



Institut luxembourgeois de la normalisation  
de l'accréditation, de la sécurité et qualité  
des produits et services

**ILNAS-EN 1468:2022**

## **Natural stone - Rough slabs - Requirements**

Naturstein - Rohplatten - Anforderungen

Pierres naturelles - Tranches brutes -  
Exigences

**11/2022**



## National Foreword

This European Standard EN 1468:2022 was adopted as Luxembourgish Standard ILNAS-EN 1468:2022.

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EUROPEAN STANDARD ILNAS-EN 1468:2022 **EN 1468**  
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ICS 73.020; 91.100.15

Supersedes EN 1468:2012

English Version

## Natural stone - Rough slabs - Requirements

Pierres naturelles - Tranches brutes - Exigences

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This European Standard was approved by CEN on 19 September 2022.

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This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

**CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels**

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## European foreword

This document (EN 1468:2022) has been prepared by Technical Committee CEN/TC 246 “Natural stones”, the secretariat of which is held by UNI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by May 2023, and conflicting national standards shall be withdrawn at the latest by May 2023.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 1468:2012.

The main technical changes in comparison to EN 1468:2012 are:

- addition of Note 1 to definition 3.4 “commercial size of a rough slab”;
- requirements for the Factory Production Control (FPC), including specimens for testing, are presented in greater detail in 6.3.1.

This document is one of a series of standards for requirements of natural stone products which includes the following:

- EN 1467, *Natural stone — Rough blocks — Requirements*
- EN 1468, *Natural stone — Rough slabs — Requirements*
- EN 1469, *Natural stone products — Slabs for cladding — Requirements*
- EN 12057, *Natural stone products — Modular tiles — Requirements*
- EN 12058, *Natural stone products — Slabs for floors and stairs — Requirements*
- EN 12059+A1, *Natural stone products — Dimensional stone work — Requirements*

Other standards on natural stone are produced by:

- a) CEN/TC 178
  - 1) EN 1341, *Slabs of natural stone for external paving — Requirements and test methods*
  - 2) EN 1342, *Setts of natural stone for external paving — Requirements and test methods*
  - 3) EN 1343, *Kerbs of natural stone for external paving — Requirements and test methods*
- b) CEN/TC 128
  - 1) EN 12326-1, *Slate and stone products for discontinuous roofing and cladding — Part 1: Product specification*
  - 2) EN 12326-2, *Slate and stone products for discontinuous roofing and cladding — Part 2: Methods of test for slate and carbonate slate*

## c) CEN/TC 125

1) EN 771-6, *Specification for masonry units — Part 6: Natural stone masonry units*

Other standards are relevant to stone aggregates for concrete, roads, railways and armourstone.

Any feedback and questions on this document should be directed to the users' national standards body. A complete listing of these bodies can be found on the CEN website.

According to the CEN-CENELEC Internal Regulations, the national standards organisations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and the United Kingdom.

## 1 Scope

This document specifies requirements for rough slabs of natural stone from which products for use in buildings or commemorative stones and other similar applications are made.

It does not cover artificially agglomerated stony material nor installation.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

NOTE Besides the European Standards for test methods mentioned in this clause there exist further standards which can be used for scientific examinations, but which are not relevant for the application in practice according to this document.

EN 1936, *Natural stone test methods — Determination of real density and apparent density, and of total and open porosity*

EN 12372, *Natural stone test methods — Determination of flexural strength under concentrated load*

EN 12407, *Natural stone test methods — Petrographic examination*

EN 12440, *Natural stone — Denomination criteria*

EN 12670:2019, *Natural stone — Terminology*

EN 13161, *Natural stone test methods — Determination of flexural strength under constant moment*

EN 13373, *Natural stone test methods — Determination of geometric characteristics on units*

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 12670:2019 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <https://www.electropedia.org/>
- ISO Online browsing platform: available at <https://www.iso.org/obp>

### 3.1

#### **dimensions of a rough slab**

length, width (height) and thickness of a rough slab

Note 1 to entry: Dimensions are given in metres to two decimal places for length and width, and in millimetres for thickness.

### 3.2

#### **gross size of a rough slab**

size corresponding to the minimum circumscribed rectangle

**3.3****net size of a rough slab**

size corresponding to the greatest inscribed rectangle

**3.4****commercial size of a rough slab**

size obtained by reducing net length and net width by 0,03 m

Note 1 to entry: The determination of the net and commercial dimensions of nonrectangular rough slabs can be agreed mutually.

**3.5****rough slabs**

flat surface semi-finished product with unfinished edges obtained by sawing or splitting from a rough block

**3.6****bush hammered finish**

finish obtained by using a bush hammer (percussion tool for roughening a surface, with a square head and with few pyramidal percussion teeth or points) or a bush hammering machine (machine consisting of feed rolls and an overhanging beam, supporting a pneumatic bush hammer)

[SOURCE: EN 12670:2019, 3.3.12, modified — Notes 1 and 2 to entry added to the definition]

**3.7****flamed finish**

surface texture obtained by thermal treatment of the stone using a high temperature flame

[SOURCE: EN 12670:2019, 3.3.39]

**3.8****sand blasted finish**

matt finishing resulting from the impact of the sand or other abrasive grains expelled by a sand jet

[SOURCE: EN 12670:2019, 3.3.70]

**3.9****machine tooled finish**

a) finish resulting from the mechanical surface treatment with tools;

b) dressed finish clearly showing tool marks

[SOURCE: EN 12670:2019, 3.3.85]

**4 Requirements****4.1 Requirements for geometric characteristics****4.1.1 Measurement criteria**

All measurements shall be carried out in accordance with EN 13373 and indicated in metres to two decimal places.