

# SITE PRACTICE AND TROUBLESHOOTING SIZE TOLERANCES & MEASUREMENT - SPECIAL-SHAPED BRICKS

To establish a mean size for specials of the same Length-Width-Height format as a standard brick, the three prime dimensions A – B– C, are measured in the same way using the PAS 70 brick test. Any remaining dimensions (D, E, F etc) are classed as ‘non-critical’ and guidelines are set out below.

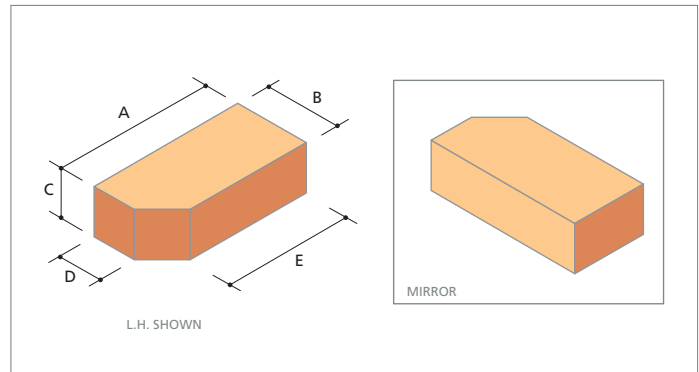
## TOLERANCES

The main dimensions, A, B & C are usually taken to be the same tolerance as the main-line version (T1, T2 or Tm).

Individual measurements can be taken due to unusual shapes, as the 10 brick test may not be feasible on site in some cases.

The non- critical measurements have a tolerance too taking into account the quoted dimension.

For example, referring to the table below taken from BS 4729, the up-stand of a wirecut cant, quoted as 46mm for the AN5.1 and 60mm for



Type No.	A	B	C	D	E
AN.5.1	215	102	65	46	159
AN.5.2	215	102	65	60	173

the AN5.2, both fall into the 21-120mm dimension meaning they have a tolerance of plus or minus 2 mm.

Any dimension labeled as A; B or C is to be measured to an accuracy as specified in BS EN 772-1:6 taking a single measurement along the centre of the special shape. These dimensions are regarded as “critical” and will conform to the tolerance declared in BS EN 771 - 1 as T1, T2/Tm.

All other dimensions (D; E; F etc) are regarded as “non-critical” and can be measured by any suitable device (eg steel rule, flexible tape etc) to an accuracy of the nearest whole mm.

The tolerances which apply to these non critical dimensions are given in the table below.

Dimension	Tolerance (Wirecut)	Tolerance (Moulded)
Up to (and including) 20mm	±1.5mm	±2.0mm
>21 to 120mm	±2.0mm	±3.0mm
>121 to 220mm	±3.0mm	4.0mm
>221 to 300mm	±4.0mm	±5.0mm
>301mm	±4.5mm	±5.0mm

## ANGLES

Where angular faces are featured in the special shape, the angle should comply with a tolerance of +/- 1° as measured with a protractor which itself should be calibrated with an accuracy of +/- 1°.

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