



Standard Specification for Rigid Poly(Vinyl Chloride) (PVC) Exterior-Profile Extrusions Used for Assembled Windows and Doors¹

This standard is issued under the fixed designation D4726; 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.

1. Scope*

1.1 This specification establishes requirements for the material properties, including dimensional stability, weatherability, and extrusion quality, of rigid poly(vinyl chloride) (PVC) exterior profile extrusions used for assembled windows and doors. Methods for testing and for identifying exterior profile extrusions that comply with this specification are also provided.

1.2 The use of rigid PVC recycled plastic in this product shall be in accordance with the requirements in Section 6.

NOTE 1—Information with regard to application, assembly, and installation should be obtained from the manufacturers of the profiles and of the windows and doors.

NOTE 2—Refer to Specification **D3678** for interior profile extrusions.

1.3 Color-hold guidelines are provided in an appendix for the manufacturer's product development and quality performance use.

1.4 Color-hold guidelines are presently limited to white, grey, beige, light brown, and dark brown (see Figs. X1.1 through X1.5). Additional colors will be added as color guidelines are developed.

1.5 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are for information only.

NOTE 3—There is no known ISO equivalent to this standard.

1.6 The text of this standard references notes and footnotes, which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of this standard.

1.7 The following safety hazards caveat pertains only to the test methods portion, Section 11, of this specification: *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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.8 *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

D618 Practice for Conditioning Plastics for Testing

D883 Terminology Relating to Plastics

D1042 Test Method for Linear Dimensional Changes of Plastics Caused by Exposure to Heat and Moisture

D1435 Practice for Outdoor Weathering of Plastics

D1600 Terminology for Abbreviated Terms Relating to Plastics

D2244 Practice for Calculation of Color Tolerances and Color Differences from Instrumentally Measured Color Coordinates

D3678 Specification for Rigid Poly(Vinyl Chloride) (PVC) Interior-Profile Extrusions

D3892 Practice for Packaging/Packing of Plastics

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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

- D4216** Specification for Rigid Poly(Vinyl Chloride) (PVC) and Related PVC and Chlorinated Poly(Vinyl Chloride) (CPVC) Building Products Compounds
- D4226** Test Methods for Impact Resistance of Rigid Poly(Vinyl Chloride) (PVC) Building Products
- ~~**D7209** Guide for Waste Reduction, Resource Recovery, and Use of Recycled Polymeric Materials and Products (Withdrawn 2015)³~~
- E631** Terminology of Building Constructions
- E805** Practice for Identification of Instrumental Methods of Color or Color-Difference Measurement of Materials
- G147** Practice for Conditioning and Handling of Nonmetallic Materials for Natural and Artificial Weathering Tests

3. Terminology

3.1 *General*—Definitions are in accordance with Terminologies **D883** or **E631** and **D1600**, unless otherwise indicated.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *color-hold guidelines*—target color regions within a three-dimensional model which constitute acceptable appearance retention levels of color change resulting from weathering of a specific product type and color.

3.2.2 *temperate northern climate*—in weather testing, a North American metropolitan area testing site located within 73 to 100° W longitude and 37 to 45° N latitude.

4. Classification

4.1 *Color Regions*—The color region for a color is determined by measuring the Hunter L, a, b color values for a sample. Use the integer value (by truncating any fractional results) to determine the color region for the color using the following region boundaries.

4.1.1 *Region 1—Beige:*

L = 60 to 87
a = -2.5 to 4.0
b = 6.5 to 23

4.1.2 *Region 2—Dark Brown:*

L = 13 to 33
a = -1.0 to 6.0
b = 1.0 to 6.5

4.1.3 *Region 3—Gray:*

L = 33 to 74
a = -3 to 4
b = -5.5 to 5.5

4.1.4 *Region 4—Light Brown:*

L = 30 to 60
a = -1.5 to 12.5
b = 3.0 to 12.5

4.1.5 *Region 5—White:*

L = 83 to 100
a = -4 to 0
b = -5.5 to +5.5

NOTE 4—*L, a, b* is determined in accordance with the Hunter *L, a, b* opponent color space system in Test Method **D2244**.

5. Significance and Use

5.1 The purpose of this specification is to establish a recognized standard of quality for rigid poly(vinyl chloride) (PVC) exterior weatherable profile extrusions for use in assembling windows and doors. The information contained in this specification is intended to be helpful to producers, distributors, and users, and to promote understanding between buyers and sellers. It is also intended to serve as the basis for specification requirements of exterior windows and doors which are made from rigid PVC profile extrusions in their construction.

6. Materials and Manufacture

6.1 The profile extrusions used for assembled windows and doors shall be made principally of weatherable, rigid poly(vinyl chloride) (PVC) compounds meeting or exceeding the requirements of Class 1-20131-13 as defined in Specification **D4216**.

