



Standard Specification for Rubber Sheet Floor Covering Without Backing¹

This standard is issued under the fixed designation F1859; 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 (ϵ) indicates an editorial change since the last revision or reapproval.

^{ε1} NOTE—Reference to Test Method F1515 in Table 1 was removed editorially in April 2016.

1. Scope

1.1 This specification covers the requirements for the compound and physical characteristics of rubber sheet floor covering without backing.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 The following precautionary statement pertains only to the test method portion, Section 10, of this specification: *This standard does not purport to address all 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 The following documents of the issue in effect on the date of the material purchase form a part of this specification to the extent referenced herein:

2.2 *ASTM Standards*:²

- D412 Test Methods for Vulcanized Rubber and Thermoplastic Elastomers—Tension
- D883 Terminology Relating to Plastics
- D1566 Terminology Relating to Rubber
- D2240 Test Method for Rubber Property—Durometer Hardness
- F141 Terminology Relating to Resilient Floor Coverings
- F386 Test Method for Thickness of Resilient Flooring Materials Having Flat Surfaces
- F410 Test Method for Wear Layer Thickness of Resilient

¹ This specification is under the jurisdiction of ASTM Committee F06 on Resilient Floor Coverings and is the direct responsibility of Subcommittee F06.80 on Specifications.

Current edition approved Nov. 1, 2014. Published December 2014. Originally approved in 1998. Last previous edition approved in 2012 as F1859-12. DOI: 10.1520/F1859-14.

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.

Floor Coverings by Optical Measurement

F710 Practice for Preparing Concrete Floors to Receive Resilient Flooring

F925 Test Method for Resistance to Chemicals of Resilient Flooring

F970 Test Method for Static Load Limit

F1482 Practice for Installation and Preparation of Panel Type Underlayments to Receive Resilient Flooring

F1514 Test Method for Measuring Heat Stability of Resilient Flooring by Color Change

F1515 Test Method for Measuring Light Stability of Resilient Flooring by Color Change

2.3 *ANSI Standard*:

ANSI/ASQC Z1.4 Sampling Procedures and Tables for Inspection by Attributes³

3. Terminology

3.1 *Definitions*—For definitions of other terms used in this standard, see Terminology F141.

4. Classification

4.1 Rubber sheet floor covering covered by this specification shall conform to the following types:

4.1.1 *Type I*—Homogeneous rubber sheet floor covering,

4.1.2 *Type II*—Heterogeneous (Layered) rubber sheet floor covering.

4.2 The above may have either smooth, embossed, or molded pattern surfaces.

4.3 These products shall not contain asbestos.

5. Ordering Information

5.1 Purchasers shall state whether this specification is to be used, select the preferred options permitted herein and include the following information in the invitation to bid or purchase order:

5.1.1 Title, number, and date of this specification,

5.1.2 Type, color, and surface (see Section 4 and Section 6),

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

5.1.3 Quantity, in square feet, square yards, or square metres,

5.1.4 Thickness required. (see Section 8),

5.1.5 Overall thickness, if molded pattern sheet flooring is specified (see 8.1),

5.1.6 Width required (see 8.4),

5.1.7 Length required (see 8.5),

5.1.8 Resistance to chemicals, (see 7.4),

5.1.9 Lot information, if other than as specified in ANSI/ASQC Z1.4 (see 10.1 and 11.1),

5.1.10 Sampling, if other than as specified in ANSI/ASQC Z1.4 (see 10.1 and 11.1),

5.1.11 Statement requesting certification, if certification of compliance is required (see 12.1),

5.1.12 Packing requirements, if other than as specified (see 14.1),

5.1.13 Palletization, if required,

5.1.14 Marking required, if other than specified (see 13.1), and

5.1.15 Other requirements.

6. Materials and Manufacture

6.1 *Material*—The polymeric binder of the rubber sheet floor covering shall satisfy the definition of rubber in Terminology D1566, and have been vulcanized, as defined in Terminology D1566 (under vulcanization), such that it becomes thermoset as defined in Terminology D883. The rubber sheet flooring made from this compound shall be resistant to neutral pH cleaners.

6.2 *Color, Pattern, and Wear Layer Surface*—The color, pattern, and wear layer surface, as applicable, shall be as specified in the contract or order (see 5.1).

NOTE 1—The colors and patterns that are available are indicated in individual manufacturer's current catalogs. As manufactured, colors may vary somewhat in hue or shade from the catalog.

NOTE 2—Where color match is a concern, samples from the manufacturer shall be obtained to verify color acceptability.

6.3 *Homogeneous Rubber Sheet Floor Covering*—The surface coloring or mottling shall be uniform throughout the entire thickness of the rubber sheet floor covering.

