



Standard Specification for Rigid Poly(Vinyl Chloride) (PVC) Exterior-Profile Extrusions Used for Assembled Windows and Doors¹

This standard is issued under the fixed designation D4726; 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 establishes requirements for the material properties, including dimensional stability, weatherability, and extrusion quality, of rigid poly(vinyl chloride) (PVC) exterior profile extrusions used for assembled windows and doors. Methods for testing and for identifying exterior profile extrusions that comply with this specification are also provided.

1.2 The use of rigid PVC recycled plastic in this product shall be in accordance with the requirements in Section 6.

NOTE 1—Information with regard to application, assembly, and installation should be obtained from the manufacturers of the profiles and of the windows and doors.

NOTE 2—Refer to Specification D3678 for interior profile extrusions.

1.3 Color-hold guidelines are provided in an appendix for the manufacturer's product development and quality performance use.

1.4 Color-hold guidelines are presently limited to white, grey, beige, light brown, and dark brown (see Figs. X1.1 through X1.5). Additional colors will be added as color guidelines are developed.

1.5 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are for information only.

NOTE 3—There is no known ISO equivalent to this standard.

1.6 The text of this standard references notes and footnotes, which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of this standard.

1.7 The following safety hazards caveat pertains only to the test methods portion, Section 11, of this specification: *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.

1.8 *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

- D618 Practice for Conditioning Plastics for Testing
- D883 Terminology Relating to Plastics
- D1042 Test Method for Linear Dimensional Changes of Plastics Caused by Exposure to Heat and Moisture
- D1435 Practice for Outdoor Weathering of Plastics
- D1600 Terminology for Abbreviated Terms Relating to Plastics
- D2244 Practice for Calculation of Color Tolerances and Color Differences from Instrumentally Measured Color Coordinates
- D3678 Specification for Rigid Poly(Vinyl Chloride) (PVC) Interior-Profile Extrusions
- D3892 Practice for Packaging/Packing of Plastics
- D4216 Specification for Rigid Poly(Vinyl Chloride) (PVC) and Related PVC and Chlorinated Poly(Vinyl Chloride) (CPVC) Building Products Compounds
- D4226 Test Methods for Impact Resistance of Rigid Poly(Vinyl Chloride) (PVC) Building Products
- E631 Terminology of Building Constructions
- E805 Practice for Identification of Instrumental Methods of Color or Color-Difference Measurement of Materials
- G147 Practice for Conditioning and Handling of Nonmetallic Materials for Natural and Artificial Weathering Tests

3. Terminology

3.1 *General*—Definitions are in accordance with Terminologies D883 or E631 and D1600, unless otherwise indicated.

¹ This specification is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.24 on Plastic Building Products.

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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.

*A Summary of Changes section appears at the end of this standard

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *color-hold guidelines*—target color regions within a three-dimensional model which constitute acceptable appearance retention levels of color change resulting from weathering of a specific product type and color.

3.2.2 *temperate northern climate*—in weather testing, a North American metropolitan area testing site located within 73 to 100° W longitude and 37 to 45° N latitude.

4. Classification

4.1 *Color Regions*—The color region for a color is determined by measuring the Hunter L, a, b color values for a sample. Use the integer value (by truncating any fractional results) to determine the color region for the color using the following region boundaries.

4.1.1 Region 1—Beige:

L = 60 to 87
a = -2.5 to 4.0
b = 6.5 to 23

4.1.2 Region 2—Dark Brown:

L = 13 to 33
a = -1.0 to 6.0
b = 1.0 to 6.5

4.1.3 Region 3—Gray:

L = 33 to 74
a = -3 to 4
b = -5.5 to 5.5

4.1.4 Region 4—Light Brown:

L = 30 to 60
a = -1.5 to 12.5
b = 3.0 to 12.5

4.1.5 Region 5—White:

L = 83 to 100
a = -4 to 0
b = -5.5 to +5.5

NOTE 4—L, a, b is determined in accordance with the Hunter L, a, b opponent color space system in Test Method [D2244](#).

5. Significance and Use

5.1 The purpose of this specification is to establish a recognized standard of quality for rigid poly(vinyl chloride) (PVC) exterior weatherable profile extrusions for use in assembling windows and doors. The information contained in this specification is intended to be helpful to producers, distributors, and users, and to promote understanding between buyers and sellers. It is also intended to serve as the basis for specification requirements of exterior windows and doors which are made from rigid PVC profile extrusions in their construction.

6. Materials and Manufacture

6.1 The profile extrusions used for assembled windows and doors shall be made principally of weatherable, rigid poly(vinyl chloride) (PVC) compounds meeting or exceeding the requirements of Class 1-20131-13 as defined in Specification [D4216](#).

NOTE 5—Non-PVC materials may be used as a capstock.

6.2 Rigid PVC recycled plastic is acceptable for use in this product if all the requirements in the sections on Terminology

(Section 3), Materials and Manufacture (Section 6), Physical Requirements (Section 7), and Performance Requirements (Section 8) are met by the extrusions containing PVC recycled plastic.

6.3 The PVC compound in the extruded section shall have visual uniform color and be free of any visual surface or structural changes, such as peeling, chipping, cracking, flaking, or pitting.

6.4 *Rework Material*—Clean, homogeneous PVC rework material or rework material containing PVC capstock generated from the manufacturer's own production of the same class compound is acceptable for use by the same manufacturer providing that the extruded profiles meet all the requirements of this specification. Clean principally PVC rework material containing non-PVC capstock is acceptable for use in the substrate of a capstocked product by the same manufacturer, providing that the extruded profiles meet all of the requirements of this specification.

