



**SLOVENSKI STANDARD**  
**SIST EN 1342:2002**

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**Nadomešča:**  
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**Tlakovci iz naravnega kamna za zunanje tlakovanje - Zahteve in preskusne metode**

Setts of natural stone for external paving - Requirements and test methods

Pflastersteine aus Naturstein für Außenbereiche - Anforderungen und Prüfverfahren

Pavés de pierre naturelle pour le pavage extérieur - Exigences et méthodes d'essai  
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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 1342**

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English version

## Setts of natural stone for external paving - Requirements and test methods

Pavés de pierre naturelle pour le pavage extérieur -  
Exigences et méthodes d'essai

Pflastersteine aus Naturstein für Außenbereiche -  
Anforderungen und Prüfverfahren

This European Standard was approved by CEN on 14 October 2001.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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## Foreword

This European Standard has been prepared by Technical Committee CEN/TC 178 "*Paving units and kerbs*", the secretariat of which is held by BSI.

This European Standard supersedes EN 1342:2000.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 2002, and conflicting national standards shall be withdrawn at the latest by September 2003.

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

For relationship with EU Directive(s), see informative Annex ZA, which is an integral part of this standard.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard : Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

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**EN 1342:2001 (E)****1 Scope**

This European Standard specifies the performance requirements and the corresponding test methods for all natural stone setts for external paving use.

It provides for product marking and for the evaluation of conformity of the product to this European Standard.

This European Standard also covers characteristics that are of importance to the trade.

It does not cover the effect of the de-icing salts.

**2 Normative references**

This European Standard incorporates, by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment, or revision. For undated references the latest edition of the publication referred to applies (including amendments).

EN 12371, *Natural stone test methods — Determination of frost resistance*

EN 1926, *Natural stone test methods — Determination of compressive strength*

EN 12407, *Natural stone test methods — Petrographic description*

EN 10083-2:1996, *Quenched and tempered steels — Part 2: Technical delivery conditions for unalloyed quality steels*

EN 13755, *Natural stone test methods — Determination of water absorption at atmospheric pressure*

**3 Terms and definitions**

For the purposes of this European Standard the following terms and definitions apply:

**3.1****sett**

small natural stone paving block with work dimensions between 50 mm and 300 mm and no plan dimension generally exceeding twice the thickness. The minimum nominal thickness is 50 mm

**3.2****textured sett**

sett with a modified appearance resulting from one or several mechanical or thermal surface treatments

**3.3****work dimension**

any dimension of a sett specified for its manufacture to which the actual dimension should conform within specified permissible deviations

**3.4****actual dimension**

any dimension of a sett as measured

**3.5****overall length**

the longer side of the rectangle with the smallest length able to enclose the sett

**3.6****overall width**

the shorter side of the rectangle with the smallest area able to enclose the sett

**3.7****thickness**

distance between the upper face and the bedface of the sett

**3.8****upper face**

surface of a sett intended to be seen when in use

**3.9****fine textured**

surface treatment with a maximum difference of 0,5 mm between peaks and depressions (for example polished, honed or sawn with a diamond disc or blade)

**3.10****honed**

dull polish or matt finish

**3.11****coarse textured**

surface treatment with more than 2 mm difference between peaks and depressions (for example dolly pointed, tooled, shot blasted or flame textured)

**3.12****dolly pointed**

finish consisting of peaks and depressions achieved by using a four pointed dolly bit

**3.13****tooled**

finish resulting from mechanical surface treatment and showing tool marks

**3.14****hewn**

unworked, as-riven surface

**4 Requirements****4.1 Dimensions****4.1.1 General**

The supplier shall state the work dimensions of each sett that is tested, unless supplied in random sizes. Dimensions shall be measured in accordance with annex A.

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## 4.1.2 Permissible deviations

## 4.1.2.1 Plan dimensions and thickness

When measured in accordance with A.2, the deviations from the work plan dimensions shall conform to those in Table 1.

