



Standard Specification for Poly(Vinyl Chloride) Sheet Roofing¹

This standard is issued under the fixed designation D4434/D4434M; 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.

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

1. Scope

1.1 This specification covers flexible sheet made from poly(vinyl chloride) resin as the primary polymer intended for use in single-ply roofing membranes exposed to the weather. The sheet shall contain reinforcing fibers or reinforcing fabrics.

1.2 The tests and property limits used to characterize the sheet are values intended to ensure minimum quality for the intended purpose. In-place roof system design criteria, such as fire resistance, material compatibility, wind uplift resistance, in-situ shrinkage, among others, are factors that must be considered but are beyond the scope of this specification.

1.3 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.4 *This standard may involve hazardous materials, operations, and equipment. 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 limitation prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

- D570 Test Method for Water Absorption of Plastics
- D638 Test Method for Tensile Properties of Plastics
- D751 Test Methods for Coated Fabrics
- D1004 Test Method for Tear Resistance (Graves Tear) of Plastic Film and Sheeting

¹ This specification is under the jurisdiction of ASTM Committee D08 on Roofing and Waterproofing and is the direct responsibility of Subcommittee D08.18 on Nonbituminous Organic Roof Coverings.

Current edition approved Dec. 1, 2015. Published January 2016. Originally approved in 1985. Last previous edition approved in 2012 as D4434/D4434M – 12. DOI: 10.1520/D4434_D4434M-15.

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.

- D1204 Test Method for Linear Dimensional Changes of Nonrigid Thermoplastic Sheeting or Film at Elevated Temperature
- D2136 Test Method for Coated Fabrics—Low-Temperature Bend Test
- D3045 Practice for Heat Aging of Plastics Without Load
- D5602 Test Method for Static Puncture Resistance of Roofing Membrane Specimens
- D5635 Test Method for Dynamic Puncture Resistance of Roofing Membrane Specimens
- D7635/D7635M Test Method for Measurement of Thickness of Coatings Over Fabric Reinforcement
- G151 Practice for Exposing Nonmetallic Materials in Accelerated Test Devices that Use Laboratory Light Sources
- G154 Practice for Operating Fluorescent Ultraviolet (UV) Lamp Apparatus for Exposure of Nonmetallic Materials
- G155 Practice for Operating Xenon Arc Light Apparatus for Exposure of Non-Metallic Materials

3. Classification

3.1 *Type II*—Reinforced sheet in which fibers are incorporated into a production process, for example as a carrier, without appreciably affecting such physical property characteristics of the finished product as tensile strength or ultimate elongation, but may provide other desirable characteristics, such as dimensional stability.

3.2 *Type III*—Sheet that is internally reinforced with fabric and which may also have a fabric backing.

3.3 *Type IV*—Sheet that is internally reinforced with fabric and which may also have a fabric backing with minimum thickness of 0.91 mm [0.036 in.].

4. Materials and Manufacture

4.1 The sheet shall consist of poly(vinyl chloride) resin in amounts greater than 50 % of the total polymer content suitably compounded with plasticizers, stabilizers, fillers, pigments, and other ingredients to satisfy the physical property requirements and accelerated durability tests.

4.2 To make seams and repairs, the sheet shall be capable of being bonded watertight to itself during the design service life of the sheets. The manufacturer shall recommend a suitable

method. Design service life is defined as the designated time period of intended system performance.

5. Physical Requirements

5.1 The sheet shall conform to the physical requirements prescribed in **Table 1**.

5.2 The tolerance for time conditions (aging, weathering, and so forth) is ± 15 min or ± 1 % of the period, whichever is greater, unless otherwise specified.

5.3 The tolerance for temperature conditions (aging, weathering, and so forth) is $\pm 2^\circ\text{C}$ [$\pm 4^\circ\text{F}$] of the specified temperature, unless otherwise specified.

6. Dimensions

6.1 The width and length of the sheet shall be agreed upon between the purchaser and the supplier as part of the purchase contract. The width and length tolerance shall be $+3$ %, -0 % after permitting the sheet to relax for 1 h at $21 \pm 3^\circ\text{C}$ [$70 \pm 5^\circ\text{F}$].

6.2 The thickness tolerance shall be ± 10 % of the thickness agreed upon by the purchaser and supplier, but in no case shall the thickness be less than the minimum in **Table 1**.

6.3 The sheet shall have a minimum coating or laminant thickness of 0.40 mm [0.016 in.] above the cross points of any fabric or fiber and the surface exposed to the weather.

