
Ceramic tiles — Definitions, classification, characteristics and marking

*Carreaux et dalles céramiques — Définitions, classification,
caractéristiques et marquage*

iTeh Standards
(<https://standards.iteh.ai>)
Document Preview

ISO 13006:2018

<https://standards.iteh.ai/catalog/standards/iso/7b7b59e4-12c3-4709-96d2-8d33797a6ccd/iso-13006-2018>



iTeh Standards
(<https://standards.iteh.ai>)
Document Preview

ISO 13006:2018

<https://standards.iteh.ai/catalog/standards/iso/7b7b59e4-12c3-4709-96d2-8d33797a6ccd/iso-13006-2018>



COPYRIGHT PROTECTED DOCUMENT

© ISO 2018

All rights reserved. Unless otherwise specified, or required in the context of its implementation, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Fax: +41 22 749 09 47
Email: copyright@iso.org
Website: www.iso.org

Published in Switzerland

Contents

Page

Foreword	iv
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Classification	4
4.1 Basis of classification.....	4
4.2 Methods of manufacture.....	4
4.3 Water absorption according to group.....	4
4.3.1 General.....	4
4.3.2 Subdivision of the three groups.....	4
5 Characteristics	5
6 Sampling and basis for acceptance	5
7 Requirements	5
8 Marking and specifications	5
8.1 Marking.....	5
8.2 Product literature.....	6
8.3 Specifications.....	6
9 Ordering	7
Annex A (normative) Extruded ceramic tiles with low water absorption $0,5 < E_v \leq 3 \%$ Group AI_b	10
Annex B (normative) Extruded ceramic tiles $3 \% < E_v \leq 6 \%$ Group AII_a — Subgroup (Part) 1	13
Annex C (normative) Extruded ceramic tiles $3 \% < E_v \leq 6 \%$ Group AII_a — Subgroup (Part) 2	16
Annex D (normative) Extruded ceramic tiles $6 \% < E_v \leq 10 \%$ Group AII_b — Subgroup (Part) 1	19
Annex E (normative) Extruded ceramic tiles $6 \% < E_v \leq 10 \%$ Group AII_b — Subgroup (Part) 2	22
Annex F (normative) Extruded ceramic tiles $E_v > 10 \%$ Group AIII	25
Annex G (normative) Dry-pressed ceramic tiles with low water absorption $E_v \leq 0,5 \%$ Group BI_a	28
Annex H (normative) Dry-pressed ceramic tiles with low water absorption $0,5 \% < E_v \leq 3 \%$ Group BI_b	32
Annex I (informative) Intentionally blank	35
Annex J (normative) Dry-pressed ceramic tiles $3 \% < E_v \leq 6 \%$ Group BII_a	36
Annex K (normative) Dry-pressed ceramic tiles $6 \% < E_v \leq 10 \%$ Group BII_b	39
Annex L (normative) Dry-pressed ceramic tiles $E_v > 10 \%$ Group BIII	42
Annex M (normative) Extruded ceramic tiles with low water absorption $E_v \leq 0,5 \%$ Group AI_a	45
Annex N (informative) Classification of glazed tiles for floors according to their abrasion resistance	48
Annex O (informative) Intentionally blank	49
Annex P (informative) Test methods	50
Annex Q (informative) Intentionally blank	51
Annex R (informative) Symbols recommended for use	52
Bibliography	53

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see: www.iso.org/iso/foreword.html.

This document was prepared by ISO/TC 189, *Ceramic tile*.

This third edition cancels and replaces the second edition (ISO 13006:2012), which has been technically revised.

