Standard Test Methods for Sampling and Testing Concrete Masonry Units and Related Units

This standard is issued under the fixed designation C140; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (e) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 These test methods provide various testing procedures commonly used for evaluating characteristics of concrete masonry units and related concrete units. Methods are provided for sampling, measurement of dimensions, compressive strength, absorption, unit weight (density), moisture content, flexural load, and ballast weight. Not all methods are applicable to all unit types, however.

1.2 Specific testing and reporting procedures are included in annexes to these test methods for the following specific unit types:

- Annex A1—Concrete masonry units (Specifications C90, C129)
- Annex A2—Concrete and calcium silicate brick (Specifications C55, C73, C1634)
- Annex A3—Segmental retaining wall units (Specification C1372)
- Annex A4—Concrete interlocking paving units (Specification C936/C936M)
- Annex A5—Concrete grid paving units (Specification C1319)
- Annex A6—Concrete roof pavers (Specification C1491)
- Annex A7—Dry-cast articulating concrete block (Specification D6884)

1.3 The test procedures included in these test methods are also applicable to other types of units not referenced in these test methods, but specific testing and reporting requirements for those units are not included.

1.4 These test methods include the following sections:

- Scope
- Referenced Documents
- Terminology
- Significance and Use
- Sampling
- Measurement of Dimensions
- Compressive Strength
- Absorption
- Calculations
- Report
- Keywords

1.5 The values stated in inch-pound units are to be regarded as the standard, except in Annex A4, where either SI units or inch-pound units are to be regarded separately as standard. The values given in parentheses throughout are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.6 This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. Referenced Documents

2.1 ASTM Standards:

- C55 Specification for Concrete Building Brick
- C73 Specification for Calcium Silicate Brick (Sand-Lime Brick)

2 For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For Annual Book of ASTM Standards volume information, refer to the standard’s Document Summary page on the ASTM website.

*A Summary of Changes section appears at the end of this standard.
3. Terminology

3.1 Terminology defined in Terminologies C1232 and E6 shall apply for these test methods.

4. Significance and Use

4.1 These test methods provide general testing requirements for application to a broad range of concrete products. Those general testing requirements are included in the body of this standard.

NOTE 2—Consult manufacturer, supplier, product specifications, or other resources for more specific measurement or testing guidelines for those products not addressed with the annex of this standard.

4.2 These test methods provide specific testing requirements in two distinct sections, the requirements applicable to all units covered by these test methods and those applicable to the specific unit types. The requirements applicable to all units are included in the body of these test methods and those applicable to the specific unit types are included within the annexes.

5. Sampling

5.1 Selection of Test Specimens:

5.1.1 For purposes of testing, full-sized units shall be selected by the purchaser or authorized representative. The selected specimens shall be of similar configuration and dimensions. Specimens shall be representative of the whole lot of units from which they are selected.

5.1.2 The term “lot” refers to any number of concrete masonry units of any configuration or dimension manufactured by the producer using the same materials, concrete mix design, manufacturing process, and curing method.

5.2 Number of Specimens:

5.2.1 Unless specified otherwise in the applicable annex, a set of units shall consist of six full-size units.

5.2.2 Unless specified otherwise in the applicable annex, for the compressive strength, absorption, unit weight (density), and moisture content determinations, one set of units shall be selected from each lot of 10,000 units or fraction thereof and two sets of units from each lot of more than 10,000 and less than 100,000 units. For lots of more than 100,000 units, one set of units shall be selected from each 50,000 units or fraction thereof contained in the lot. Additional specimens shall be taken if directed by the purchaser.

5.3 Remove loose material from the specimens (including the cores) prior to determining the received weight.

NOTE 3—An abrasive stone or wire brush is typically used to remove loose material.

5.4 Identification—Mark each specimen so that it may be identified at any time. Markings shall cover not more than 5% of the surface area of the specimen.

5.5 Received Weight—Weigh each specimen immediately after sampling and marking, and record as \( W_r \) (received weight). Record time and place \( W_r \) was measured.

NOTE 4—Received weights often have direct relationships with other unit properties and are therefore a useful method of evaluating results or for sorting purposes. The weight of a concrete masonry unit and related unit changes with time and exposure conditions, primarily as a result of the moisture within the unit. Therefore, to understand the context of a received weight value, it is also important to understand the point in time and the frame of reference when that weight was determined. “Time and place” should not refer to when and where the unit was sampled but when and where the received weights were determined.

In addition to date and time references, it is also important to know if those weights were determined after units reached equilibrium with lab environment, or before units were shipped, or after delivery to the job site, and so forth.

6. Measurement of Dimensions

6.1 Apparatus:

6.1.1 Measurement Devices—Devices used to measure specimen dimensions shall have divisions not greater than 0.1 in. (2.5 mm) when the dimension is to be reported to the nearest 0.1 in. (2.5 mm) and not greater than 0.01 in. (0.25 mm) when the dimension is to be reported to the nearest 0.01 in. (0.25 mm).

6.1.2 Measuring devices shall be readable and accurate to the division required to be reported. Accuracy shall be verified at least once annually. Verification record shall include date of verification, person or agency performing verification, identification of reference standard used, test points used during verification, and readings at test points.

6.2 Specimens—Three full-size units shall be selected for measurement of dimensions.

6.3 Measurements—Measure specimens in accordance with the applicable annex of this standard. For those products not covered by the annexes of this standard, measure overall dimensions (width, height, length) in at least two locations on opposite sides of the specimen to the nearest division required to be reported. Document location of each measurement on a sketch or photograph of the specimen.

NOTE 5—Specimens used for measurement of dimensions may be used in other tests.

NOTE 6—Calipers, micrometers, and steel scales and dividers of the appropriate accuracy and readability have been shown to be adequate for these measurements.

7. Compressive Strength

7.1 Test Apparatus:
7.1.1 The testing machine shall have an accuracy of ±1.0 % over the anticipated load range. The upper platen shall be a spherically seated, hardened metal block firmly attached at the center of the upper head of the machine. The center of the sphere shall lie at the center of the surface held in its spherical seat but shall be free to turn in any direction, and its perimeter shall have at least ¼ in. (6.3 mm) clearance from the head to accommodate specimens whose bearing surfaces are not parallel. The diameter of the upper platen (determined in accordance with Annex A8) shall be at least 6 in. (150 mm). A hardened metal bearing plate may be used beneath the specimen to minimize wear of the lower platen of the machine.

7.1.2 When the bearing area of the upper platen or lower platen is not sufficient to cover the area of the specimen, a single steel plate with a thickness equal to at least the distance from the edge of the platen to the most distant corner of the specimen shall be placed between the platen and the capped specimen. The length and width of the steel plate shall be at least ¼ in. (6 mm) greater than the length and width of the units.

7.1.3 The surfaces of the platen or plate intended for contact with the specimen shall have a hardness not less than HRC 60 (BHN 620). The surfaces of the platen and plate shall not depart from plane surfaces by more than 0.001 in. (0.03 mm) in any 6 in. (150 mm) dimension.

**NOTE:** Research has shown that thickness of bearing plates has a significant effect on the tested compressive strength of masonry units when the bearing area of the platen is not sufficient to cover the area of the specimen. Plate bending results in nonuniform stress distributions that can influence the failure mechanisms of the tested specimens. The magnitude of this effect is controlled by the stiffness of the plate, the size of the specimen tested, and the strength of the specimen. Tested compressive strengths will typically increase with increased plate thickness and with reduced distance to the furthest corner of the specimen. Some testing laboratories have limitations that limit the practicality of eliminating plate bending entirely. Therefore the plate thickness requirements in 7.1 are intended to provide an adequate level of accuracy in the compression test results so as to conform to the limits of practicality of the testing laboratory.