7. Workmanship, Finish, and Appearance

7.1 The sheet and any factory seams shall be watertight. It shall be visually free of pinholes, particles of foreign matter, undispersed raw material, protruding fibers or reinforcement, or other manufacturing defects that might affect serviceability.

7.2 The sheet shall be visually free of nicks and cuts, voids, thin areas, delaminations, or other defects.

7.3 The sheet shall lay straight and flat to permit seaming without fishmouths.

8. Test Methods

8.1 *Conditioning*—Condition the test specimens in accordance with the individual test methods.

8.2 *Overall Thickness*—Test Method **D638** for Type II and Test Method **D751** for Type II, III, and Type IV.

8.3 *Thickness of Coating Over Scrim (Reinforcing Fabric)*—Test Method **D7635/D7635M**—Follow preparation test methods as specified in Test Method **D7635/D7635M**. The thickness measurements shall be conducted as described in the test method on the coating on the side intended to be exposed to the weather.

8.4 *Breaking Strength*—Test Methods **D751**, Procedure B—1 in. strip for Type II and Procedure A for Type III and IV.

8.5 *Elongation at Break*—Test Method **D751**, Procedure B—1 in. strip for Type II and Procedure A for Type III and IV.

8.6 *Seam Strength*—Test Method **D751**, Procedure B—1 in. strip for Type II and Procedure A for Type III and IV. All testing shall be performed on seamed specimens with the passing criteria specified as a percent of either unseamed sample tensile strength at break or unseamed sample breaking strength, dependent on type.

8.7 *Heat Aging*—Practice **D3045** at $80 \pm 1^\circ\text{C}$ [$176 \pm 2^\circ\text{F}$] for 56 days ± 1 h.

8.8 *Tear Resistance*—Test Method **D1004**, for Type II.

8.9 *Tearing Strength*—Test Methods **D751**, B-Tongue Tear Method, for Type III and Type IV. Specimen size shall be 200×200 mm [8×8 in.].

8.10 *Low Temperature Bend Test*—Test Method **D2136**, at -40°C [-40°F].

TABLE 1 Physical Requirements for Poly(Vinyl Chloride) Sheet

Property	Type II	Type III	Type IV
Overall thickness of PVC sheet, min, mm [in.]	1.14 [0.045]	1.14 [0.045]	0.91 [0.036]
Thickness over scrim, min, mm [in.] ^A	0.40 [0.016]	0.40 [0.016]	0.40 [0.016]
Breaking strength, min, N [lbf/in.]	245 [55]	890 [200]	1223 [275]
Elongation at break, min, %:			
Machine direction	250	15 ^B	25 ^B
Cross-machine direction	220	15 ^B	25 ^B
Seam strength, min, % of tensile or breaking strength	75	75	75
Retention of properties after heat aging:			
Tensile strength, min, % of original	90
Breaking strength, min, % of original	...	90	90
Elongation, min, % of original	90	90	90
Tear resistance, min, N [lbf]	45.0 [10.0]
Tearing strength, min, N [lbf]	...	200 [45.0]	400 [90.0]
Low temperature bend	pass	pass	pass
Accelerated weathering test:			
Cracking (7× magnification)	none	none	none
Crazing (7× magnification)	none	none	none
Linear dimensional change, max, %	0.1	0.5	0.5
Change in weight after immersion in water, max, %	± 3.0	± 3.0	± 3.0
Static Puncture Resistance	pass	pass	pass
Dynamic Puncture Resistance	pass ^C	pass ^C	pass ^C

^A Above the cross points of any fabric or fiber and the surface exposed to the weather.

^B For reinforcing fabric only; elongation of PVC material shall be the same as Type II.

^C For Type II products, dynamic puncture shall be evaluated at an energy level of 10 J min. For Type III products, dynamic puncture shall be evaluated at an energy level of 20 J min.

8.11 *Accelerated Weathering*—Perform accelerated weathering for 5000 h using the exposure described either in 8.11.1 or 8.11.2. Choice of apparatus and exposure conditions selected shall be by mutual agreement among the interested parties. The two different types of exposures may produce different test results. Therefore, they cannot be used interchangeably without supporting data that demonstrates equivalency of the procedures for the materials tested. Refer to Practice G151 for cautionary guidance regarding laboratory weathering.