NOTE 5—Non-PVC materials may be used as a capstock.

6.2 Rigid PVC recycled plastic, as defined in Guide plastic **D7209**, is acceptable for use in this product if all the requirements in the sections on Terminology (Section 3), Materials and Manufacture (Section 6), Physical Requirements (Section 7), and Performance Requirements (Section 8) are met by the extrusions containing PVC recycled plastic.

6.3 The PVC compound in the extruded section shall have visual uniform color and be free of any visual surface or structural changes, such as peeling, chipping, cracking, flaking, or pitting.

6.4 *Rework Material*—Clean, homogeneous PVC rework material or rework material containing PVC capstock generated from the manufacturer’s own production of the same class compound is acceptable for use by the same manufacturer providing that the extruded profiles meet all the requirements of this specification. Clean principally PVC rework material containing non-PVC capstock is acceptable for use in the substrate of a capstocked product by the same manufacturer, providing that the extruded profiles meet all of the requirements of this specification.

~~6.5 The PVC compound shall have a minimum impact resistance of 0.6 in.-lb/mil (2670 J/m) after weathering for six months and one year in a hot, dry climate such as Phoenix, AZ; a hot, humid climate, such as Miami, FL; and a temperate northern climate.~~

~~6.6 The PVC compound in the extruded section shall maintain uniform color and be free of any surface or structural changes, such as peeling, chipping, cracking, flaking, or pitting after weathering for six months, one year, and two years in a hot, dry climate, such as Phoenix, AZ; a hot, humid climate, such as Miami, FL; and a temperate northern climate when tested in accordance with Annex A1.~~

6.5 The PVC compound shall have successfully met the weathering requirements prescribed in 6.4 and 6.5 for six months at each climatic testing site prescribed in A1.1.1 prior to use in production of exterior-profile extrusions for either market development or sales.

NOTE 6—The six-month-test requirement constitutes a screening process to eliminate catastrophic failure in the marketplace.

7. Physical Requirements

7.1 *Dimensions*—The size, thickness, and dimensional tolerances of the exterior profiles shall be as agreed upon between the supplier and the purchaser in the purchase order, or by established internal process control standards.

7.2 *Dimensional Stability*—The dimensional stability of the exterior-profile extrusions shall be determined in accordance with 11.3. Extrusions over 0.040 in. (1.02 mm) shall have a maximum average shrinkage of 2.2 % for all sides measured, with no single value exceeding 2.4 %. Extrusions of 0.040 in. (1.02 mm) or less shall have a maximum average shrinkage of 3 %.

7.3 *Impact Resistance*—Flat sections of the exterior profile extrusion shall have a minimum brittle impact failure of 1.0 in.-lb/mil (4450 J/m) when tested in accordance with Test Methods D4226, Procedure B, using impactor C.125. Refer to 11.4.

8. Performance Requirements

8.1 *Weathering*:

8.1.1 The exposures listed in 6.6 Annex A1 shall be conducted in order to meet the requirements of this specification. All exposures shall be conducted at an angle of 45° S, plywood-backed, in accordance with Practice D1435 and Practice G147.

8.1.2 After six-month and 1-year exposure times, the minimum mean impact for 20 measurements conducted on the exposed specimens shall be at least 0.6 in.-lb/mil (2670 J/m). Test impact in accordance with 11.4, A1.4, and A1.5.

8.1.3 After each exposure time, the tested specimens shall maintain a visual uniform color and be free of any visual surface or structural changes changes in appearance at the surface, such as peeling, chipping, cracking, flaking, and pitting when tested in accordance with Annex A1.

NOTE 7—It is recommended that manufacturers use the color-hold guidelines in Appendix X1 to ensure quality performance.

8.1.4 Weatherability conformance testing requirements are to reflect performance of a “typical” extrusion system profile representing a specific PVC compound and a specific extrusion technology. In no case is there an implied requirement for testing all the various shaped profiles. The lengthy outdoor weatherability testing shall be performed concurrently with market development of new applications and sales of profiles to existing markets. Completion of weatherability testing prior to marketing of the product is not required. The profile extrusion producer shall immediately respond in terms of compound change or extrusion technology change to unsatisfactory weatherability behavior of the profiles under test in any climatic test site at any stage of the weatherability testing.

9. Workmanship, Finish, and Appearance

9.1 The extrusions shall be acceptable between the buyer and the seller or meet internal process control standards in section, color, and finish. The extrusions shall be substantially straight and free from defects that might affect appearance or serviceability.

10. Sampling

10.1 Select samples using a statistically acceptable procedure. The samples shall be representative of the compound used.

