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**Netekstilne talne obloge - Plošče iz stiskanega plutinega hrbtišča s polivinilkloridno uporabno vrhnjo plastjo - Specifikacija**

Resilient floor coverings - Tiles of agglomerated composition cork with polyvinyl chloride wear layer - Specification

Elastische Bodenbeläge - Platten auf einem Rücken aus Presskork mit einer Polyvinylchlorid-Nutzschicht - Spezifikation

Revetements de sol résiliants - Dalles d'aggloméré de liège avec couche d'usure à base de polychlorure de vinyle - Spécifications

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Netekstilne talne obloge

Non-textile floor coverings

**SIST EN 655:1999****en**

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EUROPEAN STANDARD

EN 655

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ICS 91.180

Descriptors: floor coverings, plastic coverings, floor slabs, cork, vinyl resins, specifications, characteristics, wear, classifications, graphic symbols, utilization, marking

English version

**Resilient floor coverings - Tiles of agglomerated  
composition cork with polyvinyl chloride wear  
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Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

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**CEN**

European Committee for Standardization  
Comité Européen de Normalisation  
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart, 36 8-1050 Brussels

Page 2  
EN 655:1996

## Foreword

This European Standard has been prepared by Technical Committee CEN/TC 134 "Resilient and textile floor coverings", the secretariat of which is held by BSI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by April 1997, and conflicting national standards shall be withdrawn at the latest by April 1997.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

Annex A is informative, Annex B is informative and Annex C is informative.

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## 1 Scope

This European Standard specifies the characteristics of agglomerated cork with a wear layer based on polyvinyl chloride and modifications thereof.

To encourage the consumer to make an informed choice, the standard includes a classification system (see EN 685) based on intensity of use, which shows where these floor coverings should give satisfactory service. It also specifies requirements for marking.

## 2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 424	Resilient floor coverings - Determination of the effect of the simulated movement of a furniture leg
EN 425	Resilient floor coverings - Determination of the effect of a castor chair
EN 427	Resilient floor coverings - Determination of the side length, squareness and straightness of tiles
EN 428	Resilient floor coverings - Determination of overall thickness
EN 429	Resilient floor coverings - Determination of the thickness of layers
EN 430	Resilient floor coverings - Determination of mass per unit area
EN 431	Resilient floor coverings - Determination of peel resistance
EN 433	Resilient floor coverings - Determination of residual indentation after static loading
EN 434	Resilient floor coverings - Determination of dimensional stability and curling after exposure to heat
EN 436	Resilient floor coverings - Determination of density
prEN 660-1	Resilient floor coverings - Determination of wear resistance - Part 1 : Stuttgart test
prEN 660-2	Resilient floor coverings - Determination of wear resistance - Part 2 : Frick-Taber test
EN 684	Resilient floor coverings - Determination of seam strength
EN 685	Resilient floor coverings - Classification

### 3 Definitions

For the purposes of this standard, the following definitions apply:

**3.1 polyvinyl chloride floor covering:** Floor covering with surface layers which are produced using polyvinyl chloride (and modifications thereof) as binder.

**3.2 agglomerated composition cork with polyvinyl chloride wear layer:** Floor coverings whose main component is agglomerated cork and whose wear layer is a homogeneous polyvinyl chloride layer. Decorative materials, e.g. decorative cork or wood veneers, can be incorporated under the wear layer.

### 4 Requirements

#### 4.1 General requirements

Floor coverings described in this standard shall conform to the appropriate general requirements specified in table 1, when tested in accordance with the methods given therein.

#### 4.2 Classification requirements

##### 4.2.1 Wear group classification

Polyvinyl chloride floor coverings shall be classified in the appropriate wear group specified in table 2, when tested in accordance with prEN 660 -1 or prEN 660 -2.

NOTE: The tests are intended to determine the wear resistance of wear layers either by thickness loss (prEN 660 -1) or volume loss (prEN 660 -2).

Floor coverings described in this standard have a transparent wear layer, are *a priori* group T and need not be tested.

##### 4.2.2 Level of use classification

Floor coverings described in this standard shall be classified as suitable for different levels of use in accordance with the performance requirements specified in table 3, when tested with the methods given therein. Classification shall conform to the scheme specified in EN 685.

Table 1: General requirements

Characteristic	Requirement	Test method
Side length of tiles                      mm	Deviation $\leq 0,13$ % of nominal length up to 0,5 mm maximum	EN 427
Squareness and straightness for side length $\leq 400$ mm $> 400$ mm                      mm	Deviation allowed at any point  $\leq 0,25$ $\leq 0,35$	
Overall thickness                      mm  average  individual results	  Nominal value $+0,18$ $-0,15$  Average value $\pm 0,20$	EN 428
Thickness of agglomerated composition cork base                      mm	Nominal thickness shall be stated	EN 429
Thickness of polyvinylchloride backing (average)                      mm	Nominal value $\pm 10$ %	
Total mass per unit area (average)                      g/m <sup>2</sup>	Nominal value $+13\%$ $-10\%$	EN 430
Density of wear layer (average)                      kg/m <sup>3</sup>	Nominal value $\pm 50$	EN 436
Dimensional stability after exposure to heat <sup>1)</sup> %	$\leq 0,40$ after reconditioning for 7 days after test	EN 434
Curling after exposure to heat                      mm	$\leq 6$ after reconditioning for 7 days after test	
Peel resistance <sup>2)</sup> N/50 mm  average  individual values	  $\geq 35$  $\geq 25$	EN 431
<sup>1)</sup> This test is not applicable when the decorative layer is wood veneer		
<sup>2)</sup> The separation shall lie within the agglomerated cork line		

**Table 2: Classification requirements for wear groups**

Characteristic	Requirements for wear group				Test method
	T	P	M	F	
Thickness loss $\Delta l$ mm	$\Delta l \leq 0,08^{1)}$	$0,08 < \Delta l \leq 0,15$	$0,15 < \Delta l \leq 0,30$	$0,30 < \Delta l \leq 0,60$	prEN 660-1
volume loss $F_v$ mm <sup>3</sup>	$F_v \leq 2,0^{1)}$	$2,0 < F_v \leq 4,0$	$4,0 < F_v \leq 7,5$	$7,5 < F_v \leq 15,0$	prEN 660-2
<sup>1)</sup> If tested for verification.					










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Table 3 Classification requirements for level of use

Class	Symbol	Level of use	Overall thickness: Nominal value <sup>1)</sup> , mm	Thickness of wear layer: Nominal value <sup>2)</sup> , mm	Effect of castor chair	Simulated movement of a furniture leg	Seam strength when welded in accordance with manufacturer's instructions N/50 mm	Residual indentation after static loading, average, mm
21		Domestic moderate	2,0	Wear group T	No requirement	No damage shall be visible after testing with a type 3 foot	No requirement	$\leq 0,30$
22		Domestic general		0,15 0,20				
23		Domestic heavy	2,5	0,25	No disturbance to the surface other than slight change in appearance and no delamination shall occur	No damage shall be visible after testing with a type 2 foot	Average $\geq 150$ Individual values $\geq 120$	$\leq 0,20$
31		Commercial moderate						
32		Commercial general	3,0	0,35				
41		Light industrial moderate						
33		Commercial heavy	3,0	0,50				
42		Light industrial general						
34		Commercial very heavy		0,65				
Test method			EN 428	EN 429	EN 425	EN 424	EN 684	EN 433