory.

6.2.1 For freeze/thaw durability testing, prepare five beams complying with the dimensional requirements of Test Method **C666/C666M**. The molded beams shall be de-molded 24-32 hours after casting and shall be air cured for 28 days.

6.3 Testing Requirements:

6.3.1 Specimens shall be tested using Test Method **C666/C666M**, Procedure A, with the following modifications:

6.3.1.1 ~~The method of evaluation is based on cumulative percent loss in mass and not relative dynamic modulus of elasticity~~ and durability factor. Measurement of fundamental transverse frequency is optional.

6.3.1.2 ~~Subject the molded beams to 50 consecutive cycles of freezing and thawing.~~

6.3.1.3 ~~Determine mass loss in accordance with the procedures in 6.3.3.~~

6.3.2 ~~No single specimen in a group of five specimens shall exhibit a mass loss greater than 1.5 % or show any fracture completely through the cross section when tested in accordance with Test Method C666/C666M, Procedure A, with the following modifications:~~ modifications listed in 6.3.1.

6.3.2.1 ~~The molded beams are subjected to 50 consecutive cycles of freezing and thawing.~~

6.3.3 Determine mass loss in accordance with the following procedure:

6.3.3.1 Following immersion in water for a period of 48 hours, the initial specimen mass shall be measured. Excess surface water shall be immediately removed by blotting with damp cloth or fabric towel prior to mass ~~measurement;~~ measurement.

6.3.3.2 Following the completion of 50 freeze thaw cycles in accordance with Test Method **C666/C666M**, Procedure A, the specimens shall be removed from the containers and excess surface water shall be removed by blotting with damp cloth or fabric ~~towel;~~ towel. Following blotting, measure and record the mass of the specimen.

6.3.3.3 The Percent Mass Loss (PWL) for each specimen shall be determined at 50 cycles and be calculated as follows:

$$\text{PWL (beam), \%} = [(M_0 - M_1)/M_0] \times 100$$

where:

PWL (beam) = percent mass loss of beam

M₀ = initial mass of beam following 48-hour saturation

M₁ = final mass of beam following 50 freeze/thaw cycles

6.3.3.4 Any test specimen which fractures completely through the cross section into two or more discrete sections shall be recorded as a failure.

6.3.4 In the case of specimen failure under ~~6.3.2.4~~ 6.3.3.4, the failure mode must be reported in detail.