Designation: C 1405 – 05

Standard Specification for Glazed Brick (Single Fired, Brick Units)[1]

This standard is issued under the fixed designation C 1405; 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 brick, having a ceramic glaze finish fused to the body during the same process as the unit body firing, that are intended for use in masonry and supplying structural or facing components, or both, to the structure. This specification does not cover double-fired glazed brick. Some double-fired decorative glazes have physical properties which vary from those of single-fired glazes due to the lower temperatures used in applying the decorative coating.

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 of this specification is beyond the scope of this specification.

1.3 Glazed brick are prismatic units available in a variety of sizes, textures, colors, and shapes. Glazed brick are manufactured from clay, shale, or similar naturally occurring earthy substances and subjected to a heat treatment at elevated temperatures (firing). The heat treatment shall develop a fired bond between the particulate constituents to provide the strength and durability requirements of this specification (see firing, fired bond, glaze, and incipient fusion in Terminology C 43).

1.4 Glazed brick are shaped during manufacture by molding, pressing, or extrusion, and the shaping method is a way to describe the brick.

1.5 Glazed brick are classified into one of two grades, one of two types, one of two classes, and one of three divisions.

1.6 Opacity of the glaze is not required unless specified by the purchaser.

1.7 The text of this standard 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 this standard.

1.8 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.9 *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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards:* [2]

C 43 Terminology of Structural Clay Products

C 67 Test Methods for Sampling and Testing Brick and Structural Clay Tile

C 1093 Practice for Accreditation of Testing Agencies for Unit Masonry

E 84 Test Method for Surface Burning Characteristics of Building Materials

2.2 *NFPA Standard:*

NFPA No. 255 Test for Surface Burning Characteristics of Building Materials[3]

2.3 *UL Standard:*

UL No. 723 Flammability Studies of Cellular Plastics and Other Building Materials Used for Interior Finishes[4]

2.4 *ICBO Standard:*

UBC No. 42-1 Test Method for Fire Hazard Classification of Building Material[5]

2.5 *Federal Standard:*

Federal Standard Test No. 141 Abrasion Resistance (Taber Abraser)[6]

3. Terminology

3.1 *Definitions*—Terms used in this specification are defined in accordance with Terminology C 43.

4. Classification

4.1 *Grades*—Grades classify glazed brick according to their permissible variation in face dimension as follows. When grade is not specified, the requirements for Grade S govern.

[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.

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[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.

[3] Available from the National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

[4] Available from Underwriters Laboratories, 1285 Walt Whitman Road, Melville, NY 11747.

[5] Available from the International Conference of Building Officials, 5360 South Workman Mill Road, Whittier, CA 90601.

[6] Available from Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.

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

4.1.1 *Grade S (Standard)*, units for use where standard dimensional tolerances are desired.

4.1.2 *Grade SS (Select Sized)*, units for use where a higher degree of precision and lower permissible variation in size are desired.

4.2 *Types*—Two types of glazed brick are covered. When type is not specified, the requirements for Type I govern.

4.2.1 *Type I (Single-Faced Units)*, for general use where only one face is finished.

4.2.2 *Type II (Two-Faced Units)*, for use where two opposite faces are finished.

4.3 *Classes*—Two classes of glazed brick are covered. When class is not specified, the requirements for Class Exterior govern.

4.3.1 *Class Exterior*, for exterior applications.

4.3.2 *Class Interior*, for interior applications.

NOTE 1—Special brick shapes may be desired by the purchaser that do not meet all of the requirements of this specification (see 8.2.1). Consult the manufacturer for availability of special units and suitability for the intended purpose.

4.4 *Divisions*—Three divisions of glazed brick are covered. Divisions identify the amount and placement of hollow spaces (cores, cells and deep frogs) in the cross section of the unit. In the Division nomenclature, H shall be understood to mean hollow, and V shall be understood to mean void.

4.4.1 *Division Solid*—Brick with void area less than or equal to 25 % of its gross cross sectional area, measured in any plane parallel to the surface containing the cores, cells, or deep frogs.

4.4.2 *Division H40V*—Brick with void area greater than 25 % but less than or equal to 40 % of its gross cross sectional area, measured in any plane parallel to the surface containing the cores, cells, or deep frogs.

4.4.3 *Division H60V*—Brick with void area greater than 40 % but less than or equal to 60 % of its gross cross sectional area, measured in any plane parallel to the surface containing the cores, cells, or deep frogs. The shell thicknesses shall comply with the requirements in Table 1. See Fig. 1.