**NOTE:** Annex A8 includes guidance on determining the required plate thickness based on the configuration of the test specimen and the test machine.

7.1.4 The testing machine shall be verified in accordance with Practices E4 at a frequency defined by Practice C1093.

7.2 Test Specimens:

7.2.1 Unless specified otherwise in the applicable annex, test three specimens in compression.

7.2.2 When possible and unless specified otherwise in the applicable annex, specimens shall be full-sized units. When the units cannot be tested full-size due to specimen configuration or testing machine requirements, reduce the specimen size in accordance with Annex A1.

7.2.3 After delivery to the laboratory, store compression specimens (unstacked and separated by not less than 0.5 in. (13 mm) on all sides) continuously in air at a temperature of 75 ± 15°F (24 ± 8°C) and a relative humidity of less than 80 % for not less than 48 h. Alternatively, if compression results are required sooner, store units unstacked in the same environment described above with a current of air from an electric fan passing over them for a period of not less than 4 h. Continue passing air over the specimens until two successive weighings at intervals of 2 h show an increment of loss not greater than 0.2 % of the previously determined weight of the specimen and until no moisture or dampness is visible on any surface of the unit. Specimens shall not be subjected to oven-drying.

**NOTE:** In this test method, net area (other than certain solid units, see 9.4) is determined from specimens other than those subjected to compression testing. The compressive strength method is based on the assumption that units used for determining net volume (absorption specimens) have the same net volume as units used for compression testing. Sampled split face units, which have irregular surfaces, should be divided at the time they are sampled from the lot, such that the absorption test specimens have a net volume that is visually representative and a weight that is representative of the compression test specimens.

7.2.4 Where saw-cutting of test specimens is allowed or required by the standard or applicable annex, sawing shall be performed in an accurate, competent manner, subjecting the specimen to as little saw vibration as possible. Use a diamond saw blade of proper hardness. If the specimen is wetted during sawing, allow the specimen to dry to equilibrium with laboratory air conditions before testing, using the procedures outlined in 7.2.3.

7.2.5 If compression test specimens have been saw-cut from full-sized units and the net area of the compression test specimens can not be determined by 9.4.1, saw-cut an additional three units to the dimensions and configuration of the three compression test specimens. The average net area for the saw-cut compression specimens shall be taken as the average net area of the additional three saw-cut units calculated as required in 9.4. Calculated net volumes of saw-cut specimens shall not be used in calculating equivalent thickness.

7.3 Capping—Cap test specimens in accordance with Practice C1552.

7.4 Compression Testing Procedure:

7.4.1 **Position of Specimens**—Test specimens with the centroid of their bearing surfaces aligned vertically with the center of thrust of the spherically seated steel bearing block of the testing machine (Note 10). Except for special units intended for use with their cores in a horizontal direction, test all hollow concrete masonry units with their cores in a vertical direction. Test masonry units that are 100 % solid and special hollow units intended for use with their hollow cores in a horizontal direction in the same direction as in service. Prior to testing each unit, ensure that the upper platen moves freely within its spherical seat to attain uniform seating during testing.

**NOTE:** For those masonry units that are symmetrical about an axis, the location of that axis can be determined geometrically by dividing the dimension perpendicular to that axis (but in the same plane) by two. For those masonry units that are nonsymmetrical about an axis, the location of that axis can be determined by balancing the masonry unit on a knife edge or a metal rod placed parallel to that axis. If a metal rod is used, the rod shall be straight, cylindrical (able to roll freely on a flat surface), have a diameter of not less than $\frac{1}{4}$ in. (6.4 mm) and not more than $\frac{3}{4}$ in. (19.1 mm), and its length shall be sufficient to extend past each end of the specimen when placed upon it. The metal rod shall be placed on a smooth, flat, level surface. Once determined, the centroidal axis shall be marked on the end of the unit using a pencil or marker having a marking width of not greater than 0.05 in. (1.3 mm). A tampering rod used for consolidation of concrete and grout for slump tests performed in accordance with Test Method C143/C143M is often used as a balancing rod.
7.4.2 Moisture Condition of Specimens—At the time the specimens are tested, they shall be free of visible moisture or dampness.

7.4.3 Speed of Testing—Apply the load (up to one half of the expected maximum load) at any convenient rate, after which adjust the controls of the machine as required to give a uniform rate of travel of the moving head such that the remaining load is applied in not less than 1 nor more than 2 min.

7.4.4 Maximum Load—Record the maximum compressive load in pounds (newtons) as $P_{\text{max}}$.

8. Absorption

8.1 Apparatus—The balance used shall be sensitive to within 0.5 % of the weight of the smallest specimen tested.

8.2 Test Specimens:

8.2.1 Unless specified otherwise in the applicable annex, test three specimens in absorption.

8.2.2 Unless specified otherwise in the applicable annex, tests shall be performed on full-sized units or specimens saw-cut from full-sized units. Calculated values for absorption and density of reduced-size absorption specimens shall be considered as representative of the whole unit.

8.2.2.1 When test specimens are saw-cut from full-sized units, the test specimen shall have an initial weight after cutting of no less than 20 % of the initial received weight of the full-sized unit.

Note 11—When performing absorption tests on reduced-sized specimens, it is preferable to have a test specimen that is as large as practically possible and can be accommodated by laboratory equipment. This helps to reduce any location-specific variability from the absorption results.

8.3 Procedure:

8.3.1 Saturation—Immerse the test specimens in water at a temperature of 60 to 80°F (15.6 to 26.7°C) for 24 to 28 h such that the top surfaces of the specimens are no less than 6 in. (152 mm) below the surface of the water. Specimens shall be separated from each other and from the bottom of the immersion tank by at least ½ in. (3.1 mm). Weigh the specimens while suspended by a metal wire and completely submerged in water and record $W_s$ (immersed weight). Remove from the water and allow to drain for 60 ± 5 s by placing them on a ¾-in. (9.5-mm) or coarser wire mesh, removing visible surface water with a damp cloth; weigh and record as $W_d$ (oven-dry weight).

8.3.2 Drying—Subsequent to saturation, dry all specimens in a ventilated oven at 212 to 239°F (100 to 115°C) for not less than 24 h and until two successive weighings at intervals of 2 h show an increment of loss not greater than 0.2 % of the last previously determined weight of the specimen. Record weight of dried specimens as $W_d$ (oven-dry weight).

9. Calculations

9.1 Absorption—Calculate absorption as follows:

Absorption, lb/ft³ = \( \frac{W_s - W_d}{(W_s - W_i)} \times 62.4 \)\hspace{1cm} (1)

Absorption, kg/m³ = \( \frac{W_s - W_d}{(W_s - W_i)} \times 1000 \)

Absorption, % = \( \frac{W_s - W_d}{W_i} \times 100 \)

where:

$W_s$ = saturated weight of specimen, lb (kg),

$W_i$ = immersed weight of specimen, lb (kg), and

$W_d$ = oven-dry weight of specimen, lb (kg).

9.2 Moisture Content—Calculate the moisture content of the unit at the time it is sampled (when $W_s$ is measured) as follows:

Moisture Content, % of total absorption = \( \frac{(W_s - W_d)(W_s - W_i)}{W_s} \times 100 \)\hspace{1cm} (2)

where:

$W_s$ = received weight of unit, lb (kg),

$W_d$ = oven-dry weight of unit, lb (kg), and

$W_i$ = saturated weight of unit, lb (kg).

