Designation: ~~C1167 – 11 (Reapproved 2017)~~ C1167 – 22

Standard Specification for Clay Roof Tiles[1]

This standard is issued under the fixed designation C1167; 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.

1. Scope

1.1 This specification covers clay tiles intended for use as roof covering where durability and appearance are required to provide a weather-resistant surface of specified design.

1.2 Tiles are manufactured from clay, shale, or similar naturally occurring earthy substances and subjected to heat treatment at elevated temperatures (firing). The heat treatment must develop a fired bond between the particulate constituents to provide the strength and durability requirements of this specification (see *firing* and *fired bond* in Terminology C1232).

1.3 Tiles are shaped during manufacture by molding, pressing, or extrusion and it is permitted to use the shaping method to describe the tiles.

1.4 Tiles are generally planar or undulating rectangular shapes available in a variety of cross-sectional profiles, shapes, sizes, surface textures, and colors.

1.5 Three grades of tile having various degrees of resistance to weathering are covered in this specification. Three types of tile are defined to cover the features that influence appearance.

1.6 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 standard.

1.7 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.

1.8 *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.*

1.9 *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.*

[1] This specification is under the jurisdiction of ASTM Committee C15 on Manufactured Masonry Units and is the direct responsibility of Subcommittee C15.06 on Roofing Tile.

Current edition approved ~~Dec. 1, 2017~~March 1, 2022. Published ~~January 2018~~April 2022. Originally approved in 1990. Last previous edition approved in ~~2011~~2017 as ~~C1167 – 11.~~C1167 – 11(2017). DOI: ~~10.1520/C1167-11R17.~~10.1520/C1167-22.

TABLE 1 Grade Classification for Clay Roof Tiles

Grade (All Types)	Weathering Index (see Annex A1)
1	500 and greater
2	50 to 500
3	less than 50

2. Referenced Documents

2.1 *ASTM Standards:*[2]

~~C1232 Terminology for Masonry~~

~~C67~~C67/C67M Test Methods for Sampling and Testing Brick and Structural Clay Tile

C297/C297M Test Method for Flatwise Tensile Strength of Sandwich Constructions

C554 Test Method for Crazing Resistance of Fired Glazed Ceramic Whitewares by a Thermal Shock Method

C1232 Terminology for Masonry

3. Terminology

3.1 *Definitions*—For definitions of terms relating to structural clay products, and clay roof tiles, see Terminology C1232.

4. Classification

4.1 Clay roof tiles covered by this specification are classified by grade for durability and type for appearance as follows:

4.1.1 *Grades:*

4.1.1.1 *Grade 1*—Providing resistance to severe frost action.

4.1.1.2 *Grade 2*—Providing resistance to moderate frost action.

4.1.1.3 *Grade 3*—Providing negligible resistance to any frost action.

4.1.1.4 Grades relate to exposure to weather as defined in Table 1.

4.2 *Types:*

4.2.1 *Type I*—High-profile tiles—tiles having a rise-to-width ratio greater than 1:5.

4.2.2 *Type II*—Low-profile tiles—tiles having a rise-to-width ratio equal to, or less than 1:5.

4.2.3 *Type III*—All other tiles, including flat.

5. Material and Finish

5.1 Colors and textures produced by application of inorganic coatings to the faces of the tiles are not prohibited provided that evidence satisfactory to the purchaser is furnished regarding the durability of the coatings. Tiles that are colored by flashing or textured by sanding, where the sand does not form a continuous coating, are not considered as surface-colored tiles for the purpose of this specification.

NOTE 1—When surface colored tiles (other than sanded or flashed) are specified, data satisfactory to the purchaser shall be submitted showing that after 50 cycles of freezing-thawing (5.2) there is no observable difference in the applied finish when viewed from a distance of 40 ft (12 m) under an illumination of not less than 50 fc (538 lm/m^2) by an observer with normal vision. It is not prohibited to present service records of the performance of the particular coated tiles in appropriate locations in place of the freezing and thawing test, with the consent of the purchaser.

[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.

