



Designation: D7465/D7465M – 15 (Reapproved 2023)

Standard Specification for Ethylene Propylene Diene Terpolymer (EPDM) Sheet Used In Geomembrane Applications¹

This standard is issued under the fixed designation D7465/D7465M; 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 covers flexible sheet made from ethylene propylene diene terpolymer (EPDM) geomembrane intended for use in geotechnical and geoenvironmental applications. The tests and property limits used to characterize the sheet are values to ensure minimum quality for the intended use. The vulcanized rubber sheet may be non-reinforced, fabric or scrim reinforced.

1.2 In-place geomembrane design criteria, such as field seaming strength and material compatibility, among others, are factors that must be considered but are beyond the scope of this specification.

1.3 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system are not necessarily exact equivalents; therefore, to ensure conformance with the standard, each system shall be used independently of the other, and values from the two systems shall not be combined.

1.4 *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.*

1.5 *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

¹ This specification is under the jurisdiction of ASTM Committee D35 on Geosynthetics and is the direct responsibility of Subcommittee D35.06 on Geosynthetic Specifications.

Current edition approved April 15, 2023. Published April 2023. Originally approved in 2008. Last previous edition approved in 2019 as D7465/D7465M – 15 (2019). DOI: 10.1520/D7465_D7465M-15R23.

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.

- D412 Test Methods for Vulcanized Rubber and Thermoplastic Elastomers—Tension
- D471 Test Method for Rubber Property—Effect of Liquids
- D518 Test Method for Rubber Deterioration—Surface Cracking (Withdrawn 2007)³
- D573 Test Method for Rubber—Deterioration in an Air Oven
- D624 Test Method for Tear Strength of Conventional Vulcanized Rubber and Thermoplastic Elastomers
- D751 Test Methods for Coated Fabrics
- D1149 Test Methods for Rubber Deterioration—Cracking in an Ozone Controlled Environment
- D1204 Test Method for Linear Dimensional Changes of Nonrigid Thermoplastic Sheet or Film at Elevated Temperature
- D1418 Practice for Rubber and Rubber Latices—Nomenclature
- D2137 Test Methods for Rubber Property—Brittleness Point of Flexible Polymers and Coated Fabrics
- D4439 Terminology for Geosynthetics
- D4833/D4833M Test Method for Index Puncture Resistance of Geomembranes and Related Products
- D5884 Test Method for Determining Tearing Strength of Internally Reinforced Geomembranes
- D7004/D7004M Test Method for Grab Tensile Properties of Reinforced Geomembranes
- D7635/D7635M Test Method for Measurement of Thickness of Coatings Over Fabric Reinforcement
- G151 Practice for Exposing Nonmetallic Materials in Accelerated Test Devices that Use Laboratory Light Sources
- G155 Practice for Operating Xenon Arc Lamp Apparatus for Exposure of Materials

3. Terminology

3.1 Definitions:

3.1.1 For definitions of other geosynthetic terms used in this specification, refer to Terminology D4439.

3.1.2 *composite, n*—factory-laminated non-woven geotextile and EPDM.

³ The last approved version of this historical standard is referenced on www.astm.org.

3.1.3 *EPDM, n*—terpolymer of ethylene, propylene, and diene with the residual unsaturated portion of the diene in the side chain. **D1418**

4. Classification

4.1 Types describe the sheet construction:

4.1.1 *Type I*—Non-reinforced.

4.1.2 *Type II*—Scrim (or fabric) internally reinforced.

5. Materials and Manufacture

5.1 The sheet shall be formulated from EPDM polymers and other compounding ingredients. EPDM shall be the principal

polymer used in the sheet and shall be greater than 95 % of the total polymer content.

5.2 To make seams and repairs, the sheet shall be capable of being bonded watertight to itself and the supplier or fabricator shall recommend suitable methods.

6. Physical Properties and Requirements

6.1 The sheet shall conform to the physical requirements prescribed in **Table 1**.

6.2 The tolerance for time conditions (aging, weathering, and so forth) is ± 15 min or ± 1 % of the period, whichever is greater, unless otherwise specified.

