



Designation: ~~F1344 – 21~~ F1344 – 21a

Standard Specification for Rubber Floor Tile¹

This standard is issued under the fixed designation F1344; 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.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This specification covers requirements for the compound and physical characteristics of rubber floor tile.

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 applies only to the test method portion, Section 7, 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.*

1.4 *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 The following documents of the issue in effect on the date of this material purchase form a part of this specification to the extent referenced herein:

2.2 *ASTM Standards:*²

D883 Terminology Relating to Plastics

D1566 Terminology Relating to Rubber

D2240 Test Method for Rubber Property—Durometer Hardness

D3389 Test Method for Coated Fabrics Abrasion Resistance (Rotary Platform Abrader)

F141 Terminology Relating to Resilient Floor Coverings

F373 Test Method for Embossed Depth of Resilient Floor Coverings

F386 Test Method for Thickness of Resilient Flooring Materials Having Flat Surfaces

F410 Test Method for Wear Layer Thickness of Resilient 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 Measuring Recovery Properties of Floor Coverings after Static Loading

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.

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 Gauge Method
F2199 Test Method for Determining Dimensional Stability and Curling Properties of Resilient Flooring after Exposure to Heat

2.3 *ANSI Standards:*

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 floor tile covered by this specification shall be classified as:

- Type I—Homogeneous Rubber Floor Tile
 - A. Solid Color
 - B. Through Mottled
- Type II—Heterogeneous (Layered) Rubber Floor Tile
 - A. Solid Color Wear Layer
 - B. Mottled Wear Layer
- Grade—Based on Shore A durometer hardness
 - Grade 1 \geq 85
 - Grade 2 \geq 70 but less than 85

4.2 The tile in **4.1** may have either smooth, embossed, or molded pattern wearing surfaces.

4.3 These products shall not contain asbestos.

5. Ordering Information

5.1 Purchaser 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. [ASTM F1344-21a](https://standards.iteh.ai/catalog/standards/sist/4303cda6-8a9a-409c-81c3-6d399e951a5f/astm-f1344-21a)
<https://standards.iteh.ai/catalog/standards/sist/4303cda6-8a9a-409c-81c3-6d399e951a5f/astm-f1344-21a>
- 5.1.2 Type, color, pattern, and wearing surface (see Sections **4.4** and **6.4** and **6.6**).
- 5.1.3 Quantity, in square feet, square meters, or cartons.
- 5.1.4 Size required (see **8.4**).
- 5.1.5 Thickness required (see **8.3**).
- 5.1.6 Overall thickness, if molded pattern tile is specified (see **8.1**).
- 5.1.7 Base thickness, if molded pattern tile is specified (see **8.2**).
- 5.1.8 Resistance to chemicals (see **7.4**).
- 5.1.9 Lot formation, if other than as specified in ANSI/ASQC Z1.4 (see Sections **10** and **11**).
- 5.1.10 Sampling, if other than as specified in ANSI/ASQC Z1.4 (see Sections **10** and **11**).
- 5.1.11 Statement requesting certification, if certification of compliance is required (see Section **12**).
- 5.1.12 Packaging and packing requirements, if other than as specified (see Section **14**).

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

5.1.13 Palletization, if required.

5.1.14 Marking required, if other than specified (see Section 13).

5.1.15 Other requirements.

6. Materials and Manufacture

6.1 *Material*—The polymeric binder of the rubber floor tile 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. The rubber floor tile 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 Floor Tile*—The surface coloring or mottling shall be uniform throughout the entire thickness of the rubber floor tile.

6.4 *Heterogeneous (Layered) Rubber Floor Tile*—The surface color or mottling need not extend through the entire thickness of the rubber floor tile, 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 floor tile, after removing 0.020 in. (0.51 mm) of the wear layer thickness, shall compare favorably in appearance with the rubber floor tile original appearance. The removal of the wear layer may be accomplished by any suitable method.

7. Performance Requirements

7.1 *Hardness*—The rubber floor tile shall have a durometer hardness as follows:

Grade 1 ≥ 85

Grade 2 ≥ 70 but less than 85 (Shore, Type A, instantaneous reading) when tested in accordance with Test Method D2240.

7.2 *Static Loading*—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).

7.3 *Resistance to Short-Term Chemical Exposure—Chemicals*—When tested in accordance with Test Method F925, the rubber floor tile shall have no more than a slight change in surface dulling, color change or surface attack, when exposed to the following chemicals:

7.3.1 White vinegar (5 % acetic acid),

7.3.2 Rubbing alcohol (70 % isopropyl alcohol),

7.3.3 Sodium hydroxide solution (5 % NaOH),

7.3.4 Hydrochloric acid solution (5 % HCl),

7.3.5 Sulfuric acid solution (5 % H₂SO₄),

7.3.6 Household ammonia solution (5 % NH₄OH), and

7.3.7 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 rubber floor tile 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 floor tiles are 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.

7.4 *Resistance to Heat*—When tested in accordance with Test Method F1514, the color change of the rubber floor tile shall have an average ΔE not greater than 8.0 after 7 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.

7.5 *Abrasion Resistance*—When tested in accordance with Test Method D3389 and with the abrader equipped with H-18 wheels and a load of 500 gf (gram-force) per wheel, the maximum material loss shall not exceed 1 g after 1000 cycles.

7.6 *Dimensional Stability*—When tested in accordance with Test Method F2199, the dimensional change of the rubber floor tile in both the machine direction (MD) and the across machine direction (AMD) shall not exceed 0.15 %.

7.7 *Resistance to Light*—Existing Q-UV and Xenon-Arc test methods used to test rubber floor tiles resulted in extremely high failure rates which is not typical in everyday use of these products.

8. Dimensions and Permissible Variations

8.1 *Overall Thickness*—Unless otherwise specified (see 5.1), the molded pattern rubber floor tile shall have a minimum thickness of 0.080 in. (2 mm) and shall be measured for overall thickness at the thickest cross-sectional area of the tile. The thickness of the molded pattern shall be uniform throughout the tile.

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

8.3 *Thickness Tolerances*—Thickness shall be as specified in the contract or order (see 5.1). A total tolerance of ± 0.005 in. (± 0.127 mm) for smooth rubber floor tile or $+0.015/-0.005$ in. ($+0.381/-0.127$ mm) for molded and embossed pattern rubber floor tile, 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 for smooth and molded pattern rubber floor tile and Test Method F373 for embossed pattern rubber floor tile. In case of molded and embossed pattern rubber floor tile, overall thickness and base thickness shall be reported (see Fig. 1).

8.4 *Size*—Rubber floor tiles are available in a variety of sizes and shall be specified (see 5.1). The following permissible tolerances shall be permitted per tile when measured in accordance with Test Method F2055.

Up to and including 12 by 12 in. = ± 0.016 in. (± 0.4 mm).

Larger than 12 by 12 in. and up to and including 24 by 24 in. = ± 0.018 in. (± 0.45 mm).

Larger than 24 by 24 in. = ± 0.020 in. (± 0.5 mm).

8.5 *Squareness*—When tested in accordance with Test Method F2055, the out of squareness of the rubber floor tile shall not exceed 0.010 in. (0.254 mm).

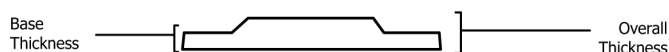


FIG. 1 Overall and Base Thickness