TABLE 2 Physical Requirements

Grade	Absorption Requirements			
	Cold Water Absorption Maximum Percent		Maximum Saturation Coefficient[A]	
	Average of Five Tiles	Individual Tile	Average of Five Tiles	Individual Tile
1	6	8	0.74	0.76
2	11	13	0.80	0.82
3	13	15	0.84	0.86

[A]The saturation coefficient is the ratio of absorption by 24-h submersion in water at a temperature of 75 ± 10°F (24 ± 6°C) to that after 5 h submersion in boiling water.

5.2 The tiles shall be free of defects, deficiencies, or bloating, that would interfere with the proper laying of the tiles, the performance of the roof, or the requirements of this specification.

5.2.1 Tiles that, when broken, have a dark area that has a steely appearance and is sharply delineated from the surrounding normal color of tile are not prohibited. This dark area is known as black heart or black core. Black heart is generally the result of the reduction of iron minerals during the firing process. Its presence, regardless of the size in the tile that otherwise meets the physical performance of this specification, shall not be cause for rejection.

5.3 The exposed tile surface shall be free of chippage or other imperfections detracting from the appearance of the designated sample when viewed from a distance 40 ft (12 m) under an illumination of not less than 50 fc (538 lm/m^2) by an observer with normal vision.

5.4 Unless otherwise agreed upon between the purchaser and the seller, a delivery of tiles shall contain not less than 95 % whole tiles. In this specification, the term *whole tiles* shall be understood to mean tiles meeting the appearance requirements of this specification.

5.5 After tiles are placed in usage, the manufacturer or his agent shall not be held responsible for compliance of tiles with the requirements of this specification for dimensional tolerances, finish, texture, or color.

6. Performance Requirements

6.1 *Durability*—The tiles shall conform to the physical requirements for the Grade specified as prescribed in Table 2. Unless otherwise specified by the purchaser, tiles of a higher Grade (greater weathering index) shall be accepted instead of a lower Grade. The saturation coefficient requirement does not apply when the average cold water absorption of a random sample of five tiles does not exceed 6 %, no more than one tile of the sample exceeds 6 % and its cold water absorption is less than 8 %. When Grade 3 tiles are used in regions where the weathering index is less than 50 (see Annex A1), unless otherwise specified, the requirements for water absorption and for saturation coefficient shall not apply.

NOTE 2—Frost is of profound importance in mechanical weathering where its effectiveness is dependent on the frequency of temperature fluctuation across the freezing point in the presence of water. The ability of a tile to resist failure in a wet and freezing environment is, therefore, of paramount importance. If a tile fails in such an environment, its use will result in an unacceptable deterioration of appearance or more likely, a total failure to function (that is, protect the underlying structure from rain), or both. Such a tile is completely unacceptable for use regardless of its other properties such as strength.

NOTE 3—The resistance of clay roof tiles to weathering cannot be predicted with complete assurance using any of the physical tests prescribed. However, practical experience has demonstrated satisfactory performance of clay roof tiles, some for hundreds of years, and this experience forms the basis of the prescriptive requirements of Table 2. There is generally excellent correlation between field performance and the requirements. However, it is possible that some tiles that meet this specification are not suitable for severe climates. Furthermore, it is also possible for other tiles that do not meet this specification to show acceptable serviceability in the most severe climates. The best indication of clay roof tile durability is the service record of experience with the specified product in the environment of its intended use.

6.1.1 Measure the water absorption, and calculate the saturation coefficient, in accordance with Test Methods ~~C67~~C67/C67M. The test sample shall consist of five whole tiles.

6.1.2 The physical requirements in Table 2 shall be achieved as a result of the firing process and associated thermal reactions within the tile body (and glaze, if present) which include development of the fired bond, increase in density, increase in strength,

and reduction in water absorption. Tiles shall not comply with this specification if other processes, for example, immersion in solutions of organic materials to effect impregnation or surface sealing, are used to change the physical properties which result from the firing process. It is not prohibited to test tiles in accordance with this Specification after the impregnation and sealing materials are removed as prescribed in Test Methods ~~C67~~C67/C67M.

6.2 *Freezing and Thawing*—The requirements specified in 6.1 for water absorption (5-h boiling) and saturation coefficient shall not apply for all Grades provided that a sample of five tiles, meeting all of the other requirements, experiences no breakage, no crack development that exceeds the minimum dimension of the specimen, and not greater than 0.5 % loss in dry weight when subjected to 50 cycles of the freezing-and-thawing test of Test Methods ~~C67~~C67/C67M, modified in accordance with 6.2.1.

