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Standard Specification for Bonded Rubber Crumb Floor Coverings¹

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1. Scope

1.1 This specification covers the requirements for the compound and physical characteristics of bonded rubber crumb floor coverings.

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 *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.*

1.4 *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

- [D883 Terminology Relating to Plastics](#)
- [D1566 Terminology Relating to Rubber](#)
- [D3389 Test Method for Coated Fabrics Abrasion Resistance \(Rotary Platform Abrader\)](#)
- [F137 Test Method for Flexibility of Resilient Flooring Materials with Cylindrical Mandrel Apparatus](#)
- [F141 Terminology Relating to Resilient Floor Coverings](#)
- [F386 Test Method for Thickness of Resilient Flooring Materials Having Flat Surfaces](#)
- [F710 Practice for Preparing Concrete Floors to Receive Resilient Flooring](#)

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.

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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.

- [F925 Test Method for Resistance to Chemicals of Resilient Flooring](#)
 - [F970 Test Method for Measuring Recovery Properties of Floor Coverings after Static Loading](#)
 - [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](#)
 - [F2055 Test Method for Size and Squareness of Resilient Floor Tile by Dial Gage Method](#)
 - [F2199 Test Method for Determining Dimensional Stability and Curling Properties of Resilient Flooring after Exposure to Heat](#)
- 2.2 *American National Standard:*³
- [ANSI/ASQ Z1.4 Sampling Procedures and Tables for Inspection by Attributes](#)

3. Terminology

3.1 *Definitions:*

3.1.1 *crumb rubber, n*—Material derived from reducing rubber material into smaller granules. The granular material shall (1) satisfy the definition of rubber in Terminology [D1566](#), and (2) have been vulcanized, as defined in Terminology [D1566](#) (under vulcanization), such that it becomes thermoset as defined in Terminology [D883](#).

3.1.2 *skive, vt*—to cut thin layers off (leather or rubber, for example); pare.

3.1.3 *skive marks, n*—marks left on the material from the process of skiving; blade marks; striations.

3.2 For additional definitions refer to Terminology [F141](#).

4. Classification

4.1 Bonded rubber crumb floor coverings covered by this specification shall be classified as follows:

4.1.1 Type:

4.1.1.1 Type I – Roll

4.1.1.2 Type II – Tile

4.1.2 Class – Recycled content by weight

4.1.2.1 Class A – Recycled content $\geq 80\%$

4.1.2.2 Class B – Recycled content $\geq 50\%$ and $< 80\%$

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

4.1.2.3 Class C – Recycled content $\geq 10\%$ and $< 50\%$

4.1.2.4 Class D – Recycled content $< 10\%$

5. Ordering Information

5.1 The 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, class and pattern number.
- 5.1.3 Quantity, in square feet, lineal feet or as specified.
- 5.1.4 Roll thickness required (see 8.1.1).
- 5.1.5 Roll width required (see 8.1.2).
- 5.1.6 Roll length required (see 8.1.2).
- 5.1.7 Tile thickness required (see 8.2.1).
- 5.1.8 Tile size required (see 8.2.2).
- 5.1.9 Lot information, if other than as specified in ANSI/ASQC Z1.4.
- 5.1.10 Packing requirements, if other than as specified.
- 5.1.11 Palletization, if required.
- 5.1.12 Other requirements.

6. Materials and Manufacture

6.1 The color, finish and wearing surface characteristics shall match the sample mutually agreed upon between the buyer and seller.

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

NOTE 2—Differences in color and texture can result in shading variation from piece to piece. Color and texture differences or striation is inherent in the manufacturing process and is not considered a defect.

NOTE 3—Where color match is a concern, samples from the manufacturer shall be obtained to verify color or shade acceptability, or both.

6.2 Bonded rubber crumb flooring shall be of uniform structure and composition throughout, consisting of rubber granules thoroughly and uniformly bonded together.