TABLE 1 Physical Requirements for EPDM Sheet

Property	ASTM	Nominal Sheet Thickness	Type I	Type II
Thickness, min, mm [in.]: Sheet-overall	D412		1.14 [0.045]	
	D751		1.52 [0.060]	1.14 [0.045] 1.52 [0.060]
Coating over scrim or fabric	D7635/D7635M	1.14 [0.045] 1.52 [0.060]	...	0.38 [0.015] 0.59 [0.022]
Breaking Strength, min, N [lbf]	D7004/D7004M Grab Method	1.14 [0.045] 1.52 [0.060]	...	400 [90] 400 [90]
Tensile strength, min, MPa [psi]	D412 Die C	1.14 [0.045] 1.52 [0.060]	9.0 [1305] 9.0 [1305]	...
Puncture Resistance N [lbf] Min.	D4833/D4833M	1.14 [0.045] 1.52 [0.060]	133 [30] 178 [40]	270 [60] 350 [80]
Elongation, ultimate, min %	D412 Die C	1.14 [0.045] 1.52 [0.060]	300 300	250 ^A 250 ^A
Elongation @ fabric break, ultimate, min, % Machine direction	D7004/D7004M , Grab Method, 50 mm [2 in.] per minute jaw separation rate	1.14 [0.045]		15
		1.52 [0.060]		15
Cross direction		1.14 [0.045] 1.52 [0.060]		15 15
Tensile set, max	D412 Method A, Die C	1.14 [0.045] 1.52 [0.060]	10 10	...
Tear resistance, min, kN/m [lbf/in.]	D624 Die C	1.14 [0.045] 1.52 [0.060]	26.27 [150] 40.28 [230]	...
Tearing strength, min, N [lbf]	D5884	1.14 [0.045] 1.52 [0.060]	...	580 [130] 750 [170]
Brittleness point, max °C [°F]	D2137	1.14 [0.045]	-45 [-49]	-45 [-49]
		1.52 [0.060]	-45 [-49]	-45 [-49]
Ozone resistance, no cracks	D1149	1.14 [0.045]	pass	pass
		1.52 [0.060]	pass	pass
Heat Aging:	D573			
Breaking strength, min, N [lbf]	D7004/D7004M	1.14 [0.045]		356 [80]
		1.52 [0.060]		888 [200]
Tensile strength, min, MPa [psi]	D412 Method A, Die C	1.14 [0.045]	8.3 [1205]	...
		1.52 [0.060]	8.3 [1205]	...
Elongation, ultimate, min, %	D412 Die C	1.14 [0.045]	200	200 ^A
		1.52 [0.060]	200	200 ^A
Tear resistance, min, kN/m [lbf/in.]	D624 Die C	1.14 [0.045]	21.9 [125]	...
		1.52 [0.060]	37.3 [213]	...
Linear dimensional change, max, %	D1204	1.14 [0.045]	± 1	± 1
		1.52 [0.060]	± 1	± 1
Water absorption, max, mass, %	D471	1.14 [0.045]	$\pm 8, -2$	$\pm 8, -2^A$
		1.52 [0.060]	$\pm 8, -2$	$\pm 8, -2^A$
Laboratory Accelerated Weathering:	G151 and G155			
Visual Inspection	D518	1.14 [0.045]	No cracks	No cracks
		1.52 [0.060]	No cracks	No cracks
PRFSE, min, %		1.14 [0.045]	30	...
		1.52 [0.060]	30	...
Elongation, ultimate, min, %		1.14 [0.045]	200	...
		1.52 [0.060]	200	...

^A Specimens to be prepared from coating rubber compound, vulcanized in a similar method to the reinforced products.

6.3 Tolerances for temperature shall be $\pm 2\text{ }^{\circ}\text{C}$ [$\pm 4\text{ }^{\circ}\text{F}$].

7. Dimensions

7.1 The width and length of the sheet shall be agreed upon between the purchaser and the supplier.

7.1.1 The width and length tolerance shall be +3 %, –0 %.

7.2 The thickness tolerance shall be +15 %, –10 % of the thickness agreed upon between the purchaser and supplier, but in no case shall the thickness be less than the minimum listed in [Table 1](#).

8. Workmanship, Finish, and Appearance

8.1 The sheet, including the full width of factory seams if present, shall be fully adhered, watertight, and visibly free of pinholes, particles of foreign matter, undispersed raw material, or other manufacturing defects that might affect serviceability. If the number of irregularities in the form of pockmarks (see [Note 1](#)) appears excessive on the sheet (or portion thereof), then its rejection shall be negotiated between involved parties.

NOTE 1—Pockmarks are oblong depressions, cavities, or craters on the surface of the sheet that have an approximate surface dimension of 3.2 by 1.6 mm [$1/8$ by $1/16$ in.], and have a maximum depth approaching one half of the sheet thickness.

8.2 Edges of the sheets shall be straight and flat so that they may be seamed to one another without fishmouthing.

9. Test Methods

9.1 *Dimensions*—Test Methods [D751](#), after permitting the sheet to relax at $23 \pm 2\text{ }^{\circ}\text{C}$ [$73.4 \pm 4\text{ }^{\circ}\text{F}$] for $1\text{ h} \pm 15\text{ min}$.

9.2 *Thickness, Sheet Overall*—From across the full width of the unbuffered sheet, take three samples, 300 by 300 mm [1 by 1 ft]. Measure the thickness of each corner. Refer to Test Methods [D412](#) for Type I sheet and Test Methods [D751](#) for Type II sheet.