This main changes compared to the previous edition are as follows:

- The boiling method in ISO 10545-3 is no longer referenced for the determination of water absorption. The vacuum method is now referenced for the determination of water absorption.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Ceramic tiles — Definitions, classification, characteristics and marking

1 Scope

This document defines terms and establishes classifications, characteristics and marking requirements for ceramic tiles of the best commercial quality (first quality). This document is not applicable to tiles made by other than normal processes of extrusion or dry pressing. It is not applicable to decorative accessories or trim such as edges, corners, skirting, capping, coves, beads, steps, curved tiles and other accessory pieces or mosaics (i.e. any piece that can fit into a square, the side of which is less than 7 cm).

NOTE ISO 10545 (all parts) describes the test procedures required to determine the product characteristics listed in this document. ISO 10545 is a multi-part standard, each part describes a specific test procedure or related matter.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1006, *Building construction — Modular coordination — Basic module*

ISO 10545-1, *Ceramic tiles — Part 1: Sampling and basis for acceptance*

ISO 10545-2, *Ceramic tiles — Part 2: Determination of dimensions and surface quality*

ISO 10545-3, *Ceramic tiles — Part 3: Determination of water absorption, apparent porosity, apparent relative density and bulk density*

ISO 10545-4, *Ceramic tiles — Part 4: Determination of modulus of rupture and breaking strength*

ISO 10545-5, *Ceramic tiles — Part 5: Determination of impact resistance by measurement of coefficient of restitution*

ISO 10545-6, *Ceramic tiles — Part 6: Determination of resistance to deep abrasion for unglazed tiles*

ISO 10545-7, *Ceramic tiles — Part 7: Determination of resistance to surface abrasion for glazed tiles*

ISO 10545-8, *Ceramic tiles — Part 8: Determination of linear thermal expansion*

ISO 10545-9, *Ceramic tiles — Part 9: Determination of resistance to thermal shock*

ISO 10545-10, *Ceramic tiles — Part 10: Determination of moisture expansion*

ISO 10545-11, *Ceramic tiles — Part 11: Determination of crazing resistance for glazed tiles*

ISO 10545-12, *Ceramic tiles — Part 12: Determination of frost resistance*

ISO 10545-13, *Ceramic tiles — Part 13: Determination of chemical resistance*

ISO 10545-14, *Ceramic tiles — Part 14: Determination of resistance to stains*

ISO 10545-15, *Ceramic tiles — Part 15: Determination of lead and cadmium given off by glazed tiles*

ISO 10545-16, *Ceramic tiles — Part 16: Determination of small colour differences*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 1006 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <https://www.electropedia.org/>
- ISO Online browsing platform: available at <https://www.iso.org/obp>

3.1

ceramic tile

thin slab made from clays and/or other inorganic raw materials, generally used as covering for floors and walls, usually shaped by extruding (A) or pressing (B) at room temperature, but may be formed by other processes (C), then dried and subsequently fired at temperatures sufficient to develop the required properties

Note 1 to entry: Tiles may be glazed (GL) or unglazed (UGL); they are incombustible and are not affected by light.

3.2

porcelain tile

fully vitrified tile with water absorption coefficient less than or equal to a mass fraction of 0,5 %, belonging to groups AI_a and BI_a

3.3

glaze

vitrified covering that is impermeable

3.4

engobed surface

clay-based covering with a matt finish which may be permeable or impermeable

Note 1 to entry: A tile with an engobed surface is regarded as an unglazed tile.

3.5

polished surface

surface of glazed and unglazed tile which has been given a glossy finish by mechanical polishing as the last stage of manufacture

3.6

extruded tile

tile, whose body is shaped in the plastic state in an extruder, the column obtained being cut into tiles of pre-determined dimension, and which is designated as Group A

Note 1 to entry: This document classifies extruded tiles as “precision” or “natural”. The classification is dependent upon the different technical characteristics as listed in the individual product standards.

Note 2 to entry: Traditional terms used for extruded products are “split tiles” and “quarry tiles”. They commonly indicate double-extruded and single-extruded tiles, respectively. The term “quarry tiles” only refers to extruded tiles with a water absorption coefficient of a mass fraction not exceeding 6 %.