Note 12—When determining the moisture content of a unit or set of units, the value determined is a measure of the water content of a unit based upon the received weight of the unit $W_s$. Thus, the moisture content calculation above is only applicable to the unit moisture content at the time the received weight, $W_s$, is obtained.

9.3 Density—Calculate oven-dry density as follows:

Density (D), lb/ft³ = \( \frac{W_s}{(W_s - W_d)} \times 62.4 \)\hspace{1cm} (3)

Density (D), kg/m³ = \( \frac{W_s}{(W_s - W_d)} \times 1000 \)

where:

$W_d$ = oven-dry weight of specimen, lb (kg),

$W_s$ = saturated weight of specimen, lb (kg), and

$W_i$ = immersed weight of specimen, lb (kg).

9.4 Average Net Area—Calculate average net area as follows:

\[ \text{Net Volume} (V_n), \text{ft}^3 = W_s/D = (W_s - W_d)/62.4 \] \hspace{1cm} (4)

\[ \text{Net Volume} (V_n), \text{mm}^3 = W_s/D = (W_s - W_d) \times 10^9 \]

Average Net Area ($A_n$), in.² = \( V_n/1728/H \)

Average Net Area ($A_n$), mm² = \( V_n/H \)

where:

$V_n$ = net volume of specimen, ft³ (mm³),

$W_s$ = oven-dry weight of specimen, lb (kg),

$D$ = oven-dry density of specimen, lb/ft³ (kg/m³),

$W_s$ = saturated weight of specimen, lb (kg),

$W_d$ = immersed weight of specimen, lb (kg),

$A_n$ = average net area of specimen, in.² (mm²), and

$H$ = average height of specimen, in. (mm).

9.4.1 Except for irregularly shaped specimens, such as those with split surfaces, calculate the net area of coupons and those specimens whose net cross-sectional area in every plane parallel to the bearing surface is the gross cross-sectional area measured in the same plane, as follows:

\[ \text{Net Area} (A_n), \text{in.}^2 = L \times W \] \hspace{1cm} (5)

where:

$A_n$ = net area of the coupon or specimen, in.² (mm²),

$L$ = average length of the coupon or specimen, in. (mm), and

$W$ = average width of the coupon or specimen, in. (mm).

9.5 Gross Area—Calculate gross area as follows:

\[ \text{Gross Area} (A_g), \text{in.}^2 = L \times W \] \hspace{1cm} (6)
where:
\[ A_g = \text{gross area of the specimen, in.}^2 (\text{mm}^2), \]
\[ L = \text{average length of the specimen, in. (mm), and} \]
\[ W = \text{average width of the specimen, in. (mm).} \]

9.5.1 The gross cross-sectional area of a specimen is the total area of a section perpendicular to the direction of the load, including areas within cells and reentrant spaces, unless these spaces are to be occupied in the masonry by portions of adjacent masonry.

9.6 Compressive Strength:

9.6.1 Net Area Compressive Strength—Calculate the net area compressive strength of the specimen as follows:

\[ \text{Net Area Compressive Strength, psi (MPa)} = \frac{P_{max}}{A_n} \quad (7) \]

where:
\[ P_{max} = \text{maximum compressive load, lb (N)} \]
\[ A_n = \text{average net area of specimen, in.}^2 (\text{mm}^2). \]

9.6.2 Gross Area Compressive Strength—Calculate the gross area compressive strength of the specimen as follows:

\[ \text{Gross Area Compressive Strength, psi (MPa)} = \frac{P_{max}}{A_g} \quad (8) \]

where:
\[ P_{max} = \text{maximum compressive load, lb (N)} \]
\[ A_g = \text{gross area of specimen, in.}^2 (\text{mm}^2). \]

10. Report

10.1 For the purpose of reporting test results, all observed or calculated values shall be rounded using the following procedure:

10.1.1 When the digit immediately after the last place to be retained is less than 5, retain unchanged the digit in the last place retained.

10.1.2 When the digit immediately after the last place to be retained is greater than or equal to 5, increase by 1 the digit in the last place retained.

Note 13—As an example, density results are required to be reported to the nearest 0.1 lb/ft\(^3\) (1 kg/m\(^3\)). A calculated value of 130.85 lb/ft\(^3\) should be reported as 130.9 lb/ft\(^3\).

10.2 A complete report shall include the following general information:

10.2.1 Name and address of the testing laboratory,

10.2.2 Identification of the report and the date of issue,

10.2.3 Name and address of the client or the identification of the project,

10.2.4 Description and identification of the test sample,

10.2.5 Date of receipt of the test sample,

10.2.6 Date(s) of test performance,

10.2.7 Identification of the standard test method used and a notation of any known deviation from the test method,

10.2.8 Name of the person(s) accepting technical responsibility for the test report,

10.2.9 Age of test specimens, if known,

10.2.10 Identification of subcontractor test results, and

10.2.11 A photograph, sketch, or description of the configuration of the unit.

10.3 Unless specified otherwise in the applicable annex, a complete report shall include the following test results for the tests performed:

10.3.1 The average width, height and length to the nearest 0.1 in. (2.5 mm) separately for each specimen and as the average for the three specimens tested.

10.3.2 The net area to the nearest 0.1 in.\(^2\) (65 mm\(^2\)) separately for each specimen and as the average for the three specimens tested.

10.3.3 The maximum load separately for each specimen and as the average for the three specimens tested. Record the load as indicated to the nearest 10 lb (5 N) or the minimum resolution of the test machine as used during testing, whichever is greater.

10.3.4 The net area compressive strength to the nearest 10 psi (0.1 MPa) separately for each specimen and as the average for the three specimens tested.

10.3.5 The immersed, saturated, and oven dry weights (W\(_i\), W\(_s\), and W\(_d\)) to the nearest 0.1 lb (0.05 kg) separately for each specimen and as the average for the three specimens tested.

10.3.6 The absorption to the nearest 0.1 lb/ft\(^3\) (1 kg/m\(^3\)) separately for each specimen and as the average for the three specimens tested.

10.3.7 The density to the nearest 0.1 lb/ft\(^3\) (1 kg/m\(^3\)) separately for each specimen and as the average for the three specimens tested.

10.3.8 When required, the received weight (W\(_r\)) to the nearest 0.1 lb (0.05 kg) and the moisture content to the nearest 0.1 % separately for each specimen and as the average for the three specimens tested. The time when the moisture content is determined (when W\(_r\) is measured) shall also be reported.

10.3.9 The size and configuration of the specimens tested for compressive strength and absorption.

10.4 A complete report shall also include the other reporting requirements from the applicable annex.

11. Keywords

11.1 absorption; compressive strength; concrete masonry units; density; equivalent thickness; equivalent web thickness; face shell; moisture content; roof paver; webs; web thickness
A1. TEST PROCEDURES FOR CONCRETE MASONRY UNITS

A1.1 Scope
A1.1.1 This annex includes testing requirements that are particular for concrete masonry units that are manufactured for compliance with the following unit specifications: C90, C129.

A1.2 Measurement
A1.2.1 For each unit, measure and record the width (W) across the top and bottom bearing surfaces at mid-length, height (H) at mid-length of each face, and length (L) at mid-height of each face to the nearest division required to be reported.
A1.2.2 For each unit, measure the face shell thicknesses (ts) and web thicknesses (tw) at the thinnest point of each such element ½ in. (12.7 mm) down from the top surface of the unit as manufactured (typically the bottom surface of the unit as laid) and record to the nearest division required to be reported. Disregard grooves, scores, and similar details in the measurements.
A1.2.3 For each unit, when the thinnest point of opposite face shells differ in thickness by less than ¼ in. (3.2 mm), calculate the minimum face shell thickness by averaging the recorded measurements. When the thinnest points differ by more than ¼ in. (3.2 mm), the minimum face shell thickness shall be taken as the smaller of the two recorded measurements.
A1.2.4 For each unit, calculate the average minimum web thickness by averaging all web measurements with a thickness of 0.75 in. (19.1 mm) or greater.

