

IMA / SPRA QUALITY STANDARDS

Specification for laminated Board (roofboards) with auto-adhesively bonded facings for use as roofboard thermal insulation under single-ply non-bituminous external roofing membranes.

The requirements have been written so that the product automatically complies with EN13165 whilst satisfying the specified minimum performance levels of the properties included in this standard which are necessary to confer fitness for purpose.

Physical property	Identification of material to be tested i.e. roofboard or foam core	Requirement	Test method	Equivalent class or values in BS EN 13165
Minimum compressive strength, normal to the major plane of the board (in kPa) (see note 1)	Roofboard	150	BS EN 826	CS (10\Y) 150
Minimum compressive strength, perpendicular to the plane of the board (in kPa) (see note 1)	Foam core	100	BS EN 826	CS (10\Y) 100
Maximum water vapour permeability normal to the major plane of the board PUR and PIR roofboards (in ng/Pa.s.m) PUR and PIR roofboards (in MNsg/m)	Foam core Foam core	8.5 300	Carry out the test at $(38 \pm 0.5)^{\circ}\text{C}$ with a r.h. of $(88 \pm 2)\%$ on one face of the test piece and 0% on the other. Cut the cylindrical test pieces $25 \pm 0.5\text{mm}$ thick such that their plane faces are parallel to the major plane of the board and then carry out the test in accordance with method 8 of BS 4370: Part 2: 1993, condition a)	See clause 4.3.8 of BS EN 13165
Dimensional stability: Maximum linear change (in %) 24h at $(-20 \pm 3)^{\circ}\text{C}$ 24h at $(+70 \pm 2)^{\circ}\text{C}$ and $(90 \pm 5)\%$ r.h. (see note 1)	Roofboard	± 1.0 ± 3.0	Cut the length and width of the test specimen parallel to the major plane of the board and test in accordance with method 5A of BS 4370: Part 1: 1988	See clause 4.2.6 of BS EN 13165
Tensile strength perpendicular to faces (in kPa) (See note 1)	Roofboard	Mean 80 Min 60	BS EN Method 1607	TR80 TR60

NOTE 1. The tests are often used by manufacturers for quality control.

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DIMENSIONAL TOLERANCES FOR LENGTH AND WIDTH	
The length and width of roofboards shall be as given in Table 2 when measured in accordance with BS EN 822.	
Table 2 Dimensional tolerances for lengths and widths	
Length and width	Permissible deviations
Up to and including 1200mm	+ or - 2.5mm

NOTE. Tolerances on roofboards with a length and width greater than 1200mm should be as specified by the manufacturer.

THICKNESS		
Roofboard nominal thicknesses, dN, shall be stated after measuring in accordance with BS EN 823. They shall comply with the tolerances given in Table 3 and no roofboard shall differ by more than 1.5mm in thickness across its width at any distance along its length.		
Table 3 Thickness tolerances		
Nominal thickness mm	Tolerances mm	Tolerances mm
20 to 30	± 1.5	T3
31 to 49	± 2.0	T2
≥ 50	± 2.5	T2

FLATNESS		
Flatness shall be determined in accordance with BS EN 825. The deviation from flatness, S _{max} , shall not exceed the values given in Table 4.		
Table 4 Deviations from flatness		
Full size product		Deviation from flatness S _{max} mm
Length m	Area m ²	
≥ 2.50	≤0.75	≤5
	>0.75	≤10