3.7

dry-pressed tile

tile, formed from a finely milled body mixture and shaped (e.g. in dies or moulds) at high pressure, and which is designated as Group B

3.8

water absorption

E_v

percentage of water impregnating a tile

Note 1 to entry: This is measured in accordance with ISO 10545-3.

Note 2 to entry: Water absorption is expressed as a mass fraction of dry mass.

3.9 Sizes

Note 1 to entry The sizes are only defined for rectangular tiles. If the sizes of non-rectangular tiles are required, they are defined by the smallest rectangle into which they fit.

3.9.1

nominal size

size used to describe the product

Note 1 to entry: See [Figures 1](#) and [2](#).

3.9.2

work size

size of a tile specified for manufacturing to which the actual size shall conform within specified permissible deviations

Note 1 to entry: See [Figures 1](#) and [2](#).

3.9.3

actual size

size obtained by measuring the face of a tile

Note 1 to entry: This is measured in accordance with ISO 10545-2.

Note 2 to entry: See [Figures 1](#) and [2](#).

3.9.4

coordinating size

work size plus the joint width

Note 1 to entry: See [Figures 1](#) and [2](#).

3.9.5

modular size

tile and size based on module M, 2 M, 3 M and 5 M and also their multiples or subdivisions, except for tiles with a surface area of less than 9 000 mm²

Note 1 to entry: See ISO 1006, where 1 M = 100 mm.

Note 2 to entry: See [Figures 1](#) and [2](#).

3.9.6

non-modular size

size not based on module M

Note 1 to entry: See ISO 1006, where 1 M = 100 mm.

Note 2 to entry: Tiles of these sizes are those commonly used in most countries.

Note 3 to entry: See [Figures 1](#) and [2](#).

3.9.7

tolerance

difference between the permissible limits of size

Note 1 to entry: See [Figures 1](#) and [2](#).

3.10

spacer lug

projection that is located along certain edges of tiles so that where two tiles are placed together, in line, the lugs on adjacent edges separate the tiles by a distance of not less than the specified width of the joint

Note 1 to entry: See [Figure 2](#).

3.11

rectified tile

ceramic tile that, after firing, is subjected to a precise mechanical finishing of the edges

3.12

back feet

parallel ridges running across the back surface of some exterior wall tiles which possess a geometry intended to facilitate an interlocking connection between tile and cement mortar

Note 1 to entry: See [Figure 3](#).

Note 2 to entry: Back feet dimensions shall be measured with vernier calipers, and each specimen in a 10-tile sample is required to satisfy the requirements in [Annexes A](#) to [H](#) and [Annexes J](#) to [M](#).

4 Classification

4.1 Basis of classification

Ceramic tiles are divided into groups according to their method of manufacture and their water absorption (see [3.8](#) and [Table 1](#)). The groups do not presuppose the usage of the products.

4.2 Methods of manufacture

The following are the two methods of manufacture:

- method A, extruded tiles (see [3.6](#));
- method B, dry-pressed tiles (see [3.7](#)).

4.3 Water absorption according to group

4.3.1 General

The following are the three groups according to water absorption, E_v .

4.3.2 Subdivision of the three groups

The three groups are divided into tiles of low, medium and high water absorption, namely Groups I, II and III, respectively.

- a) Tiles of low water absorption, i.e. absorption coefficient less than or equal to a mass fraction of 3 %, $E_v \leq 3$ %, belong to Group I. Group I consists of the following:
 - 1) for extruded tiles
 - i) $E_v \leq 0,5$ % (Group AI_a), and
 - ii) $0,5$ % $< E_v \leq 3$ % (Group AI_b);
 - 2) for dry-pressed tiles:
 - i) $E_v \leq 0,5$ % (Group BI_a);

