



Designation: C936/C936M – 18

Standard Specification for Solid Concrete Interlocking Paving Units¹

This standard is issued under the fixed designation C936/C936M; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope*

1.1 This specification covers the requirements for interlocking concrete pavers manufactured for the construction of paved surfaces.

1.2 When particular features are desired, such as weight classification, higher compressive strength, surface textures, finish, color, or other special features, such properties should be specified by the purchaser. Local sellers, however, should be consulted as to availability of units having the desired features.

1.3 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.

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

- C33/C33M Specification for Concrete Aggregates
- C140/C140M Test Methods for Sampling and Testing Concrete Masonry Units and Related Units
- C150/C150M Specification for Portland Cement
- C207 Specification for Hydrated Lime for Masonry Purposes
- C260/C260M Specification for Air-Entraining Admixtures for Concrete
- C331/C331M Specification for Lightweight Aggregates for

Concrete Masonry Units

- C418 Test Method for Abrasion Resistance of Concrete by Sandblasting
- C494/C494M Specification for Chemical Admixtures for Concrete
- C595/C595M Specification for Blended Hydraulic Cements
- C618 Specification for Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use in Concrete
- C979/C979M Specification for Pigments for Integrally Colored Concrete
- C989/C989M Specification for Slag Cement for Use in Concrete and Mortars
- C1157/C1157M Performance Specification for Hydraulic Cement
- C1240 Specification for Silica Fume Used in Cementitious Mixtures
- C1645/C1645M Test Method for Freeze-thaw and De-icing Salt Durability of Solid Concrete Interlocking Paving Units

3. Terminology

3.1 Definitions:

3.1.1 *architectural finishes*—surface modified by mechanical means such as blasting, hammering, polishing, tumbling, washing, or other methods.

4. Materials

4.1 *Cementitious Materials* shall conform to the following applicable ASTM specifications:

- 4.1.1 *Portland Cements*—Specification C150/C150M.
- 4.1.2 *Blended Hydraulic Cements*—Specification C595/C595M.
- 4.1.3 *Hydraulic Cement*—Specification C1157/C1157M.
- 4.1.4 *Hydrated Lime, Type S*—Specification C207.
- 4.1.5 *Fly Ash*—Specification C618.
- 4.1.6 *Ground Slag*—Specification C989/C989M.
- 4.1.7 *Silica Fume*—Specification C1240.

4.2 *Aggregates* shall conform to the following ASTM specifications, except that grading requirements shall not necessarily apply:

- 4.2.1 *Normal Weight*—Specification C33/C33M.
- 4.2.2 *Lightweight*—Specification C331/C331M.

¹ This specification is under the jurisdiction of ASTM Committee C15 on Manufactured Masonry Units and is the direct responsibility of Subcommittee C15.03 on Concrete Masonry Units and Related Units.

Current edition approved Sept. 1, 2018. Published September 2018. Originally approved in 1982. Last previous edition approved in 2016 as C936/C936M – 16. DOI: 10.1520/C0936_C0936M-18.

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

4.3 *Chemical Admixtures* shall conform to the following applicable ASTM specifications:

4.3.1 *Air-entraining Admixtures*—Specification C260/C260M.

4.3.2 *Water-reducing, Retarding, and Accelerating Admixtures*—Specification C494/C494M.

4.3.3 *Pigments for Integrally Colored Concrete*—Specification C979/C979M.

4.4 *Other Constituents*—Integral water repellents, and other materials for which no ASTM standards exist, shall be previously established as suitable for use in concrete or shall be shown by test or experience not to be detrimental to the concrete.

5. Physical Requirements

5.1 Units shall have an exposed face area $\leq 101 \text{ in.}^2$ [0.065 m^2], and their overall length divided by thickness shall be ≤ 4 . The minimum specified thickness shall be 2.36 in. [60 mm]. See Fig. 1.

5.2 Concrete units covered by this specification may be made from lightweight or normal weight aggregates or mixed lightweight and normal weight aggregates.

5.3 *Compressive Strength*—At the time of delivery to the work site, the average compressive strength of the test samples shall be not less than 8000 psi [55 MPa] with no individual unit less than 7200 psi [50 MPa] as required in 6.2.

