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Standard Specification for Linoleum Floor Tile¹

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1. Scope

1.1 This specification covers floor tiles made of a homogeneous mixture of linoleum cement binder calendered or pressed onto a fibrous or suitable backing. This specification also covers linoleum floor tile without backing.

1.2 Four types of linoleum floor tile are covered. The floor covering is intended for use in commercial, light commercial, and residential buildings based on serviceability characteristics. General information and performance characteristics, which determine serviceability and recommended use, are included in this document.

1.3 The following safety hazards caveat pertains only to the test methods portion, Sections 7 and 8, of this specification.

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

1.5 The values stated in inch-pound units are to be regarded as the standard; the values in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

2. Referenced Documents

2.1 *ASTM Standards:*²

[F137 Test Method for Flexibility of Resilient Flooring Materials with Cylindrical Mandrel Apparatus](#)

[F141 Terminology Relating to Resilient Floor Coverings](#)

[F150 Test Method for Electrical Resistance of Conductive and Static Dissipative Resilient Flooring](#)

[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](#)

[F925 Test Method for Resistance to Chemicals of Resilient Flooring](#)

[F970 Test Method for Static Load Limit](#)

[F1514 Test Method for Measuring Heat Stability of Resilient Flooring by Color Change](#)

[F1515 Test Method for Measuring Light Stability of Resilient Flooring by Color Change](#)

[F2055 Test Method for Size and Squareness of Resilient Floor Tile by Dial Gage Method](#)

2.2 *Other Standards:*

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

[EN 433 Determination of Residual Indentation after Static Loading](#)⁴

[EN 669 Determination of the Dimensional Changes of Tiles Caused by Atmospheric Humidity Changes](#)⁴

[EN 670 Identification and Composition of Linoleum—Determination of Cement and Ash Residue](#)⁴

3. Terminology

3.1 *Definitions:*

3.1.1 For definitions, refer to Terminology [F141](#).

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.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

⁴ Available from CEN European Committee for Standardization—Central Secretariat: rue de Stassart, 36 B-1050 Brussels.

4. Classification

- 4.1 The floor coverings shall be of the following types:
- 4.1.1 *Type I*—Linoleum floor tile with fibrous backing.
 - 4.1.2 *Type II*—Linoleum floor tile with special backing.
 - 4.1.3 *Type III*—Linoleum floor tile without backing.
 - 4.1.4 *Type IV*—Static dissipative linoleum floor tile with or without backing.

NOTE 1—If any of the above structures incorporate a stabilizing inner-layer mat or fabric between the top wear-layer and the back of the structure, the flooring type will include the hyphenated suffix of “-IL.” (for example, Type II-IL, a linoleum floor tile with a special backing including an inner-layer mat or fabric).

5. Ordering Information

- 5.1 Linoleum floor tile shall be ordered by type, thickness, and other characteristics important to the purchaser for the intended use.
- 5.1.1 Title, number, and date of this specification,
 - 5.1.2 Type and pattern number,
 - 5.1.3 Quantity in square feet, square meters, pieces or cartons,
 - 5.1.4 Size required (Section 7),
 - 5.1.5 Thickness required (Section 7),
 - 5.1.6 Sampling if other than as specified in ANSI/ASQC Z1.4, level 5-1 as noted in Table 1,
 - 5.1.7 Packing requirement if other than as specified (Section 14),
 - 5.1.8 Marking required if other than specified (Section 14), and
 - 5.1.9 Specific Chemical Resistance (Section 8).

6. Materials and Manufacture

6.1 *Wear Surface*—The wear surface is the portion above the fibrous or suitable backing/bedding layer or base coat. The wear surface should have a minimum thickness of 0.04 in. (1 mm).

6.1.1 *Type I / Type II / Type III / Type IV*—For all types, the wear surface of the linoleum shall consist of a homogeneous mixture. For Type IV, the linoleum shall have incorporated into the wearing surface additives, which will give the linoleum electrostatic discharge controlling properties.

6.2 *Backings:*

6.2.1 *Fibrous*—The fibrous backing shall be firmly bonded and keyed to the linoleum mix so as to be partially imbedded in the mix.

6.2.2 *Special Backing*—In some cases a special backing is added such as cork, foam, or other suitable backing.

6.3 *Composition:*

6.3.1 *Linoleum Cement Content*—The minimum amount of linoleum cement shall be 30 % when tested in accordance with European Norm 670.⁴

TABLE 1 Characteristics and Tests

Property	Requirement	Test Method	Reference
Wear Surface	Wear surface shall be a minimum thickness of 0.040 in. (1.0 mm).	ASTM F410	7.1
Size, tolerance	±0.016 in. (0.4 mm) per tile (305 mm)	ASTM F2055	7.2
Thickness	Average overall thickness shall be the nominal thickness with a tolerance of ±0.006 in. (0.15 mm)	ASTM F386	7.3
Squareness	Shall not exceed 0.010 in. (0.25 mm) for tiles ≤16 in. (400 mm) or 0.014 in. (0.35 mm) for tiles >16 in. (400 mm).	ASTM F2055	7.4
Residual Indentation	Shall not exceed 0.006 in. (0.15 mm) for tiles ≤0.100 in. (2.5 mm) thick or 0.008 in. (0.20 mm) for tiles >0.100 in. (2.5 mm) thick, tested with a load of 112 lb (50.8 kg), 0.445 in. (11.3 mm) diameter flat foot, 150 min loading dwell time and measured after a 150 min recovery.	EN 433	8.1
Static Load	Residual indentation shall not exceed 0.005 in. (0.12 mm), tested with a load of 150 lb (67.5 kg)	ASTM F970	8.2
Flexibility	The wear surface will not crack or break when bent face out. See Table 2.	ASTM F137	8.3
Dimensional Stability	No more than 0.1 %	EN 669	8.4
Resistance to Chemicals	No more than a slight change in surface dulling, surface attack or staining	ASTM F925	8.5
Resistance to Heat	ΔE not more than 8.0	ASTM F1514	8.6
Resistance to Light	ΔE not more than 8.0	ASTM F1515	8.7
Static Dissipation (Type IV)	Surface to ground resistance in the range of 1.0×10^6 to 1.0×10^9 Ohms tested at 100 or 500 V.	ASTM F150	8.8