



Designation: C652 – 19a

Standard Specification for Hollow Brick (Hollow Masonry Units Made From Clay or Shale)¹

This standard is issued under the fixed designation C652; 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.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 This specification covers hollow building brick and hollow facing brick made from clay, shale, fire clay, or mixtures thereof, and fired to incipient fusion. Four types of hollow brick in each of two grades and two classes are covered. In this specification, the term hollow brick shall be understood to mean hollow clay masonry units whose net cross-sectional area (solid area) in any plane parallel to the surface, containing the cores, cells, or deep frogs, is less than 75 % of its gross cross-sectional area measured in the same plane (see 4.3). This specification does not cover brick intended for use as paving brick (see Specification C902).

1.2 The property requirements of this specification apply at the time of purchase. The use of results from testing of brick extracted from masonry structures for determining conformance or nonconformance to the property requirements (Section 7) of this standard is beyond the scope of this specification.

1.3 Brick covered by this specification are ceramic products manufactured primarily from clay, shale, or similar naturally occurring substances and subjected to a heat treatment at elevated temperatures (firing). The heat treatment shall develop sufficient fired bond between the particulate constituents to provide the strength and durability requirements of this specification. Additives or recycled materials are permitted to be included at the option of the manufacturer. (See “firing” and “firing bond” in Terminology C1232.)

1.3.1 This specification and its individual requirements shall not be used to qualify or corroborate the performance of a masonry unit made from other materials, or made with other forming methods, or other means of binding the materials.

1.4 Hollow brick differ from unglazed structural clay tile (Specifications C34 and C212) and solid brick (Specifications C62 and C216). Hollow brick require greater shell and web

thicknesses and higher minimum compressive strength than structural clay tile, but permit greater void area and lesser distance from exposed edge to core hole than solid brick. Therefore, environmental and structural performance may be different in elements constructed of hollow brick from those constructed of structural clay tile or solid brick.

1.5 The text of this specification references notes and footnotes which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the specification.

1.6 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

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:²

- C34 Specification for Structural Clay Loadbearing Wall Tile
- C62 Specification for Building Brick (Solid Masonry Units Made From Clay or Shale)
- C67/C67M Test Methods for Sampling and Testing Brick and Structural Clay Tile
- C212 Specification for Structural Clay Facing Tile
- C216 Specification for Facing Brick (Solid Masonry Units Made from Clay or Shale)
- C902 Specification for Pedestrian and Light Traffic Paving Brick
- C1232 Terminology for Masonry

¹ This specification is under the jurisdiction of ASTM Committee C15 on Manufactured Masonry Units and is the direct responsibility of Subcommittee C15.02 on Brick and Structural Clay Tile.

Current edition approved Aug. 1, 2019. Published August 2019. Originally approved in 1970. Last previous edition approved in 2019 as C652 – 19. DOI: 10.1520/C0652-19A.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

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

3. Terminology

3.1 *Definitions*—For definitions relating to masonry and hollow brick, refer to Terminology C1232.

4. Classification

4.1 *Grades*—Grades classify brick according to their resistance to damage by freezing and thawing when saturated at a moisture content not exceeding the 24-h cold water absorption. Two grades of hollow brick are covered and the requirements are given in Section 7.

NOTE 1—Although grade is associated with resistance to deterioration under freeze/thaw exposures, freeze/thaw resistance of a clay brick unit is also affected by the properties of the surrounding materials, the construction details, and the overall environment in which the clay unit is placed; each of which may influence exposure to moisture and freezing conditions. Brick masonry should be detailed to minimize saturation or near-saturation of the units in freezing conditions. Measurement of moisture content of brick in buildings indicates that, when the building is designed and constructed to reduce water penetration, the 24-h cold water absorption is unlikely to be exceeded. See Specification C216, Appendix for additional information regarding freeze/thaw durability in service.

4.1.1 *Grade SW (Severe Weathering)*—Hollow brick intended for use where high resistance to damage caused by cyclic freezing and thawing is desired.

4.1.2 *Grade MW (Moderate Weathering)*—Hollow brick intended for use where moderate resistance to cyclic freezing and thawing damage is permissible.

4.2 *Types*—Four types of hollow brick are covered:

4.2.1 *Type HBS*—Hollow brick for general use in masonry.