11. Test Methods

11.1 *General*—Use the inspection and test procedures contained in this section to determine the conformance of products to the requirements of this specification. A producer or distributor representing products as conforming to this specification shall use

statistically based sampling plans that are appropriate to each manufacturing process. Keeping essential records are necessary to document with a high degree of assurance the claim that all of the requirements of this specification have been met. Additional sampling and testing of the product, as agreed upon between the supplier and the purchaser, is not precluded by this section.

11.2 *Conditioning of Specimens*—Condition the test specimens in accordance with Procedure A of Practice D618. For the purpose of quality control testing, the minimum conditioning time shall be four hours.

11.3 *Dimensional Stability:*

11.3.1 Determine the dimensional stability in accordance with Test Method D1042, except that one or more specimens shall be exposed to either of the following test cycles:

11.3.1.1 30 min immersed in water maintained at $180 \pm 2^\circ\text{F}$ ($82 \pm 1^\circ\text{C}$), or

11.3.1.2 30 min conditioned in a forced-ventilation oven at $180 \pm 2^\circ\text{F}$ ($82 \pm 1^\circ\text{C}$).

11.3.2 Specimens shall condition for no less than 1 h in accordance with Procedure A of Practice D618, prior to measurement. If a specimen were to fail, select and retest two additional specimens.

11.4 *Impact Test*—Determine the impact strength in accordance with Test Methods D4226, Procedure B, using the C.125 impactor.

12. Packing, Packaging, and Package Marking

12.1 The exterior profile extrusions shall be packaged in such a manner as to provide reasonable protection against damage in ordinary handling, transportation, and storage.

12.2 Provisions of Practice D3892 shall apply to this specification.

12.3 Marking on each package of extruded profile extrusions shall include the following:

12.3.1 Manufacturer’s name or trademark;

12.3.2 Identity of code number of extrusion profiles;

12.3.3 Class of compound (Specification D4216) used in profiles;

12.3.4 The designation ASTM D4726, affirming that the product so marked has been qualified to all the provisions of this specification, and

12.3.5 The date and any other relevant information, such as factory, machine, production shift, and so forth, either directly or all or partly coded.

13. Keywords

13.1 color-hold guidelines; doors; exterior-profile extrusions; poly(vinyl chloride) (PVC); recycled plastic; windows

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ANNEXES

(Mandatory Information)

A1. WEATHERABILITY PROCEDURE

A1.1 Summary of Procedure of Determining Weatherability

A1.1.1 Flat section specimens cut from finished product lineals or laboratory extruded samples are exposed in accordance with Practice D1435 and Practice G147 at 45° S, plywood-backed, in a hot, dry (desert) ~~climate, such as Phoenix, AZ; climate;~~ a hot, humid ~~climate such as Miami, FL; climate;~~ and in a northern temperate climate for periods of six months, one year and two years.

~~A1.1.2 Color change as a result of weather exposure at each climatic exposure site is measured after six months, one year and two years.~~

A1.1.2 Degree of retention of the original impact strength due to weather exposure in each exposure site is measured after six-months and one-year exposure.

A1.1.3 The acceptability of color uniformity, and surface ~~or structural~~ changes resulting from weathering at each test site and each exposure frequency is determined by visual observation in comparison to the ~~unweathered~~ unexposed specimens.

A1.2 Significance

A1.2.1 The processing of poly(vinyl chloride) (PVC) compounds has ~~greater influence on impact retention and some influence on color appearance retention.~~ For this reason samples prepared for ~~weathering impact retention~~ must be processed in a manner similar to the commercial product while still permitting the use of laboratory scale equipment. ~~Color hold guidelines are represented by ellipsoids or as an alternative, mathematical equations, both of which allow determination whether the product meets the performance criteria. The ellipsoids also allow determination of the direction of color change and, therefore, are useful in analyzing the weathering data.~~

NOTE A1.1—It is recommended that manufacturers use the color-hold guidelines in [Appendix X1](#) to ensure quality performance.

A1.2.2 Poly(vinyl chloride) compounds undergo complex changes when exposed to the weather. ~~Color changes~~ Changes in appearance are caused by chemical changes in the PVC, additives, or pigments. ~~Color changes~~ Changes in appearance are caused by selective erosion of some pigments faster than others. Changes in impact strength are due to chemical changes in the PVC or additives, or due to physical changes on the surface as a result of erosion and crazing.

A1.3 Sampling and Specimen Preparation

A1.3.1 Select samples using a statistically acceptable procedure. The samples shall be representative of the product to be qualified.