6.4 *Heterogeneous (Layered) Rubber Sheet Floor Covering*—The surface coloring or mottling need not extend through the entire thickness of the rubber sheet floor covering, but must extend throughout the entire thickness of the wear layer.

6.4.1 The wear layer must have a minimum thickness of 0.040 in. (1.0 mm) when measured in accordance with Test Method F410.

6.4.2 The appearance of the rubber sheet floor covering, after removing 0.020 in. (0.51 mm) of the wear layer thickness, shall compare favorably in appearance with the rubber sheet flooring's original appearance. The removal of the wear layer may be accomplished by any suitable method.

7. Performance Requirements

7.1 *Hardness*—The rubber sheet floor covering shall have a durometer hardness of not less than 85 (Shore, Type A) when tested in accordance with Test Method D2240.

7.2 *Modulus at 10 % Elongation*—When tested in accordance with Test Method D412 at a rate of 6 in. (152.4 mm)/min, using a 1 in. (25.4 mm) by 5 in. (127 mm) gage length rectangular specimen, the modulus shall not be less than 300 psi (2.07 MPa). For molded pattern rubber sheet floor covering, the raised pattern shall be removed by any suitable method.

7.3 *Static Load Limit*—When tested in accordance with Test Method F970, with an applied load of 250 lb (113.4 kg), the residual indentation shall not be greater than 0.005 in. (0.127 mm).

7.4 *Resistance to Chemicals*—When tested in accordance with Test Method F925, the rubber sheet floor covering shall have no more than a slight change in surface dulling, surface attack, or staining when exposed to the following chemicals:

7.4.1 White vinegar (5 % acetic acid),

7.4.2 Rubbing alcohol (70 % isopropyl alcohol),

7.4.3 Sodium hydroxide solution (5 % NaOH),

7.4.4 Hydrochloric acid solution (5 % HCl),

7.4.5 Sulfuric acid solution (5 % H₂SO₄),

7.4.6 Household ammonia solution (5 % NH₄OH),

7.4.7 Household bleach (5.25 % NaOCl),

NOTE 3—These basic chemicals are representative of those likely to be found in domestic, commercial, and institutional use. Many proprietary compounds contain one or more of these basic chemicals. Should the flooring for an unusual application need to be resistant to a specific chemical, this additional requirement should become part of the procurement document (see 5.1.8).

NOTE 4—Since standard SBR rubber flooring is not recommended for installation where the product will be exposed to animal fats, vegetable oils, and petroleum-based reagents, mineral oil, olive oil, kerosene, and gasoline have been removed from the standard chemical list to eliminate any confusion regarding product selection.

7.5 *Resistance to Heat*—When tested in accordance to Test Method F1514, the color change of the rubber sheet floor covering shall have an average ΔE not greater than 8.0 after seven days exposure to 158°F (70°C). The specimen surface shall be wiped with a clean, white cotton cloth prior to taking the initial and post test conditioned period color readings to remove any wax bloom or other contaminants which may affect the accuracy of the color readings.

7.6 *Resistance to Light*—Existing Q-UV and Xenon-arc test methods used to test rubber floor tiles, rubber sheets and rubber stair treads resulted in extremely high failure rates which are not typical in everyday use of these products.

8. Dimensions, Mass, and Permissible Variations

8.1 *Overall Thickness*—Molded pattern rubber sheet floor covering shall be measured for overall thickness at the thickest cross-sectional area of the flooring. The thickness of the molded pattern shall be uniform throughout the flooring.

8.2 *Base Thickness*—Molded pattern rubber sheet floor covering base thickness shall be measured at the thinnest cross-sectional area of the flooring. The thinnest cross-sectional area shall be uniform throughout the flooring.

8.3 *Thickness*—The thickness of the rubber sheet floor covering shall be as specified in the contract or order (see 5.1.4). An average tolerance, obtained from five individual

measurements, of ± 0.006 in. (± 0.15 mm) from the specified thickness shall be permitted in the base thickness alone or in combination with the overall thickness, when measured in accordance with Test Method **F386**. The difference between the five individual measurements can not be greater than 0.008 in. (0.2 mm). In the case of molded pattern rubber sheet floor covering, overall thickness and base thickness shall be reported.

8.4 *Width*—The width shall be as specified in the contract or order (see **5.1.6**). The net width (gross width less selvages) shall not be less than as marked on the label or package when measured in accordance with **8.6**.

8.5 *Length*—The length of the roll shall be as specified in the contract or order (see **5.1.7**). The sheet length shall not be less than as marked on the label or package when measured in accordance with **8.6**. Each roll shall be in one piece, except that less than 20 % of the rolls in any one shipment may consist of not more than two pieces, the shortest length shall not be less than 5 linear yards (4.57 m), or as agreed upon by the purchaser and seller. Such rolls shall be clearly marked.