Table 1 — Deviations on nominal plan dimensions

Between two hewn faces	± 15 mm
Between one textured face and one hewn face	± 10 mm
Between two textured faces	± 5 mm

When measured in accordance with A.2, the deviations from the work thickness shall conform to those in Table 2.

Table 2 — Deviations on nominal thickness

	Class 1	Class 2
Marking designation	T1	T2
Between two hewn faces	± 30 mm	± 15 mm
Between one textured face and one hewn face	± 30 mm	± 10 mm
Between two textured faces	± 30 mm	± 5 mm

When setts are laid in fan shaped arrangements not only cubic setts are required but also a number of trapezoidal and oblong setts. For setts intended for this use a maximum of 10 % of setts, the dimensions of which lie outside the permissible deviations by up to 10 mm, may be included in the delivery. In all cases the height of the setts shall be observed. If the setts are not to be laid in fans this shall be stated when ordering.

## 4.1.2.2 Undercut of hewn sides

When measured in accordance with A.3, the lack of perpendicularity of a side shall not exceed 15 mm with respect to the face.

## 4.1.2.3 Hewn and coarse textured face irregularities

When measured in accordance with A.2, face cavities and protrusions shall not exceed the deviation given in Table 3.

Table 3 — Deviations on face irregularity

Hewn	Textured
5 mm	3 mm



## 4.2 Freeze/thaw resistance

The producer shall declare the freeze/thaw resistance of the stone in accordance with Table 4 when tested in accordance with EN 12371. The number of cycles shall be 48. The test shall be carried out to determine the effect of freeze/thaw cycles on performance characteristics (EN 1926 — compressive strength). The specimens shall be in accordance with the appropriate standard.

For some specific uses it may be appropriate to use different test cycles, for example freezing in water, freezing to a lower temperature, or testing specimens embedded in non-porous siliceous granules or a different number of cycles. In these cases national specification standards may be followed but these variations shall be clearly stated in the test report.

If there is no requirement for freeze/thaw resistance or no performance has been determined, then this shall be stated.

**Table 4 — Freeze/thaw resistance**

Class	Class 0	Class 1
Marking designation	F0	F1
Requirement	No requirements for freeze/thaw resistance	Resistant  (≤ 20% change in compressive strength)

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## 4.3 Compressive strength

The producer shall declare a compressive strength (MPa) as the minimum value expected for individual test specimens when tested in accordance with EN 1926. If no performance has been determined this shall be stated.

## 4.4 Abrasion resistance

The producer shall declare the abrasion resistance (length of chord in mm) as the maximum value expected for individual test specimens when tested in accordance with annex B. If no performance has been determined this shall be stated.

## 4.5 Slip resistance

The producer shall declare the minimum Unpolished Slip Resistance Value (USRV) expected for individual test specimens of fine textured setts when tested in accordance with annex C. If no performance has been determined this shall be stated.

If a national requirement on durability of slip/skid resistance exists, this requirement shall be determined as described in the national standard valid in the country where this requirement is operational.

NOTE 1 Coarse textured and riven setts are assumed to give satisfactory slip resistance. They cannot be reliably tested.

It should also be noted that the performance of setts when laid may have a different slip resistance value to that determined on individual setts or test specimens.

NOTE 2 The unpolished slip resistance value relates to setts as manufactured and helps to ensure adequate slip/skid resistance on installation.

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NOTE 3 Experience has indicated that a USRV measurement made using a wide slider / full swing on a TRL type pendulum that is greater than 35 can usually be considered safe.

**4.6 Aspects****4.6.1 Appearance**

Stone is a naturally occurring material giving rise to variations in colour, veining and texture, therefore, general characteristics of the appearance may be given by one or more specimens (see 4.6.2).

**4.6.2 Reference sample**

A reference sample shall be a number of setts of natural stone of sufficient size to indicate the appearance of the finished work and the approximate appearance regarding the colouring, the vein pattern, the physical structure and face finish.

It shall show the general tonality and finish of the natural stone, but does not imply any total uniformity in colour and veins between the sample and supplied product.

The reference sample shall be provided and delivered to the customer as an indication to show specific characteristics such as holes for travertine, worm holes for marble, glass seams, spots, crystalline veins and rusty spots of the offered materials.

