



Designation: C126 – 13

Standard Specification for Ceramic Glazed Structural Clay Facing Tile, Facing Brick, and Solid Masonry Units¹

This standard is issued under the fixed designation C126; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This specification covers structural clay load-bearing facing tile and facing brick and other “solid masonry units” made from clay, shale, fire-clay, or mixtures thereof, with or without the addition of grog or other mixtures, having a finish consisting of a ceramic glaze fused to the body at above 1500°F (655°C) making them inseparable, excluding natural salt-glazed ware. Two grades, based on permissible variation in face dimensions, and two types are covered, as follows:

1.1.1 *Grade S (select)*, for use with comparatively narrow mortar joints.

1.1.2 *Grade SS (select sized or ground edge)*, for use where variation of face dimension must be very small.

1.1.3 *Type I (single-faced units)*, for general use where only one finished face will be exposed.

1.1.4 *Type II (two-faced units)*, for use where two opposite finished faces will be exposed.

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

1.3 Brick and tile covered by this specification are manufactured from clay, shale, or similar naturally occurring 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 requirements of this specification. (See firing and fired bond in Terminology C1232.)

1.4 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 the standard.

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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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 The following precautionary caveat pertains only to the test portion (Section 11.2) of this specification. *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
C67 Test Methods for Sampling and Testing Brick and Structural Clay Tile
C1232 Terminology of Masonry
E84 Test Method for Surface Burning Characteristics of Building Materials
- 2.2 *National Fire Protection Association Standard*:³
NFPA No. 255 Test for Surface Burning Characteristics of Building Materials
- 2.3 *Underwriters Laboratories, Inc. Standard*:⁴
UL No. 723 Flammability Studies of Cellular Plastics and other Building Materials used for Interior Finishes
- 2.4 *International Conference of Building Officials Standard*:⁵
UBC No. 8-1 Test Method for Fire Hazard Classification of Building Material
- 2.5 *Government Standard*:⁶
Federal Standard Test No. 141

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 National Fire Protection Association (NFPA), 1 Batterymarch Park, Quincy, MA 02169-7471, <http://www.nfpa.org>.

⁴ Available from Underwriters Laboratories (UL), 333 Pfingsten Rd., Northbrook, IL 60062-2096, <http://www.ul.com>.

⁵ Available from the International Conference of Building Officials, 5360 S. Workman Mill Rd., Whittier, CA 90601.

⁶ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

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

3. Terminology

3.1 *Definitions*—For definitions relating to ceramic glazed structural clay facing tile, facing brick, and solid masonry units, refer to Terminology **C1232**.

4. Ordering Information

4.1 Orders for material under this specification shall include the following information:

4.1.1 *Grade*—When the grade is not specified, the requirements for Grade S shall govern.

4.1.2 *Type*—When the type is not specified, the requirements for Type I shall govern.

4.1.3 *Sizes and Shapes*—The sizes and shapes shall be specified in accordance with Section **6.1**.

4.1.4 *Color and Texture of Finish*—The color and texture of the finish shall be specified in accordance with Section **7.6**.

4.1.5 *Back Surfaces*—Unless otherwise specified, smooth, scored, combed, or roughened unglazed backs and smooth unselected glazed backs or a mixture thereof, are furnished. When plaster is to be applied, the back surface shall be specified in accordance with Section **7.5**.

4.1.6 *Coring*—Unless otherwise specified, either standard or special duty units as prescribed in Section **10** are furnished.

4.1.7 *Opacity*—Where ceramic glazed units are not specified as opaque, they need not meet the requirements for opacity prescribed in **7.4.2**.

4.1.8 *Exterior Use*—Where ceramic glazed units are required for exterior use, the manufacturers shall be consulted for material suitable for this purpose.

NOTE 1—The requirements included in this specification do not cover minimum criteria for durability of units exposed to exterior environments.

5. Physical Properties

5.1 The compressive strengths (based on gross area) of the units shall be not less than the values prescribed in **Table 1**.

NOTE 2—Special duty units may be available from various manufacturers where higher compressive strengths are required.

6. Dimensions and Permissible Variations

6.1 The face sizes of ceramic glazed units and fittings therefore shall be as specified.

NOTE 3—The sizes shown in **Table 2** are standard in the industry for single-faced units (Type I).

6.2 *Face Dimension Tolerances*—The total variation in the finished face dimensions of units shall be not more than the values shown in **Table 3**.

6.3 *Bed-Depth Dimension Tolerances*—The total variation in the bed-depth (through the wall) dimension of units shall be not more than the value shown in **Table 4**.