NOTE A1.1—Webs with a thickness of less than 0.75 in. (19.1 mm) do not typically contribute to the unit’s structural stability. Such webs should not be included in the average minimum web thickness calculation.

A1.3 Compressive Strength Testing
A1.3.1 Test Specimens—Specimens shall be full-sized units except as modified in A1.3.1.1 through A1.3.1.3.
A1.3.1.1 Unsupported projections having a length greater than the thickness of the projection shall be removed by saw-cutting. For units with recessed webs, the face shell projecting above the web shall be removed by saw-cutting to provide a full bearing surface over the net cross section of the unit. Where the resulting unit height would be reduced by more than one-third of the original unit height, the unit shall be coupon tested in accordance with A1.3.1.3.
A1.3.1.2 When compression testing full-sized units that are too large for the test machine’s bearing block and platens or are beyond the load capacity of the test machine, saw-cut the units to properly size them to conform to the capabilities of the testing machine. The resulting specimen shall have no face shell projections or irregular webs and shall be fully enclosed in a four-sided cell or cells. The compressive strength of the segment shall be considered to be the compressive strength of the whole unit.
A1.3.1.3 When compression testing units of unusual size and shape (see Note A1.2), the specimens shall be saw-cut to remove any face shell projections. The resulting specimen shall be a cell or cells containing four sides that will ensure a 100% bearing surface. Where saw-cutting will not result in an enclosed four-sided unit, the specimen shall be a coupon cut from a face shell of each unit. The coupon size shall have a height to thickness ratio of 2 to 1 before capping and a length to thickness ratio of 4 to 1. The thickness of the coupon shall be as large as possible based on the configuration of the unit and the capacities of the testing machine and shall not be less than 1.25 in. (30 mm). The coupon shall be cut from the unit such that the coupon height dimension is in the same direction as the unit’s height dimension. The compressive strength of the coupon shall be the net area compressive strength of the whole unit.

NOTE A1.2—Examples of units having unusual size or shape include, but are not limited to, bond beam units, open end units, and pilaster units.

A1.3.2 Testing—Cap and test specimens in accordance with 7.3 and 7.4.

A1.4 Absorption Testing
A1.4.1 Test Specimens—Specimens shall be in accordance with 8.2 except as modified in A1.4.1.1.
A1.4.1.1 Tests shall be performed on full-size units when test results are to be used to determine moisture content in accordance with 9.2 or equivalent thickness in accordance with A1.5.3.
A1.4.2 Testing—Perform absorption tests in accordance with 8.3.

A1.5 Calculations
A1.5.1 Calculate absorption, moisture content, density, average net area, and net area compressive strength in accordance with Section 9.
A1.5.2 Equivalent Web Thickness—Equivalent web thickness of each unit (in inches per linear foot of specimen) is equal to the sum of the measured thicknesses of all webs whose individual thickness is equal to or greater than 0.75 in. (19.1 mm) in the unit multiplied by 12 and divided by the length of the unit.

NOTE A1.3—Equivalent web thickness does not apply to the portion of the unit to be filled with grout. The length of that portion should be deducted from the overall length of the unit.
A1.5.3 Equivalent Thickness—Equivalent thickness for concrete masonry is defined as the average thickness of solid material in the unit and is calculated as follows:

\[ T_e, \text{ in.} = \left[ V_n / (L \times H) \right] \times 1728 \] \hspace{1cm} (A1.1)

\[ T_e, \text{ mm} = \left[ V_n / (L \times H) \right] \times 100 \]

where:

- \( T_e \) = equivalent thickness, in. (mm),
- \( V_n \) = average net volume of full-size units, \( \text{ft}^3 \) (mm\(^3\)) (see 9.4),
- \( L \) = average length of full-size units, in. (mm) (see A1.2.1), and
- \( H \) = average height of full-size units, in. (mm) (see A1.2.1).

A1.5.3.1 Equivalent thickness shall only be calculated and reported for full-size concrete masonry units.

A1.5.4 Percent Solid—Calculate the percent solid as follows:

\[ \text{Percent solid, } \text{ft}^3 (\%) = \left( \frac{V_n}{L \cdot W \cdot H} \right) \times 100 \] \hspace{1cm} (A1.2)

\[ \text{Percent solid, } \text{mm}^3 (\%) = \left( \frac{V_n}{L \cdot W \cdot H} \right) \times 100 \]

where:

- \( V_n \) = net volume of specimen, \( \text{ft}^3 \) (mm\(^3\)) (see 9.4),
- \( L \) = average length of specimen, in. (mm) (see A1.2.1),
- \( W \) = average width of specimen, in. (mm) (see A1.2.1), and
- \( H \) = average height of specimen, in. (mm) (see A1.2.1).

NOTE A1.4—This calculation determines the percentage of concrete in the gross volume of the unit. It is a useful reference value, but it is not a requirement of unit specifications. This value is not comparable to the definition of a solid unit in C90 and C129, which refers to the net cross-sectional area of every plane parallel to the bearing surface relative to the gross cross-sectional area of the same plane.

A1.5.5 Maximum Variation from Specified Dimensions:

A1.5.5.1 Determine the variation from each specified dimension by calculating the average width, height, and length of each specimen and comparing each average to the respective specified dimension, resulting in three variation results for each unit and nine results for a set of units. Determine the maximum variation for the set by identifying the maximum of the nine values.

A1.5.5.2 Specified dimensions shall be obtained from the unit manufacturer.

A1.6 Report

A1.6.1 Test reports shall include all of the information in Sections 10.2, 10.3, and the following:

A1.6.1.1 The minimum face shell thickness to the nearest 0.01 in. (0.25 mm) separately for each specimen and as the average for the three specimens tested.

A1.6.1.2 The minimum web thickness to the nearest 0.1 in. (2.5 mm) separately for each specimen and as the average for the three specimens tested.

A1.6.1.3 The equivalent web thickness to the nearest 0.1 in. (2.5 mm) as the average for the three specimens tested.

A1.6.1.4 The equivalent thickness to the nearest 0.1 in. (2.5 mm) as the average for the three specimens tested.

A1.6.1.5 The percent solid results to the nearest 0.1 % separately for each specimen and as the average for the three specimens tested.

A1.6.1.6 Maximum variation from specified dimensions to the nearest 0.1 in. (2.5 mm) for the set of specimens tested.

A1.6.1.7 The gross area to the nearest 0.1 in.\(^2\) (65 mm\(^2\)) separately for each specimen and as the average for the three specimens tested.

A1.6.1.8 The gross area compressive strength to the nearest 10 psi (0.1 MPa) separately for each specimen and as the average for the three specimens tested.

A1.6.1.9 The net volume to the nearest 0.01 \( \text{ft}^3 \) (0.0002 \( \text{m}^3 \)) separately for each specimen and as the average for the three specimens tested.

A2. TEST PROCEDURES FOR CONCRETE AND CALCIUM SILICATE BRICK

A2.1 Scope

A2.1.1 This annex includes testing requirements that are particular for concrete brick that are manufactured for compliance with the following unit specifications: C55, C73, and C1634.