6.2.1 Modify Test Methods ~~C67~~C67/C67M, Section 8, as follows: The test sample shall consist of five whole tiles. The freezing trays and containers shall be of sufficient size and depth to allow the tiles to be completely submerged in water when placed horizontally. The tiles shall be completely submerged in water when the trays are placed in the freezing chamber. It is not prohibited to test individual tile or to stack tile on top of each other in the tray, provided that spacers at least ¼ in. (6 mm) thick are used between adjacent tiles and that the total stack is completely submerged.

NOTE 4—A large capacity freezer is generally necessary to accomplish freezing in the manner specified in Test Methods ~~C67~~C67/C67M for trays containing more than one tile. It is not prohibited to use custom trays to enclose the tile(s) and minimize the volume of water required to completely submerge the tile(s).

6.2.2 A lot of tiles shall be given the Grade 1 rating without repeating a freezing and thawing test provided that a previous lot made by the supplier from similar materials, by the same process, at the same production plant, and within the previous 12 months, had passed the test, and provided also that a sample of five tiles selected from the lot has an average and individual minimum transverse strength not less than the previously graded sample and has average and individual maximum water absorption and saturation coefficient not greater than those of the previously graded sample.

NOTE 5—Unless specifically requested by the purchaser, the 50-cycle freezing and thawing test is used only as an alternative when tiles do not conform to either Table 2 requirements for maximum water absorption and saturation coefficient, or to the restrictive absorption requirements in 6.1.

6.3 *Strength*—The transverse breaking strength of tiles shall be determined as described for the Flexure Test in Test Methods ~~C67~~C67/C67M except as modified in 6.3.1 to 6.3.7.

6.3.1 Five tiles shall be tested wet after a 24-h submersion in water at a temperature of 75 ± 10°F (24 ± 6°C) or five tiles shall be tested dry after heating in a ventilated oven for 24 h at a temperature of 230 to 239°F (110 to 115°C).

6.3.1.1 Tile shall be considered to comply with this specification when they pass the requirement of either the wet or the dry transverse strength test. The choice of method, wet or dry, shall be mutually agreed upon between specifier and supplier.