- ii) $0,5 \% < E_v \leq 3 \%$ (Group BI_b).
- b) Tiles of medium water absorption, i.e. $3 \% < E_v \leq 10 \%$, belong to Group II. Group II consists of the following:
 - 1) for extruded tiles
 - i) $3 \% < E_v \leq 6 \%$ [Group AII_a, Subgroups (Parts) 1 and 2; see [Annex B](#) for Subgroup (Part) 1 or [Annex C](#) for Subgroup (Part) 2], and
 - ii) $6 \% < E_v \leq 10 \%$ [Group AII_b, Subgroups (Parts) 1 and 2; see [Annex D](#) for Subgroup (Part) 1 or [Annex E](#) for Subgroup (Part) 2];
 - 2) for dry-pressed tiles
 - i) $3 \% < E_v \leq 6 \%$ (Group BII_a), and
 - ii) $6 \% < E_v \leq 10 \%$ (Group BII_b).
- c) Tiles of high water absorption, i.e. $E_v > 10 \%$, belong to Group III.

5 Characteristics

The characteristics for different applications of ceramic tiles are given in [Table 2](#).

6 Sampling and basis for acceptance

The sampling and basis for acceptance shall be in accordance with that presented in ISO 10545-1.

7 Requirements

Dimensional and surface quality requirements and physical and chemical properties shall be as given in the relevant/specific annex, of [Annexes A to H](#) and [Annexes I to M](#), for each tile class.

NOTE [Annexes I, O](#) and [Q](#) are intentionally left blank. This is as a convenience to producers in order to avoid changes to packaging and related costs. In addition, at the time of publication, the market offers consumers various products identified by the matching annex headings of this document.

8 Marking and specifications

8.1 Marking

Tiles and/or their packaging are required to bear the following marking:

- a) manufacturer's mark and/or trademark and the country where the tile was manufactured (i.e. country of origin, as determined by the relevant international regulation);
- b) indication of first quality;
- c) type of tile and reference to the appropriate group and/or annex of [Annexes A to H](#) and [Annexes I to M](#) covering the specific group of tile;
- d) nominal and work sizes, and "M" if modular;
- e) nature of the surface, i.e. glazed (GL) or unglazed (UGL);
- f) any surface treatment applied after firing;
- g) total number of tiles in the package;

- h) manufacturer's production run or batch number;
- i) an indication of colour consistency, as defined by the manufacturer;
- j) total dry weight which the tiles and their packaging shall not exceed.

EXAMPLE 1

The ABC Tile Co., Made in China, Ceramic Tile of First Quality
Extruded tile, ISO 13006:2018, Annex A, Group AI_b, Precision
M, 25 cm × 12,5 cm (*S_w* 240 mm × 115 mm × 12,5 mm), UGL, Protective Sealer Added
20 pcs/box, batch A50, 0100-Gray, Max dry weight: 20 kg

EXAMPLE 2

The 123 Tile Co., Made in Spain, Ceramic Tile of First Quality
Dry-pressed porcelain tile, ISO 13006:2018, Annex G, Group BI_a, Rectified
60 cm × 60 cm (*S_w* 598 mm × 598 mm × 10 mm) UGL
3 pcs/box, batch B52, 0590-Slate, Max dry weight: 16 kg

EXAMPLE 3

The XYX Tile Co., Made in Indonesia, Ceramic Tile of First Quality
Dry-pressed tile, ISO 13006:2018, Annex H, Group BI_b Non-rectified
30 cm × 30 cm (*S_w* 299 mm × 299 mm × 10 mm) GL
10 pcs/box, batch C60, 0320-Ivory, Max dry weight: 20 kg

Each tile conforming to this document is required to bear on its reverse side or edge, the country where it was manufactured.

8.2 Product literature

Product literature for tiles intended for use on floors shall state the abrasion class or the place of use of glazed tiles.

8.3 Specifications

Tiles shall be designated by the following:

- a) the method of shaping;
- b) the relevant group and/or annex of [Annexes A](#) to [H](#) and [Annexes J](#) to [M](#) covering the specific group of tile
- c) nominal and work sizes, and "M" if modular;
- d) the nature of the surface, i.e. glazed (GL) or unglazed (UGL);
- e) the addition of back feet, if required.