A2.2 Measurement of Dimension

A2.2.1 For each unit, measure and record the width (\( W \)) across the top and bottom bearing surfaces at mid-length, height (\( H \)) at mid-length of each face, and length (\( L \)) at mid-height of each face to the nearest division required to be reported.

A2.2.2 For brick containing cores, measure \( \frac{1}{2} \) in. down from the top surface of the unit and record the minimum distance from the any edge of each brick to the nearest edge of the nearest core to the nearest division required to be reported.

A2.3 Compressive Strength Testing

A2.3.1 Test Specimens—Specimens shall be full-sized units except as modified in A2.3.1.1 and A2.3.1.2.

A2.3.1.1 When compression testing full-sized units that are too large for the test machine’s bearing block and platens or are beyond the load capacity of the test machine, saw-cut the units to properly size them to conform to the capabilities of the testing machine. The resulting specimen shall have no projections or irregular features and cores shall be fully enclosed. The compressive strength of the segment shall be considered to be the compressive strength of the whole unit.

A2.3.1.2 Tested specimens shall have an aspect ratio (height divided by its least lateral dimension, \( h/t \)) of 0.6 \pm 0.1. If full-size units are not within that dimensional ratio requirement, the units shall be saw-cut to produce a compression test specimen with that dimensional ratio prior to capping. The
A2.2.1 Measurement of Dimensions

A2.2.1.1 For each unit, measure and record the width \((W)\) across the top and bottom bearing surfaces at mid-length, height \((H)\) at mid-length of each face, and length \((L)\) at mid-height of each face to the nearest division required to be reported.

A2.2.2 Absorption Testing

A2.2.2.1 Test Specimens—Specimens shall be in accordance with 8.2 except as modified in A2.2.1.1.

A2.2.2.2 Tests shall be performed on full-size units when test results are to be used to determine equivalent thickness.

A2.2.2.3 Testing—Perform absorption tests in accordance with 8.3.

A2.5 Calculations

A2.5.1 Calculate absorption, moisture content, and density per Section 9.

A2.5.2 For units tested to determine compliance with Specifications C55 or C1634, calculate net area as per 9.4 and net area compressive strength as per 9.6.1.

A2.5.3 For units tested to determine compliance with Specification C73, calculate gross area per 9.5 and gross area compressive strength per 9.6.2.

A2.5.4 Equivalent Thickness—Equivalent thickness is defined as the average thickness of solid material in the unit and is calculated as follows:

\[ T_e = \frac{V_n}{L \cdot W \cdot H} \times 100 \]  

where:

- \(T_e\) = equivalent thickness, in. (mm),
- \(V_n\) = average net volume of full-size units, \(ft^3 (mm^3)\) (see 9.4),
- \(L\) = average length of full-size units, in. (mm) (see A2.2.1), and
- \(H\) = average height of full-size units, in. (mm) (see A2.2.1).

A2.5.4.4 Equivalent thickness shall only be calculated and reported for full-size concrete brick.

A2.5.5 Percent Solid

A2.5.5.1 Calculate the percent solid as follows:

\[ \text{Percent solid, } \% = \left( \frac{V_n}{L \cdot W \cdot H} \right) \times 100 \]  

where:

- \(V_n\) = net volume of specimen, \(ft^3 (mm^3)\) (see 9.4),
- \(L\) = average length of specimen, in. (mm) (see A2.2.1),
- \(W\) = average width of specimen, in. (mm) (see A2.2.1), and
- \(H\) = average height of specimen, in. (mm) (see A2.2.1).

A2.6 Report

A2.6.1 Test reports shall include all of the information in Sections 10.2, 10.3, and the following:

A2.6.1.1 For cored units, the minimum distance from the edge of the brick to the nearest core to the nearest 0.1 in. (2.5 mm) separately for each specimen and as the average for the three specimens tested.

A2.6.1.2 The equivalent thickness to the nearest 0.1 in. (2.5 mm) as the average for the three specimens tested.

A2.6.1.3 The percent solid results to the nearest 0.1 % separately for each specimen and as the average for the three specimens tested.

A2.6.1.4 The gross area to the nearest 0.1 in\(^2\) (65 mm\(^2\)) separately for each specimen and as the average for the three specimens tested.

A2.6.1.5 The gross area compressive strength to the nearest 10 psi (0.1 MPa) separately for each specimen and as the average for the three specimens tested.

A2.6.1.6 The net volume to the nearest 0.01 ft\(^3\) (0.0002 m\(^3\)) separately for each specimen and as the average for the three specimens tested.

A3. TEST PROCEDURES FOR SEGMENTAL RETAINING WALL UNITS

A3.1 Scope

A3.1.1 This annex includes testing requirements that are particular for segmental retaining wall units that are manufactured for compliance with the following unit specifications: C1372.

A3.2 Measurement of Dimensions

A3.2.1 For each unit, measure and record the width \((W)\) across the top and bottom bearing surfaces at mid-length, height \((H)\) at mid-length of each face, and length \((L)\) at mid-height of each face to the nearest division required to be reported.

A3.3 Compressive Strength Testing

A3.3.1 Test Specimens—Specimens shall be a saw-cut coupon with an aspect ratio (height divided by its least lateral dimension, \(h/l\)) of 4.0 ± 0.1 before capping and length to thickness ratio \((L/h)\) of 4.0 ± 0.1. The coupon width shall be as close to 2 in. as possible, but in no case less than 1.5 in. (37 mm). Coupon dimensions shall not differ by more than ½ in. (3 mm) from the targeted dimension. The compressive strength of the coupon shall be considered to be the compressive strength of the whole unit. Saw-cutting shall be performed in accordance with 7.2.4 and 7.2.5.
NOTE A3.1—The compressive strength of coupons saw-cut from segmental retaining wall units can be measurably influenced by the unit configuration and location of the sample. Due to the variety of unit configurations available, it is not possible to specify exact locations for obtaining coupons. In order to compare results within a set or between independently performed tests, coupons should be consistently obtained from the same location for a given unit configuration. Suppliers should be consulted for the recommended coupon sample location for a given unit configuration.

A3.3.2 Testing—Cap and test specimens in accordance with 7.3 and 7.4.

A4. TEST PROCEDURES FOR CONCRETE INTERLOCKING PAVING UNITS

A4.1 Scope

A4.1.1 This annex includes testing requirements that are particular for concrete interlocking paving units that are manufactured for compliance with the following unit specifications: C936/C936M.

A4.1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

A4.2 Measurement of Dimensions

A4.2.1 For each unit, using a caliper readable and accurate to 0.1 mm [0.004 in.], measure and record the width (W) across the top and bottom bearing surfaces at mid-length, thickness (T) at mid-length of each face, and length (L) at mid-height of each face.

A4.2.2 Disregard spacer tabs when performing length and width measurements.

A4.2.3 Disregard chamfers when performing thickness measurements.

A4.3 Compressive Strength Testing

A4.3.1 Test Specimens—Specimens shall be full-sized units except as modified in A4.3.1.1.

A4.3.1.1 When compression testing full-sized units that are too large for the test machine’s bearing block and platens or are beyond the load capacity of the test machine, saw-cut the unit in half along the shortest axis and one half shall be tested. Units with protruding, smaller ends shall have the ends saw cut and the remaining larger pieces tested. The specimen shall be symmetrical about two axes.

A4.3.2 Capping—Cap test specimens in accordance with Practice C1552 except as modified below.

A4.3.2.1 Use high strength gypsum cement capping material only.

A4.3.2.2 The average cap thickness for each unit shall not exceed 1.5 mm [0.06 in.].

A4.3.2.3 Determine the average thickness of the cap as follows: after capping both sides of the specimen, measure and record the thickness of the capped specimen to the nearest 0.1 mm [0.004 in.] at the same two points where thickness of the uncapped specimen was measured in accordance with A4.2.1.

