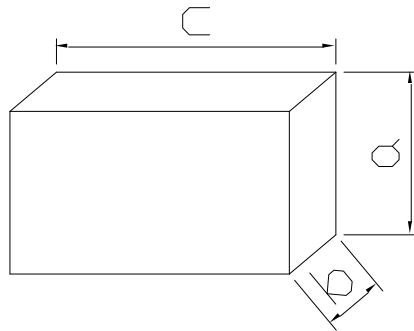


## AZS RAMMING MASS

### Appearance Standard of Electro-Fused AZS Products

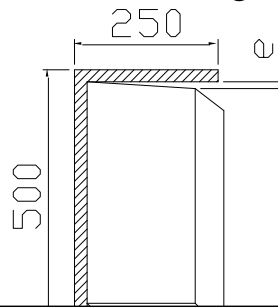
#### I . Dimensions

1. Use a steel tape which has the minimum scale of millimeter to check the dimension of products (a, b, c). the dimensional tolerance of fine machined face is  $+1 \sim -2\text{mm}$ , the rough machined face is  $+2 \sim -3\text{mm}$ .
2. The thickness tolerance of paver blocks is  $+1 \sim -2\text{mm}$ .
3. The thickness tolerance of sidewall blocks is  $+2 \sim -2\text{mm}$ .

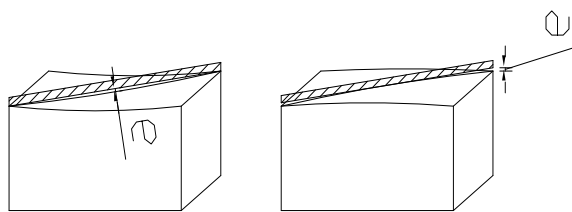


#### II . Squareness

Put one side of a square (side length:  $500 \times 250\text{mm}$ ) to the longer side of the product tightly, and measures the gap (e) between the other side of the square and the product. Fine machined face:  $e \leq 1\text{mm}$ ; Rough machined face:  $e \leq 2\text{mm}$ .



### III . Flatness



1. Installing face: put the steel square (side length 500mm) on the surface of the product in the diagonal direction. Fine machined depth:  $e \leq 1\text{mm}$ ; Rough machined depth:  $e \leq 2\text{mm}$
2. Non-installing face: refers to the above inspection method Depth tolerance:  $e \leq 3\text{mm}$
3. casting face ( regular casting): convexity not allowed; concavity  $e \leq 10\text{ mm}$
4. Faces for PT blocks which are not required to machine:  $e \leq 20\text{mm}$

### IV . Void

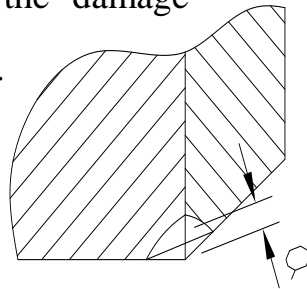
1. For PT and QX blocks, voids are controlled by weight and shapes, so the dimension and depth of voids are not considered. Void can be filled with mortar according to demand.
2. ZWS: Depth (ZWS)  $\leq 120\text{mm}$
3. WS : Depth (WS)  $\leq 15\text{ mm}$

### V . Corner and Edge Spalls:

1. Corner Spall : measurement: The corner damage  $a$  is measured by square.

(From the center of the damage face to the opposite vertex.)

1) Working faces: corner defects in one block



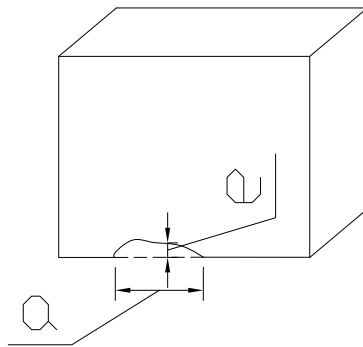
damage  $a \leq 30\text{mm}$  and two such are unacceptable.

2) Non-working faces: corner damage  $a \leq 50\text{ mm}$  and two such defects in one block are accepted.

## 2. Edge spalls:

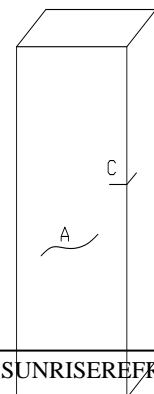
measurement: The edge damage is measured by ruler.

Depth of Edge damage  $e \leq 20\text{ mm}$ ,  $a \leq 1/4$  of edge length and 2 such defects in one block are accepted.

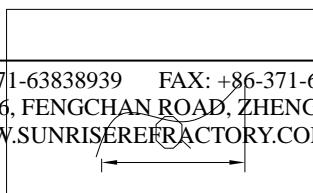


## VI. Crack

1. Measurement: the actual length  $a$  was parallel cracks; the projected length  $a$  was non-parallel cracks.



measured for  
measured for



## 2. Sidewall blocks:

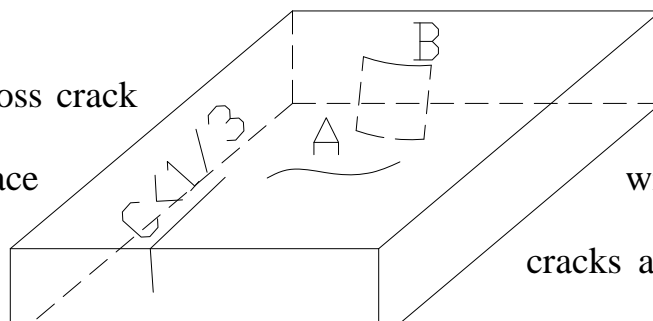
- 1) Wrap cracks are allowed.
- 2) The width of crack  $a \leq 1\text{mm}$ , the length  $\leq 1/2$  of face width; when  $a \geq 1\text{mm}$ , the crack length  $\geq 30\text{mm}$  is not allowed.
- 3) Show through cracks on the face shouldn't exceed  $1/3$  of the edge.
- 4) Cross crack C shouldn't exceed  $1/3$  of the face width;  $1/4$  face width  $\leq$  length  $C \leq 1/3$  face width allowed one piece.