8.6 *Length and Width Measurements*—Measurements shall be made with a calibrated 100 ft (30 m) steel tape graduated at intervals of $\frac{1}{16}$ in. or 1 mm. The roll shall be extended to its full length on a flat surface and all creases and buckles removed, insofar as practical, without applying stresses that cause any significant stretching. Measurements of length shall be rounded to the nearest inch or 10 mm. Net width shall be measured to the nearest $\frac{1}{16}$ in. or 1 mm at not less than ten locations uniformly distributed along the length of each roll, and the results averaged.

9. Workmanship, Finish, and Appearance

9.1 The rubber sheet floor covering furnished in accordance with this specification shall be an acceptable match to approved samples in color, pattern, and appearance. The product shall be free of defects, which adversely affect performance or appearance. Such defects include: blemishes, spots, lines, indentations, blisters, and delamination.

9.2 Unless otherwise specified in the contract or order (see **5.1**), the back or bonding surface of the rubber sheet floor covering shall be buffed, roughened, ribbed, grooved, or otherwise modified to improve the adhesive bond of the rubber sheet floor covering, but in no case shall the thickness of the

flooring be decreased to the extent that any depression or groove on the bonding surface be perceptible, under any circumstances, on the exposed surface.

10. Sampling for Test

10.1 Sampling for testing physical characteristics listed in **Table 1** shall be done in accordance with the provisions set forth in ANSI/ASQC Z1.4. The inspection level shall be special inspection level S-1, as noted in Table I of ANSI/ASQC Z1.4, and the acceptable quality level (AQL) shall be 6.5 defects per hundred units as noted in Table II-(A) of ANSI/ASQC Z1.4 or as otherwise specified in **10.2**. The lot size shall be expressed in units. A unit represents a single, manufactured, inventoried, finished roll.

10.1.1 Samples shall be obtained in the required length from the outside end of the roll and shall encompass the total width of the material.

10.2 Sampling for testing physical characteristics listed in **Table 1** shall be agreed upon by the purchaser and the manufacturer as part of the procurement document.

11. Inspection

11.1 Sampling for inspection of the rubber sheet floor covering for defects that would adversely affect performance (see **9.1**) shall be done in accordance with the provisions set forth in ANSI/ASQC Z1.4. The inspection level shall be Level I as noted in Table I of ANSI/ASQC Z1.4 with an acceptable quality level (AQL) of 6.5 defects per hundred as noted in Table II-(A) of ANSI/ASQC Z1.4 or as otherwise specified in **11.2**. The lot size shall be expressed in units. A unit represents a single, manufactured, inventoried, finished roll.

11.2 Inspection of the rubber sheet floor covering for defects that would adversely affect performance (see **9.1**) shall be agreed upon by the purchaser and the manufacturer as part of the procurement documents.

12. Certification

12.1 When specified in the purchase order or contract (see **5.1.11**), a manufacturer's certification and any other documents required to substantiate certification shall be furnished to the purchaser that the product was manufactured to meet this specification.

TABLE 1 Characteristics and Tests

Characteristic	Requirement	ASTM Test Method	Reference
Composition of Material	Certificate of Compliance		6.1
Wear Layer Thickness	min 0.040 in. (1.0 mm)	F410	6.4.1
Hardness	min 85 Shore A	D2240	7.1
Modulus at 10 % Elongation	min 300 psi (2.07 MPa)	D412	7.2
Static Load Limit	≤ 0.005 in. (0.127 mm)	F970	7.3
Resistance to Chemicals	No more than a slight change in surface dulling, surface attack, or staining.	F925	7.4
Resistance to Heat	Ave. ΔE not greater than 8.0	F1514	7.5
Average Thickness	± 0.006 in. (± 0.15 mm)	F386	8.3
Width	Not less than as specified	Section 8	8.4
Length	Not less than as specified	Section 8	8.5

13. Product Marking

13.1 Unless otherwise specified in 5.1, the rubber sheet floor covering shall be marked with the name of the material as defined by the contract or order under which the shipment is made, the pattern number, width, thickness, the quantity or length contained therein, and the name of the manufacturer.

13.2 When product sample sets, sample set cover cards, and marketing and technical literature reference this specification, the complete product classification information relative to this specification shall be included.

14. Packaging and Packing

14.1 Unless otherwise specified in 5.1, the rubber sheet floor covering shall be packaged in accordance with normal commercial practice and packed to ensure acceptance by the common carrier and to provide protection against damage during normal shipping, handling, and storage.

15. Keywords

15.1 flooring; resilient; rubber; sheet; without backing

APPENDIX

(Nonmandatory Information)

X1. ADDITIONAL INFORMATION

X1.1 The following sources can be consulted for additional information:

X1.1.1 *ASTM Standards*—See Practice **F710** and Guide **F1482**.

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