Calculate the difference in thickness for each point and divide by 2 to determine the calculated cap thickness at each point. Calculate the average cap thickness for the whole specimen by taking the average of the calculated cap thickness at each of the two points.

NOTE A4.1—Units with textured surfaces may need to be saw-cut to comply with the maximum cap thickness requirement.

NOTE A4.2—An important factor in producing high-quality gypsum caps is to use a water-to-cement ratio that yields a capping material that is fluid enough to spread while being viscous enough to allow the paver to be pushed into it forming a consistent thin cap.

A4.3.3 Testing—Test specimens in accordance with 7.4.

A4.4 Absorption Testing

A4.4.1 Perform absorption tests in accordance with 8.3.

A4.5 Calculations

A4.5.1 Calculate, using the calculations appropriate to the system of units being used, the absorption, density, net area, and net area compressive strength in accordance with Section 9.

NOTE A4.3—The requirements of Specification C936/C936M are based on either SI units or inch-pound units, separately. Therefore, all calculations and reporting on samples tested following the provisions of Annex A4 should be done using either unit system, without combining the two systems.

A4.6 Report

A4.6.1 Test reports shall include all of the information in Section 10.2 and the following:

A4.6.1.1 The average width, thickness, and length to the nearest 0.1 mm [0.004 in.] separately for each specimen and as the average for the three specimens tested.

A4.6.1.2 The net area to the nearest 50 mm² [0.1 in.²] separately for each specimen and as the average for the three specimens tested.

A4.6.1.3 The maximum load separately for each specimen and as the average for the three specimens tested. Record the load as indicated to the nearest 5 N [10 lb] or the minimum resolution of the test machine used during testing, whichever is greater.

A4.6.1.4 The net area compressive strength to the nearest 0.1 MPa [10 psi] separately for each specimen and as the average for three specimens tested.
A5. TEST PROCEDURES FOR CONCRETE GRID PAVING UNITS

A5.1 Scope

A5.1.1 This annex includes testing requirements that are particular for concrete grid paving units that are manufactured for compliance with the following unit specifications: C1319.

A5.2 Sampling

A5.2.1 Sampling

A minimum of six specimens shall be selected for each test set.

A5.3 Measurement of Dimensions

A5.3.1 Three full-size units shall be selected for measurement.

A5.3.2 For each unit, measure and record the width (W) across the top and bottom bearing surfaces at the maximum width of the unit, height (H) at mid-length of each face, and length (L) at the maximum length of the unit across the top and bottom bearing surfaces to the nearest division required to be reported. See Fig. A5.1.

NOTE A5.1—Fig. A5.1 shows a representative example of how to properly measure and obtain specimens from a common unit shape. There are many other shapes and sizes of grid paving units available which may require different procedures for measuring and obtaining specimens. Suppliers should be consulted for recommended specimen sampling procedures.

A5.3.3 For each unit, measure the width of each web at the thinnest point. Record the minimum value measured. For the web with the minimum thickness, measure and record two additional web readings. The two additional readings shall be at the maximum width of the web and at mid-height of the web. Measure and record all web width measurements to the nearest division required to be reported. Disregard grooves, scores, and similar details in the measurements.

A5.4 Compressive Strength Testing

A5.4.1 Test Specimens—Three units shall be tested for compressive strength. Specimens shall be full-sized units or reduced-size units as modified in A5.4.1.1.

A5.4.1.1 When compression testing full-sized units that are too large for the test machine’s bearing block and platens or are beyond the load capacity of the test machine, saw-cut the units to properly size them to conform to the capabilities of the testing machine. The resulting specimen shall be symmetrical, have no projections or irregular features, and shall be a fully enclosed cell or cells. The compressive strength of the segment shall be considered to be the compressive strength of the whole unit.

A5.4.2 Testing—Cap and test specimens in accordance with 7.3 and 7.4.

A5.5 Absorption Testing

A5.5.1 Three units shall be tested for absorption.

A5.5.2 Perform absorption tests in accordance with 8.3. When compression specimens are other than full-size units, absorption testing shall be performed on specimens saw-cut from full-size units with the same configuration as the reduced-size compression specimens.

A5.6 Full Size Net Area Testing

A5.6.1 Three full size units shall be tested for net area.

A5.6.2 Determine the net cross-sectional area of full-size units by performing absorption testing on full-size units in accordance with 8.3.

A5.7 Calculations

A5.7.1 Calculate absorption, density, net area, and net area compressive strength in accordance with Section 9. For determination of net area, absorption, and density, use data collected from testing in accordance with A5.5.1.

A5.7.2 Calculate the full-size net area (An,full) in accordance with Section 9 using the data collected from the testing in accordance with A5.6.

A5.7.3 Calculate the percent solid as follows:

\[
\text{Percent solid} = \left(\frac{(A_{n,\text{full}}/L \times W)}{100}ight)
\]  

(A5.1)
where:

\[ A_{n,full} = \text{full-size net area, in.}^2(\text{mm}^2) \] (A5.7.2)

\[ L = \text{full-size unit length, in. (mm)} \] (A5.3.1), and

\[ W = \text{full-size unit width, in. (mm)} \] (A5.3.1)

**A5.8 Report**

A5.8.1 Test reports shall include all of the information in Sections 10.2, 10.3, and the following:

A5.8.1.1 The minimum web width and average web width to the nearest 0.01 in. (0.25 mm) as determined by A5.3.2. The average web width is calculated from the three readings of the web with the minimum width.

A5.8.1.2 The full-size net area to the nearest 0.1 in.\(^2\) (65 m\(^2\)) as the average of the set of three specimens as determined by A5.7.2.

A5.8.1.3 The average percent solid for the set of three units to the nearest 0.1 \% as determined by A5.7.3.

**A6. TEST PROCEDURES FOR CONCRETE ROOF PAVERS**

**A6.1 Scope**

A6.1.1 This annex includes testing requirements that are particular for concrete roof pavers that are manufactured for compliance with the following unit specifications: C1491.

**A6.2 Measurement of Dimensions**

A6.2.1 For each unit, measure and record the width (W) across the top and bottom bearing surfaces at mid-length, height (H) at mid-length of each face, and length (L) at mid-height of each face to the nearest division required to be reported.

**A6.3 Compressive Strength Testing**

A6.3.1 For concrete roof paver compressive strength tests, cut three test specimens from three whole paver units. Each specimen shall consist of a strip of paver with specimen height equal to specimen width. Where a unit contains supporting ribs, obtain specimens by cutting perpendicular to the direction of the ribs so as to avoid inclusion of bevelled or recessed surfaces at top or bottom edges (see Fig. A6.1).

A6.3.2 Testing—Cap and test specimens in accordance with 7.3 and 7.4.

**A6.4 Absorption Testing**

A6.4.1 Perform absorption tests in accordance with 8.3.

**A6.5 Flexural Load Testing**

A6.5.1 Three full-sized units shall be tested.

A6.5.2 Capping—Units with wearing (top) surfaces containing recesses or other irregularities shall have such recesses capped flush with the uppermost surface in accordance with Practice C1552.

A6.5.3 Testing—The testing arrangement shall be as shown in Fig. A6.2. The load from the upper bearing block of the testing machine shall be applied through the centroid of the concrete roof paver by the bearing assembly illustrated. The flexural length of the paver unit is taken as the end-to-end plan dimension of the units. Loading shall be applied at a uniform rate such that the total load is applied in not less than 1 min and not less than 3 min.

