

## Dimensions and Tolerances

BS EN771-1 requires that the dimensions of a clay masonry unit shall be declared by the manufacturer in millimetres for length, width and height, in that order. The manufacturer shall declare also which of the tolerance categories the mean values fulfill when measured to the test method detailed in BS EN 772-16).

10 bricks are randomly sampled, superfluous material removed and using long nosed calipers, or bespoke measuring device, measurements must be taken on individual bricks for length, width and height as shown.



(This should not be confused with PAS 70, which is a BSI Publicly Available Specification for measuring brick tolerances in the case of disputes on site, as the 771-1 reference method is impractical. In cases where there is impasse, the test method below will have to be performed either at the nearest factory or at Ceram Research which will cause delays on site.)

### TOLERANCE

#### MEAN VALUE

For each dimension in question, when 10 bricks have been measured, add the individual figures and then divide by 10, rounding to the nearest whole number (see separate procedure for height overleaf). Mean values should fall between the following limits:

*The tolerance is the difference between the calculated mean size and the stated work size.*

| Declared size mm | T1<br>Lower & upper limits | Tolerances mm | T2<br>Lower & upper limits | Tolerances mm | Tm<br><br>Deviation in mm declared by the manufacturer.<br>(may be wider or closer than the other categories). Please refer to the product data sheet for quoted figure. |
|------------------|----------------------------|---------------|----------------------------|---------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 40               | 37-43                      | ±3            | 38-42                      | ±2            |                                                                                                                                                                          |
| 50               | 47-53                      | ±3            | 48-52                      | ±2            |                                                                                                                                                                          |
| 65               | 62-68                      | ±3            | 63-67                      | ±2            |                                                                                                                                                                          |
| 68               | 65-71                      | ±3            | 66-70                      | ±2            |                                                                                                                                                                          |
| 73               | 70-76                      | ±3            | 71-75                      | ±2            |                                                                                                                                                                          |
| 80               | 76-84                      | ±4            | 78-82                      | ±2            |                                                                                                                                                                          |
| 90               | 86-94                      | ±4            | 88-92                      | ±2            |                                                                                                                                                                          |
| 102              | 98-106                     | ±4            | 99-105                     | ±3            |                                                                                                                                                                          |
| 190              | 184-196                    | ±6            | 186-194                    | ±4            |                                                                                                                                                                          |
| 215              | 209-221                    | ±6            | 211-219                    | ±4            |                                                                                                                                                                          |
| 225              | 219-231                    | ±6            | 221-229                    | ±4            |                                                                                                                                                                          |
| 227              | 221-233                    | ±6            | 223-231                    | ±4            |                                                                                                                                                                          |
| 290              | 283-297                    | ±7            | 286-294                    | ±4            |                                                                                                                                                                          |

e.g: if measurements for the declared length of 215mm are recorded as:  
216 +217+215.5+217+214+217.5+217.5+218+215+218 =2165.5mm divide by 10 = 216.55 (figures of .5 or higher are rounded up) 217mm, this would fall within the tolerance T2 which indicates the limits of 211 to 219mm.

# General Tolerance Din 7167

**CL Gary**



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