## 3. Paver Blocks

- 1) Wrap cracks are allowed.
- 2) The length of face crack A which is less than  $1/2$  of face width and not shown through opposite face is permitted.
- 3) Length of show through cracks on the face does not exceed  $1/3$  of face width.

- 4) Length of cross crack C does not exceed  $1/3$  of face width.

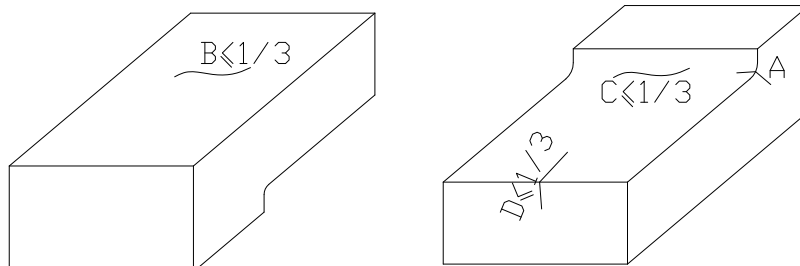
- 5) Cross cracks allowed cross the



second edge but the length shouldn't exceed  $1/3$  of the large face; the width of cross crack  $\leq 1\text{mm}$ .

#### 4. TuckStone

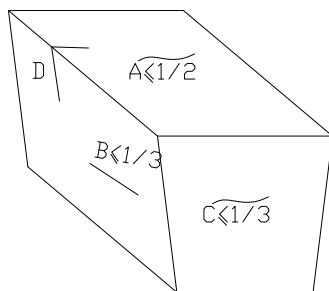
- 1) Wrap cracks are allowed.
- 2) Length of corner crack  $A \leq 40\text{mm}$ .
- 3) Length of parallel face cracks B does not exceed  $1/3$  of face width.
- 4) Length of longitudinal crack does not exceed  $1/2$  of face width.
- 5) Length of corner crack C does not exceed  $1/4$  of face width.
- 6) Cross crack D does not exceed  $1/3$  of face width.



#### 5. Arch Block

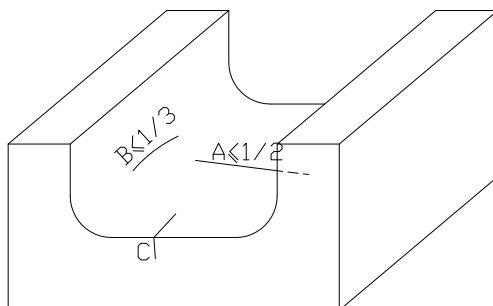
- 1) Longitudinal crack  $A \leq 1/2$  of face width.

- 2) Parallel Crack  $B \leq 1/3$  of face width but show through crack is not allowed.
- 3) Hot face crack  $C \leq 1/3$  of face width.
- 4) Cross crack  $D \leq 1/3$  of face width



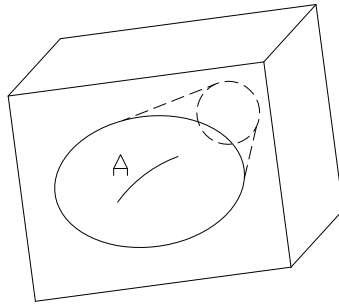
## 6. Channel Blocks

- 1) Wrap cracks are allowed.
- 2) One piece of longitudinal crack A which parallels installing face and does not exceed  $1/3$  of face width is permitted.
- 3) Length of transverse crack (including corner crack) B which is vertical with installing face does not exceed  $1/2$  of face width.
- 4) Length of cross crack does not exceed  $1/2$  of face width.



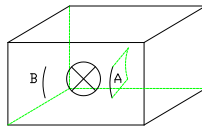
## 7. Peep Hole block、 Burner Block

- 1) Crack A which doesn't penetrate to the opposite face and doesn't extend to the edge is allowed.
- 2) Show through crack does not exceed 1/2 of face width.
- 3) Length of cross crack  $\leq 30\text{mm}$ .



#### 8. Casting Face Cracks

- 1) Crack A which penetrates through working face and casting face is not allowed.
- 2) Length of Casting face crack B does not exceed the face width.



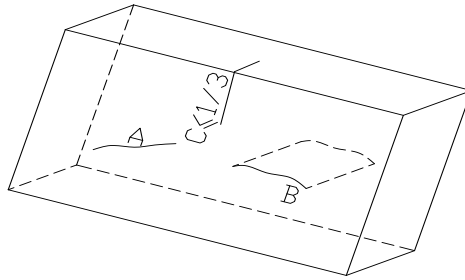
#### 9. Others

- 1) Wrap cracks are allowed.
- 2) Width of face crack  $A \leq 1\text{mm}$ , length  $\leq 1/2$  of face width;

Width of face crack A  $\geq 1\text{mm}$ , length  $\leq 50\text{mm}$ .

3) Length of show through face crack B does not exceed  $1/3$  of face width.

4) Length of cross crack C does not exceed  $1/3$  of face width.



## VII. Surface Attachments

Attachments and other fusion materials are not allowed.

Note: when special shape is required, supplier and consumer need to negotiate and list the requirement respectively.