**A6.6 Calculations**

A6.6.1 Calculate absorption, density, net area, and net area compressive strength in accordance with Section 9.

A6.6.2 Ballast Weight—For concrete roof pavers, calculate ballast weight as follows:

\[
W_b = \frac{W_d}{A_g} \times 144 \quad \text{(A6.1)}
\]

where:

\[ W_b = \text{ballast weight, lb/ft}^2 \text{ (kg/m}^2\text{)}, \]

\[ W_d = \text{oven-dry weight of unit, lb \ (kg) (see 8.3.2)}, \]

\[ A_g = \text{gross area of unit, in.}^2 \text{ (mm}^2\text{)} \text{ (see 9.5)} \text{.}

**A6.7 Report**

A6.7.1 Test reports shall include all of the information in Sections 10.2, 10.3, and the following:

A6.7.2 The flexural load to the nearest 1 lb (5 N) required to fail a specimen separately and as the average for the set of three units tested.

A6.7.3 Ballast weight to the nearest 1 psf (5 kg/m\(^2\)) separately for each specimen and as the average for the set of three specimens tested.
A7. TEST PROCEDURES FOR DRY CAST ARTICULATING CONCRETE BLOCK

A7.1 Scope

A7.1.1 This annex includes testing requirements for dry cast articulating concrete block that are manufactured for compliance with the following unit specification: D6684.

A7.2 Measurement of Dimensions

A7.2.1 Measure each unit and record the width (W) across the top and bottom bearing surfaces at mid-length, height (H) at mid-length of each face, and length (L) at mid-height of each face to the nearest division required to be reported.

A7.3 Compressive Strength Testing

A7.3.1 Test Specimens—Specimens shall be a saw-cut coupon with an aspect ratio (height divided by its least lateral dimension, \( h/l \)) of 2.0 ± 0.1 before capping and length to thickness ratio (\( l/t \)) of 4.0 ± 0.1. The coupon width shall in no case be less than 1.5 in. (37 mm). Coupon dimensions shall not differ by more than 1/8 in. (3 mm) from the targeted dimension. Coupons shall be 100% solid and not contain cable holes or other voids. The compressive strength of the coupon shall be considered to be the compressive strength of the whole unit. Saw-cutting shall be performed in accordance with 7.2.4 and 7.2.5.

NOTE A7.1—The compressive strength of coupons saw-cut from articulating concrete blocks can be measurably influenced by the unit configuration and location of the sample. Due to the variety of unit configurations available, it is not possible to specify exact locations for obtaining coupons. In order to compare results within a set or between independently performed tests, coupons should be consistently obtained from the same location for a given unit configuration. Suppliers should be consulted for the recommended coupon sample location for a given unit configuration.

A7.3.2 Testing—Cap and test specimens in accordance with 7.3 and 7.4.

A7.4 Absorption Testing

A7.4.1 Test Specimens—Specimens shall be in accordance with 8.2.

A7.4.2 Testing—Perform absorption tests in accordance with 8.3.

A7.5 Calculations

A7.5.1 Calculate absorption, density, net area, and net area compressive strength in accordance with Section 9.

A7.6 Report

A7.6.1 Test reports shall include all of the information in Sections 10 and 10.3.
A8. DETERMINING PLATE THICKNESS REQUIREMENTS FOR COMPRESSION TESTING

A8.1 Scope
A8.1.1 This annex provides additional information to assist in determining the plate thickness requirements for compression testing as written in 7.1.

A8.2 Terminology
A8.2.1 Fig. A8.1 shows the location of the referenced test equipment as used in the compression testing of units.

A8.3 Determining the Diameter of the Upper Platen
A8.3.1 As shown in Fig. A8.2, the diameter of the upper platen is considered in this test method to be equal to the maximum horizontal dimension measured across the circle created by the spherical portion of the upper platen (this measured diameter may differ from the actual geometric diameter of the sphere based on its curvature). If the upper platen includes a nonspherical section that was manufactured integrally with the spherical head from a single piece of steel, the diameter of the upper platen is considered to be the diameter of the spherical seat on the upper surface of the upper platen plus the thickness of the nonspherical section (t_{PL}). However, the diameter of the upper platen shall not be greater than the minimum horizontal dimension of the upper platen.

A8.4 Distance from the Edge of Platen to Furthermost Corner of Test Specimen (See Fig. A8.3)
A8.4.1 Determine the distance from the edge of the platen to the furthermost corner of the specimen as follows:
A8.4.2 Locate the specimen’s center of mass, and mark it on top of the specimen.
A8.4.3 Determine to the nearest ⅛ in. (3 mm) the distance from the center of mass of the specimen to the furthermost corner or edge of the test specimen. Record this distance as A.
A8.4.4 The distance from the platen to the furthermost corner of the test specimen is obtained by the following equation:

\[ d = A - \left( \frac{D_{PL}}{2} \right) \]  (A8.1)

where:
- \( d \) = distance from the platen to the furthermost corner of the test specimen, in. (mm),
- \( A \) = distance from the center of mass of the specimen to the furthermost corner of the test specimen, in. (mm), and
- \( D_{PL} \) = calculated diameter of the upper platen, in. (mm).

FIG. A8.1 Equipment Used for Compression Testing
APPENDIX

(Nonmandatory Information)

X1. WORKSHEET AND TEST REPORT FOR CONCRETE MASONRY UNITS

X1.1 Included in this section is a sample laboratory worksheet and a test report form. These samples were developed for use in recording and reporting test information for conventional concrete masonry units to determine their compliance with Specification C90. These forms are to be used as guidelines only. Users of these test methods may use or modify these forms to suit their purposes and to address the requirements of the test methods as they apply to the specific specimens being tested.
### ASTM C 140 Worksheet

**Sampling and Testing Concrete Masonry Units**

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<th>Big Block Plant</th>
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#### Compression Units

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#### Absorption Units

(Determine the following information for each of the three units to be immersed in water for absorption testing.)

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<td>@ Bottom</td>
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<td>7.52</td>
<td>7.61</td>
<td>7.67</td>
</tr>
<tr>
<td>Length (L) @ Face 1</td>
<td>15.62</td>
<td>15.61</td>
<td>15.62</td>
</tr>
<tr>
<td>@ Face 2</td>
<td>15.60</td>
<td>15.62</td>
<td>15.63</td>
</tr>
<tr>
<td>Date</td>
<td>6/1/2008</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Faceshell Thickness (FST)</th>
<th>Measurements...</th>
</tr>
</thead>
<tbody>
<tr>
<td>@ Face 1</td>
<td>1.28</td>
</tr>
<tr>
<td>@ Face 2</td>
<td>1.24</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Web Thickness (WT)</th>
<th>Measurements...</th>
</tr>
</thead>
<tbody>
<tr>
<td>@ Web 1</td>
<td>1.06</td>
</tr>
<tr>
<td>@ Web 2</td>
<td>1.04</td>
</tr>
<tr>
<td>@ Web 3</td>
<td>0.99</td>
</tr>
<tr>
<td>@ Web 4</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Received Weight (W_r)</th>
<th>Measurements...</th>
</tr>
</thead>
<tbody>
<tr>
<td>32.07</td>
<td>31.24</td>
</tr>
<tr>
<td>Immersed Weight (W_i)</td>
<td>16.85</td>
</tr>
<tr>
<td>Saturated Weight (W_s)</td>
<td>33.27</td>
</tr>
<tr>
<td>Final Oven-Dry Weight (W_d)</td>
<td>30.18</td>
</tr>
</tbody>
</table>

Intermediate Drying Weights (first reading after at least 24 hours drying, successive readings at 2 hr intervals)