EXAMPLE 1 Precision extruded tile, ISO 13006:2018, Annex M, AI_a M 25 cm × 12,5 cm (*S_w* 240 mm × 115 mm × 10 mm) GL.

EXAMPLE 2 Natural extruded tile, ISO 13006:2018, Annex A, AI_b 15 cm × 15 cm (*S_w* 150 mm × 150 mm × 12,5 mm) UGL.

EXAMPLE 3 Dry-pressed tile, ISO 13006:2018, Annex G, BI_a M 25 cm × 12,5 cm (*S_w* 240 mm × 115 mm × 10 mm) GL.

EXAMPLE 4 Dry-pressed tile, ISO 13006:2018, Annex L, BIII 15 cm × 15 cm (*S_w* 150 mm × 150 mm × 12,5 mm) UGL.

9 Ordering

Each time that an order is placed, items, such as size, thickness, type of surface, colour, profile, abrasion class for glazed tiles and other properties, shall be agreed upon by the parties concerned.

Table 1 — Classification of ceramic tiles with respect to water absorption and shaping

Shaping	Group I $E_v \leq 3 \%$	Group II _a $3 \% < E_v \leq 6 \%$	Group II _b $6 \% < E_v \leq 10 \%$	Group III $E_v > 10 \%$
A Extruded	Group AI _a $E_v \leq 0,5 \%$ (see Annex M)	Group AII _{a-1} ^a (see Annex B)	Group AII _{b-1} ^a (see Annex D)	Group AIII (see Annex F)
	Group AI _b $0,5 \% < E_v \leq 3 \%$ (see Annex A)	Group AII _{a-2} ^a (see Annex C)	Group AII _{b-2} ^a (see Annex E)	
B Dry pressed	Group BI _a $E_v \leq 0,5 \%$ (see Annex G)	Group BII _a (see Annex J)	Group BII _b (see Annex K)	Group BIII ^b (see Annex L)
	Group BI _b $0,5 \% < E_v \leq 3 \%$ (see Annex H)			

^a Groups AII_a and AII_b are divided into two subgroups (Parts 1 and 2) with different product specifications.

^b Group BIII covers glazed tiles only. There is a low quantity of dry-pressed unglazed tiles produced with water absorption greater than 10 % mass fraction, which is not covered by this product group.

Table 2 — Characteristics required for different applications

Characteristics	Floor		Wall		Test
	Interior	Exterior	Interior	Exterior	Reference
Dimensions and surface quality					
Length and width	X	X	X	X	ISO 10545-2
Thickness	X	X	X	X	ISO 10545-2
Straightness of sides	X	X	X	X	ISO 10545-2
Rectangularity	X	X	X	X	ISO 10545-2
Surface flatness (curvature and warpage)	X	X	X	X	ISO 10545-2
Surface quality	X	X	X	X	ISO 10545-2
Back feet (if specified) ^a				X	Figure 3
Physical property	Interior	Exterior	Interior	Exterior	Reference
Water absorption	X	X	X	X	ISO 10545-3
Breaking strength	X	X	X	X	ISO 10545-4
Modulus of rupture	X	X	X	X	ISO 10545-4
Resistance to deep abrasion — unglazed tiles	X	X			ISO 10545-6
Resistance to surface abrasion — glazed tiles	X	X			ISO 10545-7
Linear thermal expansion ^b	X	X	X	X	ISO 10545-8
Resistance to thermal shock ^b	X	X	X	X	ISO 10545-9
Resistance to crazing — glazed tiles	X	X	X	X	ISO 10545-11
Frost resistance ^c		X		X	ISO 10545-12
Moisture expansion ^b	X	X	X	X	ISO 10545-10
Small colour differences ^b	X	X	X	X	ISO 10545-16