NOTE These characteristics should not be considered as flaws and should not be used as a reason for rejection.

The name and address of the producer or the supplier shall be indicated on the sample as well as identification of the material including the trade name, petrographic description, country of origin and extraction area.

Reference samples shall also show the surface finish proposed.

Any comparison between test and reference samples shall be carried out by placing the reference sample against the test specimens and viewing them at a distance of two metres under normal lighting conditions and recording any visible differences in appearance, texture or colour.

**4.7 Water absorption**

Where required the producer shall declare the water absorption (% by mass) as the maximum value expected for individual specimens when tested in accordance with EN 13755.

**4.8 Petrographical description**

The producer shall provide a petrographical description, including a petrographic name of the stone type, in accordance with EN 12407.

**4.9 Chemical surface treatment**

The producer/supplier shall declare if the product has been subjected to a chemical surface treatment and what the treatment was.

## 5 Evaluation of conformity

### 5.1 General

The producer or supplier shall demonstrate compliance of his product, either new or existing, with requirements of this standard and with the declared values for the product properties by carrying out initial testing and factory production control. Where tests have previously been done in conformity with the requirements of this standard (same product, same characteristic, test method and sampling method), the results may be taken into account for initial type testing.

The value declared by the producer or supplier shall be representative of the current production, for example the lowest expected value or the minimum test value in normal production.

### 5.2 Initial type tests

When a product shall first demonstrate conformity with this standard, for example when a new product is developed, and before offering it for sale, appropriate tests shall be carried out to confirm that the properties of the product meet the requirements of this standard and the values to be declared for it by the producer. Whenever a significant change occurs in the raw material or the production process which could change the properties of the finished product, this shall be considered as constituting a new product type.

The type tests shall be the reference tests called up in this standard for the properties selected from the following list consistent with the product type's intended use:

- dimensions;
- flatness of surface;
- freeze/thaw resistance;
- compressive strength;
- abrasion resistance;
- slip resistance;
- aspects (for example visual appearance);
- water absorption;
- petrographic description;
- chemical surface treatment.

The results of the initial tests shall be recorded.

### 5.3 Factory production control

A factory production control system shall be established and documented prior to commencing production. The factory production control system shall consist of procedures for the internal control of production to ensure that products placed on the marked conform with this standard and the manufacturer's declared values.

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The internal control shall consist of regular inspection checks and tests and the utilisation of the results to control incoming materials, equipment, the production process and the finished product.

**5.3.1 Raw materials**

Specifications of all incoming materials and the procedures to be operated to ensure that they comply shall be documented.

**5.3.2 Production process**

The relevant features of the plant and production process shall be defined giving the frequency of the inspection checks and tests, together with the criteria required both on equipment and on work in progress. The action to be taken when control values or criteria are not met shall be given. Weighing and measuring equipment shall be calibrated and the procedure, frequency and criteria stated.

**5.3.3 Finished product testing**

A sampling plan for the testing of finished products shall be defined and the results shall be recorded and available for inspection. When alternative tests to the reference tests are used for the test procedure their correlation to the reference test shall be available for inspection. All test equipment shall be calibrated and the procedure, frequency and criteria stated.

**5.3.4 Stock control**

The stock control of finished products, together with procedures for dealing with non-conforming products, shall be detailed.

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**6 Acceptance criteria**

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**6.1 Sampling**

The sampling procedure from a batch to establish its conformity to this standard and the manufacturer's declared range of values shall be in accordance with annex D.

**6.2 Conformity criteria****6.2.1 Dimensions**

When tested in accordance with annex A, the mean value of the measurements taken of any one dimension on a single sett shall not vary from the manufacturer's declared work dimension by more than the permissible deviations given in 4.1.1.1 for the declared class.

**6.2.2 Freeze/thaw resistance**

When tested in accordance with EN 12371 the result for each of the test specimens shall be not less than the declared value.

**6.2.3 Compressive strength**

When tested in accordance with EN 1926 the result for each of the test specimens shall be not less than the declared value.