



Designation: F3404 – 23a

Standard Specification for Heterogeneous Polyurethane Tile or Plank Flooring¹

This standard is issued under the fixed designation F3404; 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 the requirements for the compound and physical characteristics of heterogeneous polyurethane tile or plank flooring that is printed or otherwise decorated to achieve a pattern or visual and protected by a clear wear layer.

1.2 This specification covers heterogeneous polyurethane tile or plank flooring that shall be composed of binder, fillers, and pigments. The binder shall consist of one or more resins of polyurethane, polyurethane copolymers or other suitable or any desirable combination. Other suitable polymeric resins may be incorporated as part of the binder, provided the polyurethane portion of the binder is greater than 60 % in the base layer.

1.3 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.

1.4 *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

F137 Test Method for Flexibility of Resilient Flooring Materials with Cylindrical Mandrel Apparatus

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.

- F141** Terminology Relating to Resilient Floor Coverings
 - 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 Measuring Recovery Properties of Floor Coverings after Static Loading
 - F1410** Test Method for Measuring Maximum Functional Wet Volume of Utility Vacuum Cleaners
 - 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
 - F1914** Test Methods for Short-Term Indentation and Residual Indentation of Resilient Floor Covering
 - F2055** Test Method for Size and Squareness of Resilient Floor Tile by Dial Gauge Method
 - F2199** Test Method for Determining Dimensional Stability and Curling Properties of Resilient Flooring after Exposure to Heat
 - F2421** Test Method for Measurement of Resilient Floor Plank by Dial Gauge
- 2.2 *ISO Standard:*³
ISO 4918 Resilient, textile and laminate floor coverings — Castor chair test
- 2.3 *ANSI Standard:*⁴
ANSI/ASQC Z1.4 Sampling Procedures and Tables for Inspection by Attributes

3. Terminology

3.1 *Definitions:* For definitions of other terms used in this standard, see Terminology **F141**.

3.1.1 *polyurethane, n*—a polymer composed of organic units joined by carbamate (urethane) links. Polyurethanes can be thermosetting (duroplastic) or thermoplastic polymers.

³ Available from International Organization for Standardization (ISO), ISO Central Secretariat, Chemin de Blandonnet 8, CP 401, 1214 Vernier, Geneva, Switzerland, <https://www.iso.org>.

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

4. Classification

4.1 Polyurethane tile or plank flooring covered by this specification shall be classified as: heterogeneous polyurethane tile or plank flooring with a clear wear layer. The surface structure can be either smooth or embossed.

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 bid or purchase order:

- 5.1.1 Title, number, and date of this specification;
- 5.1.2 Pattern number;
- 5.1.3 Quantity in square feet;
- 5.1.4 Size required (9.2);
- 5.1.5 Thickness required (9.1);
- 5.1.6 Lot formation if other than as specified in ANSI/ASQC Z1.4 (see Sections 11 and 13);
- 5.1.7 Sampling if other than as specified in ANSI/ASQC Z1.4 (see Sections 11 and 13);
- 5.1.8 Packing requirements if other than as specified (Section 16);
- 5.1.9 Palletization if required (agreement between the manufacturer and the purchaser);
- 5.1.10 Marking required if other than specified (Section 15) (agreement between the manufacturer and the purchaser);
- 5.1.11 Chemical Resistance (8.1). The basic chemicals used in the test are those likely to be found in domestic, commercial and institutional use. Many proprietary compounds contain one or more of these basic chemicals. Should the flooring for unusual application need to be resistant to a specific chemical, this additional requirement should become part of the procurement document;
- 5.1.12 Other requirements (agreement between the manufacturer and the purchaser).

6. Materials and Manufacture

6.1 Wear Layer:

6.1.1 The flooring wear layer consists of polyurethane or other suitable combinations that minimally provide the same results as listed in Table 1.

6.1.2 The wear layer shall have a minimum thickness of 0.00394 in. (0.1 mm).

6.1.3 The wear layer shall not be removable by maintenance procedures in accordance with manufacturer's guidelines.

6.1.4 The wear layer shall be clear, a background or pattern may be printed on a pattern carrier with suitably formulated, color stable inks or otherwise prepared to create a color stable pattern. The color of the pattern created must be stable against heat and light deterioration. See 8.4 and 8.5.

6.1.5 The surface of the wear layer may be smooth, embossed or otherwise textured.

6.2 Base Layer:

6.2.1 The flooring base layer consists of polyurethane and a filler.

6.2.2 If necessary to meet the results listed in Table 1 the base layer can be equipped with a reinforcement layer to stabilize the product.

7. Physical Properties

7.1 The polyurethane tile or plank floor covering shall meet the requirements in Table 1.

8. Performance Requirements

8.1 *Resistance to Chemicals*—Tested in accordance with Test Method F925 for residential and commercial usages, polyurethane flooring tiles shall have no more than a slight change in surface dulling, surface attack, or staining when exposed to the following chemicals:

- 8.1.1 White vinegar (5 % acetic acid),
- 8.1.2 Rubbing alcohol (70 % isopropyl alcohol),
- 8.1.3 White mineral oil (medicinal grade),
- 8.1.4 Sodium hydroxide solution (5 % NaOH),
- 8.1.5 Hydrochloric acid solution (5 % HCl),
- 8.1.6 Sulfuric acid solution (5 % H₂SO₄),
- 8.1.7 Household ammonia solution (5 % NH₄OH),

TABLE 1 Characteristics and Tests

Characteristic	Requirement	Test Method	Reference
Size, tolerance			9.3
up to 12 in. ^A	±0.016 in. (0.40 mm)	F2055 Tile	
>12 in. ≤ 18 in. ^A	±0.018 in. (0.45 mm)		
> 18 in. ^A	±0.020 in. (0.50 mm)		
≥24 in. < 48 in. ^A	±0.060 in. (1.50 mm)	ISO 24337 Plank/F2421 Plank	9.4
≥ 48 in. ^A	±0.080 in. (2.00 mm)		
Thickness, product	as specified ±0.006 in. (±0.15 mm)	F386	9.1
Thickness, wear layer	min. 0.00394 in. (0.1 mm)	F410	9.2
Dimensional stability	≤ 0.02 in. per linear feet	F2199	8.6
Static Load Recovery	250 lb load, max residual indent 0.004 in. (0.1016 mm) after 24 h recovery	F970	8.2
Residual indentation	75 lb load, average ≤8 %, maximum single reading 10 %	F1914	8.3
Resistance to chemicals	no more than a slight change in surface dulling, surface attack or staining from listed chemicals	F925	8.1
Resistance to light	avg ΔE ≤ 4.0 after 300 h	F1515	8.5
Resistance to heat	avg ΔE ≤ 4.0 after 7 days exposure	F1514	8.4
Flexibility	passes 0.250 in. (6.4 mm) mandrel	F137	8.7
Castor chair test	25 000 cycles	ISO 4918	8.8

^A 12 in. (305 mm); 18 in. (457 mm); 24 in. (610 mm); 48 in. (1220 mm).