
**Resilient floor coverings —
Specification for floor coverings based
on thermoplastic polymers**

*Revêtements de sol résilients — Spécifications pour revêtements de
sol à base de polymères thermoplastiques*

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ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Fax: +41 22 749 09 47
Email: copyright@iso.org
Website: www.iso.org

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Foreword

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The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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This document was prepared by Technical Committee ISO/TC 219, *Floor coverings*.

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Resilient floor coverings — Specification for floor coverings based on thermoplastic polymers

1 Scope

This document specifies the characteristics for resilient floor coverings based upon thermoplastic polymers, supplied either in roll, plank or tile form.

To encourage the consumer to make an informed choice, this document includes a classification system (see ISO 10874) based on intensity of use, which shows where these floor coverings should give satisfactory service. It also specifies requirements for marking.

This specification does not apply to floor coverings specified in ISO 10581, ISO 10582, ISO 10595, ISO 11638, ISO 10575, ISO 10577, ISO 24011 and ISO 26986.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 105-B02, *Textiles — Tests for colour fastness — Part B02: Colour fastness to artificial light: Xenon arc fading lamp test*

ISO 291, *Plastics — Standard atmospheres for conditioning and testing*

ISO 4918, *Resilient, textile and laminate floor coverings — Castor chair test*

ISO 9405, *Textile floor coverings — Assessment of changes in appearance*

ISO 10874, *Resilient, textile and laminate floor coverings — Classification*

ISO 16581, *Resilient and laminate floor coverings — Determination of the effect of simulated movement of a furniture leg*

ISO 16906, *Resilient floor coverings — Determination of seam strength*

ISO 23997, *Resilient floor coverings — Determination of mass per unit area*

ISO 23999, *Resilient floor coverings — Determination of dimensional stability and curling after exposure to heat*

ISO 24340, *Resilient floor coverings — Determination of thickness of layers*

ISO 24341, *Resilient and textile floor coverings — Determination of length, width and straightness of sheet*

ISO 24342, *Resilient and textile floor-coverings — Determination of side length, edge straightness and squareness of tiles*

ISO 24343-1, *Resilient and laminate floor coverings — Determination of indentation and residual indentation — Part 1: Residual indentation*

ISO 24343-2, *Resilient and laminate floor coverings — Determination of indentation and residual indentation — Part 2: Short-term residual indentation of resilient floor covering*

ISO 24344, *Resilient floor coverings — Determination of flexibility and deflection*

ISO 24345, *Resilient floor coverings — Determination of peel resistance*

ISO 24346, *Resilient floor coverings — Determination of overall thickness*

EN 1372, *Adhesives — Test method for adhesives for floor coverings and wall coverings — Peel test*

ASTM F 1515, *Standard Test Method for Measuring Light Stability of Resilient Flooring by Color Change*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

3.1 homogeneous floor covering
floor covering with one or more layers of the same composition and colour, patterned throughout its thickness

3.2 heterogeneous floor covering
floor covering consisting of a *wear layer* (3.8) and other layer(s) which differ in composition and/or design and can contain a reinforcement

3.3 factory finish
transparent coating applied during the manufacture, usually not thicker than 0,03 mm not using thermoplastic polymer (3.6) as base resin

Note 1 to entry: This coating should not be counted as part of the *wear layer* (3.8).

3.4 product with backing
homogeneous (3.1) or a *heterogeneous floor covering* (3.2) with a backing of any material different from the upper layers or a backing made with a foamed layer

Note 1 to entry: Typical example backings include materials such as cork, foams, polyester or jute.

3.5 scratch
permanent damage or mark on the surface of the floor covering made with a sharp or pointed object

3.6 thermoplastic polymer
polymers that become liquid when heated above T_g (glass transition temperature) or T_m (melting temperature) and return to the solid state when cooled

Note 1 to entry: This cycle of melting and freezing can be repeated.

3.7 plank
tile with a ratio length divided by width superior or equal to 1,3

3.8 wear layer
portion of a resilient floor covering that contains or protects the pattern and design exclusive of temporary *factory finishes* (3.3) or maintenance coating(s)

4 Requirements

Floor coverings described in this document shall comply with the appropriate general requirements specified in [Table 1](#), when tested in accordance with the methods given therein.

Some optional properties required for specific applications are defined in [Annex B](#) (informative).