4.2.2 *Type HBX*—Hollow brick for general use in masonry where a higher degree of precision and lower permissible variation in size than permitted for Type HBS is required.

4.2.3 *Type HBA*—Hollow brick for general use in masonry selected to produce characteristic architectural effects resulting from nonuniformity in size and texture of the individual units.

4.2.4 *Type HBB*—Hollow brick for general use in masonry where a particular color, texture, finish, uniformity, or limits on cracks, warpage, or other imperfections detracting from the appearance are not a consideration.

4.2.5 When the type is not specified, the requirements for Type HBS shall govern.

4.3 *Class*—Two classes of hollow brick are covered:

4.3.1 *Class H40V*—Hollow brick intended for use where void areas or spaces greater than 25 %, but not greater than 40 %, of the gross cross-sectional area of the unit measured in any plane parallel to the surface containing the cores, cells, or deep frogs are desired. The void spaces, the web thicknesses, and the shell thicknesses shall comply with the requirements of Section 11 on Coring and Frogging.

4.3.2 *Class H60V*—Hollow brick intended for use where larger void areas are desired. The sum of these void areas shall be greater than 40 %, but not greater than 60 %, of the gross cross-sectional area of the unit measured in any plane parallel to the surface containing the cores, cells or deep frogs. The void spaces, the web thicknesses, and the shell thicknesses shall comply with the requirements of Section 11 on Coring and Frogging and to the minimum requirements contained in Table 1 (see Fig. 1).

TABLE 1 Class H60V—Hollow Brick Minimum Thickness of Face Shells and Webs, in. (mm)

Nominal Width of Units	Face Shell Thicknesses		End Shells or End Webs
	Solid	Cored or Double Shell	
3 and 4 (76 and 101)	¾ (19.05)	...	¾ (19.05)
6 (152)	1 (25.4)	1½ (38)	1 (25.4)
8 (203)	1¼ (32)	1½ (38)	1 (25.4)
10 (254) and greater	1¼ (32)	1⅝ (41)	1 (25.4)

4.3.3 When the class is not specified, the requirements of Class H40V shall govern.

5. Ordering Information

5.1 Orders for hollow brick under this specification shall include the following information:

5.1.1 *Grade (4.1)*—Grade SW governs when grade is not specified.

5.1.2 *Type (4.2)*—Type HBS governs when type is not specified.

5.1.3 *Class (4.3)*—Specify Class H40V or H60V. or accept Class H40V governs if Class is not specified.

5.1.4 *Size (9.1)*—Specify size of brick, width by height by length.

5.1.4.1 For Type HBA, specify tolerances on dimensions (9.1), warpage (9.2), or approve a designated sample.

5.1.5 Color, color range, and texture (10.5) by approving a sample.

5.1.5.1 For Type HBB, color, color range and texture are not required.

5.1.6 Finish on more than one face and one end (10.6).

5.1.7 *Sampling (12.2)*—Place(s) of selection for test specimens.

5.2 Orders for hollow brick under this specification may include the following information:

5.2.1 *Strength (7.2)*—Specify only if above minimum compressive strength in Table 2.

5.2.2 *Special Shapes (10.6)*—Specify size, dimensions and finished faces by approved shop drawing or other means.

5.2.3 *Frogging (10.5)*—Frog permitted in one bearing surface if not specified.

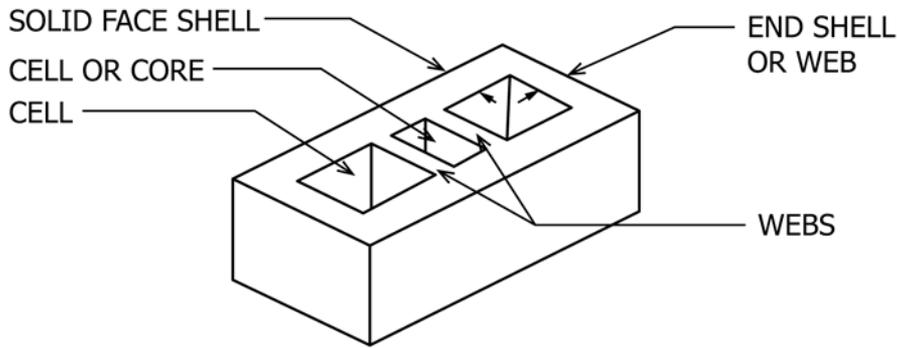
5.2.4 *Costs of Tests (Note 11)*—Party who will pay and conditions of payment of compliance testing.