9.3 *Thickness of Coating Over Scrim (Reinforcing Fabric) – Optical Method*—see [Annex A1](#).

9.4 *Breaking Strength*—Test Methods [D751](#), Grab Method.

9.5 *Tensile Strength*—Test Methods [D412](#), Die C.

9.6 *Puncture Resistance*—Test Method [D4833/D4833M](#).

9.7 *Elongation, Ultimate*—Test Methods [D412](#), Die C.

9.8 *Elongation at Fabric Break, Ultimate*—Test Methods [D751](#), Grab Method, 50 mm [2 in.] per minute jaw separation rate.

9.9 *Tensile Set*—Test Methods [D412](#), Method A, Die C, 50 % elongation.

9.10 *Tear Resistance*—Test Method [D624](#), Die C.

9.11 *Tearing Strength*—Test Methods [D751](#), B-Tongue Tear.

9.12 *Brittleness Point*—Test Methods [D2137](#).

9.13 *Ozone Resistance*—Test Methods [D1149](#), Terminology [D4439](#). Inspect at 7× magnification on specimens exposed to 100 mPa [1×10^{-5} psi] ozone in air at $40 \pm 2\text{ }^{\circ}\text{C}$ [$104 \pm 4\text{ }^{\circ}\text{F}$]. Elongate Type I specimens 50 % for $166 \pm 1.66\text{ h}$ exposure. And Type II specimens must be wrapped around a 75 mm

[3 in.] diameter mandrel for $166 \pm 1.66\text{ h}$ exposure. The required specimen width is 25 mm [1 in.].

9.14 *Heat Aging*—Test Method [D573](#). Age sheet at $116 \pm 2\text{ }^{\circ}\text{C}$ [$240 \pm 4\text{ }^{\circ}\text{F}$] for $670 \pm 6.7\text{ h}$. Specimens are then cut from the aged sheet for testing of breaking strength, tensile strength, elongation, and tear resistance.

9.15 *Linear Dimensional Change*—Test Method [D1204](#).

9.16 *Water Absorption*—Test Method [D471](#), at $70 \pm 2\text{ }^{\circ}\text{C}$ [$158 \pm 4\text{ }^{\circ}\text{F}$] for $166 \pm 1.66\text{ h}$.

9.17 *Laboratory-Accelerated Weathering*—Accelerated weathering tests shall be performed in accordance with Practices [G151](#) and [G155](#). These tests are performed on the intact sheet with the weathering side facing the lamps. Mount specimens for exposure under no strain. After exposure, the specimens shall be removed and inspected immediately for cracks and crazing at 10 % strain in the bent loop configuration in accordance with Test Method [D518](#) under 7× magnifications. A specimen is rated “pass” if no cracks or crazing are observed. In addition, for Type I sheet, determine tensile strength and ultimate elongation after exposure to laboratory-accelerated weathering. Calculate the specimen percent retained fractional strain energy (PRFSE):

$$\text{PRFSE} = \frac{(\text{Tensile Strength} \times \text{Elongation})_{\text{aged}}}{(\text{Tensile Strength} \times \text{Elongation})_{\text{original}}} \times 100$$

9.18 The Xenon-Arc exposure devices shall be operated in accordance with Practices [G151](#) and [G155](#) and the following conditions:

Filter type:	Daylight Filter
Irradiance:	0.35 to 0.70 W/(m ² .nm) at 340 nm: ±0.02 W/(m ² .nm) maximum allowed fluctuation (42 to 84 W/m ² at 300 to 400 nm: ±2 W/m ² maximum allowed fluctuation)
Cycle:	690 min ± 15 min light, 30 min light plus water spray
Uninsulated black panel temp:	80 ± 2.5 °C maximum allowed fluctuation [176 ± 4 °F maximum allowed fluctuation]
Chamber air temperature (if controlled):	50 ± 2 °C maximum allowed fluctuation
Relative humidity:	50 %; ±10 % maximum allowed fluctuation
Spray water:	Deionized: refer to Practice G155 , Section 6.6.1 for temperature of the water
Specimen repositioning (if required):	Every 315 kJ (m ² .nm) at 340 nm (37.8 MJ/m ² at 300 to 400 nm)
Exposure duration:	5040 kJ (m ² .nm) at 340 nm (604.8 MJ/m ² at 300 to 400 nm).

10. Inspection and Special Testing

10.1 The manufacturer shall inspect and test production to ensure compliance of the product with this specification.

11. Rejection and Resubmittal

11.1 Failure to conform to any one of the requirements prescribed in this specification shall constitute grounds for rejection. Rejection shall be reported to the producer or supplier promptly and in writing. The seller shall have the right to reinspect the rejected shipment and resubmit the lot after removal of those packages not conforming to the specified requirements.

12. Product Marking

12.1 The sheet shall be identified on the side intended to be exposed to the weather with this ASTM designation number