

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 Lower & upper limits	Tolerances mm	T2 Lower & upper limits	Tolerances mm	Tm
40	37-43	±3	38-42	±2	Deviation in mm declared by the manufacturer. (may be wider or closer than the other categories). Please refer to the product data sheet for quoted figure.
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.

Bs En 771 1

Arturo Cuomo



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1. Understanding the eBook Bs En 771 1
 - The Rise of Digital Reading Bs En 771 1
 - Advantages of eBooks Over Traditional Books
2. Identifying Bs En 771 1
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Bs En 771 1
 - User-Friendly Interface
4. Exploring eBook Recommendations from Bs En 771 1
 - Personalized Recommendations
 - Bs En 771 1 User Reviews and Ratings
 - Bs En 771 1 and Bestseller Lists
5. Accessing Bs En 771 1 Free and Paid eBooks

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- Bs En 771 1 Public Domain eBooks
 - Bs En 771 1 eBook Subscription Services
 - Bs En 771 1 Budget-Friendly Options
6. Navigating Bs En 771 1 eBook Formats
 - ePub, PDF, MOBI, and More
 - Bs En 771 1 Compatibility with Devices
 - Bs En 771 1 Enhanced eBook Features
 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Bs En 771 1
 - Highlighting and Note-Taking Bs En 771 1
 - Interactive Elements Bs En 771 1
 8. Staying Engaged with Bs En 771 1
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Bs En 771 1
 9. Balancing eBooks and Physical Books Bs En 771 1
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Bs En 771 1
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Bs En 771 1
 - Setting Reading Goals Bs En 771 1
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Bs En 771 1
 - Fact-Checking eBook Content of Bs En 771 1
 - Distinguishing Credible Sources
 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development

- Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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