

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.

Din 7167

Gheorghe Ghibănescu



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Geometrical Dimensioning and Tolerancing for Design, Manufacturing and Inspection Georg

Henzold,2006-10-13 Geometrical tolerancing is used to specify and control the form location and orientation of the features of components and manufactured parts This book presents the state of the art of geometrical tolerancing covers the latest ISO and ANSI ASME standards and is a comprehensive reference and guide for all professional engineers designers CAD users quality managers and anyone involved in the creation or interpretation of CAD plans or engineering designs and specifications For all design and manufacturing engineers working with these internationally required design standards Covers ISO and ANSI geometrical tolerance standards including the 2005 revisions to the ISO standard Geometrical tolerancing is used in the preparation and interpretation of the design for any manufactured component or item essential information for designers engineers and CAD professionals Inspection-oriented Tolerancing - Size, Form and Location

Robert Roithmeier,2016-10-13 *Handbook of Geometrical Tolerancing* G. Henzold,1995-05-30 This book presents the state of the art regarding geometrical tolerancing It describes the international standardisation laid down in ISO Standards and the differences with the American National Standards ANSI and the East European Standards Additional specifications laid down in the British and German standards DIN Standards are also addressed New techniques e g vectorial dimensioning and tolerancing statistical tolerancing and general geometrical tolerancing are explained Hints for manufacturing according to geometrical tolerancing are given Principles for the inspection of geometrical deviations are outlined providing a basis for tolerancing suitable for inspection Examples for tolerancing appropriate to various functional requirements are given

Production Metrology Tilo Pfeifer,2015-03-10 This work presents the systematics of production metrology starting from the inspection planning across the recording of the inspected data up to the evaluation of this data On the one hand the reader will be supplied with basic knowledge for the understanding of the presented procedures and their practical use On the other hand he will also learn about the importance of production metrology for quality control in production processes It is not only an indispensable reference book for the daily work of the engineer but also a invaluable and easy to read text book for students As a supplement for the studies the book gives a fast overlook to the basics of production metrology and at the same time shows how this knowledge is put into practice **Automotive Handbook** Robert Bosch GmbH,2022-05-02 The

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