8.11.1 *Xenon Arc Light Exposure*—Practice G155 apparatus shall be operated in accordance with the following conditions:

Filter Type	Daylight
Irradiance Set Point	0.35 W/(m ² ·nm) at 340 nm. The maximum allowable operational fluctuation of the irradiance setting is (±0.02 W/(m ² ·nm)).
Cycle	102 min light, 18 min light plus water spray on the front surface.
Black Panel Temperature, uninsulated	63°C [145°F] during the dry period. The maximum allowable operational fluctuation is ±2.5°C [±5°F].
Relative Humidity	30 %. The maximum allowable operational fluctuation is ±5 %.
Chamber Air Temperature (where applicable)	44°C [111°F]. The maximum allowable operational fluctuation is ±2°C [3.6°F].
Spray Water	Deionized. Refer to Practice G155, Section 6.6.1. Typical water temperature used for specimen spray is 21 ± 5°C [70 ± 9°F], but if ambient temperature is low and holding tank is not used to store purified water, the water temperature can be below the typical range.
Irradiance Uniformity	Refer to Practice G155.

8.11.2 *Fluorescent UV/Condensation Exposure*—Practice G154 apparatus shall be operated in accordance with the following conditions: Using fluorescent UVA –340 lamps. Irradiance level shall be 0.68 W/(m²·nm) at 340 nm. The maximum allowable operational fluctuation of the irradiance setting is ±0.02 W/(m²·nm). Cycle 8 h light at 60°C [145°F], 4 h condensation at 50°C [122°F] uninsulated black panel temperature. The maximum allowable operational fluctuation is ±2.5°C [±5°F].

NOTE 1—If the operational fluctuations are greater than the maximum allowable after the equipment has stabilized, discontinue the test and correct the cause of the problem before continuing.

8.12 *Linear Dimensional Change*—Test Method D1204, 6 h at 80 ± 1°C [176 ± 2°F].

8.13 *Change in Weight After Immersion in Water*—Test Method D570, except for 168 ± 1 h at 70 ± 1°C [158 ± 2°F].

8.14 *Static Puncture Resistance*—Test Method D5602, at a load of 15 kg [33 lbf] min at 23 ± 1°C [73 ± 2°F].

8.15 *Dynamic Puncture Resistance*—Test Method D5635, at an energy of 10 J min at 23 ± 1°C [73 ± 2°F] for Type II and an energy of 20 J min for Type III and Type IV.

9. Inspection and Special Testing

9.1 The manufacturer shall inspect and test his production to ensure compliance of the product with this specification.

9.2 The purchaser may, in the contract, order special tests that the supplier shall be required to make beyond those described in Table 1.

9.3 If the results of any tests do not conform to the requirements of this specification, retesting to determine conformity shall be performed as agreed upon between the purchaser and the supplier.

10. Rejection and Resubmittal

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

11. Product Marking

11.1 The sheet shall be identified on the side intended to be exposed to the weather with this ASTM designation, the name of the manufacturer or supplier, or PVC. The type of identification is at the manufacturer's option. Such identification shall occur at intervals not to exceed 3 m [9.84 ft] in the long direction. The identification shall be applied in such a manner as to be legible five years from installation. Identification shall not be required when so specified by purchaser.

12. Packaging and Package Marking

12.1 The material shall be 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 Name of the material,

12.2.2 Product code,

12.2.3 ASTM designation number, type and grade,

12.2.4 Size and quantity as defined by the contract order,

12.2.5 Name of the manufacturer or supplier, and

12.2.6 Number of the contract order.

13. Keywords

13.1 fillers; flexible sheet; physical properties; plasticizers; poly(vinyl chloride) resin; PVC; reinforcing fabrics; reinforcing fibers; seams; single-ply roofing membrane; stabilizers



ANNEX

(Mandatory Information)

A1. THICKNESS OF COATING OVER FABRIC REINFORCEMENT TEST METHOD D7635/D7635M

A1.1 Follow preparation procedures as specified in Test Method **D7635/D7635M**. The thickness measurements shall be conducted as described in the test method on the coating on the side intended to be exposed to the weather.

ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this standard. Users of this standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

This standard is subject to revision at any time by the responsible technical committee and must be reviewed every five years and if not revised, either reapproved or withdrawn. Your comments are invited either for revision of this standard or for additional standards and should be addressed to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. If you feel that your comments have not received a fair hearing you should make your views known to the ASTM Committee on Standards, at the address shown below.

This standard is copyrighted by ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, United States. Individual reprints (single or multiple copies) of this standard may be obtained by contacting ASTM at the above address or at 610-832-9585 (phone), 610-832-9555 (fax), or service@astm.org (e-mail); or through the ASTM website (www.astm.org). Permission rights to photocopy the standard may also be secured from the Copyright Clearance Center, 222 Rosewood Drive, Danvers, MA 01923, Tel: (978) 646-2600; <http://www.copyright.com/>