6.4 *Warpage Tolerances*—The maximum permissible deviation of the plane and the edges of the face of individual units from a plane surface and from a straight line, respectively, shall not exceed the value shown in **Table 5**.

NOTE 4—When convex units are laid upon a plane surface, the apparent variation is greater than the actual variation from the plane of the unit.

7. Finish and Appearance

7.1 The body of the units shall be free of cracks or other imperfections which would impair the strength or durability of the masonry.

7.2 Unless otherwise agreed upon between the purchaser and the seller, a delivery of brick or tile shall not contain more than 3 % brick or tile that are chipped, cracked or broken.

7.3 The finished face (one face of stretcher units and the finished faces of shapes) that will be exposed when in place 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 finished wall when viewed from a distance of 5 ft (1.52 m) at right angles from the wall.

NOTE 5—The purchaser or his authorized representative shall be accorded opportunity for sampling and inspecting units at the place of manufacture, prior to shipment. At least 10 days from the time of sampling should be allowed for completion of the tests. Unless otherwise specified in the purchase order, the cost of tests is typically borne as follows: If the results of the tests show that the brick does not conform to the requirements of this specification, the cost is typically borne by the seller. If the results of the tests show that the brick does conform to the requirements of this specification, the cost is typically borne by the purchaser.

7.4 Properties of Glaze:

7.4.1 *Imperviousness*—After the imperviousness test, no stain 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 finishes.

7.4.2 *Opacity*—Where opacity of finish is desired and so specified, discoloration of the body shall not be visible through the glaze in the opacity test. Clear ceramic glazes and special decorative glazes shall not be required to meet this requirement.

7.4.3 *Resistance to Fading*—The color of the glaze shall not change in the chemical resistance test. Finishes of metallic or special decorative glazes shall not be required to meet this requirement.

7.4.4 *Resistance to Crazing*—The glaze shall not craze, spall, or crack when subjected to one cycle of autoclaving in the crazing test.

7.4.5 *Flame Spread, Fuel Contribution and Smoke Density*—Body and finish must withstand temperatures up to 1900°F (878°C) without distortion or melting and rate “non-combustible.” When tested in accordance with the provisions of Test Method **E84**, structural facing tile shall measure 0 flame spread, 0 fuel contribution, and 0 smoke density. This test method is similar to that specified in NFPA No. 255, UL No. 723, and UBC No. 8-1.

7.4.6 *Toxic Fumes*—Toxic fumes will not be released from the body or glaze finish at temperatures up to 1900°F, and when tested under Test Method **E84**.

TABLE 1 Compressive Strengths of Units

Direction of Coring	Minimum Average of Five Tests, psi (MPa)	Individual Minimum, psi (MPa)
Vertical	3 000 (20.7)	2 500 (17.2)
Horizontal	2 000 (13.8)	1 500 (10.3)

TABLE 2 Size of Single-Faced Units

Series Designation	Specified Face Dimensions		Specified Thickness, in. (mm)
	Height, in. (mm)	Length, in. (mm)	
4S	2¼ (57.2)	7⅝ (193.7)	1¼, 3⅝, 5⅝, or 7⅝ (44.5, 92.1, 142.9, or 193.7)
4W	7⅝ (193.7)	7⅝ (193.7)	1¼, 3⅝, 5⅝, or 7⅝ (44.5, 92.1, 142.9, or 193.7)
6P	3⅝ (92.1)	11⅝ (295.3)	1¼, 3⅝, 5⅝, or 7⅝ (44.5, 92.1, 142.9, or 193.7)
6T	5 (127)	11⅞ (296.9)	1¼, 3⅝, 5⅝, or 7⅝ (44.5, 92.1, 142.9, or 193.7)
8W	7⅝ (193.7)	15⅝ (396.9)	1¼, 3⅝, 5⅝, or 7⅝ (44.5, 92.1, 142.9, or 193.7)

TABLE 3 Permissible Variations in Face Dimensions

NOTE 1—Permissible variations for units having specified dimensions more than ¼ in. (6.4 mm) greater than shown in this table shall be the same as for the next larger dimension.