A1.3.2 If commercial parts are used, cut them into sections so that flat test specimens at least 1.5 in. (38 mm) wide can be obtained. The back surface of the specimen must lay as flat as possible on the specimen support anvil. Cut the flat sections such that there are no ridges or raised areas remaining on the back surface of the specimen that would make contact with the specimen support anvil. The specimens shall be free of obvious imperfections, grooves, ribs, and so forth. Material prepared in the laboratory by a similar process is an alternate to a commercial part. If the commercial product is extruded, the laboratory specimen must be extruded; if the commercial product is a laminate of two materials, the laboratory specimen must be laminated with the two materials, and so forth.

A1.3.3 The number of specimens or the size of the specimen must be sufficient to obtain at least 20 impact locations of the dropped dart for each weathering interval.

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A1.3.4 The thickness of any test specimen must differ from the average test specimen by no more than 10 %.

A1.4 Conditioning

A1.4.1 Condition the test specimens, including specimens removed from the weather exposure, at $73.4 \pm 3.6^\circ\text{F}$ ($23.0 \pm 2.0^\circ\text{C}$) and $50 \pm 10\%$ relative humidity for not less than 24 h before testing. In no case shall weathered specimens be oven-dried before testing.

NOTE A1.2—The operational fluctuations are allowable deviations from the specified temperature and relative humidity settings. They do not imply that these settings can be higher or lower than that specified. If the operational fluctuations are greater than the maximum allowed, correct the cause of the problem before continuing the conditioning.

A1.5 Procedure

A1.5.1 Obtain test specimens in accordance with [A1.3](#).

A1.5.2 ~~Measure the original tristimulus X, Y, and Z values in replicate for each specimen using 2° observer and Illuminant C, specular components included, in accordance with Practice E805. Calculate the Hunter L,a,b units in accordance with the equations in the Section on Hunter L,a,b Color Space and Color-Difference Equation in Test Method D2244. Average the calculated units from the replicate measurements and record them in a permanent record.~~

A1.5.2 Measure the impact resistance on an ~~unweathered~~unexposed specimen in accordance with Test Methods [D4226](#), Procedure B, with a C.125 impactor and record permanently.

A1.5.3 Mark the specimens permanently so as to not lose their identity during weathering. Weather specimens at 45°S, plywood-backed, in accordance with Practice [D1435](#) in both a ~~dry, hot (desert) climate such as Phoenix, AZ; a hot, humid climate such as Miami, FL; and a temperate northern climate.~~dry/hot and hot/humid, and northern temperate climate zones. Remove specimens for testing after six-months, one-year, and two-year exposure. Further testing is optional. More frequent exposure increments are preferred to some applications.

A1.5.4 After exposure, ~~measure the color and~~ evaluate the appearance of the exposed specimens. ~~Color measurement shall take place within seven days of specimen removal from the exposure test rack.~~

NOTE A1.3—Additional color development is known to occur for PVC products after removal from exposure to solar radiation. This ~~color change in appearance~~ is referred to as ~~Dark~~“Dark Time Yellowing. For a hot, humid climate such as Miami, FL and in a northern temperate climate, color measurement Yellowing.” For two locations representing hot/humid and northern temperate climate zones, visual color comparisons within 48 h of removal is strongly recommended for PVC products. For a ~~hot and dry (desert) climate, such as Arizona,~~hot/dry climate zone, it is strongly recommended the visual color measurement comparison be made within 8 h of removal from the exposure rack.

A1.5.5 Wash the exposed specimens in accordance with the procedure in [Annex A2](#).

A1.5.6 Condition in accordance with [A1.4](#).

A1.5.7 After removal from the exposure rack and within the time period specified in [The acceptability of A1.5.5](#), measure color on the exposed specimen(s) in accordance with [color uniformity, and surface or structural changes resulting A1.5.2](#). Record color ~~in~~from weathering at each ~~L, test, b~~ units and record the average change in color as compared to the unweathered specimen in site and each exposure frequency is determined by visual observation in comparison to the unexposed specimens.~~L, a, b~~ units.

A1.5.8 Note and record any nonuniform change in color.

A1.5.9 Measure average impact resistance of the weathered specimens, weathered side up, using the same method used for the ~~unweathered~~unexposed specimen ([A1.5.3](#)[A1.5.2](#)).

A2. WASHING WEATHERED SPECIMENS

A2.1 Scope

A2.1.1 This procedure provides a consistent and reproducible practice for washing weathered ~~specimens prior to instrumental color measurement.~~specimens. The procedure is designed to minimize any effects of altering the surface of the specimen in other than a predictable manner.

A2.2 Equipment

A2.2.1 ~~Mild Detergent,~~Detergent, such as Joy, Liquid Tide, or equivalent.

A2.2.2 *Sponge or Soft Cloth.*

A2.3 Procedure

A2.3.1 Flush the exposed specimen with distilled or deionized water.