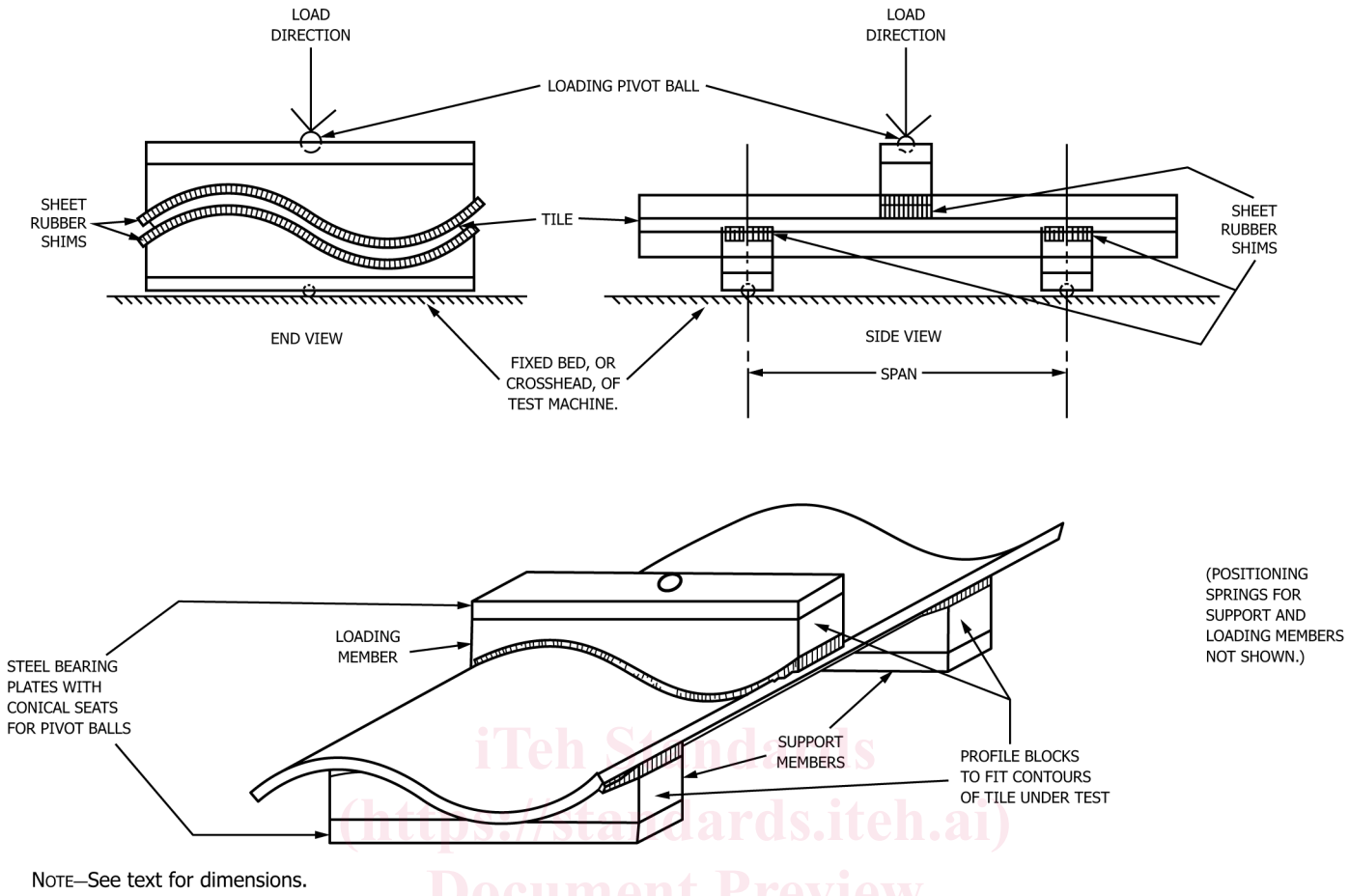
6.3.2 The span chosen for the test shall be 12 in. (30.5 cm) ± 5 % or ⅔ of the length of the tile, whichever is greater. The span is measured between the centers of the lower support members (6.3.3 and Fig. 1).

6.3.2.1 It is not prohibited to use a shorter span than required by 6.3.2 when the length of the tile to be tested is not sufficient to allow a 12 in. (30.5 cm) span to be used. In that case, a shorter span, not less than two-thirds of the length of the tile, shall be used and the required minimum values in Table 3 shall be increased proportionately to the reduction in span, that is, multiplied by:

$$\frac{12}{\text{span used (in.)}} \tag{1}$$

6.3.3 The tile shall be tested in a three-point bending mode in a horizontal plane with the bottom surface of the tile resting on two lower support members and with the load being applied to the upper (exposed) surface of the tile by a third member moving in a direction perpendicular to the plane of the tile and at mid-span (that is, equidistant from each of the lower support members).

6.3.4 The two support members and the loading member shall be of metal or hardwood with 1 in. (25 mm) ± 5 % wide faces. The faces shall be shaped (see Note 6) to closely conform to the profile of the surface of the tile upon which they bear during the test (it is prohibited to use different profiles for each member depending on the profile and cross-sectional shape of the tile). The total height of the members shall not be more than 1 in. (25 mm) greater than the rise of the tile profile and, if hardwood, they shall be backed up with steel bearing plates at least ½ in. (13 mm) thick. A rubber shim strip 3⁄16 in. (4.8 mm) ± 10 % thick of



NOTE 1—See text for dimensions.

FIG. 1 Schematic of Assembly for Flexure Strength Testing

TABLE 3 Transverse Breaking Strength Requirements

Type (All Grades)	Wet Transverse Strength, min, lbf (N)		Dry Transverse Strength, min, lbf (N)	
	Average of Five Tiles	Individual Tile	Average of Five Tiles	Individual Tile
Type I—High Profile	300 (1334)	260 (1157)	400 (1779)	350 (1556)
Type II—Low Profile	225 (1001)	200 (890)	300 (1334)	250 (1112)
Type III—Other Tiles	225 (1001)	200 (890)	300 (1334)	250 (1112)

hardness no greater than Shore Durometer 30 (A scale), and 1 in. (25 mm) ± 5 % wide, shall be placed between the faces of the support and loading members and the surface of the tile. A schematic of the assembly for testing a typical " S" tile is shown in Fig. 1.