Table 2 (continued)

Characteristics	Floor		Wall		Test
Dimensions and surface quality	Interior	Exterior	Interior	Exterior	Reference
Impact resistance ^b	X	X			ISO 10545-5
Chemical property	Interior	Exterior	Interior	Exterior	Reference
Resistance to staining					ISO 10545-14
— glazed tiles	X	X	X	X	ISO 10545-14
— unglazed tiles ^b	X	X	X	X	ISO 10545-14
Resistance to low concentrations of acids and alkalis	X	X	X	X	ISO 10545-13
Resistance to high concentrations of acids and alkalis ^b	X	X	X	X	ISO 10545-13
Resistance to household cleaners and swimming pool salts	X	X	X	X	ISO 10545-13
Lead and cadmium release — glazed tiles ^b	X	X	X	X	ISO 10545-15

^a For application to exterior tiles installed by cement mortar, including tunnels, where back feet are specified.

^b Test method is available.

^c For tiles intended to be used in situations where frost conditions apply.

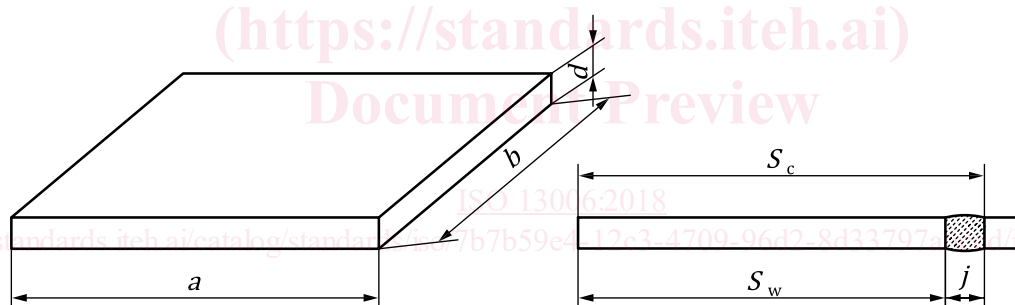
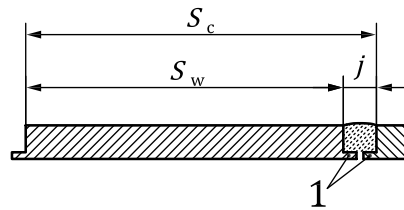
**Key** a, b dimensions of the tile d thickness j joint S_c coordinating size S_w work size $S_c = S_w + j$ $S_w = a, b, d$

