



Designation: ~~C482 – 02 (Reapproved 2009)~~ C482 – 02 (Reapproved 2014)

## Standard Test Method for Bond Strength of Ceramic Tile to Portland Cement Paste<sup>1</sup>

This standard is issued under the fixed designation C482; 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.

### 1. Scope

1.1 This test method covers the determination of the ability of glazed ceramic wall tile, ceramic mosaic tile, quarry tile, and pavers to be bonded to portland cement paste. This test method includes both face-mounted and back-mounted tile.

1.2 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.

1.3 *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:*<sup>2</sup>

[C150 Specification for Portland Cement](#)

[C185 Test Method for Air Content of Hydraulic Cement Mortar](#)

[C207 Specification for Hydrated Lime for Masonry Purposes](#)

[C242 Terminology of Ceramic Whitewares and Related Products](#)

### 3. Terminology

3.1 *Definitions:*

3.1.1 For definitions of the types of tile listed in 1.1, refer to Terminology [C242](#).

### 4. Summary of Test Method

4.1 This test method consists of bonding tile under controlled conditions to a pure portland cement paste bond coat, supported by a cement mortar bed.

4.2 After proper cure of the test assembly, a load is applied to one edge of the tile and the load increased at a definite rate until the bond between tile and bond coat is broken.

4.3 Because the laboratory method of applying shear stress rapidly loads both tile and setting bed in compression, a stronger than normal setting bed for the test specimens is specified. This avoids failure of the setting bed before the desired failure at the tile-bond coat interface occurs. In real tile installations with portland cement paste an entirely different loading mechanism, usually generated primarily by shrinking of the setting bed or structural backing, results in mild tension in setting bed and mild compression in the tile, but the same type of shear stress occurs between tile and bond coat as does in response to the laboratory loading method. The finding of an adequate bond strength under the conditions of this test method can be taken as proof that the tested tile could be permanently bonded in a properly installed conventional installation using the lean, low-shrinkage mortars customarily specified for this particular purpose.

4.4 To maintain practical sample size and limit maximum breaking load, tile larger than nominal 4¼ in. (108 mm) on a side must be cut to 4 in. (102 mm).

<sup>1</sup> This test method is under the jurisdiction of ASTM Committee C21 on Ceramic Whitewares and Related Products and is the direct responsibility of Subcommittee C21.06 on Ceramic Tile.

Current edition approved Jan. 1, 2009; Dec. 1, 2014. Published February 2009; December 2014. Originally approved in 1961. Last previous edition approved in 2002; 2009 as ~~C482~~C482 – 02 (2009). – 02; DOI: ~~10.1520/C0482-02R09~~10.1520/C0482-02R14.

<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.

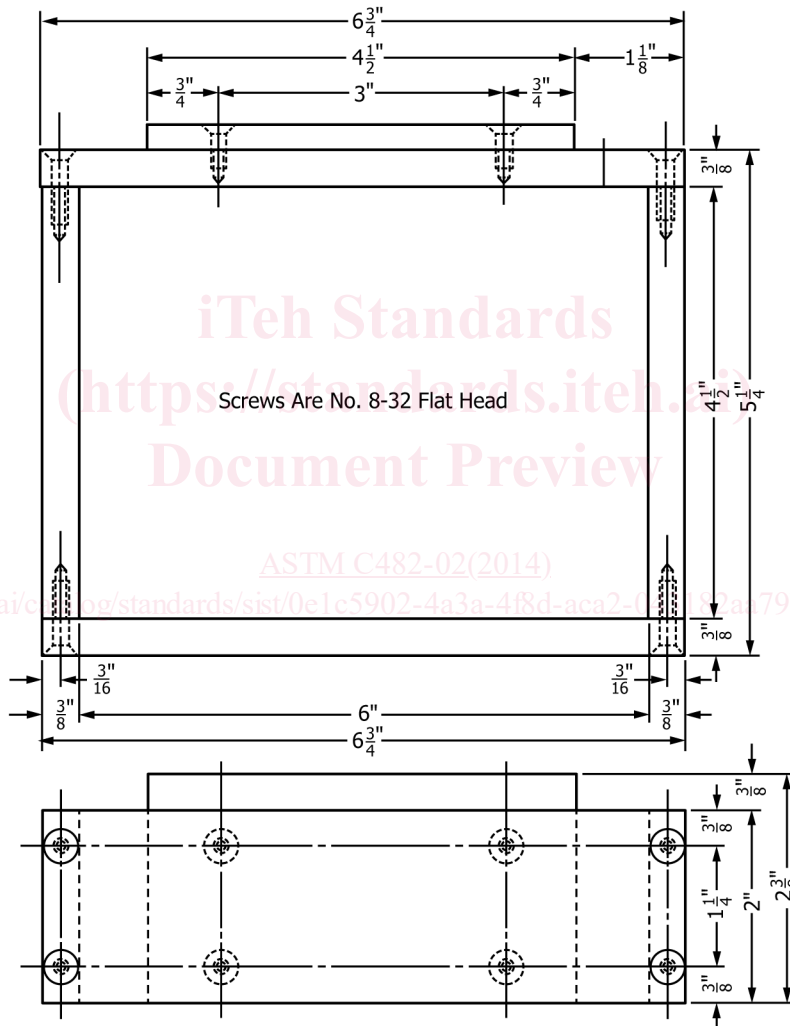
5. Significance and Use

5.1 This test method provides a means of determining whether or not tile of the types indicated in 1.1 can be bonded with adequate strength to portland cement paste. Tile specifications can refer to this test method in order to establish minimum bond strength limits appropriate to the service conditions that are anticipated.

5.2 Separation between bond coat and setting bed, or breakage of the setting bed itself shall not be considered failures of tile bond.

6. Apparatus

6.1 *Molds*—Five frame-type molds having inside dimensions 6 by 4½ by 2 in. (152 by 114 by 51 mm) in depth. The molds shall be made of ⅜-in. (9.5-mm) thick rigid material such as brass, and the inside faces of the molds shall present a smooth surface. They shall be constructed in such a manner that they can be taken apart without damage to the molded cement block. Diagrams of suitable molds are shown in Fig. 1.



Metric Equivalents

Letter	in.	mm
A	3/16	4.8
B	3/8	9.5
C	6	152
D	6 3/4	171
E	4 1/2	114
F	5 1/4	133
G	1 1/4	32
H	2	51

FIG. 1 Mold for Mortar Block (Five Required)