<table>
<thead>
<tr>
<th>Time (hr)</th>
<th>1st</th>
<th>2nd</th>
<th>3rd</th>
</tr>
</thead>
<tbody>
<tr>
<td>lb. Time</td>
<td>11:30 am</td>
<td>2:00 pm</td>
<td></td>
</tr>
</tbody>
</table>

**FIG. X.1.1 Example CMU Worksheet**
FIG. X1.2 Example CMU Test Report

ASTM C 140 Test Report

Client: Big Block Plant
Address: 111 Block Drive
Anytown, USA 12345

Testing Agency: Accurate Testing Laboratory
Address: 123 Main Street
Anytown, USA, 12345

Job No.: 08-100
Report Date: 6/10/2008

Unit Specification: ASTM C39-06
Sampling Party: Big Block Plant
Unit Designation/Description: 8 x 8 x 16 inch Concrete Masonry Unit
Date Samples Received: 6/1/2008

Summary of Test Results

<table>
<thead>
<tr>
<th>Physical Property</th>
<th>Specified Values</th>
<th>Average Test Results</th>
<th>Physical Property</th>
<th>Specified Values</th>
<th>Average Test Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>Net Compressive Strength</td>
<td>1900 min</td>
<td>1950 psi</td>
<td>Min. Faceshell Thickness ((t_{f}))</td>
<td>1.25 min</td>
<td>1.34 in.</td>
</tr>
<tr>
<td>Gross Compressive Strength</td>
<td>****</td>
<td>1000 psi</td>
<td>Min. Web Thickness ((t_{w}))</td>
<td>1.00 min</td>
<td>1.1 in.</td>
</tr>
<tr>
<td>Density</td>
<td>****</td>
<td>111.9 pcf</td>
<td>Equivalent Web Thickness</td>
<td>2.25 min</td>
<td>2.6 in.</td>
</tr>
<tr>
<td>Absorption</td>
<td>15 max</td>
<td>12.5 pcf</td>
<td>Equivalent Thickness</td>
<td>****</td>
<td>3.6 in.</td>
</tr>
<tr>
<td>Percent Solid</td>
<td>****</td>
<td>50.3 %</td>
<td>Max. Var. from Spec. Dimensions</td>
<td>1.125 max</td>
<td>0.054 in.</td>
</tr>
</tbody>
</table>

| Net Cross-Sectional Area        | 60.01 in²        |                       | Gross Cross-Sectional Area      | 119.24 in²       |                       |

Individual Unit Test Results

<table>
<thead>
<tr>
<th>Compression Units</th>
<th>Specimen No.</th>
<th>Wt, Wt</th>
<th>Gross Area *</th>
<th>Max. Cross-Sectional Area</th>
<th>Compressive Strength</th>
</tr>
</thead>
<tbody>
<tr>
<td>Units</td>
<td></td>
<td>lb</td>
<td>in²</td>
<td>lb</td>
<td>in²</td>
</tr>
<tr>
<td></td>
<td>#1</td>
<td>32.49</td>
<td>119.24</td>
<td>60.01</td>
<td>125770</td>
</tr>
<tr>
<td></td>
<td>#2</td>
<td>31.22</td>
<td>119.24</td>
<td>60.01</td>
<td>113550</td>
</tr>
<tr>
<td></td>
<td>#3</td>
<td>30.92</td>
<td>119.24</td>
<td>60.01</td>
<td>114590</td>
</tr>
<tr>
<td>Average</td>
<td></td>
<td>31.54</td>
<td>119.24</td>
<td>60.01</td>
<td>119470</td>
</tr>
</tbody>
</table>

* Unit areas determined as the average of the three absorption units and are assumed to be the same as those units tested in compression.

Absorption Units

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>#4</td>
<td>7.6</td>
<td>7.5</td>
<td>15.6</td>
<td>6.01</td>
<td>125.77</td>
<td>125.77</td>
<td>125.77</td>
<td>125.77</td>
<td></td>
</tr>
<tr>
<td>#5</td>
<td>7.6</td>
<td>7.6</td>
<td>15.6</td>
<td>6.01</td>
<td>113.55</td>
<td>113.55</td>
<td>113.55</td>
<td>113.55</td>
<td></td>
</tr>
<tr>
<td>#6</td>
<td>7.6</td>
<td>7.7</td>
<td>15.7</td>
<td>6.01</td>
<td>114.59</td>
<td>114.59</td>
<td>114.59</td>
<td>114.59</td>
<td></td>
</tr>
<tr>
<td>Average</td>
<td>7.6</td>
<td>7.6</td>
<td>15.6</td>
<td>6.01</td>
<td>119.47</td>
<td>119.47</td>
<td>119.47</td>
<td>119.47</td>
<td></td>
</tr>
</tbody>
</table>

**Where the thinnest point of opposite face shells differ in thickness by less than 0.125 inches, their measurements are averaged.

<table>
<thead>
<tr>
<th>Date Tested:</th>
<th>Specimen No.</th>
<th>Wt, Wt</th>
<th>Wt, Wt</th>
<th>Wt, Wt</th>
<th>Wt, Wt</th>
<th>Absorp</th>
<th>Density</th>
<th>Net Volume</th>
<th>Percent Sold</th>
</tr>
</thead>
<tbody>
<tr>
<td>6/2/2008</td>
<td>#4</td>
<td>32.07</td>
<td>16.85</td>
<td>33.27</td>
<td>30.18</td>
<td>11.7</td>
<td>114.7</td>
<td>0.2631</td>
<td>50.7</td>
</tr>
<tr>
<td></td>
<td>#5</td>
<td>31.24</td>
<td>16.22</td>
<td>32.76</td>
<td>29.33</td>
<td>12.9</td>
<td>110.7</td>
<td>0.2581</td>
<td>50.4</td>
</tr>
<tr>
<td></td>
<td>#6</td>
<td>30.90</td>
<td>16.05</td>
<td>32.51</td>
<td>28.94</td>
<td>12.8</td>
<td>110.5</td>
<td>0.2536</td>
<td>49.9</td>
</tr>
<tr>
<td>Average</td>
<td></td>
<td>31.40</td>
<td>16.37</td>
<td>32.85</td>
<td>29.55</td>
<td>12.5</td>
<td>111.9</td>
<td>0.2540</td>
<td>50.3</td>
</tr>
</tbody>
</table>

Signature
Laboratory Official

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Not for Resale, 02/20/2012 03:46:25 MST
SUMMARY OF CHANGES

Committee C15 has identified the location of selected changes to this standard since the last issue (C140 – 11) that may impact the use of this standard. (Approved Aug. 1, 2011.)

(1) Sections 10.3 and A4.6 were revised.
(2) Added section 8.2.2.1 on minimum specimen size for absorption testing and a new Note 11.
(3) Added minimum immersion depth for absorption testing in subsection 8.3.1.

Committee C15 has identified the location of selected changes to this standard since the last issue (C140 – 10) that may impact the use of this standard. (Approved Feb. 1, 2011.)

(1) Changes to reporting requirements were made to Section 10 and Annex A1-Annex A7.
(2) Changes were made to 6.1.2 to clarify language.
(3) Revised Note A3.1 and Note A7.1.
(4) Revised Annex A5.

Committee C15 has identified the location of selected changes to this standard since the last issue (C140 – 09a) that may impact the use of this standard. (Approved June 15, 2010.)

(1) Revised 5.2 to define a “set” of units, and revised the sampling requirements to require a specific number of sets.
(2) Changes were made to Section 6 and Annex A1 through Annex A7 to allow additional measurement devices.

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