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## Standard Specification for Rubber Floor Tile<sup>1</sup>

This standard is issued under the fixed designation F 1344; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

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

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<sup>ε1</sup> NOTE—Removed the year/date from ANSI/ASQC Z1.4 editorially in May 2009.

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### 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 the standard. The values given in parentheses are for information only.~~

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 and health practices and determine the applicability of regulatory limitations prior to use.*

### 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:*<sup>2</sup>

D 883 [Terminology Relating to Plastics](#)

D 1566 [Terminology Relating to Rubber](#)

D 2240 [Test Method for Rubber Property—Durometer Hardness](#)

D 3389 [Test Method for Coated Fabrics Abrasion Resistance \(Rotary Platform Abrader\)](#)

F 141 [Definitions of Terms Relating to Resilient Floor Coverings](#)—[Terminology Relating to Resilient Floor Coverings](#)

F 373 [Test Method for Embossed Depth of Resilient Floor Coverings](#)

F 386 [Test Method for Thickness of Resilient Flooring Materials Having Flat Surfaces](#)

F 410 [Test Method for Wear Layer Thickness of Resilient Floor Coverings by Optical Measurement](#)

F 511 [Test Method for Quality of Cut \(Joint Tightness\) of Resilient Floor Tile](#)

F 710 [Practice for Preparing Concrete Floors and Other Monolithic Floors to Receive Resilient Flooring](#)

F 925 [Test Method for Resistance to Short-Term Chemical Exposure—Chemicals of Resilient Flooring](#)

F 970 [Test Method for Static Load Limit](#)

F 1482 [Guide to Wood Underlayment Products Available for Use Under Resilient Flooring](#)<sup>5</sup>—[Practice for Installation and Preparation of Panel Type Underlayments to Receive Resilient Flooring](#)

F 1514 [Test Method for Measuring Heat Stability of Resilient Vinyl Flooring by Color Change](#)

F 2055 [Test Method for Size and Squareness of Resilient Floor Tile by Dial Gage Method](#)

F 2199 [Test Method for Determining Dimensional Stability of Resilient Floor Tile After Exposure to Heat](#)

2.3 *American National Standards:*

ANSI/ASQC Z1.4—1993 [ANSI/ASQC Z1.4 Sampling Procedures and Tables for Inspection by Attributes](#)<sup>3</sup>

<sup>1</sup> 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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<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* Vol 08.01, volume information, refer to the standard's Document Summary page on the ASTM website.

<sup>3</sup> *Annual Book of ASTM Standards*, Vol 09.01.

<sup>5</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.



### 3. Terminology

3.1 *Definitions*—For definitions of other terms used in this standard, see Terminology F 141.

### 4. Classification

4.1 Rubber floor tile covered by this specification shall be classified as:

- Class I—Homogeneous Rubber Floor Tile
  - A. Solid Color
  - B. Through Mottled
- Class II—Laminated Rubber Floor Tile
  - A. Solid Color Wear Layer
  - B. Mottled Wear Layer

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.
- 5.1.2 Class, color, pattern, and wearing surface (see Section 4).
- 5.1.3 Quantity, in square feet, square metres, 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 Z1.4–1993Z1.4 (see Sections 10 and 11).
- 5.1.10 Sampling, if other than as specified in ANSI/ASQC Z1.4–1993Z1.4 (see Sections 10 and 11).
- 5.1.11 Statement requesting certification, if certification of compliance is required (see Section 12).
- 5.1.12 Packing requirements, if other than as specified (see Section 14).
- 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 D 1566, and (2) have been vulcanized, as defined in Terminology D 1566 (under vulcanization), such that it becomes thermoset as defined in Terminology D 883. 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 *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 F 410.

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 of not less than 85 (Shore, Type A) when tested in accordance with Test Method D 2240.

7.2 *Static Load Limit*—When tested in accordance with Test Method F 970, with an applied load of  $\pm 25250$  lb (56.7(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*—When tested in accordance with Test Method F 925, the rubber floor tile shall have no more than a slight change in surface dulling, surface attack, or staining when exposed to the following chemicals: