



Standard Specification for Nonvulcanized Rubber Sheet Used as Roof Flashing¹

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1. Scope

1.1 This specification covers nonvulcanized rubber sheet made of EPDM (ethylene-propylene-diene terpolymer) or CR (polychloroprene) intended for use as watertight roof flashing exposed to the weather.

1.2 The tests and property limits used to characterize these flashing materials are specific for each classification and are minimum values to make the product fit for its intended purpose.

1.3 SI units shall be used in referee decisions.

1.4 In-place roof system design criteria, such as fire resistance, field seaming strength, material compatibility, and uplift resistance, among others, are beyond the scope of this specification.

1.5 The following precautionary caveat pertains to the test methods portion only, Section 8, of this specification: *This standard may involve hazardous materials, operations, and equipment. This standard does not purport to address the safety concerns 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 ASTM Standards:

- D 412 Test Methods for Rubber Properties in Tension²
- D 471 Test Methods for Rubber Property—Effect of Liquids²
- D 518 Test Method for Rubber Deterioration—Surface Cracking²
- D 573 Test Methods for Rubber—Deterioration in Air Oven²
- D 624 Test Methods for Rubber Property—Tear Resistance²
- D 1079 Terminology Relating to Roofing, Waterproofing, and Bituminous Materials³
- D 1149 Test Method for Rubber Deterioration—Surface Ozone Cracking in a Chamber²
- D 1204 Test Method for Linear Dimensional Changes on a

Nonrigid Thermoplastic Sheeting or Film at Elevated Temperatures⁴

D 1418 Practice for Rubber and Rubber Latices—Nomenclature²

D 2137 Test Methods for Rubber Property—Brittleness Point of Flexible Polymers and Coated Fabrics²

D 3182 Practice for Rubber—Materials, Equipment, and Procedures for Mixing Standard Compounds and Preparing Standard Vulcanized Sheets²

G 26 Practice for Operating Light-Exposure Apparatus (Xenon-Arc Type) With and Without Water for Exposure of Nonmetallic Materials⁵

G 53 Practice for Operating Light and Water Exposure (Fluorescent UV/Condensation Type) for Exposure of Nonmetallic Materials⁵

3. Classification

3.1 The following types are used to identify the principal polymer components of the flashing material (see Note 1):

3.1.1 *Type I*—Ethylene-Propylene-Diene Terpolymer (EPDM).

3.1.2 *Type II*—Chloroprene Polymer (CR).

NOTE 1—For definitions of polymer types, see Practice D 1418. For definitions of terms related to roofing, see Terminology D 1079.

4. Materials and Manufacture

4.1 The flashing material shall be formulated from the appropriate polymer type and other compounding ingredients. The principal polymer in the flashing material shall be one of those listed in 3.1 in accordance with proportions listed in 3.2 and greater than 95% of the total polymer.

4.2 The flashing material shall be capable of being bonded to itself, to the roofing membrane, and to substrate for making watertight field splices and repairs. The manufacturer or fabricator shall recommend suitable bonding methods and materials.

5. Physical Requirements

5.1 Class V flashing material shall conform to the physical property requirements prescribed in Table 1 and Table 2. Class NV flashing material shall conform to the physical property requirements prescribed in Table 1.

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² *Annual Book of ASTM Standards*, Vol 09.01.

³ *Annual Book of ASTM Standards*, Vol 04.04.

⁴ *Annual Book of ASTM Standards*, Vol 08.01.

⁵ *Annual Book of ASTM Standards*, Vol 14.02.

TABLE 1 Property Requirements for Flashing Before Vulcanization

	Type I	Type II
Thickness, min, in. (mm)	0.055 (1.4)	0.055 (1.4)
Green Strength Modulus 100 % at 75°F (20°C) psi (kPa)	25–250 (172–1725)	25–75 (172–517)
Elongation (Ultimate), min %	400	400
Modulus 100 % at 122°F (50°C) psi (kPa)	12 (83)	12 (83)
Elongation (Ultimate), min, %	200	200
Shelf Stability: Modulus 100 % at 75°F (20°C), max, psi (kPa)	250 (1725)	250 (1725)
Elongation, min, %	400	400
Vulcanizability: Tensile strength, min, psi (kPa)	406 (2800)	406 (2800)
Elongation, min %	400	400
Tensile Set: min, %	80	80
Dimensional Stability, max, %	±10	±10
Weatherability, no cracks or crazing	pass	pass