5.4 *Absorption*—The average absorption of the test samples shall not be greater than 5 % with no individual unit greater than 7 % as required in 6.2.

5.5 *Resistance to Freezing and Thawing*—If the units are exposed to freezing and deicing materials during service, the manufacturer shall satisfy the purchaser either by proven field performance or a laboratory freezing-and-thawing test that the paving units have adequate resistance to freezing and thawing. If a laboratory test is used, sample and test in accordance with 6.2 using Test Method C1645/C1645M. Specimens sampled from units that will not be exposed to deicing salts in service shall be tested in tap water. Specimens sampled from units that will be exposed to deicing materials in service shall be tested in 3 % saline solution. The average mass loss of all the specimens tested shall not be greater than: (a) 225 g/m^2 when subject to 28 freeze-thaw cycles, or (b) 500 g/m^2 when subject to 49 freeze-thaw cycles.

NOTE 1—For some pavement applications subject to severe winter

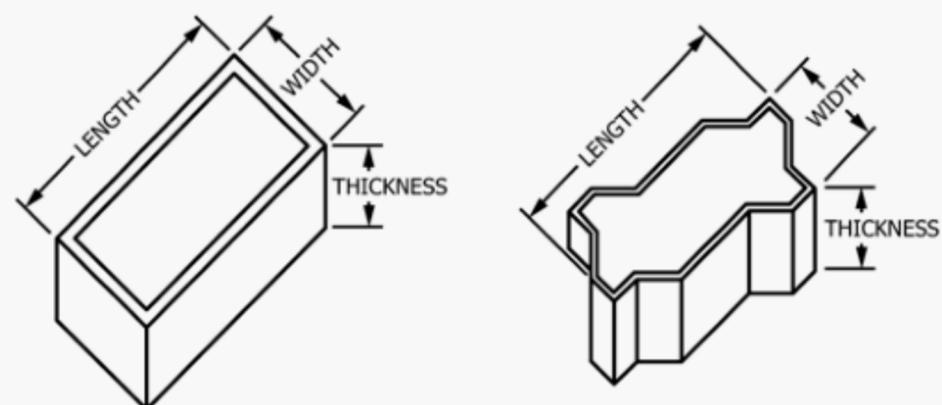


FIG. 1 Length, Width, and Thickness of Concrete Paving Units

temperatures and deicing materials, a lower freezing temperature should be considered when conducting Test C1645/C1645M using a 3 % saline solution. See the non-mandatory Appendix X1 for this temperature option.

5.6 *Abrasion Resistance*—When requested by the specifier or purchaser, sample and test in accordance with 6.4 using Test Method C418 or the manufacturer shall provide adequate record of field performance from a similar application. Specimens shall not have an average volume loss greater than $0.92 \text{ in.}^3/7.75 \text{ in.}^2$ [$15 \text{ cm}^3/50 \text{ cm}^2$]. The average thickness loss shall not exceed 0.118 in. [3 mm].

NOTE 2—Applications that may require testing include areas with severe abrasion, such as exposure to point loads from the repeated turning of hard rubber non-pneumatic wheels or heavy channelized foot traffic. Vehicular traffic usually does not constitute a severe abrasion condition.

5.7 *Dimensional Tolerance*—Measured length or width of test specimens shall not differ by more than $\pm 0.063 \text{ in.}$ [$\pm 1.6 \text{ mm}$] from specified dimensions. Measured thickness of test specimens shall not differ by more than $\pm 0.125 \text{ in.}$ [$\pm 3.2 \text{ mm}$] from the specified dimension. All tests shall be performed as required in 6.2. Units shall meet dimensional tolerances prior to the application of architectural finishes.

6. Sampling and Testing

6.1 The purchaser or his authorized representative shall be accorded proper facilities to inspect and sample the units at the place of manufacture from the lots ready for delivery. Prior to delivery of units, the supplier and purchaser shall decide on the lot size from which to sample test specimens for resistance to freezing and thawing, abrasion resistance, absorption, compressive strength, and dimensional tolerances.