Table 1 — General requirements

Characteristic	Requirement		Test method
	For product without backing or with non-foamed backing	For product with foamed backing	
Roll form — Length (in m) — Width (in mm)	not less than the nominal value		ISO 24341
Tiles/planks: Side length and square panel Width Squareness and straightness ≤ 400 mm > 400 mm > 400 mm (intended for welding)	Deviation ≤ 0,13 % of nominal length up to 0,5 mm maximum. Deviation < 0,1 % up to 0,5 mm maximum. Deviation allowed at any point ≤ 0,25 mm ≤ 0,35 mm ≤ 0,50 mm		ISO 24342
Overall thickness — Average thickness ^a — Individual results	Nominal value + 0,13 mm - 0,10 mm	Nominal value + 0,18 mm - 0,15 mm	ISO 24346
Thickness of wear layer — Average thickness ^a — Individual results	For heterogeneous floor coverings, thickness of wear layer should be declared in mm. Nominal value + 13 % - 10 % and shall not exceed ± 0,1 mm Individual results shall not exceed 0,05 mm or 15 % below the average, whichever is greater. Where this requirement is not met by only one individual value, a new single value has to be measured. If this still does not meet the requirement, the test result does not pass.		ISO 24340
Total mass per unit area in g/m ² (average)	Nominal value + 13 % - 10 %		ISO 23997
Dimensional stability after exposure to heat:			ISO 23999
^a Average of the batch. ^b Average of the results of one sample. ^c Provided that manufacturer-specified installation procedures are strictly followed to ensure an adhesive strength of more than 50 N/50 mm at 90 °, when pulled and measured at a speed of 100 mm/min complying with EN 1372. ^d Floating installation: Without any fixation to the subfloor. Loose lay (e.g. pressure-sensitive adhesives): Installed with an adhesive strength less than 50 N/50 mm at 90 °, when pulled and measured at a speed of 100 mm/min complying with EN 1372. ^e Test with blue wool scale N°6 according to ISO 105-B02. Compare the sample with a reference sample which was stored in the dark.			

Table 1 (continued)

Sheets and tiles intended for welding and glued installation ^c	change of dimension ≤ 0,4 %	Two procedures are set up: Procedure A: 80 °C Procedure B: 50 °C
Tiles/planks intended for dry-joint laying and glued installation ^c	change of dimension ≤ 0,25 %	The choice of the procedure is the decision of the manufacturer. A result cannot be claimed without reporting the procedure used.
Tiles/planks intended for loose lay or floating installation ^d	change of dimension ≤ 0,15 %	
Curling under exposure to heat in mm		ISO 23999
Rolls and tiles intended for welding and glued installation ^c	curling ≤ 8 mm	Two procedures are set up: Procedure A: 80 °C Procedure B: 50 °C
Tiles/planks intended for dry-joint laying and glued installation ^c	curling ≤ 2 mm	The choice of the procedure is the decision of the manufacturer. A result cannot be claimed without mentioning the procedure used.
Tiles/planks intended for loose lay or floating installation ^d	curling ≤ 1 mm	
Flexibility (only for sheet floorings)	Test using a 20 mm mandrel. For products which show signs of cracking, perform a further test using a 50 mm mandrel. If results show no further cracking, record the use of a 50 mm diameter mandrel.	ISO 24344:2008, Method A
Colour fastness to artificial light	≥ 6 or ΔE ≤ 8 after 300 h, where ΔE is the colour change.	ISO 105-B02 Method 3 ^e ASTM F1515
Peel resistance of the backing	Average: ≥ 50 N/50 mm Individual results: ≥ 40 N/50 mm	ISO 24345
<p>^a Average of the batch.</p> <p>^b Average of the results of one sample.</p> <p>^c Provided that manufacturer-specified installation procedures are strictly followed to ensure an adhesive strength of more than 50 N/50 mm at 90 °, when pulled and measured at a speed of 100 mm/min complying with EN 1372.</p> <p>^d Floating installation: Without any fixation to the subfloor. Loose lay (e.g. pressure-sensitive adhesives): Installed with an adhesive strength less than 50 N/50 mm at 90 °, when pulled and measured at a speed of 100 mm/min complying with EN 1372.</p> <p>^e Test with blue wool scale N°6 according to ISO 105-B02. Compare the sample with a reference sample which was stored in the dark.</p>		

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5 Classification requirements

The classification scheme for resilient floor coverings shall be as defined in ISO 10874. The requirements for the use of resilient floor coverings based upon thermoplastic polymers in accordance with this scheme are specified in [Table 2](#).

