



Standard Specification for Industrial Floor Brick¹

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1. Scope

1.1 This specification covers brick made from clay or shale or mixtures thereof and are suitable for surfacing industrial floors. Ceramic shapes known as quarry tile are not covered by this specification. Four types of industrial floor brick are covered (Note 1):

1.1.1 *Type T*—For use where a high degree of resistance to thermal and mechanical shock is required but low absorption is not required.

1.1.2 *Type H*—For use where resistance to chemicals and thermal shock are service factors but low absorption is not required.

1.1.3 *Type M*—For use where low absorption is required. Brick of this type are normally characterized by limited mechanical (impact) shock resistance but are often highly resistant to abrasion.

1.1.4 *Type L*—For use where minimal absorption and a high degree of chemical resistance are required. Brick of this type are normally characterized by very limited thermal and limited mechanical (impact) shock resistance but are highly resistant to abrasion.

NOTE 1—*Discussion of Types of Floor Brick*—The four types of brick included in this specification are designed to cover the diverse needs of many industries for floor units. Recognizing that the requirements of primary aluminum producers for floor brick are quite different from those of chemical manufacturers, and similarly, that the needs of a builder for

brick with which to pave an airport terminal building may vary considerably from those of food processing plants, for example, a minimum of four brick types has been deemed necessary. The factors of absorption and chemical resistance have been selected as the bases for the classification system.

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

2. Referenced Documents

2.1 ASTM Standards:

- C 67 Test Methods of Sampling and Testing Brick and Structural Clay Tile²
- C 279 Specification for Chemical-Resistant Masonry Units²

3. Physical Properties

3.1 Brick shall conform to the physical requirements for the type specified as prescribed in Table 1.

4. Sizes

4.1 The sizes of brick shall be as specified by the purchaser. The maximum permissible variations in dimensions of individual units shall not exceed those given in Table 2.

5. Warpage

5.1 Tolerances for deviation of face or edges of individual brick from a plane surface and from a straight line, respectively, shall not exceed the maximum values specified in Table 3.

¹ This specification is under the jurisdiction of ASTM Committee C15 on Manufactured Masonry Units and is the direct responsibility of Subcommittee C15.09 on Chemical-Resistant Units.

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² *Annual Book of ASTM Standards*, Vol 04.05.

TABLE 1 Physical and Chemical Requirements

Designation	Minimum Modulus of Rupture (brick flatwise), psi (MPa) gross area		Maximum Water Absorption by 5 h Boiling, %		Maximum Mass Loss by Chemical Resistance Test, %
	Average of 5 Brick	Individual	Average of 5 Brick	Individual	
Type T	1000 (6.9)	750 (5.2)	10	12	^A
Type H	1000 (6.9)	750 (5.2)	6	7	20
Type M	2000 (13.8)	1500 (10.3)	2	2.5	^A
Type L	2000 (13.8)	1500 (10.3)	1	1.5	8

^A No requirement.

TABLE 2 Permissible Variations in Dimensions

Specified Dimensions, in. (mm)	Maximum Permissible Variations in Dimensions between Largest and Smallest Unit in One Lot, ^A in. (mm)
Up to 2 (50.8), incl	1/16 (1.6)
Over 2 to 4 (50.8 to 101.6), incl	1/2 (3.2)
Over 4 to 9 (101.6 to 228.6), incl	3/16 (4.8)
Over 9 to 12 (228.6 to 304.8), incl	1/4 (6.4)

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

TABLE 3 Tolerances on Warpage

Maximum Face Dimension, in. (mm)	Maximum Permissible Deviation, in. (mm)
Up to 9 (228.6), incl	1/16 (1.6)
Over 9 to 12 (228.6 to 304.8), incl	3/32 (2.4)

6. Texture

6.1 The texture of the finished surface that will be exposed when in place shall conform to an approved sample consisting of not less than four bricks, each representing the texture desired.

7. Sampling and Testing

7.1 The brick shall be sampled and tested for modulus of rupture, absorption, measurement of size, and measurement of warpage in accordance with Test Methods C 67 and for chemical resistance in accordance with the sulfuric acid solubility test in Section 7 on a sulfuric acid solubility test in Specification C 279.

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