NOTE 2—See 6.3 and Section 7 for optional information.

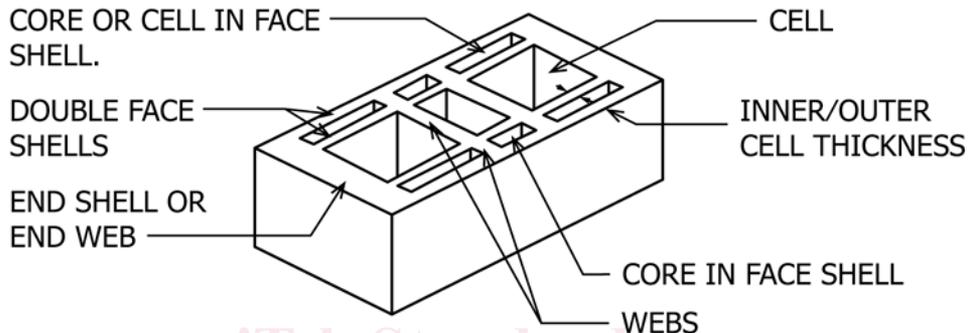
6. Materials and Manufacture

6.1 The body of all hollow brick shall be of clay, shale, fire clay, or mixtures of these materials, with or without admixtures, burned to meet the requirements of this specification. Any coloring or other materials added to the clay shall be suitable ceramic materials and shall be well distributed throughout the body.

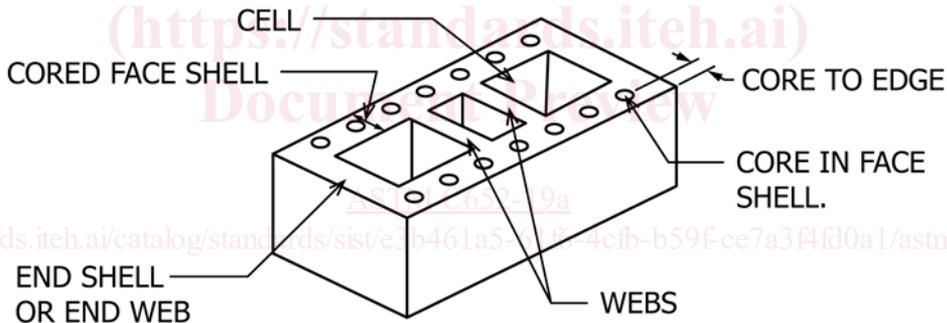
6.2 Colors and textures produced by application of inorganic coatings to the finished face(s) of the brick shall be permitted with the consent of the purchaser, provided that evidence is furnished of the durability of the coatings. Brick that are colored by flashing or textured by sanding, where the



SOLID SHELL HOLLOW BRICK UNITS



DOUBLE SHELL HOLLOW BRICK UNITS



CORED SHELL HOLLOW BRICK UNITS

FOR MINIMUM DIMENSIONS SEE SECTION 10 AND TABLE 1

FIG. 1 Hollow Brick Units

TABLE 2 Physical Requirements

Designation	Compressive Strength gross area, min, psi (MPa)		Water Absorption by 5-h Boiling, max, %		Saturation Coefficient, max	
	Average of 5 brick	Individual	Average of 5 brick	Individual	Average of 5 brick	Individual
Grade SW	3000 (20.7)	2500 (17.2)	17.0	20.0	0.78	0.80
Grade MW	2500 (17.2)	2200 (15.2)	22.0	25.0	0.88	0.90

NOTE 3—When surface colored brick, other than sanded or flashed, are specified for exterior use, the purchaser should require that data be submitted showing that after 50 cycles of freezing thawing there is no observable difference in the applied finish when viewed from a distance of 10 ft (3.0 m) under an illumination of not less than 50 ft-candles (538 lx) by an observer with normal vision.

Service records of the performance of the particular coated brick in exterior locations may be accepted in place of the freezing and thawing test, upon consent of the purchaser.

6.3 The brick shall be free of defects, deficiencies, and surface treatments, including coatings, that would interfere with the proper laying of the brick or significantly impair the strength or performance of the construction.

sand does not form a continuous coating, shall not be considered as surface-colored brick for the purpose of this specification.