Specified Face Dimension, Return or Reveal (Height, Length), in. (mm)	Maximum Difference Between Dimension of Any Unit and the Specified Dimension		Maximum Difference Between Largest and Smallest Unit in One Lot, ^A in. (mm)
	If Larger, in. (mm)	If Smaller, in. (mm)	
Grade S Units			
6 (152.4) and Under	⅛ (1.6)	⅜ (2.4)	⅜ (2.4)
Over 6 to 8 (152.4 to 203.2)	⅛ (1.6)	⅙ (3.2)	⅝ (4.0)
Over 8 to 16 (203.2 to 406.4)	⅛ (1.6)	⅝ (4.0)	¾ (4.8)
Grade SS—Select Sized or Ground-Edge Units Only			
Any dimension	⅛ (1.6)	⅛ (1.6)	⅙ (3.2)

^A Size of lot shall be determined by agreement between the purchaser and the seller.

TABLE 4 Permissible Variation in Bed Depth Dimensions

NOTE 1—Permissible variations for units having specified dimensions more than ¼ in. (6.4 mm) greater than shown in this table shall be the same as for the next larger dimension.

NOTE 2—Variation in the bed depth of individual units is controlled by the limitations on warpage. The thickness of a unit shall be considered either the maximum or minimum thickness, whichever is the farther from the specified dimension.

Specified Bed Depth Dimension (Wall Thickness), in. (mm)	Maximum Difference Between Dimension of Any Unit and the Specified Dimension		Maximum Difference Between Largest and Smallest Unit in One Lot, in. (mm) ^A
	If Larger, in. (mm)	If Smaller, in. (mm)	
Type I—Single-Faced Units			
2 (50.8) and Under	⅛ (3.2)	⅛ (3.2)	⅛ (3.2)
Over 2 to 4 (50.8 to 101.6)	⅛ (3.2)	⅜ (4.7)	⅜ (4.7)
Over 4 to 6 (101.6 to 152.4)	⅛ (3.2)	¼ (6.4)	¼ (6.4)
Over 6 to 8 (152.4 to 203.2)	⅛ (3.2)	⅝ (7.9)	⅝ (7.9)
Type II—Two-Faced Units			
8 (203.2) and Under	⅛ (3.2)	⅛ (3.2)	⅛ (3.2)

^A Size of lot shall be determined by agreement between the purchaser and the seller.

7.4.7 **Hardness and Abrasion Resistance**—Glaze must 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 (Federal Standard Test No. 141), using a standard Taber Abraser Model CS-17 calibrase wheel and a 1000 g weight for 1000 wear cycles, the glazed face shall

TABLE 5 Permissible Warpage

NOTE 1—Warpage tolerances for units having specified dimensions more than ¼ in. (6.4 mm) greater than shown in this table shall be the same as for the next larger dimension.

Specified Face Dimensions (Height and Length), in. (mm)	Grade	Maximum Permissible Warpage, in. (mm)
2¼ × 7⅝ (57.2 × 193.7)	S	⅛ (1.6)
3⅝ × 7⅝ (92.1 × 193.7)	S	⅛ (1.6)
7⅝ × 7⅝ (193.7 × 193.7)	S	⅛ (1.6)
5 × 11⅝ (127 × 295.3)	S	⅛ (1.6)
3⅝ × 11⅝ (92.1 × 295.3)	S	⅛ (1.6)
7⅝ × 11⅝ (193.7 × 295.3)	S	⅝ (4.0)
7⅝ × 15⅝ (193.7 × 396.9)	S	⅝ (4.0)
7⅝ × 11⅝ (193.7 × 295.3)	SS	⅜ (2.4)
7⅝ × 15⅝ (193.7 × 396.9)	SS	⅜ (2.4)

have a wear factor not in excess of 15. Finishes of metallic or special decorative glazes shall not be required to meet this requirement.

7.5 Plaster Base Finish:

7.5.1 Unless otherwise specified by the purchaser, smooth, scored, combed or roughened-back units or a mixture thereof are furnished.

7.5.2 When smooth, at least 90 % of the tile area shall be free of glaze and the average absorption shall be not less than 5 %, unless acceptable plaster adhesion bond test data is provided.

7.5.3 When scored, each groove shall be dovetailed and shall be not less than ⅛ in. (1.6 mm) nor more than ¼ 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.

7.5.4 When combed, the tile shall be scarified, prior to burning, by mechanical means which shall make scarifications on the surface of the tile not less than ⅛ in. (1.6 mm) nor more than ⅙ in. (3.2 mm) in depth, and not more than ¼ in. (6.4 mm) 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.)

7.6 The textures shall be mottled, stippled, or smooth as specified and the color of the finished surface shall be indicated by a sample consisting of not less than three stretcher units representing the range of shades.

8. Number of Cells

8.1 Requirements for number of cells apply to hollow units only. Cells are hollow spaces enclosed within the perimeter of the exterior shells having a minimum dimension of not less