Table 2 — Classification requirement for level of use (minimal)









Class	Symbol	Level of use	Overall thickness (mm)		Residual indentation (mm)		Seam strength if welding is required (N/50 mm)
Test method			ISO 24346		^a ISO 24343-1 ^b ISO 24343-2		ISO 16906
			Product without backing or with non-foamed backing	Product with foamed backing	Product without backing or with non-foamed backing	Product with foamed backing	
Domestic							
21		Moderate/Light	≥ 1	≥ 2,5	≤ 0,1 ^a	≤ 0,35 ^b	No requirement
22		General/Medium	≥ 1,5	≥ 2,5	≤ 0,1 ^a	≤ 0,35 ^b	
22+		General	≥ 1,5	> 2,5	≤ 0,1 ^a	≤ 0,35 ^b	
23		Heavy	≥ 1,5	≥ 2,5	≤ 0,1 ^a	≤ 0,35 ^b	
Commercial							
31		Moderate	≥ 2	≥ 2,5	≤ 0,1 ^a	≤ 0,35 ^a	When welded in accordance with the manufacturer's instructions: Average value ≥ 240 Individual values ≥ 180
32		General	≥ 2	≥ 2,5	≤ 0,1 ^a	≤ 0,2 ^a	
33		Heavy	≥ 2	≥ 2,5	≤ 0,1 ^a	≤ 0,2 ^a	
34		Very heavy	≥ 2	≥ 2,5	≤ 0,1 ^a	≤ 0,2 ^a	

Table 2 (continued)

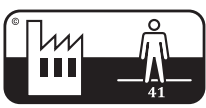
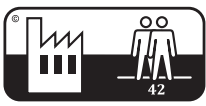
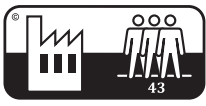











Light industrial						
Class	Symbol	Level of use	Scratch appearance assessment (N)	Simulated movement of a furniture leg	Castor chair suitability	
41		Moderate	≥ 2	≥ 2,5	≤ 0,1 ^a	When welded in accordance with the manufacturer's instructions: Average value ≥ 240 Individual values ≥ 180
42		General	≥ 2	≥ 2,5	≤ 0,1 ^a	
43		Heavy	≥ 2	≥ 2,5	≤ 0,1 ^a	
Test Method			Annex A		ISO 16581	ISO 4918
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21		Moderate /Light	No requirement	No requirement	No damage shall be visible with foot 3 (70 kg)	No requirement
22		General/ Medium				
22+		General				
23		Heavy				

Table 2 (continued)

Class	Symbol	Level of use	Scratch appearance assessment (N)	Simulated movement of a furniture leg	Castor chair suitability
Commercial					
31		Moderate	No requirement	No damage shall be visible with foot 3 (70 kg)	No requirement
32		General	≥ 3	No damage shall be visible with foot 2 (100 kg). When welded in accordance with manufacturer's instructions: No damage shall be visible with foot 0 (32 kg) to the weld	After 25 000 cycles, no delamination shall occur. No disturbance to the surface other than a slight change in appearance. ^c
33		Heavy	≥ 3		
34		Very heavy	≥ 3		
Light industrial					
41		Moderate	≥ 3	No damage shall be visible with foot 2 (100 kg). When welded in accordance with manufacturer's instructions: No damage shall be visible with foot 0 (32 kg) to the weld	After 25 000 cycles, no delamination shall occur. No disturbance to the surface other than a slight change in appearance. ^c
42		General	≥ 3		
43		Heavy	≥ 3		
<p>^c For planks intended for loose lay or floating installation (see NOTE 1), a test should be performed with floor specimens fixed only in their perimeter for products aimed to be installed without any fixation to the subfloor. For products aimed to be installed with an adhesive, a test should be performed with floor specimens fixed with an adequate adhesive (see NOTE 2).</p> <p>Take a representative sample from the available material. The test area shall include at least one short side joint in the path of the castor when the specimens are assembled according to the manufacturer's instructions. An example of an assembled test area is shown in Figure 1. The dimension, <i>l</i>, shall be at least 300 mm.</p> <p>For rolls, the test should include at least one side joint in the path of the castor. For tiles/planks, the test should include at least two joints crossed in the path of the castor. In any case, the sample should allow mounting according to Figure 2.</p> <p>The diameter of the test area shall be at least 750 mm.</p> <p>NOTE 1 Floating installation: Without any fixation to the subfloor. Loose lay (e.g. pressure-sensitive adhesives): Installed with an adhesive strength less than 50 N/50 mm at 90°, when pulled and measured at a speed of 100 mm/min, complying with EN 1372.</p> <p>NOTE 2 Provided that manufacturer-specified installation procedures are strictly followed to ensure an adhesive strength of more than 50 N/50 mm at 90°, when pulled and measured at a speed of 100 mm/min, complying with EN 1372.</p>					