7. Performance Requirements

7.1 *Abrasion Resistance*—Test in accordance with Test Method **D3389** method B and with the abrader equipped with H-18 wheels and a load of 500 g. The flooring shall not lose more than 1 g after 1000 cycles.

7.2 Flexibility:

7.2.1 *Material measuring 0.25 in. (6.35 mm) or thinner*—Test in accordance with Test Method **F137**, both face-in and face-out, using a 0.25 in. (6.35 mm) mandrel. The flooring shall show no tears, flakes, or splitting of the product matrix.

7.2.2 *Material measuring more than 0.25 in. (6.35 mm)*—Test in accordance with Test Method **F137**, both face-in and face-out, using a mandrel of the same diameter as the material thickness. The flooring shall show no tears, flakes or splitting of the product matrix.

7.3 *Static Load Limit*—Test in accordance with Test Method **F970**, with an applied load of 250 lb (113.4 kg).

7.3.1 Bonded rubber crumb flooring shall have a residual indentation of not more than 0.005 in. (0.127 mm).

NOTE 4—Test Method **F970** is suitable only for tiles up to 1 in. thick.

7.4 *Dimensional Stability*—Test in accordance with Test Method **F2199**.

7.4.1 Bonded rubber crumb flooring shall not change in linear dimensions more than nominal 0.050 in. per linear foot ($\pm 0.40\%$).

NOTE 5—Test Method **F2199** is suitable only for tiles up to 1 in. thick.

7.5 *Resistance to Heat*—When tested in accordance with Test Method **F1514**, the flooring shall have an average ΔE of not more than 8.00.

7.6 *Resistance to Short-Term Chemical Exposure*—Test in accordance with Test Method **F925** using the following chemicals, which represent an abbreviated list:

- White vinegar (5 % acetic acid)
- Rubbing alcohol (70 % isopropyl alcohol)
- Sodium hydroxide solution (5 % NaOH)
- Hydrochloric acid solution (5 % HCl)
- Sulfuric acid solution (5 % H₂SO₄)
- Household ammonia solution (5 % NH₄OH)
- Disinfectant cleaner (5 % active phenol)

The flooring shall have no more than a slight change in surface dulling, surface attack or color change.

NOTE 6—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 need to be resistant to a specific chemical, this additional requirement should become part of the procurement document.

8. Dimensions and Permissible Variations

8.1 Type I material, roll:

8.1.1 *Thickness*—The thickness of the floor covering shall be as specified in the contract or order. The minimum thickness shall be 0.060 in. (1.5 mm). A tolerance of ± 0.020 in. (± 0.50 mm) from the specified thickness shall be permitted, provided the product thickness does not go below the minimum thickness of 0.060 in. (1.5 mm). Thickness is measured in accordance with Test Method **F386**.

8.1.2 *Length and Width*—The length/width shall not be less than as marked on the label, package or as specified in the contract or order.

8.2 Type II material, tile:

8.2.1 *Thickness*—The thickness of the bonded rubber crumb floor covering tile shall be as specified in the contract or order. The minimum thickness shall be 0.060 in. (1.5 mm). A tolerance of ± 0.020 in. (± 0.50 mm) from the specified thickness shall be permitted, provided the product thickness does not go below the minimum thickness of 0.060 in. (1.5 mm). Thickness is measured in accordance with Test Method **F386**.

8.2.2 *Size*—Bonded rubber crumb floor tiles are available in a variety of sizes and shall be as specified. The following tolerances shall be permitted per tile when measured in accordance with Test Method **F2055**.

8.2.2.1 Up to and including 12 by 12 in. = ± 0.032 in. (305 by 305 mm ± 0.8 mm).

8.2.2.2 Larger than 12 by 12 in. = ± 0.060 in. (305 by 35 mm ± 1.5 mm).

8.2.3 *Squareness*—When tested in accordance with Test Method **F2055**, the out of squareness of the bonded rubber crumb floor tile shall not exceed 0.030 in. (0.76 mm).