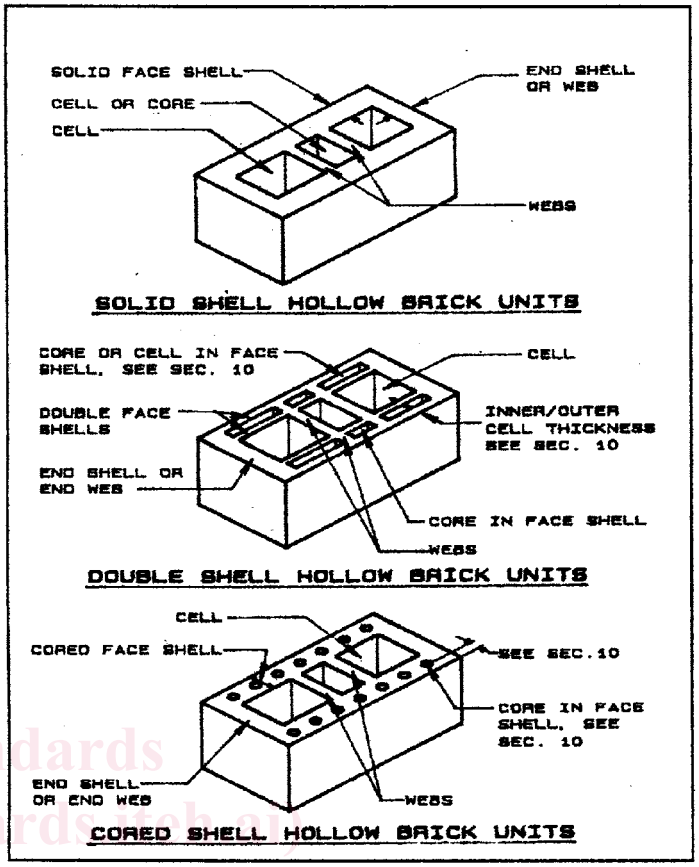

FIG. 1 Types of Hollow Glazed Brick Units

5. Physical Properties

5.1 *Durability*—Glazed brick shall conform to the physical properties requirements for the class specified as prescribed in Table 2 or in 5.1.1 or 5.1.2. For the compressive strength requirements, test the unit with the compressive force perpendicular to the bed surface of the unit, with the unit in the stretcher position.

NOTE 2—The physical property requirements for durability are based upon correlation of these physical properties and freeze-thaw testing of units in standard production. They indicate durability. Conformance with these property requirements provides a reasonable level of confidence as to durability in lieu of freeze-thaw testing.

5.1.1 *Strength and Absorption Requirements Alternate*—The saturation coefficient requirement for Class Exterior does not apply, provided the average compressive strength of a random sample of five brick equals or exceeds 8000 psi (55.2 MPa) with no individual strength less than 7500 psi (51.8 MPa). Additionally, the 24-h cold water absorption of each unit shall not exceed 6.0 %.

5.1.2 *Freezing and Thawing Alternative*—The requirements for cold water absorption (5.1.1) and absorption and saturation coefficient (Table 2) for Class Exterior do not apply, provided a sample of five brick, meeting the strength requirements of Table 2, passes the freezing and thawing test as described in the Rating Section of the Freezing and Thawing test procedures of Test Methods C 67.

NOTE 3—The 50 cycle freezing and thawing test is used as an

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

Nominal Width of Unit	Face Shell Type		End Shells
	Solid	Cored or Double Shell	
3 and 4 (76 and 102)	¾ (19.0)	...	¾ (19.0)
6 (152)	1 (25.4)	1 ½ (38.1)	1 (25.4)
8 (203)	1 ¼ (31.8)	1 ½ (38.1)	1 (25.4)
10 (254)	1 ⅜ (34.9)	1 ⅝ (41.3)	1 ⅛ (28.6)
12 (305)	1 ½ (38.1)	2 (50.8)	1 ⅛ (28.6)

TABLE 2 Physical Requirements

Designation	Minimum Compressive Strength, psi (MPa), Gross Area		Maximum Water Absorption by 24-h Cold, 7°	Maximum Saturation Coefficient[A]	
	Average of 5 Brick	Individual	Individual	Average of 5 Brick	Individual
Class Exterior	6000 (41.4)	5000 (34.8)	7.0	0.78	0.80
Class Interior	3000 (20.7)	2500 (17.2)			

[A] The saturation coefficient is the ratio of absorption by 24 h submersion in cold water to that after 5 h submersion in boiling water.

alternative only when units do not conform to either Table 2 requirements for maximum water absorption and saturation coefficient, or to the requirements of the Strength and Absorption Alternate in 5.1.1.

