

BS EN 771-1 TECHNICAL INFORMATION SHEET

Site Size test – Mean dimensions (to PAS 70 method)

The EN771-1 reference method for determination of size tolerance is impractical for use on site, therefore BSI has published a Publicly Available Specification, PAS 70, formulated to resolve any complaints quickly and without using impractical equipment.

For complaints on size, sample 10 bricks by randomly choosing from a consignment, or, representatively sample by selecting 6 packs from a consignment or dividing the bricks available into 6 imaginary sections of equal size, taking out an equal number of not more than four from each section and choosing 10 at random from this selection.

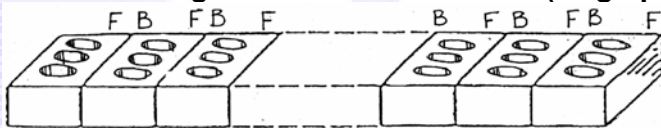
Remove any superfluous material, blisters or loose particles of clay adhering to each brick by rubbing bricks together.

Place the bricks in contact with each other in a straight line upon a level, flat surface, as shown in the diagram below, ensuring that all bricks are in the same direction. DO NOT fit bricks together by alternately turning them around.

LENGTH Arrangement A - Faces forward (frog up if applicable).

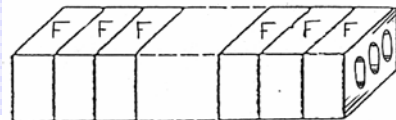


WIDTH Arrangement B - Face to back (frog up if applicable).



Since Ibstock supplies bricks to 102mm and not 102.5mm, measurements should be rounded to the nearest whole mm and Note 1 in PAS 70 ignored.

HEIGHT Arrangement C - Faces up (frog to one common side, if applicable).



Measure the overall dimension to the nearest millimetre using a retractable steel pocket rule. Then divide the figure by 10 to give the mean value for each dimension to the nearest whole mm. Compare the figure against the manufacturers stated tolerance for that product in the table below. The tolerance is the difference between the average calculated size and the work size.

(See separate worksheet)

Tolerance category	Length mm ±	Width mm ±	Height mm ±
T1	5	3	2
T2	3	2	1
Tm Birtley	6	5	5
Tm Funton	6	4	3
Tm Laybrook	3	2	2

These values are LOWER than those stated in BS EN771-1 and those quoted by the manufacturer in the case of Tm so that there is sufficient confidence that the result would be confirmed using the more detailed procedure.

A valid test can only be carried out in the presence of the supplier.

In practice, it may only be required to demonstrate 1 or 2 dimensions are within the tolerances stated.

For unresolved disputes, the sample of 10 bricks must be forwarded to the nearest factory for testing to BSEN772-16 using BS EN 771-1 procedures. If the Customer insists on independent verification then the sample must be sent to CERAM. This may cause delays on site.

**TECHNICAL SERVICES
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