6.5 The PVC compound shall have successfully met the weathering requirements for six months at each climatic testing site prescribed in [A1.1.1](#) prior to use in production of exterior-profile extrusions for either market development or sales.

NOTE 6—The six-month-test requirement constitutes a screening process to eliminate catastrophic failure in the marketplace.

7. Physical Requirements

7.1 *Dimensions*—The size, thickness, and dimensional tolerances of the exterior profiles shall be as agreed upon between the supplier and the purchaser in the purchase order, or by established internal process control standards.

7.2 *Dimensional Stability*—The dimensional stability of the exterior-profile extrusions shall be determined in accordance with [11.3](#). Extrusions over 0.040 in. (1.02 mm) shall have a maximum average shrinkage of 2.2 % for all sides measured, with no single value exceeding 2.4 %. Extrusions of 0.040 in. (1.02 mm) or less shall have a maximum average shrinkage of 3 %.

7.3 *Impact Resistance*—Flat sections of the exterior profile extrusion shall have a minimum brittle impact failure of 1.0 in.-lb/mil (4450 J/m) when tested in accordance with Test Methods [D4226](#), Procedure B, using impactor C.125. Refer to [11.4](#).

8. Performance Requirements

8.1 Weathering:

8.1.1 The exposures listed in [Annex A1](#) shall be conducted in order to meet the requirements of this specification. All exposures shall be conducted at an angle of 45° S, plywood-backed, in accordance with Practice [D1435](#) and Practice [G147](#).

8.1.2 After six-month and 1-year exposure times, the minimum mean impact for 20 measurements conducted on the exposed specimens shall be at least 0.6 in.-lb/mil (2670 J/m). Test impact in accordance with [11.4](#), [A1.4](#), and [A1.5](#).

8.1.3 After each exposure time, the tested specimens shall maintain a visual uniform color and be free of any visual

changes in appearance at the surface, such as peeling, chipping, cracking, flaking, and pitting when tested in accordance with **Annex A1**.

NOTE 7—It is recommended that manufacturers use the color-hold guidelines in **Appendix X1** to ensure quality performance.

8.1.4 Weatherability conformance testing requirements are to reflect performance of a “typical” extrusion system profile representing a specific PVC compound and a specific extrusion technology. In no case is there an implied requirement for testing all the various shaped profiles. The lengthy outdoor weatherability testing shall be performed concurrently with market development of new applications and sales of profiles to existing markets. Completion of weatherability testing prior to marketing of the product is not required. The profile extrusion producer shall immediately respond in terms of compound change or extrusion technology change to unsatisfactory weatherability behavior of the profiles under test in any climatic test site at any stage of the weatherability testing.

9. Workmanship, Finish, and Appearance

9.1 The extrusions shall meet internal process control standards in section, color, and finish. The extrusions shall be substantially straight and free from defects that might affect appearance or serviceability.

10. Sampling

10.1 Select samples using a statistically acceptable procedure. The samples shall be representative of the compound used.

11. Test Methods

11.1 *General*—Use the inspection and test procedures contained in this section to determine the conformance of products to the requirements of this specification. A producer or distributor representing products as conforming to this specification shall use statistically based sampling plans that are appropriate to each manufacturing process. Keeping essential records are necessary to document with a high degree of assurance the claim that all of the requirements of this specification have been met. Additional sampling and testing of the product, as agreed upon between the supplier and the purchaser, is not precluded by this section.

11.2 *Conditioning of Specimens*—Condition the test specimens in accordance with Procedure A of Practice **D618**. For the purpose of quality control testing, the minimum conditioning time shall be four hours.

11.3 *Dimensional Stability:*

11.3.1 Determine the dimensional stability in accordance with Test Method **D1042**, except that one or more specimens shall be exposed to either of the following test cycles:

11.3.1.1 30 min immersed in water maintained at $180 \pm 2^\circ\text{F}$ ($82 \pm 1^\circ\text{C}$), or

11.3.1.2 30 min conditioned in a forced-ventilation oven at $180 \pm 2^\circ\text{F}$ ($82 \pm 1^\circ\text{C}$).

11.3.2 Specimens shall condition for no less than 1 h in accordance with Procedure A of Practice **D618**, prior to measurement. If a specimen were to fail, select and retest two additional specimens.

11.4 *Impact Test*—Determine the impact strength in accordance with Test Methods **D4226**, Procedure B, using the C.125 impactor.

12. Packing, Packaging, and Package Marking

12.1 The exterior profile extrusions shall be packaged in such a manner as to provide reasonable protection against damage in ordinary handling, transportation, and storage.

12.2 Provisions of Practice **D3892** shall apply to this specification.

12.3 Marking on each package of extruded profile extrusions shall include the following:

12.3.1 Manufacturer’s name or trademark;

12.3.2 Identity of code number of extrusion profiles;

12.3.3 Class of compound (Specification **D4216**) used in profiles;

12.3.4 The designation ASTM D4726, affirming that the product so marked has been qualified to all the provisions of this specification, and

12.3.5 The date and any other relevant information, such as factory, machine, production shift, and so forth, either directly or all or partly coded.

13. Keywords

13.1 color-hold guidelines; doors; exterior-profile extrusions; poly(vinyl chloride) (PVC); recycled plastic; windows