
**Resilient floor coverings —
Determination of seam strength**

Revêtements de sol résilients — Détermination de la résistance de la soudure

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Foreword

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The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#)

The committee responsible for this document is ISO/TC 219, *Floor coverings*.

Resilient floor coverings — Determination of seam strength

1 Scope

This International Standard specifies a method for determining the strength of the seams of resilient floor coverings when welded in accordance with the manufacturer's instructions.

2 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

2.1

seam strength

maximum tensile force recorded, for a defined width, when a floor covering is tested under a constant rate of extension

2.2

constant-rate-of-extension (CRE) testing machine

tensile testing machine provided with one clamp which is stationary and another clamp which moves with a constant speed throughout the test, the entire testing system being virtually free from deflection

3 Principle

An increasing tensile force is applied until the seam breaks (see [Figure 1](#); the arrows indicate the direction of the applied tensile forces).

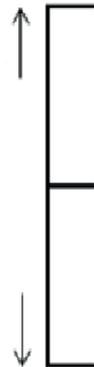


Figure 1 — Principle of test

4 Apparatus

A tensile testing machine, which allows a speed of separation of (100 ± 5) mm/min, and a force recording device shall be used.

5 Sampling and preparation of test pieces

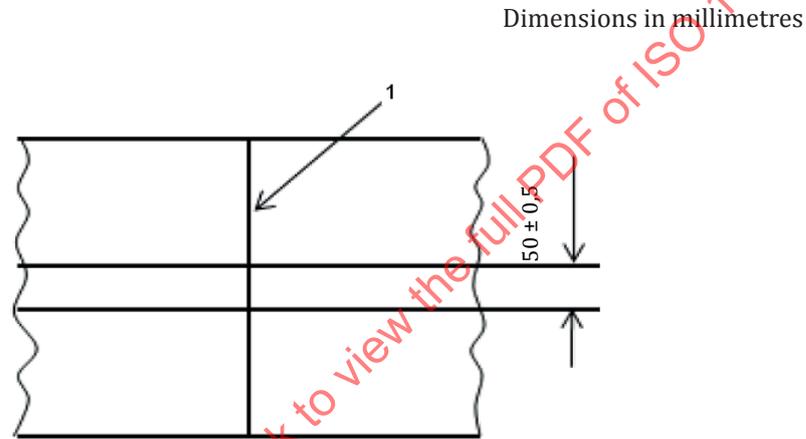
5.1 Sampling

Take a representative sample from the available material.

5.2 Preparation of test pieces

Take two pieces of a sheet floor covering with minimum length of 1 m and minimum width of 300 mm and weld them together in accordance with the manufacturer's instructions. The weld shall be done on the long side of the sample. For tiles, weld two tiles together in accordance with the manufacturer's instructions.

Cut five test pieces with minimum length of 150 mm and width of $(50 \pm 0,5)$ mm at equal distances across the sample, the distance between the outer edge of the sample and the nearest edge of the test piece being at least 100 mm, with the seam centrally located across each test piece (see Figure 2).



Key

1 seam

Figure 2 — Test piece layout

6 Conditioning

Condition the test pieces at a temperature of (23 ± 2) °C and relative humidity of (50 ± 5) % for a minimum of 24 h.

Maintain these conditions when carrying out the test.

7 Procedure

Place the test piece in the jaws (which are approximately 100 mm apart) of the tensile testing machine so that the seam is at an equal distance from the jaws and tension is applied evenly over the width. Set the machine and its recording device in operation such that the speed of separation is (100 ± 5) mm/min. Record the force at break or the maximum force exerted.

Repeat the test on the remaining test pieces to obtain five values.