TABLE 2 Property Requirements for Flashing After Vulcanization

	Type I	Type II
Vulcanization, at 320°F (160°C), min	20 ± 2	20 ± 2
Tensile Strength, min, psi (MPa)	1305 (9.0)	1205 (8.3)
Elongation, min, %	300	250
Tear Resistance, min, lbf/in. (kN/M)	125 (22)	125 (22)
Brittle Point, max, °F (°C)	-49 (-45) pass	-31 (-35) pass
Tensile Set, max, %	10	10
Ozone Resistance, (7×)	no cracks	no cracks
Heat Aging, Air Oven		
Tensile Strength, min, psi (MPa)	1205 (8.3)	1205 (8.3)
Elongation, min, %	200	200
Tear Resistance (Die C), lbf/in. (kN/m), min	125 (22)	125 (22)
Water Absorption, weight change, range, %	+8, -2	+8, -2
Linear Dimension Change, max, %	±2	±2
Weatherability, no cracks or crazing	pass	pass

5.2 Other requirements shall be agreed upon between the purchaser and the supplier as part of the purchase contract.

6. Dimensions and Permissible Variations

6.1 The width and length shall be agreed upon between the purchaser and the supplier as part of the purchase contract.

6.1.1 The width and length tolerance shall be + 3 % and - 0 %.

6.2 Sheet thicknesses greater than minimum shall be agreed upon between the purchaser and the supplier.

6.2.1 The thickness tolerance shall be + 15 % and - 10 % of the specified thickness, but in no case shall the thickness be less than the minimum listed in Table 1.

7. Workmanship, Finish, and Appearance

7.1 The flashing material shall be visually free of pinholes, particles of foreign matter, undispersed raw materials, or other manufacturing defects that might affect serviceability.

7.2 If the number of irregularities appear excessive on a sheet (or portion thereof), then its rejection should be negotiated between involved parties.

7.3 Edges of the sheet shall be capable of being seamed to one another and to other roofing components without fish mouthing.

8. Test Methods

8.1 *Thickness*—Test Methods D 412.

8.2 *Green Strength*:

8.2.1 Test a fresh sample manufactured within one week.

8.2.2 Condition Type I material at 73 ± 4°F (23 ± 2°C) for a minimum of 1 h and a maximum of 8 h before proceeding with the testing.

8.2.3 Decrystallize Type II material by placing in a circulating air oven at 158 ± 4°F (70 ± 2°C) for 15 min. After removal from the oven, condition at 73 ± 4°F (23 ± 2°C) for a minimum of 1 h and a maximum of 8 h before proceeding with the testing.

8.2.4 After conditioning, die out a 0.5-in. (12.7-mm) dumbbell (Die A) and determine the modulus at 100 % extension and the ultimate elongation at 73 ± 4°F (23 ± 2°C) in accordance with Test Methods D 412.

8.2.5 After conditioning, die out a 0.5 in. (12.7 mm) dumbbell (Die A), condition in a circulating air oven at 122 ± 4°F (50 ± 2°C) for 15 min minimum and 30 min maximum and determine the modulus at 100 % extension and the ultimate elongation at 122 ± 4°F (50 ± 2°C) in accordance with Test Methods D 412.

8.3 *Shelf Stability*— Determine green strength in accordance with 8.2 after aging in a circulating air oven for 46 h at 158 ± 4°F (70 ± 2°C).

8.4 *Vulcanizability*:

8.4.1 For Type I and Type II, oven age for 166 h at 158 ± 4°F (70 ± 2°C).

8.4.2 After removal from the oven, condition the samples at 73 ± 4°F (23 ± 2°C) for a minimum of 1 h and a maximum of 8 h before proceeding with testing.

8.4.3 Test for ultimate tensile and elongation in accordance with Test Methods D 412 using a 0.5-in. (12.7-mm) dumbbell (Die A).

8.5 *Tensile Set* (see Test Methods D 412):

8.5.1 Decrystallize Type II material in accordance with 8.2.3.

8.5.2 Hold for 10 min at 73 ± 4°F (23 ± 2°C) and 200 % elongation for Table 1.

8.5.3 Hold for 10 min at 73 ± 4°F (23 ± 2°C) and 50 % elongation for Table 2.

8.6 *Dimensional Stability* (see Test Method D 1204):

8.6.1 Obtain a flat specimen of 6 by 6 in. (150 by 150 mm) and age in an air circulating oven at 212 ± 4°F (100 ± 2°C) for 1 h. Cool to 73 ± 4°F (23 ± 2°C) for 1 h and measure the side of the specimen in both directions.

8.7 *Vulcanization*— Practice D 3182.

8.8 *Tensile Strength*— Test Methods D 412, Die C.

8.9 *Ultimate Elongation*—Test Methods D 412, Die C.

8.10 *Tear Resistance*— Test Method D 624, Die C.

8.11 *Brittle Point* Test Methods D 2137.

8.12 *Ozone Resistance*— Test Method D 1149.