5.1.2.1 *Class Exterior: Weight Loss Requirement*—Not greater than 0.5 % loss in dry weight of any individual unit.

5.1.2.2 *Class Exterior: Breakage Requirement*—No individual unit separates into two or more significant pieces.

5.1.2.3 *Class Exterior: Cracking Requirement*—No individual unit develops a crack that exceeds, in length, the unit's least dimension.

5.2 *Strength*—When glazed brick are required having strengths greater than prescribed by this specification, the purchaser shall specify the desired average compressive strength and the individual minimum compressive strength.

5.3 *Initial Rate of Absorption (IRA)*—Determine results for IRA in accordance with Test Methods C 67 and furnish results at the request of the specifier or purchaser.

NOTE 4—*Initial Rate of Absorption (Suction)*—IRA is not a qualifying condition or property of units in this specification. This property is measured in order to assist in mortar selection and material handling in the construction process.

6. Efflorescence

6.1 When the brick are tested in accordance with Test Methods C 67, the rating for efflorescence shall be: "not effloresced."

7. Properties of Glaze

7.1 *Imperviousness*—When tested for imperviousness, 12.1.1, no stain that can be seen from a distance of 5 ft (1.5 m) shall remain on or beneath the surface, except a slight discoloration in the depressions on matt, stippled, or mottled glazes and in the crevices formed into the unit face(s) providing surface features.

7.2 *Resistance to Fading*—When tested for chemical resistance, 12.1.2, the color of the glaze shall not change from the approved sample.

7.3 *Resistance to Crazing*—When tested for crazing, 12.1.3, the glaze shall not craze, spall, or crack when subjected to one cycle of autoclaving.

7.4 *Flame Spread, Fuel Contribution, and Smoke Density*—Body and finish shall withstand temperatures up to 1900°F (878°C) without distortion or melting and rate "noncombustible." When tested in accordance with the provisions of Test Method E 84, glazed brick shall measure 0 flame spread, 0 fuel contribution, and 0 smoke density.

NOTE 5—This test method is similar to that specified in NFPA No. 255, UL No. 723, and UBC No. 42-1.

7.5 *Toxic Fumes*—Toxic fumes shall not be released from the body or glaze finish at temperatures up to 1900°F (878°C). No toxic fumes shall be released from the body or glaze finish when glazed brick are tested in accordance with Test Method E 84.

7.6 *Hardness and Abrasion Resistance*—Glaze shall resist scratching by ordinary glass or steel and be rated above five on the Mohs Hardness Scale. When tested for abrasion, under Wear Index Method No. 6192 of Federal Standard Test No. 141, using a Standard Taber Abraser Model CS-17 calibrated wheel and a 2.2 lb (1000 g) weight for 1000 wear cycles, the glazed face shall have a wear factor not in excess of 15.

7.7 *Opacity*—When opacity of the glaze is specified, discoloration of the body shall not be visible through the glaze when tested for opacity, 12.1.4.

NOTE 6—Opacity (7.7) is not a required property of clear and translucent glazes. The fading resistance (7.2) and hardness and abrasion resistance (7.6) properties are not required for metallic glazes. If those properties are important for glazes, consult the manufacturer for availability and suitability for the intended purpose.

8. Appearance, Color, and Texture

8.1 The body of the units shall be free of defects, deficiencies, and other imperfections that would interfere with the proper setting of the brick or significantly impair the strength or performance of the construction.

8.2 The color, color range, and texture shall be specified by the purchaser. The stretcher face of the brick and the exposed face(s) of shapes shall have the same general texture, color range, and glaze as the approved sample. The texture of the glazed surfaces shall conform to an approved sample of not less than four stretcher brick, each representing the texture desired. The color range shall be indicated by the approved sample.

8.2.1 Where brick are required having faces glazed other than those identified by type (Section 4), the purchaser shall specify faces to be glazed and the quantity of brick needed.

NOTE 7—Consult the manufacturer for the availability of specialty units suitable for the intended purposes.

8.3 The face(s) to be glazed shall be covered with a ceramic glaze of uniform quality. The glaze shall be free of chips, crazes, blisters, crawling, or other imperfections detracting from the appearance of the designated sample when viewed from a distance, at right angles to the sample, of 15 ft (4.57 m) for Class Exterior units and 5 ft (1.52 m) for Class Interior units.

8.4 Overspray of glazes onto adjacent faces of the units shall be regulated by the manufacturer. Residue resulting from