NOTE 6—The intent of the defined loading system is (*1*) to apply the bending force with a loading member that pushes against as much of the profiled surface of the tile as is practical, (*2*) to support the tile on members that support as much of the profiled surface of the tile as is practical, and (*3*) to ensure that the contact area of both the loading and support members be equally distributed on either side of the length centerline on the tile to avoid non-symmetrical loading.

For tile with complex profiles and cross-sections but with flat bearing surfaces which are at least 50 % of the width of the tile and which are also equally distributed on either side of the length centerline it is not prohibited to use flat support and loading members to perform this test provided that they otherwise comply with the requirements of 6.3.4, 6.3.5 and 6.3.6. When sufficient flat bearing surface does not exist, wood blocks of appropriate thickness and profile and 1 in. (25 mm) wide, shall be used to provide a surface that will allow load application using a flat loading member which otherwise meets the requirements of 6.3.4, 6.3.5 and 6.3.6, and causes the load to be applied to at least 50 % of the width of the tile and equally distributed on either side of the length centerline of the tile.

Each wood block used to provide sufficient flat surface to allow loading and supporting with flat bearing members shall have a length of at least 25 % of the width of the tile. Such blocks shall be spaced no farther apart than 25 % of the width of the tile to avoid concentrated loading. Loading and support members shall be parallel to each other and be placed in the same alignment across the width of the tile, when viewed from the end of the tile, to avoid torsional loading.

6.3.5 The length of the support and loading members shall be greater than the width of the tile.

6.3.6 Both of the support members and the loading member shall be free to rotate in the longitudinal and transverse directions of the test specimen and be adjusted so that they will exert no force in these directions. It is not prohibited to accomplish this by using spherically seated steel balls with appropriate supporting springs.

6.3.7 The tile shall be loaded uniformly and continuously, without shock, at a rate not to exceed 1000 lbf (4550 N)/min until fracture.

6.3.8 Record the load in pounds (kilograms) at fracture of each of the five tiles and report the average of the five tests and the minimum individual result.

6.3.9 For tiles with width greater than 14 in. (35.6 cm) the minimum values in Table 3 are to be increased proportionately to the increase in width, that is, multiplied by:

$$\frac{\text{width (in.)}}{14} \tag{2}$$

6.4 *Efflorescence*—The rating for efflorescence shall be "not effloresced" when tiles of any grade are tested in accordance with Test Methods ~~C67~~C67/C67M (modified in accordance with 6.4.1).

6.4.1 Modify 10.4.1 of Test Methods ~~C67~~C67/C67M as follows: Set one specimen of each of the five pairs, with appropriate support formed from corrosion-resistant material to maintain the tile in an approximately vertical position, on its nose end, partially immersed in distilled water to a depth of approximately 1 in. (25.4 mm) for 7 days in the drying room.

6.5 *Reactive Particulates*—Reactive particulates shall not be used in the composition of the tile if they result in a visible imperfection when viewed from a distance of 10 ft (3 m) under an illumination of not less than 50 fc (538.2 lm/m^2) by an observer with normal vision.

6.6 *Permeability:*

6.6.1 *Apparatus*—Construct a 3 by 3 ft (1 by 1 m) frame, as shown in Fig. 2, at a pitch not to exceed 30 ±1° without nails or roofing felt. Provide access to the underside of the roof for observation. Provide illumination to the underside of the tile, if required, to identify the presence of free water on the underside of the tile.

6.6.1.1 Install the tiles as would be installed during field application for tile headlap without the use of nails.

6.6.1.2 Place a ½ in. deluge pipe (12 mm) inside diameter with 1⁄16 in. (2 mm) holes on 1½ in. (38 mm) over the top course of the roof to simulate run down from the higher course (see Fig. 2). Place a spray nozzle over the center of the tile to simulate direct rainfall and such that every tile on the roof will receive an equal volume of water. The application of water shall be such that a minimum volume is lost from overspray. Water shall be maintained at 75 ±5°F (24 ±3°C).

