



Designation: ~~C34–17~~ C34 – 23

## Standard Specification for Structural Clay Loadbearing Wall Tile<sup>1</sup>

This standard is issued under the fixed designation C34; 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 ( $\epsilon$ ) 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 structural clay loadbearing wall tile.

1.2 The property requirements of this specification apply at the time of purchase. The use of results from testing of tile extracted from masonry structures for determining conformance or non-conformance to the property requirements (Section 5) of this standard is beyond the scope of this specification.

1.3 Tile covered by this specification are manufactured from clay, shale, or similar naturally occurring earthy substances and subjected to a heat treatment at elevated temperatures (firing). The heat treatment must develop sufficient fired bond between the particulate constituents to provide the strength and durability requirements of this specification. (See *firing* and *fired bond* in Terminology [C1232](#).)

1.4 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.

1.5 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.

1.6 *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:*<sup>2</sup>

[E67C67/C67M](#) Test Methods for Sampling and Testing Brick and Structural Clay Tile  
[C216](#) Specification for Facing Brick (Solid Masonry Units Made from Clay or Shale)  
[C1232](#) Terminology for Masonry

### 3. Terminology

3.1 *Definitions*—For definitions relating to structural clay loadbearing wall tile, refer to Terminology [C1232](#).

<sup>1</sup> 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.

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<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto: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

## 4. Classification

4.1 Two grades of tile are covered, as follows:

4.1.1 *Grade LBX*—Suitable for general use in masonry construction and adapted for use in masonry exposed to weathering, provided they meet the durability requirements for Grade SW of Specification **C216**.

4.1.2 *Grade LB*—Suitable for general use in masonry where not exposed to frost action, or for use in exposed masonry where protected with a facing of 3 in. (76.2 mm) or more of stone, brick, terra cotta, or other masonry.

NOTE 1—Color of tile varies with the type of clay used and degree of firing; hence, it cannot be taken as indicative of classification until after it has been related to absorption and strength by actual tests.

~~4.1.3 If tile having a particular color, texture, or finish are desired, these features shall be specified separately by the purchaser.~~

~~NOTE 1—Color of tile varies with the type of clay used and degree of firing; hence, it cannot be taken as indicative of classification until after it has been related to absorption and strength by actual tests.~~

## 5. Physical Properties

~~5.1 Tile~~—Tile, when test in accordance with Test Methods **C67/C67M**, shall conform to the physical properties for the grade specified as prescribed in **Table 1**.

5.2 Tile of Grade LBX shall be accepted under all conditions instead of Grade LB.

5.3 End-construction tile are tile designed to be placed in the wall with axes of the cells vertical. Side-construction tile are tile designed to be placed in the wall with the axes of the cells horizontal. Where end-construction tile are used on the side they shall conform to the requirements of side-construction tile and vice versa.

5.4 Bonding tile shall be so designed as to provide recesses for header brick courses when laid up in brick-faced walls.

## 6. Dimensions and Permissible Variations

6.1 No overall dimension shall vary more than 3 % over or under the specified dimension for any form or size of tile.

NOTE 2—Purchasers and designers should ascertain the type and size of tile, modular or nonmodular, available in the locality under consideration and should specify accordingly, stating the size and type represented by the available tile.

Modular sizes are designated by the specified nominal dimensions which are equal to the actual manufactured dimensions plus the thickness of one mortar joint, not to exceed ½ in. (12.7 mm). For example, if the modular, specified, or nominal dimensions of a unit are 4 by 8 by 12 in. (101.6 by 203.2 by 304.8 mm) the actual manufactured dimensions may be 3½ by 7½ by 11½ in. (88.9 by 190.5 by 292.1 mm).

## 7. Finish and Appearance

7.1 All tile shall be reasonably free of laminations and of cracks, blisters, surface roughness, and other defects that interfere with the proper setting of the tile or impair the strength or permanence of the construction.

**TABLE 1 Physical Properties**

Grade	Maximum Water Absorption <sup>A</sup> by 1-h Boiling, %		Minimum Compressive Strength (Based on Gross Area), <sup>B</sup> psi (MPa)			
			End Construction Tile		Side Construction Tile	
	Average of Five Tests	Individual	Average of Five Tests	Individual	Average of Five Tests	Individual
LBX	16	19	1400 (9.6)	1000 (6.8)	700 (4.8)	500 (3.4)
LB	25	28	1000 (6.8)	700 (4.8)	700 (4.8)	500 (3.4)

<sup>A</sup> The range in percentage absorption for tile delivered to any one job shall be not more than 12.

<sup>B</sup> Gross area of a unit shall be determined by multiplying the horizontal face dimension of the unit as placed in the wall, by its thickness.

7.2 The finish of the outer face or faces of tile shall be plaster-base finish or exposed wall finish as specified in the invitation for bids.

7.3 Surfaces of tile for plaster-base finish shall be smooth, scored, combed, or roughened. When smooth, the tile shall be free of glaze and the absorption shall be not less than 5 % nor more than 25 %. When scored, each groove shall be not less than 1/16 in. (1.6 mm) nor more than 1/4 in. (6.4 mm) in depth, and not more than 1 in. (25.4 mm) in width. The area covered by the grooves shall not exceed 50 % of the area of the scored faces. When combed, the tile shall be scratched or scarified, prior to firing, by mechanical means which shall make scratches or scarifications on the surface of the tile not less than 1/16 in., nor more than 1/8 in. (3.2 mm) in depth, and not more than 1/4 in. apart. When roughened, the die skin on the face of the tile shall be entirely broken by mechanical means, such as wire cutting or wire brushing. (The die skin is visible within the cells of the tile.)

7.4 Surfaces of tile with exposed finish shall be smooth, combed, or roughened. Combed or roughened tile surfaces shall conform to the requirements for these finishes given in 7.3.

7.5 If tile having a particular color, texture, or finish are desired, these features shall be specified separately by the purchaser.

**8. Number of Cells and Weight of Tile**

8.1 Tile shall conform to the following requirements for minimum number of cells (see Note 3) in the direction of wall thickness (see prescribed Note 4 in Table 2 for approximate weights of tile):

Nominal Horizontal Thickness of Tile as Laid in Wall, in. (mm)	Minimum Number of Cells <sup>A</sup> in Direction of Wall Thickness
4 (101.6)	1
6 (152.4)	1
8 (203.2)	2
10 (254.0)	2
12 (304.8)	3

<sup>A</sup>Cells are hollow spaces enclosed within the perimeter of the exterior shells, and having a minimum dimension of not less than 1/2 in. (12.7 mm) and a cross-sectional area of not less than 1 in.<sup>2</sup> (6.5 cm<sup>2</sup>).

ASTM C34-23

<https://standards.iteh.ai/catalog/standards/sist/7bca9376-c571-4d39-be01-f8cb77038385/astm-c34-23>

**TABLE 2 Minimum Number of Cells**

Nominal Horizontal Thickness of Tile as Laid in Wall, in. (mm)	Minimum Number of Cells <sup>A</sup> in Direction of Wall Thickness
4 (101.6)	1
6 (152.4)	1
8 (203.2)	2
10 (254.0)	2
12 (304.8)	3

<sup>A</sup>Cells are hollow spaces enclosed within the perimeter of the exterior shells, and having a minimum dimension of not less than 1/2 in. (12.7 mm) and a cross-sectional area of not less than 1 in.<sup>2</sup> (6.5 cm<sup>2</sup>).