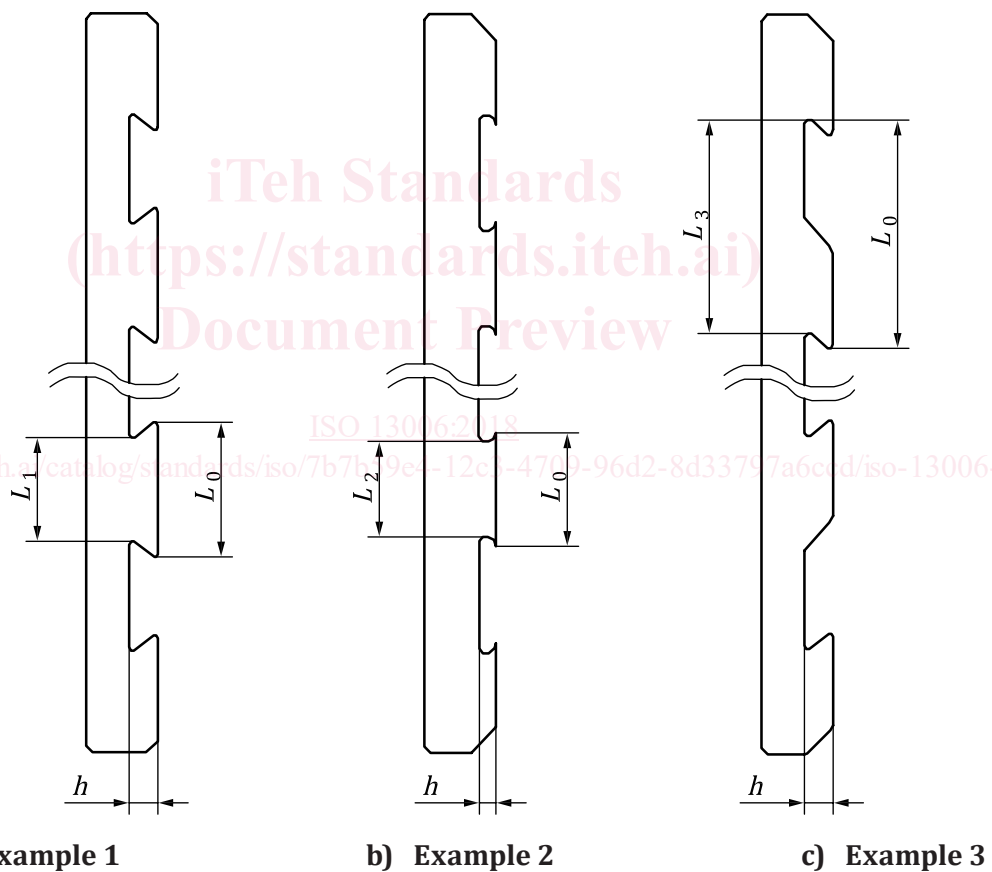
Figure 1 — Tile



Key

- 1 spacer lugs
- j joint
- S_c coordinating size
- S_w work size
- $S_c = S_w + j$
- $S_w = a, b, d$

Figure 2 — Tile with spacer lug



Key

- h height
- L length

Figure 3 — Back feet — Examples

Annex A (normative)

Extruded ceramic tiles with low water absorption $0,5 < E_v \leq 3 \%$ Group AII_b

Dimensional and surface quality requirements and physical and chemical properties are required to be in accordance with [Table A.1](#).

Table A.1 — Requirements for extruded ceramic tiles — Group AII_b, $0,5 < E_v \leq 3 \%$

Dimensions and surface quality	Precision	Natural	Test
Length and width			
The manufacturer shall choose the work size as follows:			
a) for modular tiles in order to allow a nominal joint width of between 3 mm and 11 mm ^a ;			
b) for non-modular tiles so that the difference between the work size and the nominal size is not more than ± 3 mm.			
The deviation, in percent, of the average size for each tile (two or four sides) from the work size, S_w	$\pm 1,0 \%$ to a maximum of ± 2 mm	$\pm 2,0 \%$ to a maximum of ± 4 mm	ISO 10545-2
The deviation, in percent, of the average size for each tile (two or four sides) from the average size of the 10 test specimens (20 or 40 sides)	$\pm 1,0 \%$	$\pm 1,5 \%$	ISO 10545-2
Thickness			
a) The thickness shall be specified by the manufacturer ^g			
b) The deviation, in percent, of the average thickness of each tile from the work size thickness ^g	$\pm 10 \%$	$\pm 10 \%$	ISO 10545-2
Straightness of sides^b (facial sides)			
The maximum deviation from straightness, in percent, related to the corresponding work sizes	$\pm 0,5 \%$	$\pm 0,6 \%$	ISO 10545-2
Rectangularity^b			
The maximum deviation from rectangularity, in percent, related to the corresponding work sizes	$\pm 1,0 \%$	$\pm 1,0 \%$	ISO 10545-2
Surface flatness			
The maximum deviation from flatness, in percent:			
a) centre curvature, related to diagonal calculated from the work sizes;	$\pm 0,5 \%$	$\pm 1,5 \%$	ISO 10545-2
b) edge curvature, related to the corresponding work sizes;	$\pm 0,5 \%$	$\pm 1,5 \%$	ISO 10545-2