6.6.2 *Test Procedure*—The simulated rainfall shall be applied to the roof deck at the following combined rates:

6.6.2.1 *Via Deluge Pipe*—6 in./h (150 mm/h).

6.6.2.2 *Via Spray Nozzle*—3 in./h (75 mm/h).

6.6.2.3 Total simulated rainfall shall be 9 in./h (225 mm/h).

6.6.2.4 Calculate the flow rates required for the spray unit to achieve the simulated rainfall for a given roof area by Eq 3.

$$Q\,(\text{gal/min}) = 0.31 \times A \tag{3}$$

where:

A = actual roof test area in square feet.

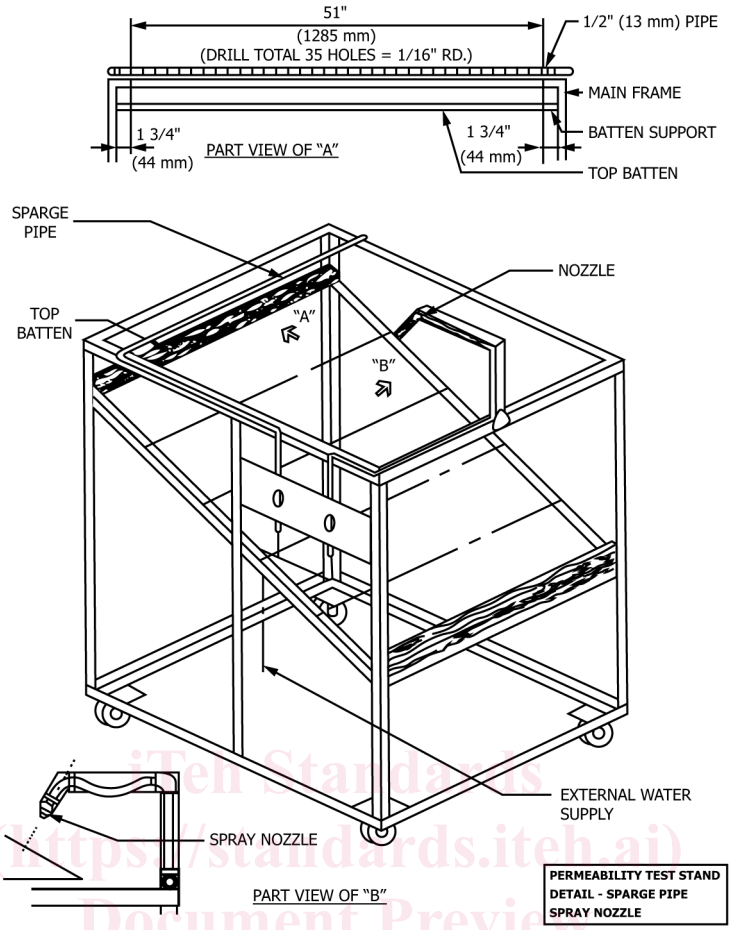


FIG. 2 Deluge Pipe

Metric equivalent:

$$Q\,(\text{L/min}) = 1.25 \times A$$

where:

A = actual roof test area in square metres.

6.6.2.5 The flow rate for the deluge pipe shall be twice that calculated for the spray unit above.

6.6.2.6 The flow rate shall be monitored by means of a flowmeter.

6.6.2.7 The flow of water shall be maintained for a time period of 2 h.

6.6.3 *Acceptance Criteria*—The tile shall be considered to have passed the test if after 2 h:

6.6.3.1 Free water has not formed on the underside of the tile, and

6.6.3.2 Not more than 25 % of the visible underside of any one tile shall show dampness.

6.6.3.3 *Example Calculation*—If a test apparatus provides a tile roof area of 4 by 4 ft, then you will have 16 ft^2 of roof deck.

Flow Q = 0.031 ×16 ft^2 = 0.50 gal/min for the spray unit. The deluge unit is twice the spray unit and would therefore have a flow of 1.0 gal/min. The combined flow would be a total of 1.5 gal/min on the tile roof.