6.2 Compressive strength, absorption, density, and dimensional tolerances shall be based on tests of solid concrete interlocking paving units of any configuration or dimensions manufactured with the same materials, concrete mix design, manufacturing process, and curing method, conducted in accordance with Test Methods C140/C140M and not more than 12 months prior to delivery. Sample a minimum of three (3) test specimens each for compressive strength and absorption. Determine dimensional tolerances from either the compressive strength or absorption specimens prior to testing.

6.3 When required, freeze-thaw durability shall be based on tests of solid concrete interlocking paving units of any configuration or dimensions manufactured with the same materials, concrete mix design, manufacturing process, and curing method, conducted in accordance with Test Method C1645/C1645M and not more than 24 months prior to delivery. Sample a minimum of three (3) test specimens each for freeze-thaw durability.

6.4 When required, abrasion resistance shall be based on tests of solid concrete interlocking paving units of any configuration or dimensions manufactured with the same materials, concrete mix design, manufacturing process, and curing method, conducted in accordance with Test Method C418 and not more than 24 months prior to delivery. Sample a minimum of two (2) test specimens each for abrasion resistance.

7. Visual Inspection

7.1 All units shall be sound and free of defects that would interfere with the proper placing of the units or impair the strength or performance of the construction. Minor cracks incidental to the usual methods of manufacture or minor chipping resulting from customary methods of handling in shipment and delivery shall not be deemed grounds for rejection.

8. Rejection

8.1 In case the shipment fails to conform to the specified requirements, the manufacturer may sort it, and new specimens shall be selected by the purchaser from the retained lot and tested at the expense of the manufacturer. In case the second set of specimens fails to conform to the test requirements, the entire lot shall be rejected.

APPENDIX

(Nonmandatory Information)

X1. OPTIONAL TEST METHOD FOR FREEZE-THAW DURABILITY

X1.1 *Scope*—This appendix provides information on using a lower freezing temperature that results in a more severe freeze-thaw durability test than that referenced in Section 5 of this standard and described in Test Method C1645/C1645M.

X1.2 *Significance and Use*—Test Method C1645/C1645M requires $-5 \pm 3^{\circ}\text{C}$ [$23 \pm 5^{\circ}\text{F}$] as the lowest temperature during laboratory freeze-thaw test cycles. To provide increased severity during freeze-thaw durability testing for pavement applications exposed to deicing materials, this appendix provides -15

$\pm 3^{\circ}\text{C}$ [$5 \pm 5^{\circ}\text{F}$] as the freezing temperature for specimens tested in a 3 % saline solution in accordance with Test Method C1645/C1645M.

X1.3 *Application*—Applying $-15 \pm 3^{\circ}\text{C}$ [$5 \pm 5^{\circ}\text{F}$] in Test Method C1645/C1645M is determined by the location of a project in terms of the climate zones shown in the map in Fig. X1.1 (see Note X1.1). The following guidelines apply to Test Method C1645/C1645M according to the climate zone conditions:

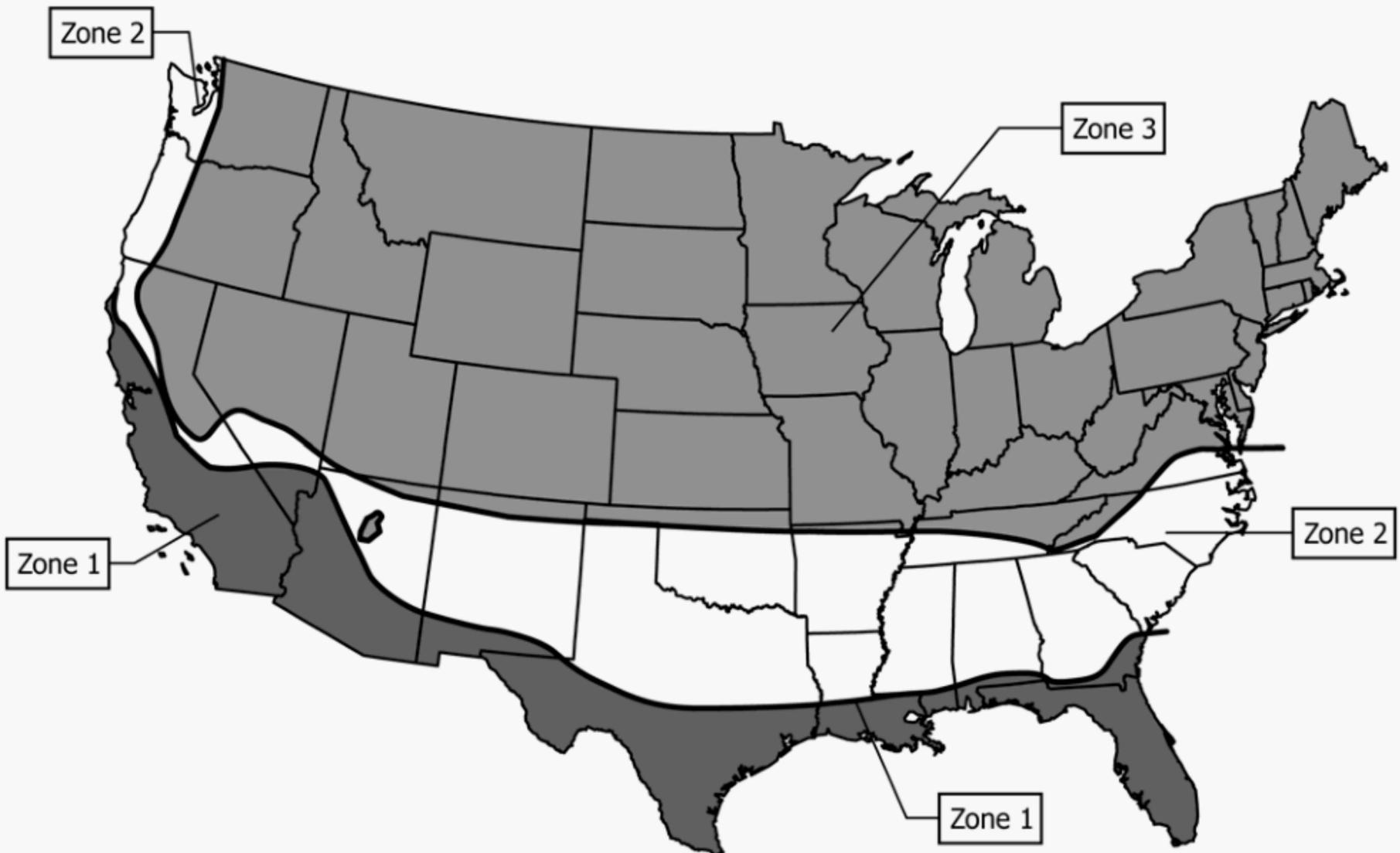


FIG. X1.1 Climate Zone Map

(1) Zone 1: Non-freezing conditions; no freeze-thaw test is required in accordance with 5.5.

(2) Zone 2: Moderate freezing conditions; test in accordance with Test Method C1645/C1645M with no change in the required freezing temperature; that is; use a freezing temperature of $-5 \pm 3^{\circ}\text{C}$ [$23 \pm 5^{\circ}\text{F}$]. The mass loss criteria applies in accordance with 5.5.

(3) Zone 3: Severe freezing conditions; test in accordance with Test Method C1645/C1645M except use a freezing temperature of $-15 \pm 3^{\circ}\text{C}$ [$5 \pm 5^{\circ}\text{F}$]. The mass loss criteria applies in accordance with 5.5.

NOTE X1.1—The weather zone map in Fig. X1.1 is essentially the same as Figure 1, Location of Weathering Regions in Specification in C33/C33M. Climate Zones 1, 2 and 3 in Fig. X1.1 correspond to the Negligible, Moderate and Severe weathering regions, respectively, of Figure 1 in Specification C33/C33M.

X1.4 *Reporting*—Report the use of optional $-15 \pm 3^{\circ}\text{C}$ [$5 \pm 5^{\circ}\text{F}$] freezing temperature with mass lost in accordance with Test Method C1645/C1645M in the freeze-thaw durability test results.

SUMMARY OF CHANGES

Committee C15 has identified the location of selected changes to this standard since the last issue (C936/C936M – 16) that may impact the use of this standard. (September 1, 2018)

(1) Modified testing frequency in Sections 5 and 6.

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