8.12.1 *Type I Material*— Test at 50 % extension, 100 MPa, 166 h at 104 ± 4°F (40 ± 2°C).

8.12.2 *Type II Material*— Test at 20 % extension, 100 MPa, 100 h at 104 ± 4°F (40 ± 2°C).

8.13 *Heat Aging (see Test Method D 573):*

8.13.1 *Type I Material*— Age 28 days at 240 ± 4°F (115 ± 2°C).

8.13.2 *Type II Material*— Age 70 h at 212 ± 4°F (100 ± 2°C).

8.14 *Water Absorption (see Test Method D 471):*

8.14.1 *Type I Material*— Age vulcanized specimen in water for 166 h at 158 ± 4°F (70 ± 2°C).

8.14.2 *Type II Material*— Age vulcanized specimen in water for 46 h at 158 ± 4°F (70 ± 2°C).

8.15 *Linear Dimensional Changes (see Test Method D 1204):*

8.15.1 *Type I Material*— Age 28 days at 239 ± 4°F (115 ± 2°C).

8.15.2 *Type II Material*— Age 70 h at 212 ± 4°F (100 ± 2°C).

8.16 *Weather Resistance (see Practice G 26):*

8.16.1 *Xenon Arc Light Exposure Apparatus Operating Conditions:*

8.16.1.1 *Filter Type*— Borosilicate inner and outer.

8.16.1.2 *Exposure*—0.35 to 0.70 W/m² at 340 nm (42 to 84 W/m² at 300 to 400 nm).

8.16.1.3 *Cycle*—690 min ± 15 min light, 30 min light and water spray.

8.16.1.4 *Black Panel Temperature*—176 ± 5°F (80 ± 3°C).

8.16.1.5 *Relative Humidity*—50 ± 5 %.

8.16.1.6 *Spray Water*— Deionized.

8.16.1.7 *Spray Water Temperature*—110 ± 4°F (43 ± 2°C).

8.16.1.8 *Spray Nozzle*—Water Cooled-F-80.

8.16.1.9 *Specimen Rotation*—Every 315 KJ/m² at 340 nm. (If required, 37.8 MJ/m² at 300 to 400 nm.)

NOTE 2—Approximately every 250 h at 0.35 W/m² to 125 h at 0.70 W/m².

8.16.1.10 *Exposure Time*— 5040 KJ/m² at 340 nm. (604.8 MJ/m² at 300 to 400 nm.)

NOTE 3—Approximately 2000 h at 0.70 W/m² to 4000 h at 0.35 W/m².

8.16.2 Mount cured and uncured specimens for exposure under no strain. Recommended specimen size is 2.75 in. (76 mm) wide by 8.0 in. (203 mm) long. After exposure, remove the specimens and inspect immediately. Strain specimens 10 % in the bent loop configuration in accordance with Test Method D 518 and visually inspect for cracks and crazing under 7× magnification.

8.17 *Weather Resistance*—Practice G 53.

8.17.1 *Lamp Type*—Fluorescent UVB-313 (UVB-B).

8.17.2 *Test Cycle*: 20 h UV at 176 ± 4°F (80 ± 2°C), 4 h condensate at 122 ± 4°F (50 ± 2°C).

8.17.3 *Exposure*—4000 h.

8.17.4 The specimens for exposure shall be mounted under no strain. After exposure the specimens shall be removed and inspected immediately for cracks and crazing at 10 % strain in the bent loop configuration in accordance with Test Method D 518 and 7X magnification. A specimen is rated PASS if no cracks or crazing are observed.

9. Inspection

9.1 Inspection of the material shall be agreed upon between the involved parties.

10. Rejection and Rehearing

10.1 Failure to conform to any of the requirements prescribed in this specification shall constitute grounds for rejection. Rejection shall be reported to the producer or supplier promptly and in writing. The seller shall then have the right to reinspect the rejected shipment material and resubmit the lot after removal of those packages not conforming to the specified requirements.

11. Certification

11.1 Upon request of the purchaser, a manufacturer's certification that the material was manufactured in accordance with the requirements outlined in this specification, together with a report of test results, will be provided.

12. Packaging and Package Marking

12.1 The material shall be wound on a release liner, rolled on a substantial core, and packaged in a standard commercial manner unless otherwise specified so as to be acceptable by commercial or other carriers for safe transportation to the point of delivery.

12.2 Shipping containers shall be marked with:

12.2.1 The name of the material,

12.2.2 Product code,

12.2.3 ASTM number and type,

12.2.4 Size or quantity, and

12.2.5 Name of manufacturer of supplier.

13. Keywords

13.1 chloroprene; EPDM; flashing; nonvulcanized; roofing

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